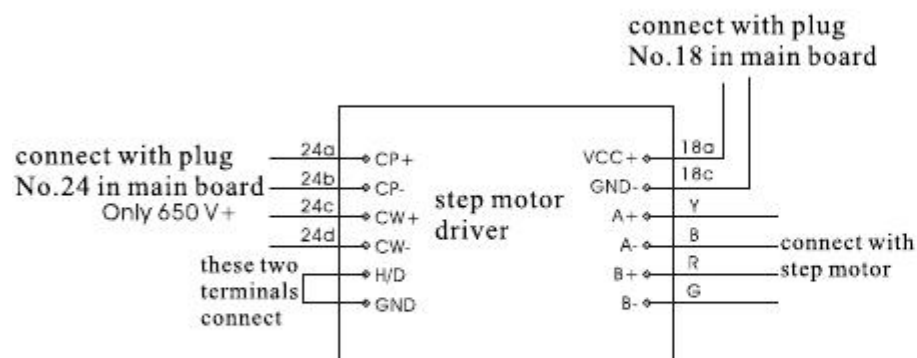


670 *Series Paper Cutter* User Manual

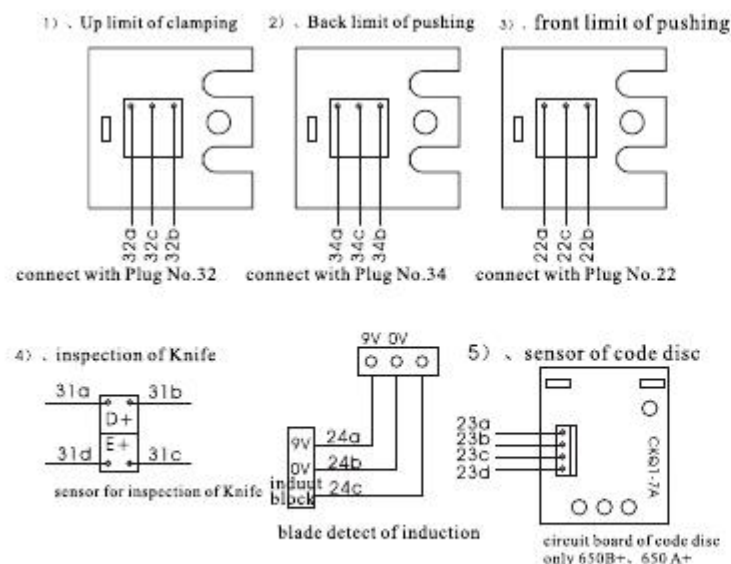


V1.1,2007.3

4、Wiring means of step motor driver



5、Connecting of all kinds of sensors



Content

Preface

Chapter one :

1. open the pack and check
2. name of the machine's parts and their functions
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1. turn on the machine
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4. blade stick adjustment
5. assembling and disassembling of the blade

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1. lubrication
2. Maintenance

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Preface

Thanks very much for choosing 650 series paper cutter ,we are trying to offer you our most perfect products and best service.

On the basis of the former products, 650 is a newly developed product. Its fittings adopt CE standard design, Microcomputer program control circuitry, auto-pressing paper, auto-pushing paper design make operation more convenient, working efficiency higher. Infrared blade light position, crystal display make cutting sizes are all clear at a glance, and cutting much quicker and more precise . Its infrared photoelectric protection , two hands cutting operation , multi-protection make operation safer , more reassurance. It can be fully applied to the small and medium sized printing enterprises, photocopies, offices to cut the paper, books, pictures, documents, files as well as other non-metal materials. Safety and reliable, high quality low price make the machine an ideal product for your cutting.

Safety warning

The personal and the machine's safety are both very important .make sure you have read this manual book carefully and also pay attention to the safety instructions stickup(or carved) on the machine.

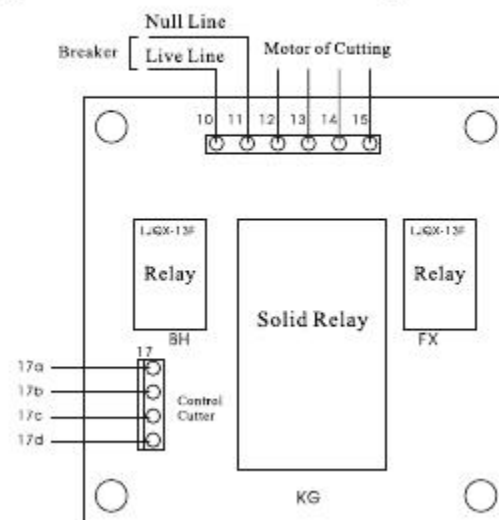
You can find the following "warning" instructions from the machine (As showed in the picture).

In order to avoid the incidents and any hurt ,please allow the specialists to operate the machine according to the relevant standards(children or non-specialized people are forbidden to operate the machine),Please pay the special attention to the following safety warning when operating or maintaining the machine :



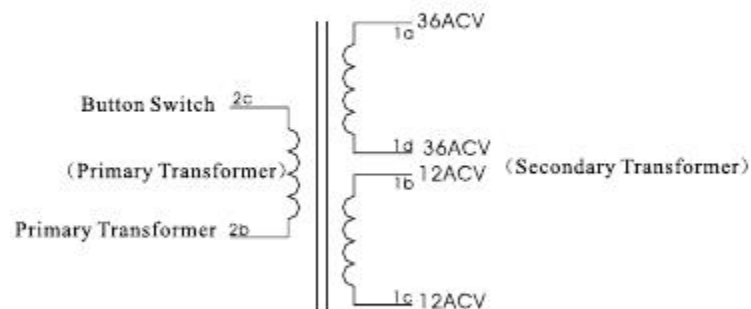
	本切紙機應放置于水平干燥的地面上。 The machine must be installed on a sturdy, dry and level foot.		刀片鋒利，手及手指要靠近。 Sharp blade, keep hand and fingers away.
	禁止未成年入操作本機。 Children must not operate the machine.		每裁切2000次，須磨刀一次。 The blade must be sharpened after 2000 cutting.
	禁止裁切金屬或其他硬質材料物品。 否則會損壞刀片。 Paper clips or hard material will damage the cutting blade!		禁止裁切厚質硬質材料物品。 which may splinter.
	每次使用好機後，請將壓紙夾刀片落在最低位置收緊螺絲，以便延長壓紙夾彈簧的使用壽命。 Each time after using the machine, please make the blade and its structure in the lowest position, so as to prolong the utility of the springs in the blade structure.		

2, Wiring means of Control the Cutting motor



Note: power spec 14 plug-in: 220V no use ; 110V Use

3, Wiring means of main transformer



Plug-in units Instructions of Main Board									
Plug Number	Plug Name	Wire Definition	Wire Number	Remark	29	Light panel	12DCV (+)	25a	Power of light panel
1	Secondary transformer	36ACV	1a	relevant terminal of transformer	Plug Number	Plug Name	Wire Definition	Wire Number	Remark
		12ACV	1b						
		12ACV	1c						
		36ACV	1d						
2	primary transformer	L	2a	Button Switch	30	Potentiometer	Power	26a	Handwheel of pusher adjustment (only 650 V+)
		N	2b	Transformer Primary			0	26b	
3	Voltage	L	3	Breaker	31	Button PUSH/CUT	Signal	27a	Only 650 V+
4		N	4				0	27b	
5	Null of Main coil		5	D.c.cpressl	32	Button PUSH	Signal	28a	Only 650 V+
6	Live line of Main coil		6				0	28b	
15	—		15	Motor or pressing paper	33	Button CLAMP	Signal	29a	Only 650 V+ 650 B+
16	+		16				0	29b	
17	—		17	D.c.cpressl	34			30a	
18	+		18					30b	
19	Cutter control	16a、17a	17a	protection of knife	35	Blade detect of photoelectric intensity	D	31a	sensor for inspection of knife
		16b、17b	17b	direction of knife			(+)	31b	
		16c、17c	17c	on/off of knife			(+)	31c	
		16d、17d	17d	(+) 12DCV			E	31d	
21	Power of drive	36DCV	18a	VCC (+)	36	Up limit of clamping	5	32a	Only 650 V+ 650 B+ 650 H+
			18b				0	32b	
		36DCV	18c	GND (-)			Signal	32c	
22	Button of RESET	Signal	19a		37	measure speed of pushing		33a	Motor of Press (only 650 V+, 650 B+)
		0	19b					33b	
23	Button of CUT	Signal	20a		38	back limit of pushing	5	34a	
		0	20b				0	34b	
24	blade Detect Of Induction	9v	24a	Blade detect of magnetic induction	39	key board	Signal	34c	
		0v	24b				5	35a	
		Signal	24c				Signal	35b	
25			21a	Standby	40	Shield	Signal	35c	
			21b				0	35d	
			21c				5	36a	
26	Press Limit of PUSH	5	22a		41	infrared wall	0	36b	for choose (it isn't necessary to connect null with signal)
		0	22b				Signal	36c	
		Signal	22c				5	37a	
27	Sensor of Encoding Disk	5	23a	Only 650 B+ 650 A+	42	Indicator	0	37b	
		Encoding Disk	23b				Signal	37c	
		Count	23c				5	38a	
		0	23d				Signal	38b	
28	Driver control	5	24a	Only 650 V+			Signal	38c	Indicator of PUSH
		Pulse	24b				Signal	38d	
		5	24c				Signal	38e	
		Direction	24d				Signal	38e	

I fixing requirements

1. if you find any damage to the machine when unpacking ,you should forward in time.
2. the machine's weight is about 270kg, please make it in stable position.
3. you should hold the button part of the machine or through the handle of carrying machine to carry the machine ,should not forcibly in other parts , otherwise will lead the machine parts to be shifted which will affect the usage .
4. Please don't plug in multi-pcs electric appliances in the power socket, as overload of the electricity may lead to fire or electric shock.

II electric safety warning

1. the power socket should install in the place near to the machine, please don't make the power cable longer at will.
2. the machine must use the appointed power specification, you can find the power specification on the machine. The socket must match with the plug.
3. Please connect the power according to the correct instructions ,high voltage or low voltage will lead the machine work abnormally.
4. For your personal safety, make sure to use the power socket which has been connected to the earth line .
5. make sure to turn off the power or plug out the plug before you cleaning up the machine or maintaining the machine.

III other requirements

please don't maintain the machine at will ,for the following cases ,please turn off the power and contact with the agent who sold you the machine .

==the damage of the power cable or socket

==some liquid drops or streams into the main board of the machine.

==After some incorrect operation ,the machine doesn't work normally .

== the machine is not the same one as instructed in the manual book and can't be operated .

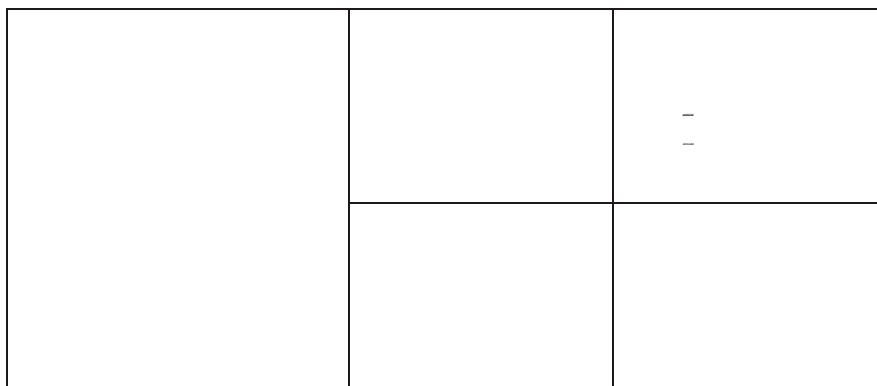
Chapter one

I Unpacking to check

After unpacking the packing , please check the machine and its fittings ,for damage or losing ,please contact with the agents or head office .

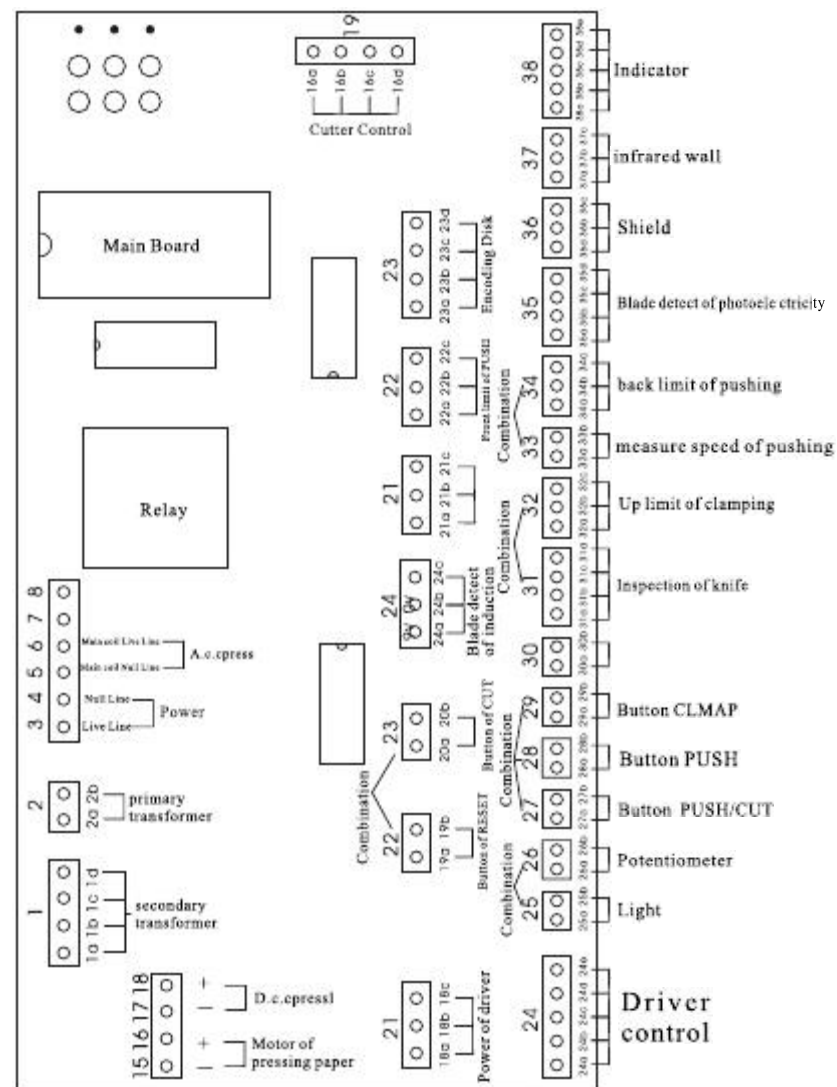
- (1)Machine 1pcs
- (2)Power cable 1pcs
- (3)Manual book 1pcs
- (4)Guaranteeing card 1pcs
- (5)Wood board for making the paper in order 1pcs
- (6)Tool bag 1set

Before your installation and operation, please be familiar with the machine's structure according to the following pictures.



III、Main Board and plug-in units

1, Explanation of connector in main board



Note: Some plug-in sockets have been united in order to simplify the connecting.

Contents of alarm in display screen	Principles and phenomenon	Reasons and the methods of disposal	Remark
2nd Error of Signal of Zero position Please dispose	Only start the machine and reset the pusher, it appears this warning. While reset, and for a comparatively long time, the zero position's signal is still in the non-sensitive state (i.e. the pusher is out of the blocking range of sensor of zero position signal), then displays the alarm, and at the same time the motor of pushing stops to run.	A. Before start the machine, the pusher stops out of zero sensor's checking scope and pusher doesn't move while reset, the possible reason is that the motor conks out, or motor's line board conks out or controller conks out, or the line of controller to main control board conks out or correlative parts of main control board conk out. B. While reset, the pusher runs backward (runs away from the direction the cutter), after arrive at the end but doesn't stop, and bounces several seconds, then stops, the possible reason is that zero sensor conks out, or alnico moves, breaks off and magnetic pole opposites, or the line of controller to main control board conks out, or correlative parts of main control board conk out. C. While reset, the pusher runs forward (runs toward the cutter), after at the end but doesn't stop, and bounces several seconds then stop, the possible reason is that the main control board conks out or the line of controller to main control board conks out, or correlative parts of main control board conk out.	
Pusher beyond the front limit Please dispose	While the pusher runs, if the limit sensor (which is installed in the end of lead screw which is near cutter. When the position of pusher is less than 30mm, it will be induced) induces the pusher, it will display this warning. At the same time, the motor of pusher stops.	A. If the pusher is in position within 30mm before runs, it needs to turn off the machine and turn the motor of pusher by hand to the position out 30mm. B. If the pusher is out of 30mm before it runs, and runs into 100mm, it means the motor of pusher is out of step when the pusher runs forward, the possible reason is that the pusher transmitted system's resistance too large in some site, or the controller's electricity too little, or the controller's pressure too low. C. The pusher location without 30mm, but display this warning, the possible reason is that limited sensor conks out, or the line in sensor conks out, or correlative parts of main control board conk out.	
Error of over zero signal Please dispose	Inside the main controlling board appears over zero signal, which is the main signal of circuit. When it is abnormal, the machine can't work correctly, it will display this warning. Attention to the inside of main controlling board, is independent of the outside of main controlling board.	A. Change or repair main board	
Infrared discoveries foreign body Please dispose	While clamps and cuts the paper, if the infrared protection device induces the foreign body, the machine will immediately stop cutting and pressing, and displays this warning.	A. In pressing or cutting paper, something comes into the area of discovery really. B. In pressing or cutting paper, nothing comes into the area of discovery really. The possible reason is that the infrared protector is dirty or fail to function (adjust potentiometer to advance the agility), or protector conks out, or interlaminar lamp-house is near the protector (as some kinds of energy saving lamp), or correlative parts of main control board conk out.	
Shield is opened Please dispose	In pressing or cutting paper, if the shield is open, it will immediately stop cutting and pressing, and display this warning.	A. In pressing or cutting paper, the shield is open really. B. In pressing or cutting paper, the shield isn't open. The possible reason is that the switch of shield breaks, or line conks out, or correlative parts of main control board conk out.	Limit to the machine equipped with shield

II Name and the functions of the machine parts Pictures as well as its instruction

Type A



Type B



Type H












Type V



II 、 Explanation of alarm

After switch on the power, if some abnormality happens, the machine will give an auto alarm to the operator. At the same time, the display screen can display the contents of alarm. The particular contents of alarm and the methods of disposal are as follows:

Contents of alarm in display screen	Principles and phenomenon	Reasons and the methods of disposal	Remark
Manual knob isn't at midpoint Please dispose	When starting the machine, the auto checking manual knob should be in the middle of the stopping position. If not, it will display this warning, then turn the knob to stop at the midpoint. After finishing, this warning will auto disappear. If can't finish during 20s, the machine will consider knob to be broken, and cancel this function, but the other functions can't be affected	A. Knob potentiometer is broken, change potentiometer (4.7k linearity potentiometer) B. Knob line or line plug broke, change or repair Knob line or line plug C. Main board is faulted, repair or change main control board	Only type V
Cutting paper is overtime Please dispose	When the cutter is working, every turning half circle (gearbox's output axle), the state of cutter position sensor must change once. If it is over half circle obviously, haven't received the change of sensor, it will display this warning. At the same time, stopping the motor of cutter	A. If the motor of cutter is off, and doesn't run, the possible reason is that the motor board or main control board or line between forecast two conks out B. If the motor of cutter is on, and doesn't run, the possible reason is that coil of motor is off or the armature can't be kick-off C. The motor runs, paper jam happens, press button RESET to removal the fault D. The motor runs, and no paper jam, the possible reason is the sensor of position is wrongly fixed or broken, or the coil is fault, or main control board is fault	
Clamping paper is overtime Please dispose	If the motor of clamping works obviously over the round trip time, and still don't receive the signal "CLAMP" (when downward) or signal of top position (when upward), then display the alarm, and the motor stop to run.	A. If the motor of clamp is off and doesn't run, the possible reason is that part of main control board conks out or line conks out B. If the motor of pressing is on and doesn't run, the possible reason is that the motor winding line is open or mechanical resistance too strong C. If the motor of clamping runs downwards, then driving system is skidded D. If the motor of clamping runs upwards, the possible reason is that the installation of sensor of position is error or broken, or line conks out or main control board conks out, or alicia position is error, direction opposites and alicia breaks off	Only type V type B
Speed-Measuring of clamping is error, Please dispose	When the motor of clamping runs downward for 1 second, and still doesn't receive the running signal(measure speed signal), it will display this warning. At the same time, the motor stop to run.	A. If the motor of clamping is off and doesn't run, the possible reason is that some parts of main controlling board conks out or line conks out B. If the motor of clamping is on and doesn't run, the possible reason is that the motor's winding line is open or mechanical resistance too strong C. If the motor already runs, the possible reason is that the measuring speed signal is error or line conks out or main controlling board conks out	Only type V type B
1" Error of Signal of Zero position Please dispose	Only start the machine and reset the pusher, it appears this warning. While reset, and for a comparatively long time, the zero position's signal is still in the sensitive state (i.e. the pusher is always in the checking range of sensor of zero position signal), then displays the alarm, and at the same time the motor of pushing stops to run.	A. If pusher stops at zero position, sensor's checking scope and pusher don't move during resetting before start the machine (the possible reason is that motor conks out, or motor's line board conks out or controller conks out, or the line of controller to main control board conks out or relevant parts of main controlling board conks out) B. If the pusher runs forward (runs toward the center) for 50mm, then stops, the possible reason is that zero position sensor conks out or alicia breaks off and stops near sensor, or correlative parts of main control board conks out C. The pusher runs backward (runs away from the cutter) during resetting, after arriving the end but doesn't stop, and bounces 2s, then stops, the possible reason is that the main control board conks out or the line of controller to main control board conks out, or correlative parts of main control board conks out	

Code	Checking content	Operating ways	Judging ways	Slowing ways	Remarks
	Reset sensor of the sensor	Press "reset" button to shift the carrier to "0" position, and then press "cut press" co-acting button and "press" button, the clamp (press frame) will press down, there is no need to press to the lowest position, you just press to three quarters and then stop, then press "cut press" co-acting button and "cut" button at the same time, the clamp (press frame) will come back to the highest position.	When the press frame came back to the highest position, and the code in digital window change from "0" to "1", which means the sensor works normally, if it hasn't changed to "1", which means there is something wrong with the sensor.	If the code "0" doesn't change, which means there is something wrong with the sensor system, it needs to be needed or changed, if the magnetic wire hasn't moved, which will also display "0", so you'd better check the magnetic wire to see if it is shifted or fall off.	Only Type B Type V
			During the procedure of the press frame's up and down, if the code in digital window change from "0" to "1", which means the press's motor works normally, if it hasn't changed to "1", which means there is something wrong with the motor.	If the code "0" doesn't change, which means there is something wrong with the motor system, it needs to be needed or changed.	
	Front-limited sensor of the pusher	Press "reset" button to shift the carrier to "0" position, and then press "cut press" co-acting button and "press" button, the pusher will move forward.			
	Back-limited sensor of the pusher	Press "reset" button to shift the carrier to "0" position, and then press "cut press" co-acting button and "cut" button, the pusher will move backward.			
	Main board "0" voltage signal	When under the self-checking condition, the signal will check itself, no need people to operate.	When under the self-checking condition, the digital window will display "0", and if it keeps changing between "0" and "1", which means the main board works normally, if only displays "0", which means there is something wrong with the main board.	If the code "0" on digital window only displays "0", which means there is something wrong with the main board, it needs to be needed or changed.	
	Encoder signal	Rotating the hand-wheel of the pusher.	When rotating the hand-wheel of the pusher, the code "0" on digital window will keep changing between "0" and "1", which means the encoder signal works normally.	If the code "0" only displays "0", which means there is something wrong with the encoder signal, it needs to be needed or changed.	Only Type B Type A
	Safety cover sensor				
	Infrared wall sensor	Use some objects to cover the infrared wall.	If the code "0" on digital window change from "0" to "1", which means the sensor of infrared wall works normally, if it hasn't changed to "1", which means there is something wrong with the sensor system.	If the code "0" doesn't change, which means there is something wrong with the sensor system, it needs to be needed or changed.	
	Reserving sensor				
Knob5	Potentiometer of the hand-wheel	Rotating the hand-wheel of the pusher.	If the code "Knob5" on digital window shifts between "1-9", which means the potentiometer works normally, if the code hasn't changed, which means there is something wrong with the potentiometer.	Change the potentiometer.	Only Type V
Total counters 00000001 means the blade motor's total counters					

III. Main parameters

SORT	TYPE A NUMERICAL-CONTROL PAPER CUTTER	TYPE B NUMERICAL-CONTROL PAPER CUTTER	TYPE H NUMERICAL-CONTROL PAPER CUTTER	TYPE V PROGRAM-CONTROL PAPER CUTTER
MAX CUT SIZE (mm)	LENGTH670*WIDTH650	LENGTH670*WIDTH650	LENGTH670*WIDTH650	LENGTH670*WIDTH650
MIN CUT SIZE (mm)	30	30	30	30
MAX CUT THICKNESS (mm)	80	80	80	80
HEIGHT (FROM WORKING PLATFORM TO EARTH) (mm)	860	860	860	860
BLADE SIZE WIDTH*HEIGHT (mm)	655*14*14	655*14*14	655*14*14	655*14*14
PRESS PAPER WAY	MANUAL	AUTO	AUTO	AUTO
PUSH PAPER WAY	MANUAL	MANUAL	AUTO	NUMERICAL-CONTROL
PROGRAMME	/	/	/	✓
POWER SUPPLY	AC110V±10% 50HZ <input type="checkbox"/> AC220V±10% 50HZ <input type="checkbox"/> AC110V±10% 60HZ <input type="checkbox"/> AC220V±10% 60HZ <input type="checkbox"/>			
POWER	1100W	1500W	1400W	1600W
MACHINE SIZE	1280*980*1200	1280*980*1200	1280*980*1200	1280*980*1200
WEIGHT	270	270	270	270

Chapter four Instruction for auto checking and connecting of main board

IV. Performances

- 1、CE standard design: Infrared wall and multiple switch protection, transparent safety cover;
- 2、Imported main motor ,pushing paper motor provide the core guarantee for the machine;
- 3、Independent design of pressing ,cutting paper, more reasonable, more convenient;
- 4、Strengthened blade frame , excellent blade insure cutting precision, and the blade frame;
- 5、Double pushing paper bars insure pushing precision, back ,left and right double push paper gauge meet different cutting requirements;
- 6、Bright light beam ,convenient and applied;
- 7、Program control design : front and back cutting can be adjusted at will ,8program store(up to 9steps each)(only type V);
- 8、Imported blade stick can be used eight times , durable and save the cost;
- 9、The cutting depth can be adjusted at will ,convenient and applied;
- 10、Stainless steel front board ,wear well;
- 11、The clearance of the blade ,pressing paper frame adjustable design insures cutting precision.

I 、650 self-checking



When the machine is not turned on, Press “ ” co-using button and at the same time turn on the machine, then the machine will be in self-check condition, the objects to be checked are: each single button, sensors, motor, etc. The detailed information is as follows:

Instructing picture of operation, each time presses button, the cursor will shift between: blade reset, press reset, press motor, pusher's front-limited sensor, pusher's back-limited sensor, when choosing the content u want to check, you, at the same time, press the “ ” co-using button and “ ” button or press the “ ” co-using button and “ ” button to check, the others can be checked separately or self check.					
Code	Checking content	Operating ways	Judging ways	Slowing ways	Remarks
A1 0	 Press, cut co-using Button	Press the “cut-press” co-using button	If the code in digital window change from “ ” to “ ”, which means the button works normally, if it doesn't change to “ ”, which means there is something wrong with the button	If the digital window still display “ ”, which means the button has been damaged, it need to be changed or be mended, u can also check the connection of the button	
A2 0	 Reset button	Press the “reset” button	If the code in digital window change from “” to “”, which means the button works normally, if it doesn't change to “”, which means there is something wrong with the button	If the digital window still display “”, which means the button has been damaged, it need to be changed or be mended, u can also check the connection of the button	
A3 0	 Push button	Press the “push” button	If the code in digital window change from “” to “”, which means the button works normally, if it doesn't change to “”, which means there is something wrong with the button	If the digital window still display “”, which means the button has been damaged, it need to be changed or be mended, u can also check the connection of the button	Only Type V
A4 0	 Press button	Press the “press” button	If the code in digital window change from “” to “”, which means the button works normally, if it doesn't change to “”, which means there is something wrong with the button	If the digital window still display “”, which means the button has been damaged, it need to be changed or be mended, u can also check the connection of the button	Only Type B Type V
A5 0	 cut button	Press the “cut” button	If the code in digital window change from “” to “”, which means the button works normally, if it doesn't change to “”, which means there is something wrong with the button	If the digital window still display “”, which means the button has been damaged, it need to be changed or be mended, u can also check the connection of the button	
A6 0	Reserve code				
 0	Blade reset sensor	Press the “reset” button to shift the cursor to the “” position, then press the “cut-press” co-using button and “press” button, the blade will cut down, when it came down, press “cut-press” co-using button and “cut” button at the same time, the blade will come back to the highest position.	When the blade is in the half-down position, the code in digital window change from “0” to “1”, which means the sensor works normally, if it doesn't change to “1”, which means there is something wrong with the sensor.	If the code “0” doesn't change, which means there is something wrong with the sensor system, it needs to be mended or changed, if the magnetic slice hasn't sensed, which will also display “0”, so you'd better check the magnetic slice to see if it is shifted or fall off.	

Chapter three: lubrication and maintenance

I .Lubrication

- 1.You should lubricate the machine one time in one month.
- 2.Turn off the power, open the relevant parts to lubricate. (as showed in picture 9, 10,11)
- 3.Pay attention to not let the oil drop on the electric circuit or electric components.
- 4.Decelerating gear of main motor should be clean and oil one time each year.

II .Maintenance

- 1.Mustn't put the non-cut material on the machine when the machine is working, which is to avoid hard materials mangling the blade, and should also avoid the staple mangling the blade when cutting the binded books.
2. When finishing the cutting each day, you should clean up the waste, Put the wax on the blade, and turn off the power.



(picture-9)
bar of press paper block



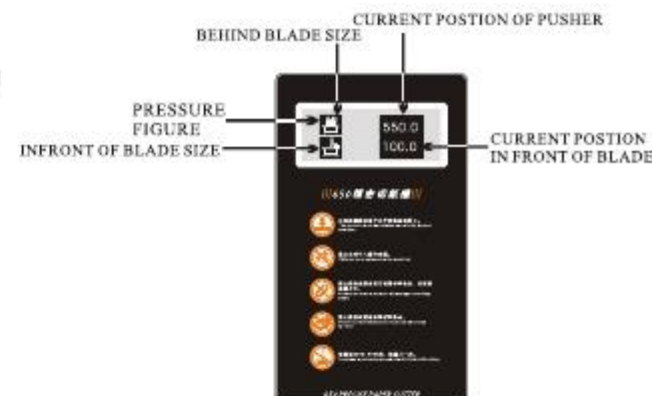
(picture-10)
bar of push paper gauge



(picture-11)
runner of blade

V. Control panel

TYPE A , TYPE B, TYPE H
DIGITAL BOARD



TYPE V DIGITAL CONTROLLING BOARD



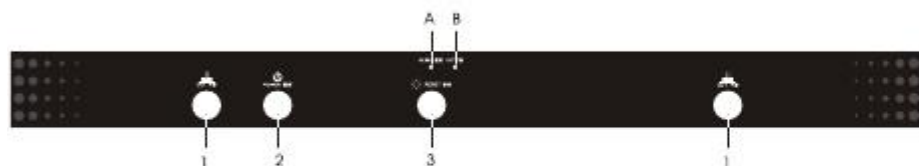
MAIN BOARD

1. DIGITAL DISPLAYING WINDOW
2. NUMBER BUTTONS (KEYS)
3. SET BUTTON (MENU KEYS)
4. UP BUTTON
5. DOWN BUTTON
6. ENTER BUTTON
7. CANCEL BUTTON

DIGITAL WINDOW INSTRUCTION

- A. BEHIND OF BLADE CONDITION
- B. IN FRONT OF BLADE CONDITION
- C. PRESSURE
- D. CURRENT PUSH PAPER GAUGE'S (PUSHER'S) POSITION
- E. PROGRAM CONTROL'GROUP' (IN FRONT OF OR BEHIND OF THE BLADE)
- F. PROGRAM CONTROL'SECT' (IN FRONT OF OR BEHIND OF THE BLADE)

TYPE A PAPER CUTTER MAIN CONTROL PANEL






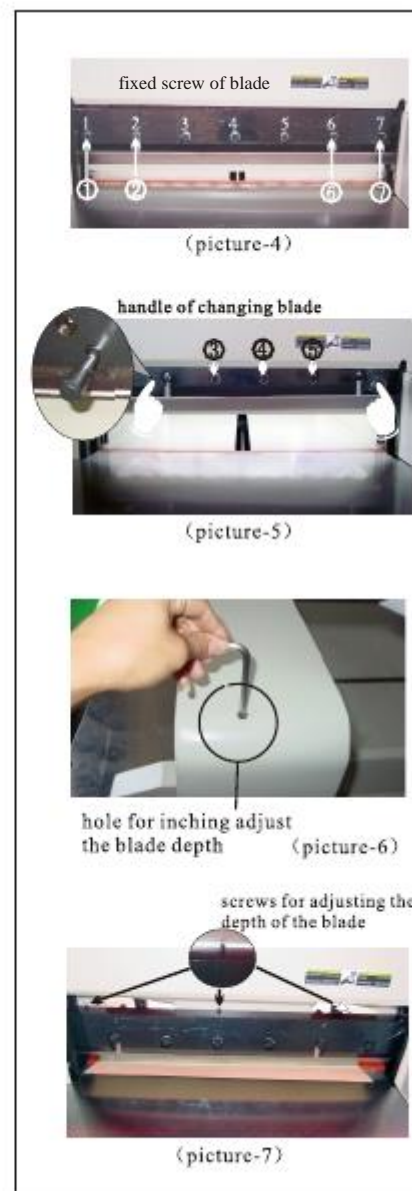
PANEL INSTRUCTION

INDICATING LIGHTS:

- A、(RESET) 复位指示灯
- B、(CUT) 下切指示灯

FUNCTIONAL KEYS:

- 1、(CUT)  下切键
- 2、(POWER)  电源键
- 3、(RESET)  复位键



3, Disassembling the blade without putting the cover, and finish it as follow:

- A) Let the blade move to the middle and then turn off the power, loosen the screws of 1,2,6,7 on the blade. (As Picture 4).
- B) Let the blade return top point by Press **Reset** key, and then put the Handle of Replacing Blade fixed on the screws of 2,6.(as picture5)
- C) After setting the handle of Replacing Blade, and then loosen the Screws of 3, 4, 5, following take off the Blade carefully by your hands taking hold of Handle of Replacing Blade(as Picture 5), instead or sharpen blade.
- 4, Please get to professional Sharpening Shop to make sure the sharpening quality.
- 5, Please follow the above opposite steps if you install blade.

Adjust the Blade Stick

- 1, If the paper can not be cut off, imply need adjust the depth of blade and change the side of blade stick.
- 2, Adjust the depth of blade, fine turning the depth of blade use M8 inner hexangular wrench, adjust the screw on right above of Blade Frame(as Picture 6)
- Note: The scale that adjusting the depth of blade: about 23mm. If the screw has been end still can not cut off paper completely, you can take off the cover by adjusting the crews that balanced the blade.**
- 3, If the depth of cutting after you install the blade after you changing or sharpening, you can adjust the three screws on the blade frame (as Picture 7)

Note: Adjust the depth of blade by balance screws; the scale is 2-3mm. After adjusting the balance screws the paper still can not been cut off completely, you need replace or grind the blade.

- 4, Adjustment way: Let the blade move to the middle, and then loosen the seven screws that been used fasting the blade (as Picture 4),
- 5, Let the blade move to the lowest point and then adjust the three screws on the blade structure, use the M3 inner hexangular wrench to adjust, usually it should be adjusted to 0.3-0.5mm(the depth is the blade cut into the blade stick). You also have a piece of paper tested and check the paper if been cut off, and then carry on adjusting according to been cut status.
- 6, Finish adjusting the blade, then fixes the 7 screws.

IV. Blade stick adjustment

1. The blade stick can bear using for eight times.
2. If the blade stick is abraded badly, it needs adjusting its side (it has four sides, each side can be used two times), or changes the stick.
3. Using the long screwdriver to put into the turnup hole and make the stick turnup (as showed in picture 1, 2)
4. Take out the stick to turn it to other side or turn it around, if is badly abraded, change another stick.
5. After changing the stick, put it into the groove from the front flat, make sure you have put the two heads of the stick flat and then you can put the whole stick into the groove. (As showed in pic-3).



hole for turn up the blade strick
(picture-1)



turn up the blade strick
(picture-2)



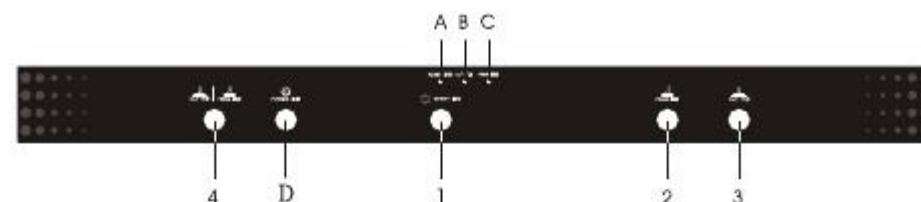
take out or put in the blade strick
(picture-3)

V. Adjustment and disassembling of the blade.

Replace Blade:

1. While cutting the material, if the material been cut not so tidy or the cutting sound sounds a little abnormal, or not easily cut, which implies that the blade needs changing or sharpening. (Usually you need sharpen the blade after it cutting 2000 times, or will be machine's using time)
2. The blade can be sharpened and then be used for cutting again.

TYPE B PAPER CUTTER MAIN CONTROL PANEL



PANEL INSTRUCTION

INDICATING LIGHTS:

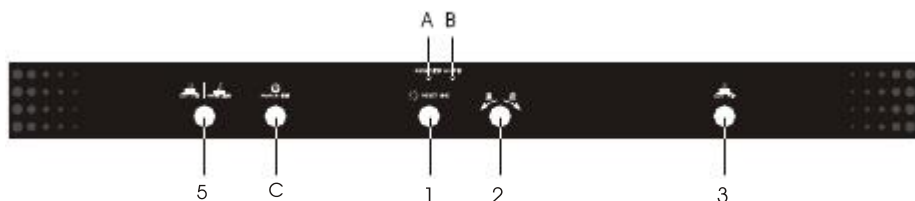
- A、(RESET) 复位指示灯
- B、(CUT) 下切指示灯
- C、(PRESS) 压纸指示灯
- D、(POWER) 电源指示灯

FUNCTIONAL KEYS:

- 1、(RESET) 复位键
- 2、(PRESS) 压纸键
- 3、(CUT) 下切键
- 4、压纸、下切公共按键
(“PRESS” “CUT” CO-USING BUTTON)

NOTICE: YOU CAN SET THE PRESSURE FIGURE BY PRESSING THE
CO-USING BUTTON AND RESET BUTTON AT THE SAME TIME.

TYPE H PAPER CUTTER MAIN CONTROL PANEL



PANEL INSTRUCTION

INDICATING LIGHTS:

- A、(RESET) 复位指示灯
- B、(CUT) 下切指示灯
- C、(POWER) 电源指示灯

FUNCTIONAL KEYS:

- 1、(RESET) 复位键
- 2、(BACKWARD FORWARD) 推纸器快进、退键
- 3、(CUT) 下切键

650V+ New function of Programmable continuous cutting

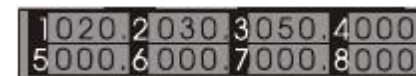
Method of operation

1, press the "set" button, shift to the front blade program control state (as picture X shows) select the sixth group to set the sizes you need. This program is available for repeat cuts in both different and same size. (notice: make sure operate this procedure under the sixth program control group under front blade condition)

Eg1: to cut paper 600mm long into 20mm 30mm 50mm long sizes successively: you should enter into the sixth group, set the sizes as follows:

20;30;50;00
00;00;00;00

The window shows:



Then the paper will be cut into the sizes you set. till the rest paper short than the size you set, the paper pusher will return to the original position, waiting for next cycle work.

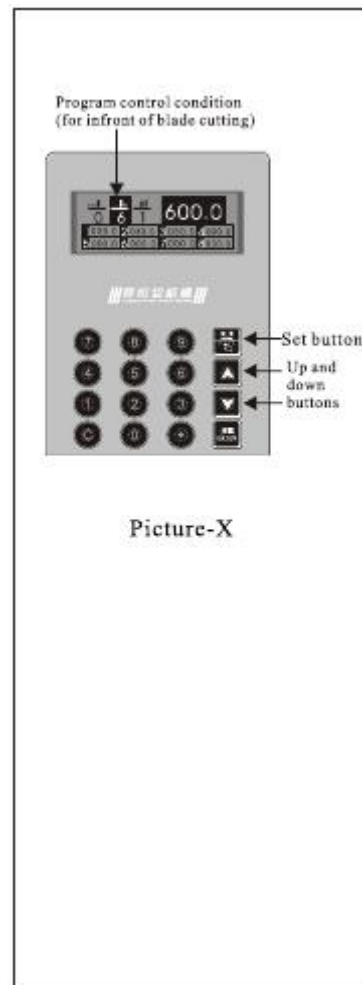
Eg2: to repeatedly cut paper 600mm long to 10 sets in 60mm: you should enter into the sixth group, set the sizes as follows:

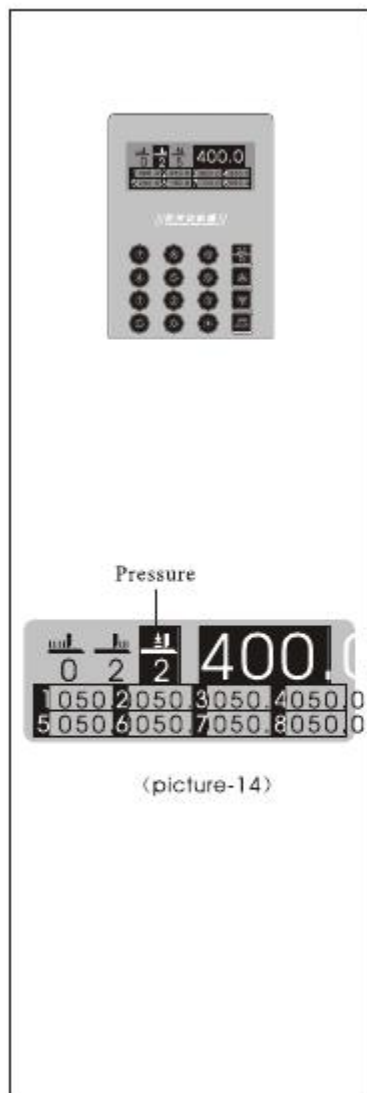
60;60;00;00
00;00;00;00


The window shows:










In this order, the paper can be cut into many same 60mm size continuously. till the rest paper smaller than the size you set, the paper pusher will return to the original position, waiting for next cycle work.









press “” for a long time and it will give out “di di” sound twice, which means it has exit the set and, the machine then can work from the program control you selected. After finishing each program control sect, the machine will work from the following sect automatically.

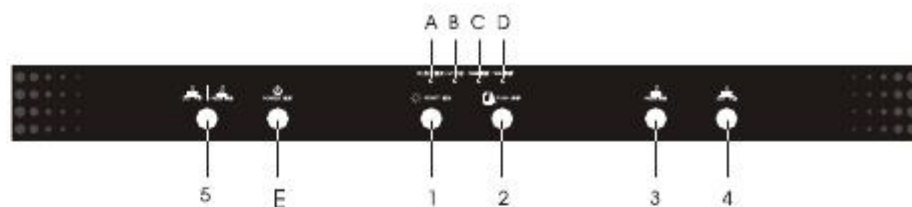
Notice: the manual adjustable wheel will not work under program control condition

2. After setting the cutting size, put the cutting material in order, press “”, the reset light will light, and the blade and the clamp paper block will come to the highest position.
 3. if the machine is under the automatic push paper condition, the push light will light, press “” to stop this push paper function, and the push paper light will off. Under the program control condition you need not use the automatic push paper function.
 4. press the “” button with two hands at the same time, the clamp light will light And the clamp paper block will press the paper until it press the cutting materials tight enough and then you stop pressing the button.
- If no need the clamp paper block to press the paper, you can press “” with two hands at the same time, then the cut light will light, the clamp paper block and the blade will respectively press and cut the paper.
5. After finishing pressing the paper, you can press, “” button to begin the cutting. Press the “” with two hands at the same time, the cut light will light and the blade will cut until it finishes the cutting, and then stop pressing the “” button, and at the same time the blade and the clamp paper block will come to the highest position, then one cycle cutting finished

6. the pusher will put forward the first sect cutting material, and move to the second sect cutting size to be ready for the cutting, press “” button, the reset light will light, press “” with two hands at the same time and the blade is cutting, then the second sect cutting finished, pusher will move to the third sect cutting size to be ready for the cutting. Then the machine will cycle the cutting.

7. According to the above set cutting size (in front of blade 50mm), the cut material will be 50mm. If you still cut the same specification material, you just need press “” button after each cutting, the reset light will light, and then press “” with two hands at the same time, then the machine will begin to cut again, after each sect cutting, the machine will move to following sect to begin the cycling cutting.

TYPE V PAPER CUTTER MAIN CONTROL PANEL



PANEL INSTRUCTION

INDICATING LIGHTS:

- A、(RESET) 复位指示灯
- B、(CUT) 下切指示灯
- C、(PRESS) 压纸指示灯
- D、(PUSH) 推书指示灯
- E、(POWER) 电源指示灯

FUNCTIONAL KEYS:

- 1、(RESET)  复位键
- 2、(PUSH)  推书键
- 3、(PRESS)  压纸键
- 4、(CUT)  下切键
- 5、  压纸、下切公共按键

(“PRESS” “CUT” CO-USING BUTTON)

VI. Functions of the keys and controlling parts

When operating the digital window(main control panel) (include "pause" or "wait"), the adjustable wheel will have no effect on any operation on digital window, when operating the adjustable wheel (including "pause" or "wait"), the operation on digital window will have no effect on the adjustment .

behind of blade



in front of blade



press paper pressure



Type V Digital control board

1. "set" button

This button is used for shifting the working ways, each time after you press ,it will be " behind of blade" condition , "in front of blade" condition , " press paper pressure" , which will be cycling shift . if then press "up" , "down" button, it will enter into set condition.

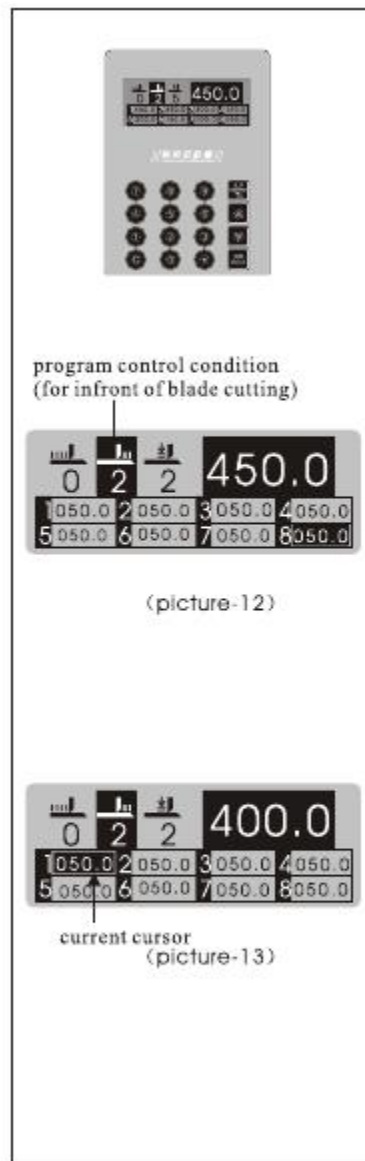
A. when under the "behind blade" condition, there are two kinds : " $\frac{0}{1}$ ", " $\frac{1}{0}$ " if digital window displays " $\frac{0}{1}$ ", which means the machine is in "behind blade" condition ,and is for manual operation, if digital window displays " $\frac{1}{0}$ " which means the machine is in "behind blade" condition ,but is for program control operation. There are 1-9 group available for setting under the " program control" condition , and each group you can set 1-8 sect cutting size .

B. when in the "in front of blade" condition, there are also two kinds: " $\frac{1}{1}$ ", " $\frac{1}{1}$ ". If digital window displays " $\frac{1}{1}$ ", which means the machine is in "in front of blade" condition, and is for manual operation, if digital window displays " $\frac{1}{1}$ " , which means the machine is in "in front of blade" condition ,but is for program control operation. There are 1-9 group available for setting under the " program control" condition , and each group you can set 1-8 sect cutting size .

C. when under the " press paper pressure" condition , which means the machine is under " $\frac{1}{1}$ " condition . " $\frac{1}{1}$ " means the setting figure of the " press paper pressure" , the machine's tolerant pressure figure is 5 level when turning on the machine, there are 1-9 levels in the pressure figure.

" $\frac{0}{1}$ " means the min pressure ,

" $\frac{1}{9}$ " means the max pressure .



Program control operation (in front of the blade cutting)

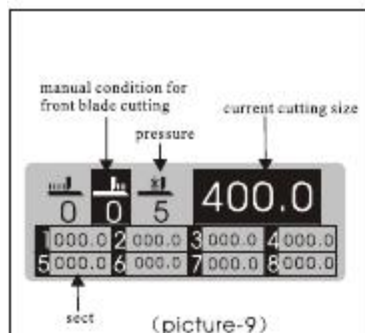
1. Press " set" button to shift to program control condition, according to the cutting requirements, you can choose the program control group on the digital displaying screen, the Program has 1-6 groups, each group has 8 sect cutting size. After choosing the control group, you can press the button to input the cutting size. And then press " $\frac{1}{1}$ " to confirm in the normal condition.

E.g: if cuts 450mm width material, need to cut 50mm width each sect , firstly, move the pusher to 450mm under manual operation (in front of the blade), and then enter into the program control manual operation to set the program sect you need.

Choose the second program group ,you should first press the " set" button to shift to the front blade condition ,then press " $\frac{1}{1}$ " to " $\frac{2}{2}$ " and then press " $\frac{1}{1}$ " to confirm to enter into the first program control sect in the second program control group.

After entering the program control sect, you can press the number button to set the first sect cutting size or modify it, press number button to input 0, 5, 0; And then press " $\frac{1}{1}$ " button to enter into the second sect to set the cutting size, press the number button to input 0, 5, 0, and then press " $\frac{1}{1}$ " to enter into the third sect to set the cutting size, press number button to input 0, 5, 0, and then press " $\frac{1}{1}$ " to enter into the forth sect to set the cutting size, press number button to input 0, 5, 0 and then press " $\frac{1}{1}$ " to enter into the fifth sect to set the cutting size, press the number button to input 0, 5, 0, and then press " $\frac{1}{1}$ " button to enter into the sixth sect to set the cutting size and press the number button to input 0, 5, 0 and then press " $\frac{1}{1}$ " to enter into the seventh sect to set the cutting size and press number button to input 0, 5, 0 and then press the " $\frac{1}{1}$ " to enter into the eighth sect to set the cutting size, press the number button to input 5, 0 (as showed in picture-12), after finishing inputting the cutting size ,move the cursor to the first sect (400.0) (as showed in picture-13) , press " $\frac{1}{1}$ " for a long time ,and then it gives out "di di" twice ,which means it has exit the set ,then you can begin the cutting .

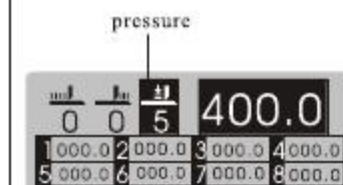
If you want to choose one of the setted cutting size in the program control sect to modify or set it, first you should press " set" button to shift to the present program control group and then press " $\frac{1}{1}$ " to enter into set condition, then press " $\frac{1}{1}$ " or " $\frac{1}{1}$ " to move the cursor to the selected program control sect and press the number button to modify or set. After setting,



(picture-9)



(picture-10)



(picture-11)

Manual operation (in front of the blade cutting)

1. Press "set" button to shift to manual condition, you can directly input the cutting size on the digital window according to the cutting requirements.

E.g: if cuts 650mm width material, it should cut 250mm in front of the blade, you should press "set" button to shift to "0", and then orderly press number keys 4,0,0, and then press "confirm" to confirm, and the pusher will move to the 400mm and then stop automatically, and be ready for the cutting. (As showed in picture-9).

You can also adjust the "pusher hand-wheel" to adjust the cutting size, you can rotate the adjustable wheel to 400mm, when the digital window displays "400" you can stop the adjustment. (As showed in picture-10). The pusher hand-wheel works under the manual condition.

2. After finishing the cutting size's position, and put the cutting material in order, press "reset", the reset light will light, the blade and clamp paper block will come to the highest position to be ready for cutting.

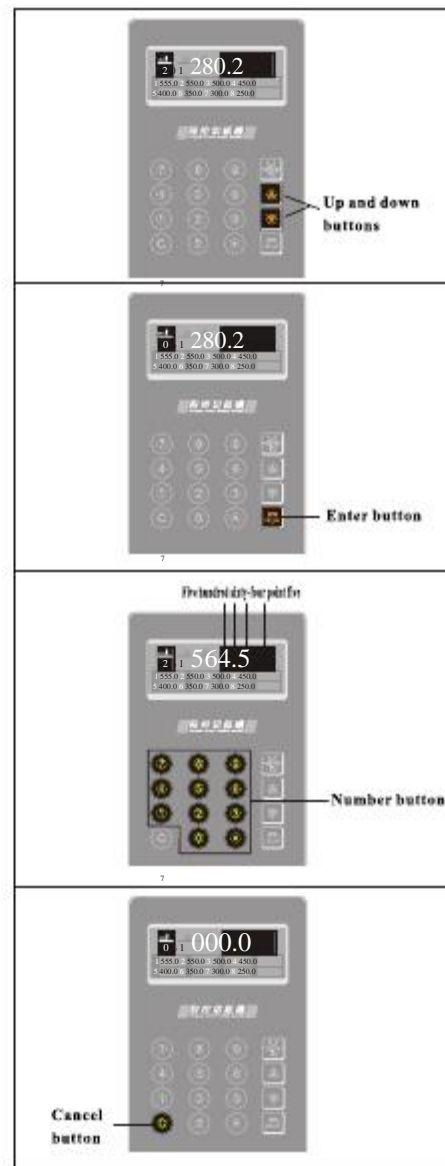
3. Press "clamp" with two hands at the same time, clamp light will light and clamp paper block will press the paper until it press the cutting material tight enough and then stop pressing the "clamp" button.

If no need the press paper block to press the paper, you can press "push" with two hands at the same time, then the cut light will light, the press paper block and the blade will respectively press and cut the paper.

4. Press "push" for three seconds, if the push light lights, which means the machine is in auto-push paper condition.

5. After finishing pressing the paper, you can press, "cut" button to begin the cutting. Press the "cut" with two hands at the same time, the cut light will light and the blade will cut until it finishes the cutting, and then stop pressing the "cut" button, and at the same the blade and the clamp paper block will come to the highest position, then one cycle cutting finished.

6. According to the above set cutting size (in front of blade 250mm), the cut material will be 250mm, if still cuts the same specification, you just need to press "reset" button after each cutting cycle, when the reset light lights, press "push" with two hands at the same time, you can begin the cutting again.



2. Up and down buttons

"▲", "▼" buttons are used together with the set button, to set, modify, change the relevant functions, when setting the figures, each time you press the "▲" button, the number will increase or some function will cycle up. when setting the figures, each time you press the "▼" button, the number will decrease or some function will cycle down.

3. Enter button

"confirm" button is used to confirm the function, together use with the other functional button such as "▲", "▼".

4. Number buttons

Press the number buttons (0-9) to set the cutting size, if you set the figures with some decimal, you just need to press the decimal point and then press the other numbers (the same usage way as the calculator).

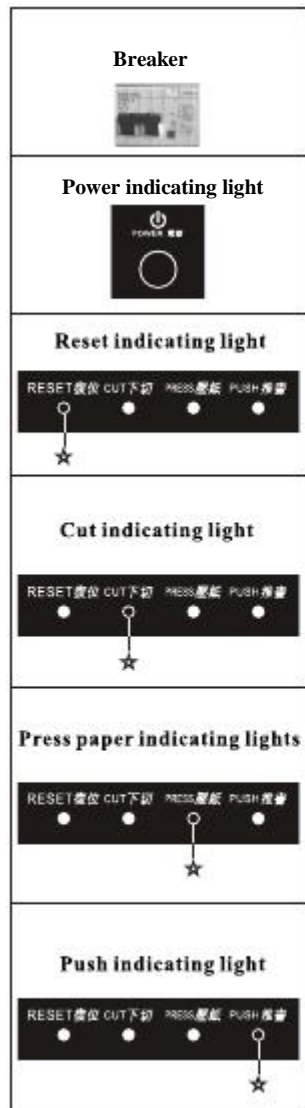
E.g: if sets cutting size of 564.5mm, you just need press 5 6 4 . 5 numbers, and then press "confirm" button. Setting cutting size of the other program set is same as the above ways.

Notice: the actual max cutting size : 670mm, and actual min cutting size is : 30mm.

5. Cancel button

When press this button, you can cancel the current numbers or cancel some warning function made by machine and keep its former condition.

Main control panel's buttons



1. Breaker

Switch it to "ON", the machine get through the electricity .(the machine is on)
switch it to "OFF", the machine is off the power .

2. Power indicating light

When the power indicating light lights , which means the machine is on, and be ready for working .

3. Reset indicating light

When press the "RESET" button, the reset indicating light lights, which means the blade and press paper block is reset: (when the blade and press paper block is not in the highest position, press the "RESET" button to make them in the highest position.

4. Cut indicating light

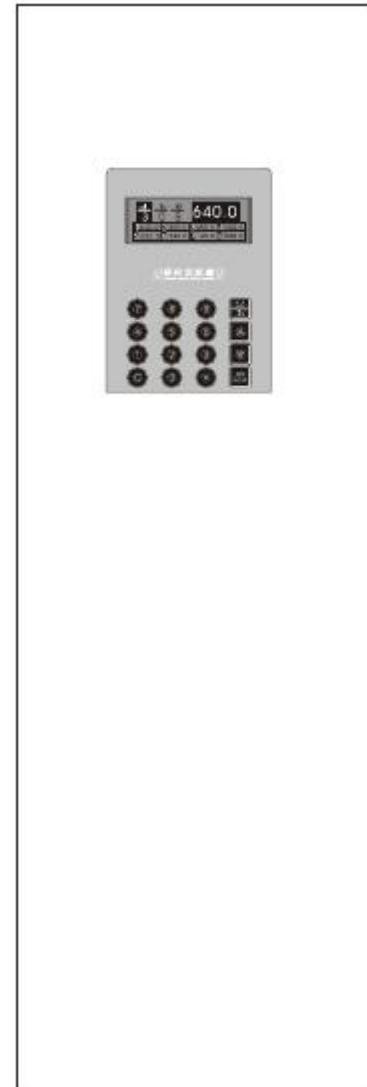
When press the "CUT" button with two hands at the same time ,the cut indicating light lights ,which means the machine is cutting ,and when the indicating lights off, which means the machine stops the cutting .

5. Press paper indicating lights (only for type B, type V)

Press "PRESS" with two hands at the same time ,the indicating light lights ,which means the press paper block is beginning to work, when the indicating lights off, machine will stop press the paper.

6. Push indicating light (only for type V)

Each time press the "PUSH" button ,the indicating light lights ,and at the same time the push paper gauge will push the paper one time automatically and when the push paper gauge stops, the indicating light is off, press the "PUSH" button for three seconds ,the indicating light lights, which means the machine is under the automatically push paper condition. (That is each time after finishing the cutting ,the machine will push the paper forward automatically).



3 .If the machine is under the automatic push paper condition, the push indicating light will light, press "PUSH" to stop this push paper function, and the push light will off. Under the program control condition you need not use the automatic push paper function.

4 .After setting the pressure, press the "CUT" button with two hands at the same time, the clamp light will light and the clamp paper block will press the paper until it press the cutting materials tight enough and then you stop pressing the button.

If no need the press paper block to press the paper, you can press "PRESS" with two hands at the same time, then the cut light will light, the press paper block and the blade will respectively press and cut the paper.

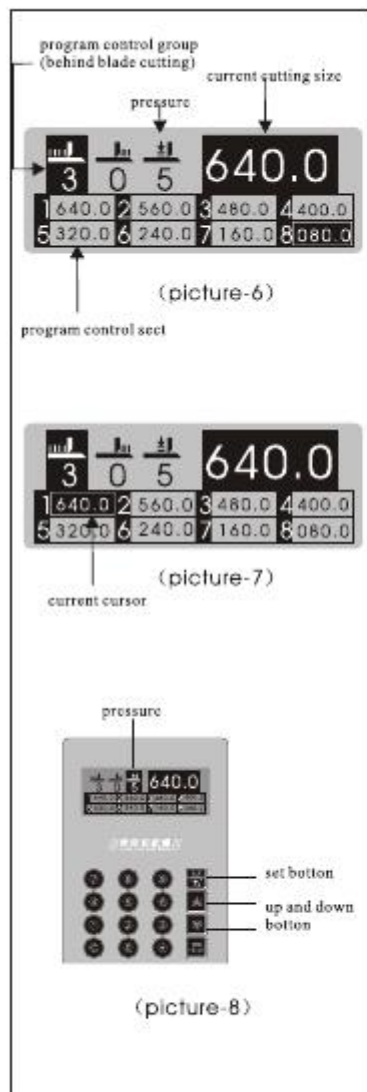
5 .After pressing, you can begin to cut, press "CUT" with two hands at the same time, the cut light will light and the blade is cutting until it finishing the cutting, and then you stop pressing the "CUT" button, at the same time the blade and the clamp paper block will come back to the highest position, and one program sect cutting finished.

6 .The pusher will push forward the first sect cutting material, and move to the second sect cutting size to be ready for the cutting, press "RESET" button, the reset light will light, Press the "PRESS" with two hands at the same time and the blade is cutting, then the second sect cutting finished, pusher will move to the third sect cutting size to be ready for the cutting. Then the machine will cycle the cutting.

7 .If you cut the same specification material, you just need press "RESET" button after each cutting, the reset light will light, and then press "CUT" with two hands at the same time, then the machine will begin to cut again, after each sect cutting, the machine will move to following sect to begin the cycle cutting.

III. Cutting operation (in front of the blade cutting)

There are manual and program control cutting in this operation. Press "set" button to shift to front blade cutting condition, the digital window displays the condition, if displays "0", which means the manual operation, if displays "1-6", which means program control operation, press "1" or "6" to choose the manual or program control condition.



After entering the program control sect, you can press the number button to set the first sect cutting size or modify it, press number button to input 6, 4, 0, and then press "▼" button to enter into the second sect to set the cutting size, press the number button to input 5, 6, 0, and then press "▼" to enter into the third sect to set the cutting size, press number button to input 4, 8, 0, and then press "▼" to enter the forth sect to set the cutting size, press number button to input 4, 0, 0 and then press "▼" to enter into the fifth sect to set the cutting size, press the number button to input 3, 2, 0, and then press "▼" button to enter into the sixth sect to set the cutting size and press the number button to input 2, 4, 0 and then press "▼" to enter into the seventh set to set the cutting size and press number button to input 1, 6, 0 and then press the "▼" to enter into the eighth sect to set the cutting size, press the number button to input 8, 0 (as showed in picture-6), after finishing inputting the cutting size, move the cursor to the first sect (640.0) (as showed in picture-7), press "■" for a long time, and then it gives out "di di" twice, which means it has exit the set, the pusher will move to the selected program control sect and stop automatically, then you can begin the cutting.

If you want to choose one of the settled cutting size in the program control sect to modify or set it, first you should press "set" button to shift to the present program control group and then press "▲" or "▼" to enter into set condition, then press "▲" or "▼" to move the cursor to the selected program control sect and press the number button to modify or set. After setting, press "■" for a long time and it will give out "di di" sound twice, which means it has exit the set and the pusher will move to the selected cutting size in the program control sect automatically, the machine then can work from the program control you selected. After finishing each program control sect, the machine will work from the following sect automatically.

Notice: the manual adjustable wheel will not work under program control condition

- After setting the cutting size, put the cutting material in order, press "☀" button, the reset light will light, and the blade and clamp paper block will come to the highest position.



7. Reset button

Each time begins the cutting, you should press this button, when one circular cutting finished, press this button, you can begin to cut again. another is that when you press this button, the blade and press paper block will come to the highest position.

8. Push button(only for type V)

Press "☀" button, the push paper gauge will push the paper forward one time, after finishing the pushing, the push paper gauge will move back to the former position, for the following push, just need to press "☀". If press the "☀" for three seconds, the "☀" indicating light lights, which means the machine is under automatically pushing paper condition. That is each time after finishing the cutting the push paper gauge push paper automatically and will move back to the former position, and be ready for the next push, no need to press the "☀".

9. Fast forward/backward key of Pusher(Only type H)

Adjust the pusher move forward and back:
Fast forward/backward key turn clockwise: the pusher move ahead quickly.
Fast forward/backward key turn Widdershins: the pusher move back quickly.

10. Press button(only for type B、type V)

After setting the pressure, press "☀" button, the reset indicating light lights, press this button with two hands at the same time to press the paper. stop pressing one of the "☀" button, the machine will stop pressing the paper.

11. Cut button

After setting the cutting size, press "☀" button, the reset indicating light lights, press "☀" button with two hands at the same time to begin the cutting, stop pressing one of the "☀", the machine will stop cutting.

Type A



12. Hand-wheel of paper clamp (only for type A)

This hand-wheel is to adjust the paper clamp to clamp paper and reset.

When adjusting the hand wheel in clockwise direction, the paper clamp will press the paper, when adjusting the hand wheel in anti-clockwise direction; the paper clamp will rise up to reset.

Type A, Type B



13. hand-wheel of pusher (only for type A, type B)

This hand-wheel is to adjust the pusher move forward or backward, each time rotates the wheel, and the size on the digital window will also change.

When adjusting the hand-wheel in clockwise direction, the pusher will move forward.

When adjusting the hand-wheel in anti-clockwise direction, the pusher will move backward.

Having adjusted the pusher, you can firm the screw and put the handle of the hand-wheel in the hand-wheel.



(picture-5)



3. Press "set" button to shift to the press paper pressure condition, you can set the pressure according to the cutting thickness.

E.g.: press "set" button to shift to press paper pressure condition, when the digital window displays pressure, then press "▲" , "▼" to set the pressure, then press "■" to confirm. (As showed in picture-5).

4. Press "■" for three seconds, if the push indicating light lights, which means the machine is in auto-push paper condition.

5. After setting the pressure, two hands press "■" at the same time, clamp paper light will light and the press paper block will press the paper until it press the cutting material tight enough and then you stop pressing the button.

If no need the press paper block to press the paper, you can press "■" with two hands at the same time, then the cut light will light, the press paper block and the blade will respectively press and cut the paper.

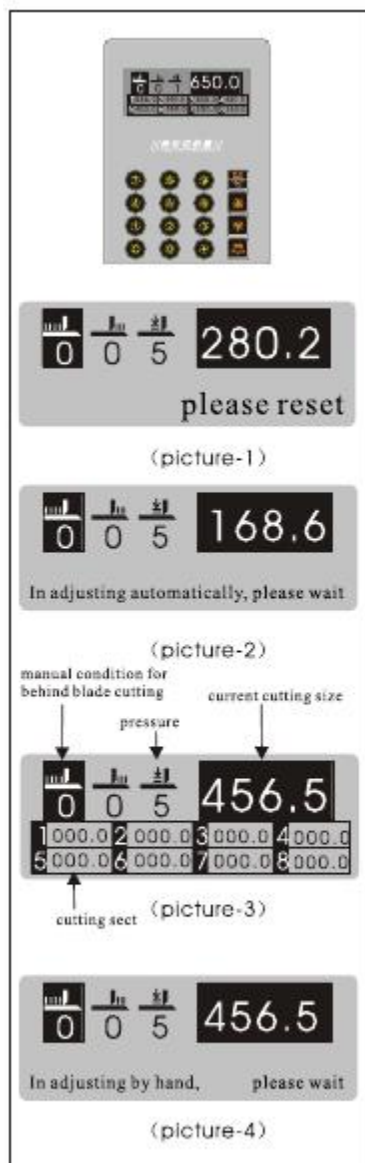
6. After finishing pressing the paper, you can press, "■" button to begin the cutting. Press the "■" with two hands at the same time, the cut light will light and the blade will cut until it finishes the cutting, and then stop pressing the "■" button, and at the same time the blade and the press paper block will come to the highest position, the pusher will push out the cutting material and come back to its former place automatically, then one cycle cutting finished.

7. After finishing the cutting, if still cut the same size, you only need press "■" button, the reset light will light, and then with two hands pressing the "■" button then you can begin the cutting again.

Program control operation (behind blade cutting)

1. Press "set" button to shift to program control condition, according to the cutting requirements, you can choose the program control group on the digital displaying screen, the program has 1-9 groups, each group has 8 sect cutting size. After choosing the control group, you can press the button to input the cutting size.

E.g: if the cutting size is 720mm width, to cut 80mm width each sect, and need to choose the third group, then you press "set" button to shift to behind blade cutting condition, then press "▲" to "3", and then press the "■" button to confirm to enter into the first program sect in the third program group.



Type V operating steps

I. Start the machine

1. Insert the power source plug.
2. Switch the breaker to "ON", the power indicating light lights on the main control panel, and the digital window displays that it normally works.
3. The digital window displays "please reset" (As showed in picture-1). Then u press " " button at this time, the blade and paper clamp block will come to the highest position and prepare for the cutting.
4. The machine is in ready condition and the pusher automatically moves to the last cutting size. (As showed in picture-2)
5. Put the cutting material inside the flat and make them abut upon the left gauge to make them in order for cutting.

II. Behind blade cutting

There are manual and program control cutting in this operation. Press "set" button to shift to behind blade cutting condition, the digital window screen displays the current condition, if displays " ", which means the manual operation, if displays " ", which means program control operation, press " " or " " to choose the manual or program control condition.

Manual operation (behind blade cutting)

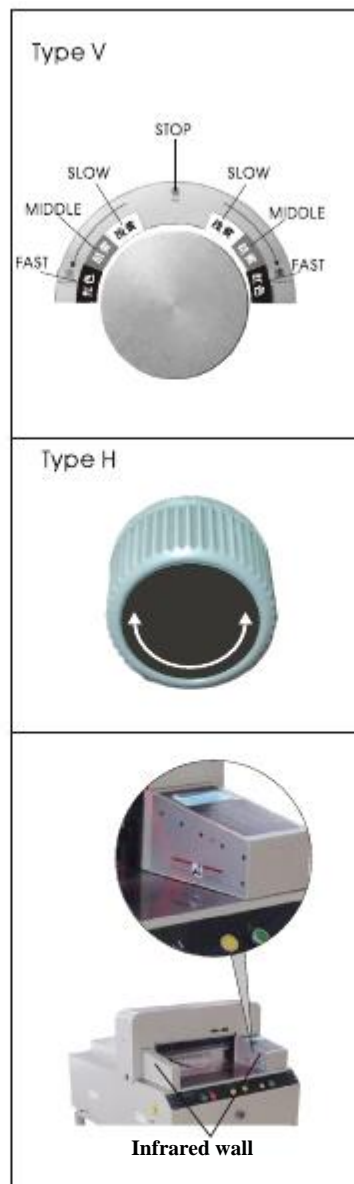
1. Press "set" button to shift to manual condition, you can directly input the cutting size on the digital window according to the cutting requirements.

E.g: if you want to cut 456.5mm length behind the blade, press "set" button to " ", and then ordinal press "4" "5" "6" "5", and then press " " to confirm, and the pusher will move to 456.5mm automatically, and then ready for the cutting (as showed in picture-3).

You can also adjust the pusher to adjust the cutting size, you can rotate the adjustable wheel to 456.5mm, when the digital window displays "456.5" you can stop the adjustment. (As showed in picture-4).

Notice: the adjustable wheel will not work under program control condition.

2. After finishing the cutting size's position, and put the cutting material in order, press " " , the reset light will light ,the blade and press paper block will come to the highest position to be ready for cutting.



14. Adjustable wheel of push paper gauge (only for type V)

This wheel has the function of moving forward or backward to adjust speed of the push paper gauge (slow ,middle speed, fast speed). Yellow ,orange, red respectively stands for slow speed ,middle speed, high speed, when the electric wheel stops at the place of gray color, the push paper gauge also stops .when rotating the wheel to yellow in clockwise way, then the push paper gauge will move forward slowly ,rotating to the orange , the push paper gauge will move forward in middle speed ,rotating to the red ,the push paper gauge will move forward fast. If rotating the wheel in anti-clockwise way ,the push paper will move backward ,and the speed is in relationship with the color.

Notice: the manual adjustable wheel will not work under program control condition

15. Fine adjustment of pusher Handwheel (only for type H)

Handle fine adjust the wheel to move ahead or back. Clockwise turn: the pusher move ahead at 0.2mm speed. Digital window show: 0.2mm
Widdershins turn: the pusher move back at 0.2mm speed. Digital window show: 0.2mm

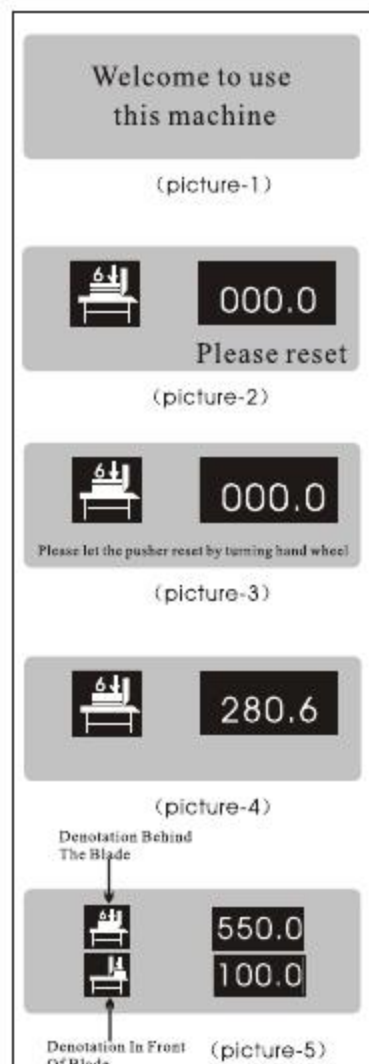
16. Infrared wall

Infrared wall is made up of two group infrared that locating the front of cutter. Its main function is to protect the operator when he put the cutting things to avoid the machine s suddenly start. At this time the machine start button will not work if the infrared wall induces any things.and gives out "di di..." warning sound.

Note: The infrared wall just can induce the things that above 65mm to operation panel. Please use the wood-board when you want clean up the paper.

Chapter two. Operation and adjustment

Please review the relevant content mentioned in the previous part before your operation, and then operate the machine according to this chapter.



Type A operation

Start the machine

1. Insert the power plug.
2. Switch the breaker to "ON" the power displaying light lights on the main control board, and the digital window displays the current condition, which means the machine works normally. (As showed in picture-1)
3. The digital window displays "Please reset" (As showed in picture-2). Then u press *reset* button at this time, the blade will come to the highest position and prepare for the cutting.
4. The digital window displays "Please let the pusher reset by turning hand wheel" (As showed in picture-3), then you rotate the pusher in anti-clockwise direction until it comes to the end , the digital window will display current cutting size , and the machine is in the ready condition.
5. Put the cutting material inside the flat and make them about upon the left gauge to make them in order for cutting.
6. Rotate the hand-wheel of the pusher until it arrives the cutting size you required and then firm the screws on the hand-wheel.
E.g : if cutting size is 280.6mm, you just rotate the hand-wheel until it comes to 280.6mm , the digital window will also display 280.6mm, and then stop rotating. (As showed in picture-4)
Notice: The adjust precision is 0.2mm.

Hint

When the pusher moves backward, you can move it a little further than the size u need, and then move it forward to the required size, as by this way, the size is more precise. If the pusher moves forward, you no need to adjust it as the above-mentioned way; you just adjust to the size u need directly.

Notice: After finishing the cutting, if rotates the hand-wheel forward, then there will be two numbers (as showed in picture-5) .the above number is the pusher's current position and the number below is the size the pusher moved relative to the former size. If the pusher moves backward, the size in front of

7, Having put the material and adjusted the size, press " ", then the indicator of RESET light, blade and press-block reset highest point.

8, Follow above, press the " " keys with two hands at the same time, the indicator of CUT light and the blade will cut till it finishes the cutting, and then stops pressing the " ", the blade will come back to the highest point, rotate the *Fast forward/backward key* to push out the cutting material or take out them directly.

9, If it is the same spec material you just press " " key after finishing one time, when the indicator of RESET light and press the " " keys with two hands at the same time, then you can repeat again.

Welcome to use
this machine

(picture-1)



000.0

please reset

(picture-2)



000.0

please let the pusher reset by turning hand wheel

(picture-3)



297.0

(picture-4)

Denotation Behind
The Blade



400.0
100.0

Denotation In Front
Of Blade

(picture-5)

Type H operation

- 1, Inset the power plug.
- 2, Switch the Breaker to "ON", the power indicator lights on the main control board, and the digital window show the current condition, which means the machine works normally.
- 3, Follow that, the digital window show "Please Reset" (as picture 2), then press **RESET** key at this time, the presser and blade will come to the highest point and prepare for the cutting.
- 4, The digital window shows "Please let the pusher reset by turning Handwheel" (as picture 3), then you rotate "**⌚**" **Fast forward/backward key** to "**⌚**" in anti-clockwise direction, then the pusher will comes to the end automatically and stop the "**⌚**", the digital window will display the current value, and the machine is in ready condition.
- 5, Put the cutting material inside the flat and make them abut upon the left gauge to make them in order for cutting.
- 6, Rotate the "**⌚**" **Fast forward/backward key** until it arrives the cutting size that you required. If the pusher move over you set size you can adjust it by rotate the Handwheel.
For example: If cutting size is 297.00mm, you just rotate the **Fast forward/backward key** to 297.00mm, the digital window will also show 297.00mm and then stop rotating (as Picture 4)
Note: the adjust precision is 0.2mm.

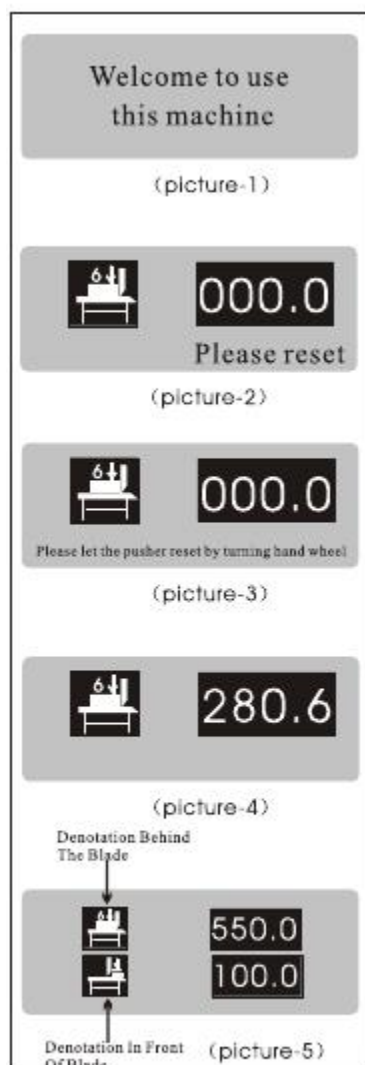
Hint:

When the pusher moves backward, you can move it a little further than the size you require, and then move it forward to required size, as by this way, the size is more precise. If the pusher moves forward, you no need to adjust it as the above-mentioned way; you just adjust to the size you need directly.

Notice:

After finishing the cutting, if rotates the Handwheel forward, then there will be two numbers (as picture 5) the above number is the pusher's current value and the number below is the size the pusher moved relative to the former size. If the pusher moves backward, the size in front of blade is zero.

7. Having put the material and adjusted the side, you can rotate the hand-wheel of paper clamp in clockwise direction until it presses the paper firmly.
8. Having finished pressing the paper, then u press "**⌚**" button and its light will light, the blade will come to the highest position.
9. Press the "**⌚**" with two hands at the same time, the cut light will light and the blade will cut until it finishes the cutting, and then stops pressing the "**⌚**" button, the blade will come back to the highest position at the same time, rotate the hand-wheel of paper clamp let it come back to the highest position and then rotate the hand-wheel of the pusher to push out the cutting material or take out them directly.
10. After finishing the cutting, if still cut the same size, you can begin the cutting again according to the 7-9 steps mentioned-above.



Type B operation

1. Insert the power plug
2. Switch the breaker to "ON", the power displaying light lights on the main control board, and the digital window displays the current condition, which means the machine works normally. (As showed in picture-1).
3. The digital window displays "Please reset" (As showed in picture-2). Then u press *reset* button at this time, the blade will come to the highest position and prepare for the cutting.
4. The digital window displays "Please let the pusher reset by turning hand wheel" (As showed in picture-3), then you rotate the pusher in anti-clockwise direction until it comes to the end, the digital window will display current cutting size, and the machine is in the ready condition.
5. Put the cutting material inside the flat and make them abut upon the left gauge to make them in order for cutting.
6. Rotate the hand-wheel of the pusher until it arrives the cutting size you required and then firm the screws on the hand-wheel.

E.g : if cutting size is 280.6mm, you just rotate the hand-wheel until it comes to 280.6mm, the digital window will also display 280.6mm, and then stop rotating. (As showed in picture-4).

Notice: The adjust precision is 0.2mm.

Hint

When the pusher moves backward, you can move it a little further than the size u need, and then move it forward to the required size, as by this way, the size is more precise. If the pusher moves forward, you no need to adjust it as the above-mentioned way; you just adjust to the size u need directly.

Notice: After finishing the cutting, if rotates the hand-wheel forward, then there will be two numbers (as showed in picture-5). the above number is the pusher's current position and the number below is the size the pusher moved relative to the former size. If the pusher moves backward, the size in front of the blade is Zero.

7. set the pressure according to the thickness of the cutting material, the ways are as follows:

Press " " co-using button and then press *reset* button, the pressure will increase one level, then each time when u press " ", the pressure will cycle between 1-9.

" " Stands for the min pressure.

" " Stands for the max pressure.

8. After positioned the size and put the material in order, then you can press " ", and its indicating light will light, the blade and clamp paper block will rise to the highest position.

9. Press " " button with two hands at the same time, the clamp indicating light will light and the clamp will press the paper until it press the paper tight and then u can stop pressing the button; if there is no need the clamp paper block to press the paper, you can press " " with two hands at the same time, then the cut light will light, the clamp paper block and the blade will respectively press and cut the paper.

10. After pressing the paper, you can begin the cut, Press the " " with two hands at the same time, the cut light will light and the blade will cut until it finishes the cutting, and then stops pressing the " " button, the blade and clamp paper block will come back to the highest position at the same time, and then rotate the hand-wheel of the pusher to push out the cutting material or take out them directly.

11. After finishing the cutting, if still cut the same size, you just need to press " " button and its indicating light will light, with two hands press " " at the same time, then you can begin the cutting again.