

## User file

Name \_\_\_\_\_ Tel \_\_\_\_\_

Address \_\_\_\_\_

Company \_\_\_\_\_

P.C \_\_\_\_\_ Date \_\_\_\_\_

Distributor \_\_\_\_\_

Model \_\_\_\_\_ Serial No \_\_\_\_\_

## Foreword

Thank you for choosing this kind of Hydraulic Paper Cutting Machine series which are produced by our company. We will provide the best quality of this machine and the best after-sale service. The Hydraulic Paper Cutting Machine series is designed and developed according to the experience from domestic and abroad. It integrates mechanical, electric and hydraulic system. The structure is precise and artistic. It is high pressure, accurate, safety with little noise in the process of operating. It owns all the merits of hydraulic system, which is widely applied in the middle-small printing offices and so on.. It is the ideal cutting equipment for offices.



**Warning: this kind machine is allowed to cut printed paper, books and soft leathers only. It is forbidden to cut any metal sheets or other hard objects that do harm to the machine.**



**Forbid children to operate the machine**



**Keep hand from underneath the blade**



**Do not extract or transport the blade without protection**



**Do not cut hand or splintery materials**



**Must use socket with ground wire connected.**

**Note: Please read this manual carefully first in order to realize and use this kind machine. It will help you improve the work efficiency, bring into play the function of the machine, prolong the service life of the machine.**

## Safety Cautions

According to relevant standards, to avoid accident and accidental injury, only professional operators are allowed to use this machine (children or non-professional operators are forbidden to operate). When you use or maintain these machines, please pay high attention to safety cautions below:



### Riding position

The weight of this kind machine is about 380-500kgs. Please put it in balance in a clean place.



### Power

Please connect with the power source correctly in accordance with the specification. The power source should be steady AC220V(110V) $\pm$ 10%/50Hz(60Hz)/1.7~4KW, and the machine will run irregularly if the voltage is too high or too low. We suggest you use alternating current (AC) power source with steady voltage to improve your working efficiency.



### Ground connection

For safety, you should use electric supply socket with ground wire connected.



### Overloading with appliance

Please don't connect too many electrical products on the electric supply socket, because overloading may cause a fire or an electric shock.



### Maintenance

Before you clean or maintain the machines, you must cut the electric source and pull out the electric supply socket.



### Keep dry

Prevent water or other liquid flow into inner machine.

3. Maintenance should be undertaken by the local sales agency.

4. We won't undertake the maintenance and accessories diversion fees caused by conditions below:

- ① Damage caused by accident, wrong operation or intent disassembling.
- ② Repaired by stations not authorized by our company, or use dependable materials and accessories not required by our company.
- ③ The customer doesn't register in the maintenance station within one month after he buys the machine.
- ④ The machine is damaged because of oil lack, oil in or water inflow.

## VI、 Repair warranty

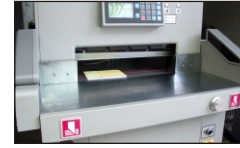
1. The guarantee period of paper-cutting machine is one year. You should register in maintenance station within one month after you buy the machine, in order to establish maintenance file.

2. Maintenance service scope:

- ① Free installation adjustment operation training periodic maintenance, elimination of error in normal operation, and repair.
- ② Freely change parts damaged in normal operation; maintain motor and circuit for one year; knife shim and blade belong to expendable supplies, so they are excluded from the maintenance scope.



**Children or non-professional person must not operate this machine.**  
**Do not reach beneath the blade.**  
**Do not reach cut.**  
**Do not cut hard material or materials which may splinter.**



**Must use socket with ground wire connected.**



**Air safety switch, non-professional persons are not allowed to open. It is much dangerous.**



**Under normal usage, add right amount lubricating oil to transmission parts and screw mandrel to ensure the machine running properly.**

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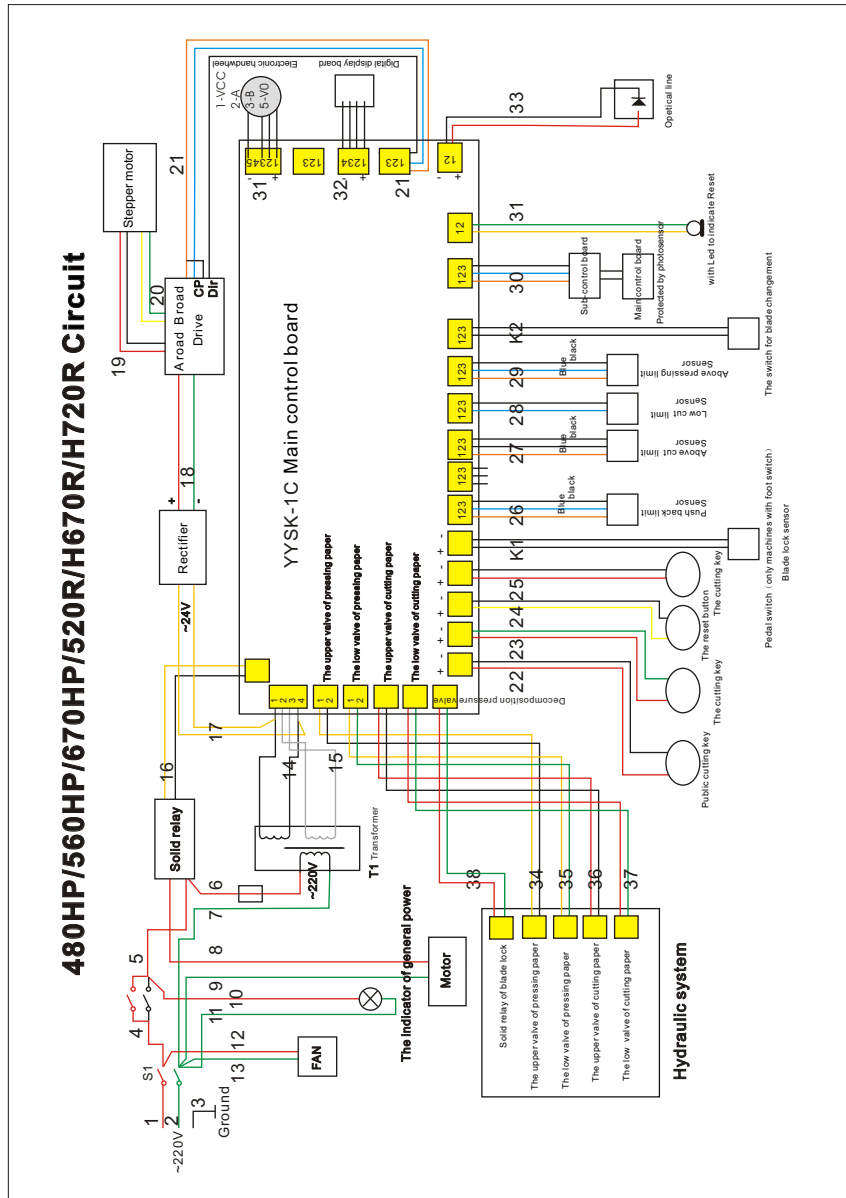
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## Chapter V Common error and elimination

Error	Phenomena	Solution
No power source display	Indicating light is off	1.Check the power source plug 2.Check main switch 3.The power source wire is bad
Capacitor of motor damage	Blade is goes up and down very slowly and powless	Replace capacitor
Paper cutting is not even or the cutting size is not accurate	The cut paper has one side wide and the other side narrow, or has big deviation on dimensions	Loosen tighten screw, and use a ruler to adjust the angle between measuring scale and paper-pushing plate
The knife can't reset or works up and down continuously	The button is invalid. The blade works up and down without stopping	1. The sensor is displaced or damaged. 2.Circuit main panel is damaged
The window can't display or display wrong or can't proofread	Power buttons are invalid	Check display board, main board of the electrical equipment, and circuit parts
Digital-controlled circuit damaged	Paper-pushing part can't work	1.Check stepping motor, driver 2. Check whether the circuit of main board is damaged.
Alarm for displaying 'E-1'	The button is invalid and cutting action stops	Check the flash Check the control panel
Alarm for displaying'E-2'	Cut normally, but blade can't return the original position.	Check limit sensor on the blade carrier Check the mainboard
Alarm for displaying'E-3'	Cut normally, cutting blade depth can not be adjusted	Check down limit sensor of blade carrier Check the mainboard
Alarm for displaying'E-4'	Press shelf return abnormal	Check limit sensor on the press shelf Check the mainboard
Alarm for displaying'E-6'	Cut normally, but paper pusher can't limit and adjust.	Check pressing motor code-wheel sensor Check the mainboard



## Chapter I Safety cautions before installation

### 1. Installation for HC/HP series

#### 1)、Open the box and check

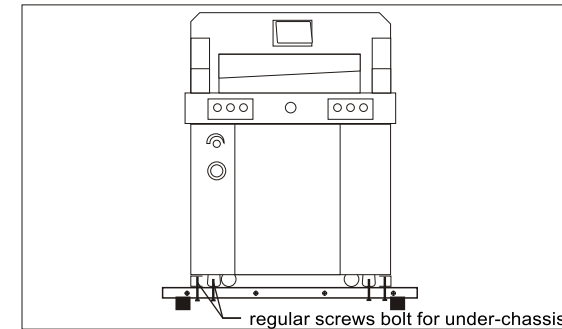
When you open the package of the machine, firstly you should check the machine and relevant accessories. Please contact the seller or our company if there is any damage or shortage.

● Main unit 1 set	● Hydraulic oil 1set	● Manual operation1 book
● Tools 1 set	● Certificate one piece	● Discharge blade rod 2 pieces
● Stick 1 piece	● Power wiring 1 piece	● Warranty receipt 1 piece

#### 2)、Settlement of the machine and debugging

##### 2-1 Settlement of the machine

- Open the wooden crate, take out the machine casing and discharge fixed screws on the base plate of the main machine; The hydraulic machine should be unloaded by fork.



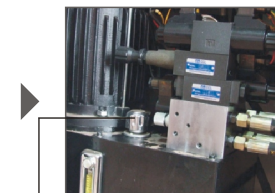
- Check the packing list is complete or not
- Check all the parts of machine and clean them.

##### 2-2、 Pour into hydraulic oil

In the process of transportation, we just pour into one third oil in the oil box. Pour oil into the machine before starting the machine. Do the operation as follows:



Open the front door



Take out the cover



Pour into hydraulic oil, covered and close the door

### 2-3、 Platform for putting books

The platform is installed backwards. You should unscrew the fasten screws and overturn this platform plate from 180° before using. Then fix the screws firmly. It's easy to install and not take more space from wooden case. It makes more convenient to put cut books or books waiting for cutting.



### 3)、 Environmental Conditions

- The machine should be placed in a clean working environment, keep away from direct sunlight and wind;
- Operating environmental temperature keep 10-30°C, cannot higher than 32°C;
- Humidity level of the operating environment keep 50-80%;
- Working power source of the machine: 220V(110V)±10%; 50Hz(60Hz); 2KW;
- Connect the ground wire correctly.

### 4)、 Special hints

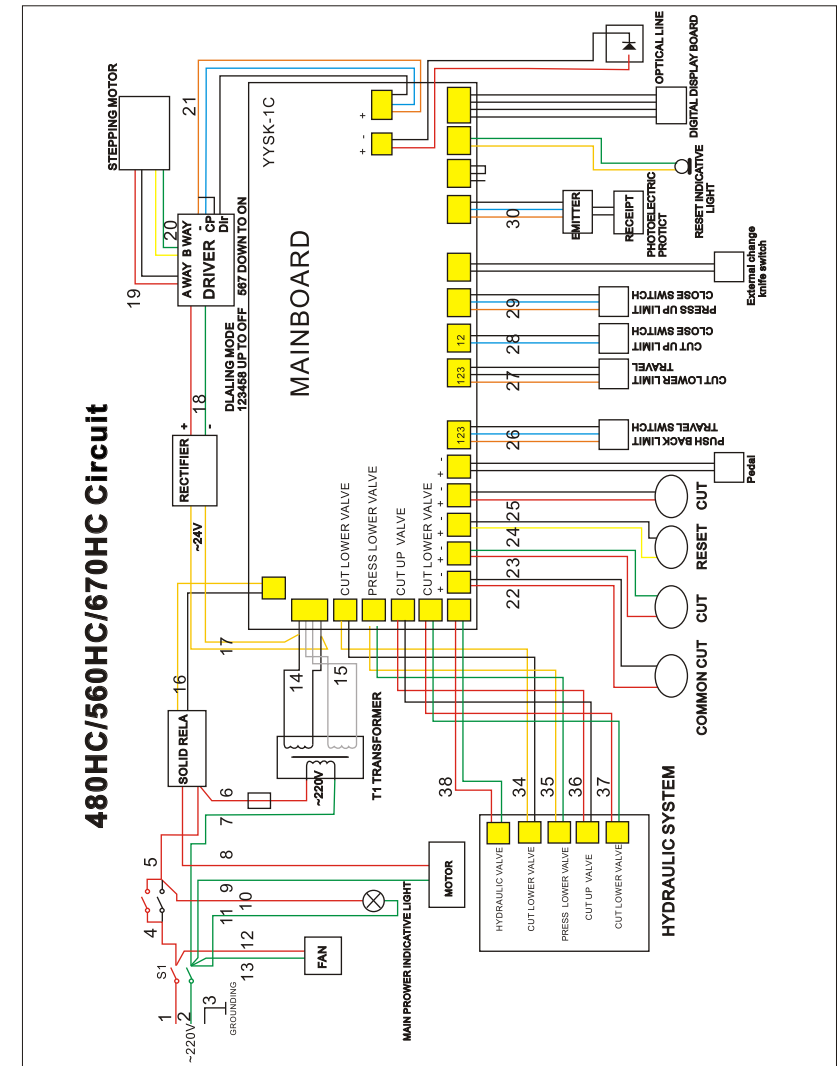
- ⚠ Remember only one professional operator is allowed to operate the machine;
- ⚠ When you cut , you should operate buttons by both your hands;
- ⚠ Please don't disassemble infrared safety covering;
- ⚠ When you put your hands or other things into the cutting area, you must cut the power firstly;
- ⚠ When you change blades, you should firmly abide the blade changing instruction;
- ⚠ You are not allowed to re-equip the construction and circuit of the machine by yourself.

## 2、 Maintenance

- 1) When the machine is working, other objects are forbidden to put on the machine. Because the blade cuts hard objects, it will be damaged. There should be no staple pin in the book, which will damage the blade when cutting.
- 2) After everyday work, you should wipe the machine, remove junk, wax the blade and cut the power.

## 3、 Attached figure

HC Series Hydraulic numerical-control paper guillotine wiring diagram

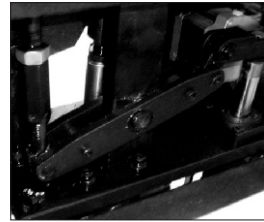
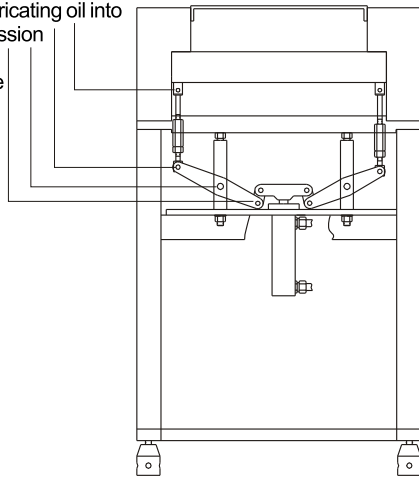


# Chapter IV Lubrication and maintenance

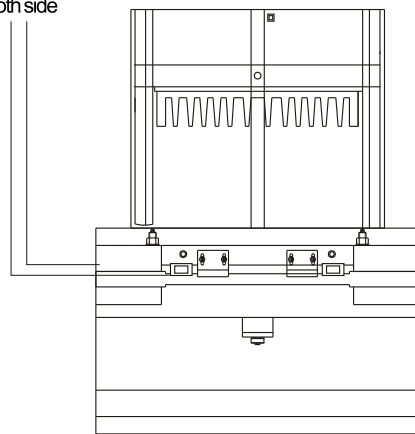
## 1、Lubrication

Every three months, you should open the brace plate of the machine, check and clean, tighten parts, and use lubricating oil to rolling parts. When you do lubrication, be careful to avoid lubricating oil dripping on the wires or electrical parts. The speed reduction box needs to be cleaned and lubricated once a year.

Add lubricating oil into transmission parts in both side



Add lubricating oil into transmission parts in both side



## 2. Installation for R series

### 1)、Open the box and check

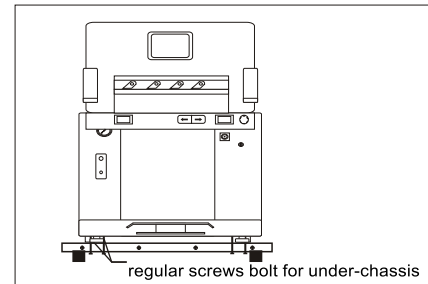
When you open the package of the machine, firstly you should check the machine and relevant accessories. Please contact the seller or our company if there is any damage or shortage.

● Main unit 1 set	● Hydraulic oil 1set	● Manual operation 1 book
● Tools 1 set	● Certificate one piece	● Stick 1 piece
● Maintenance warrant 1 piece		

### 2 )、Settlement of the machine and debugging

#### 2-1 Settlement of the machine

- Open the wooden crate, take out the machine casing and discharge fixed screws on the base plate of the main machine; The hydraulic machine should be unloaded by fork.



- Put the machine in a certain place:
1. No shaking
  2. Level ground, the ground mixes clay label must be more than 300# which is enough to load bear the 3. Keep the ground level to avoid any damage.
  3. Avoid being injured , as the land is unparallel
  4. Keep a certain distance with other equipments.
  5. Use the gradienter to adjust the operation level.

- Check the packing list is complete or not
- Check all the parts of machine and clean them.

#### 2-2、Install the paper pusher platform

The paper pusher platform adopts a folded structure in order to solve the problem that the machine is too big to enter the office and reduce the delivery cost. The paper pushing platform needs to be installed well before you settle the machine.



Fold platform



Lift up the paper pusher platform



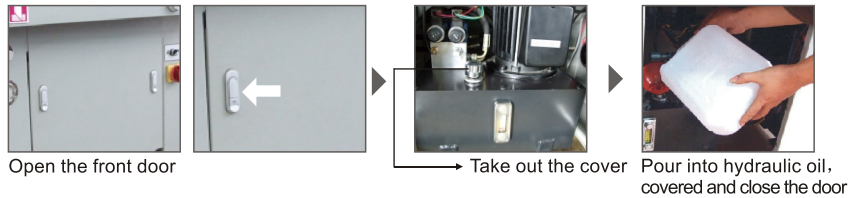
Fasten the screws and pillars



Keep the paper pusher platform and the work platform in a line

### 2-3、 Pour into hydraulic oil

In the process of transportation, we just pour into one third oil in the oil box. Pour oil into the machine before starting the machine. Do the operation as follows:



### 3)、 Environmental Conditions

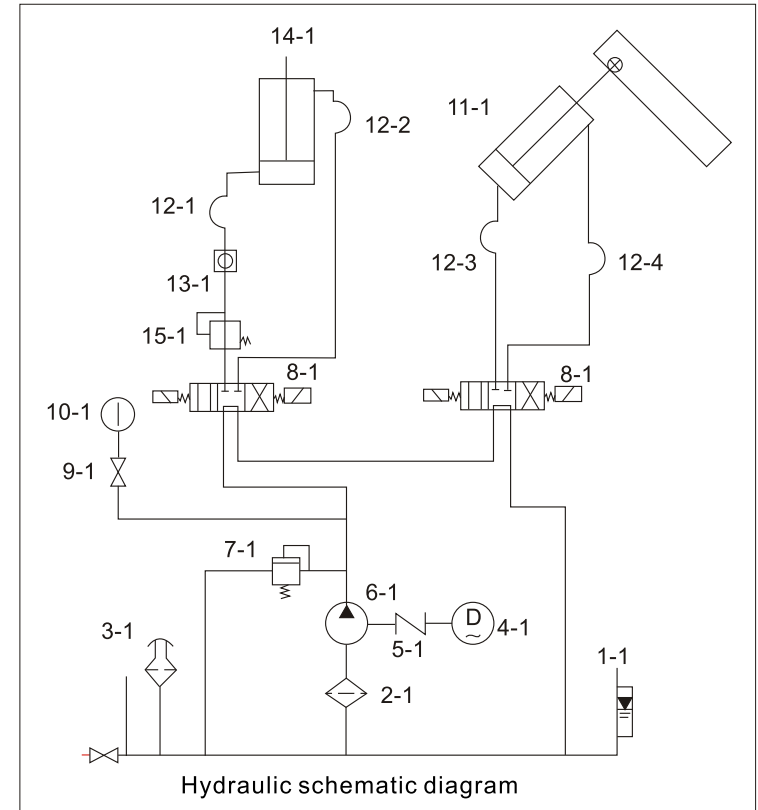
- The machine should be placed in a clean working environment and kept away from direct sunlight and wind;
- operating environmental temperature keep 10-30℃, cannot higher than 32℃;
- Humidity level of the operating environment keep 50-80%;
- Working power source of the machine: 220V±10%, 50Hz; 1.8~4.0KW
- Connect the ground wire correctly.

### 4)、 Special hints

- ⚠ Remember only one professional operator is allowed to operate the machine;
- ⚠ When you cut ,you should operate buttons by both your hands;
- ⚠ Please don't disassemble the circuit of safety protection;
- ⚠ When you put your hands or other things into the cutting area, you must cut off the power firstly;
- ⚠ When you replace blades, you should firmly abide the blade replacement instruction;
- ⚠ You are not allowed to re-assemble the construction and circuit of the machine by yourself.

### 2-12 Error / breakdown for hydraulic system

- 1、 The machine has big noise after machine starts
  - (a) oil is not sufficient, please refill 46# (at above 10 degree) or 32# (at 10 degree below) hydraulic oil
  - (b) Oil circuit filter is blocked, please clean the filter.
- 2、 Pressure is not sufficient
  - (1) Check if there is any leakage at each connection point of hydraulic control system.
  - (2) Electrical motor is abnormal, or the voltage does not comply with operation

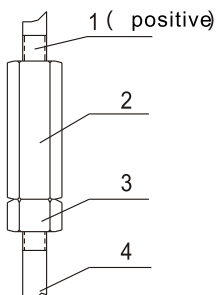




## 2-10 Adjustment of Parallel between Knife Edge and Operation Table

The parallel between knife edge and operation table should be adjusted with the eccentric axis on the machine frame back left side, see the photo.

When it is not parallel in use, make the adjustment of any paper presser pull rod in both side, loosen locking Screw 3 on the eccentric axis firstly, make screw 2 positive and negative movement. Lock screw 3 after fine adjustment.



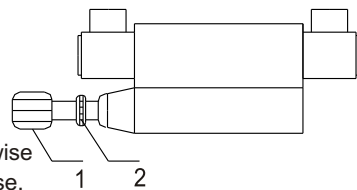
## 2-11 Paper Pressing Pressure Adjustment

Since different materials are cut, the pressing pressures shall be different. Therefore, adjustment shall be made according to photo 4.

1、 To adjust the paper pressing pressure, loosen the locking screw 2 firstly and adjust the pressure by turning adjustment handle

1. The pressure increases by rotating clockwise turning and decreases by rotating anticlockwise.

The ideal pressure is 4 Mpa. Then tighten the locking screw 2.



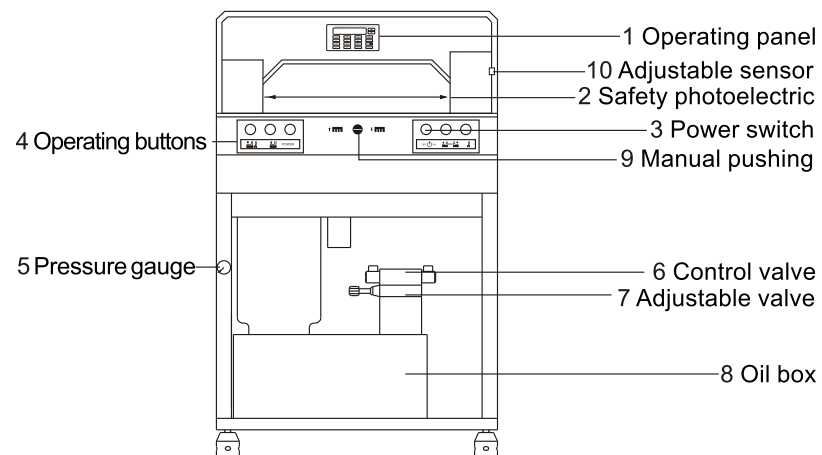
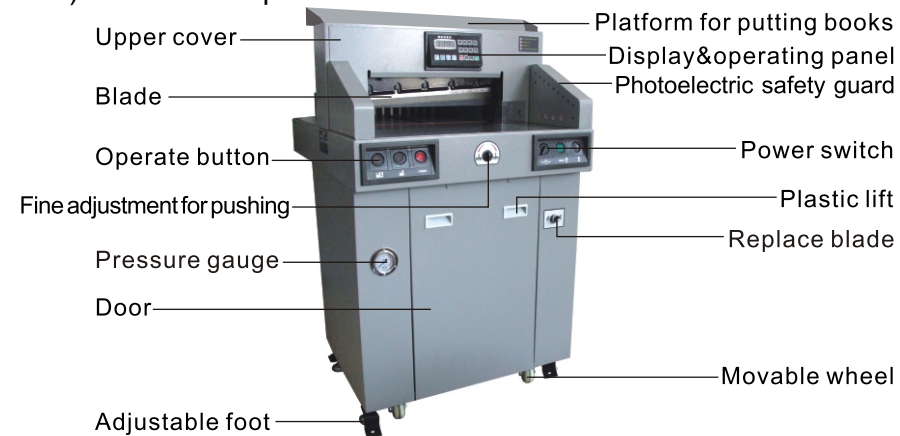
2、 No adjustment is generally needed for cutting pressure. If system pressure exceeds standard pressure, the machine is likely to be damaged. The knife shall be ground timely if paper can not be cut apart (standard pressure is 8 Mpa).

Note: The paper pressing pressure shall be minimized under the precondition that The cutting performance would not be influenced, which is beneficial the life and safety of machine.

## Chapter II Brief instruction of the paper cutting machine

### 1、 HC/HP Series paper cutter machine

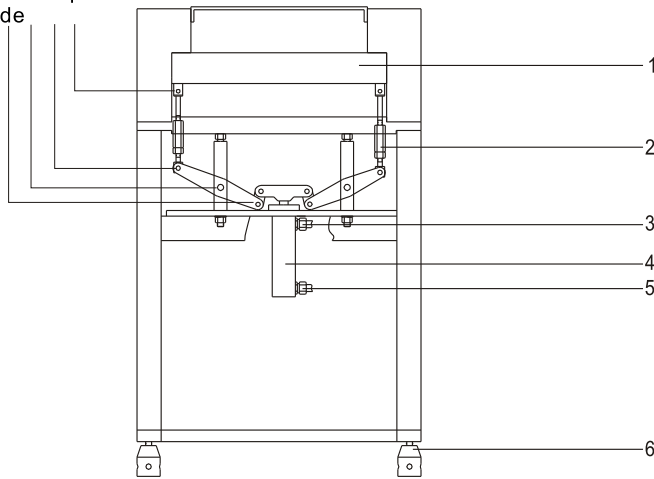
#### 1)、 Parts description



Hydraulic system & parts instruction

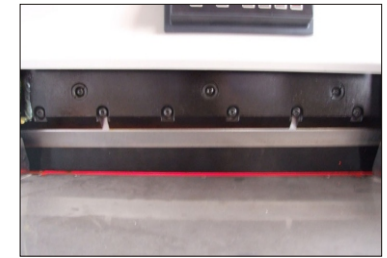
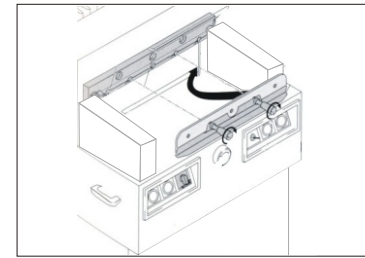
Number	Name	Specifications
1	Operating panel	Set, amend cutting size
2	Safety photoelectric	Safety protection
3	Power switch	power switch
4	Operating buttons	Cutting operation
5	Pressure gauge	Display hydraulic pressure
6	Control valve	Control hydraulic system
7	Adjustable valve	adjust pressing pressure
8	Oil box	Store the hydraulic oil
9	Manual pushing	Manual pushing switch
10	Adjustable sensor	Blade carrier down limit adjustable sensor, adjust depth of blade

Add lubricating oil into transmission parts in both side



Pressing structure

Number	Name	Specifications
1	Paper presser	For pressing paper before cutting
2	Adjustable screw rod	Keep pressingsystem and working area parallel
3	Reset oil intake	Pressure oil is filled in from this inlet when pressing paper
4	Pressing hydrocylinder	Produce reciprocating motion by means of hydraulic
5	Pressing oil intake	Pressure oil is filled in from this inlet when pressing paper
6	Adjust able foot	Adjust the balance for the machine



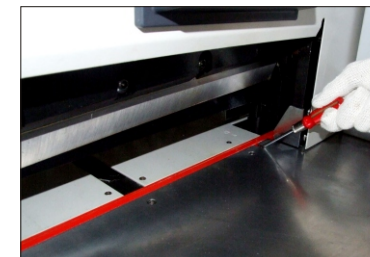
◆ Blade sharpening needs to be done in a professional factory to ensure the quality.

※ Note: Dull blade can't cut paper correctly. Blade also will become dull if it always cuts thick paper or pasteboard. If cutting quality and accuracy can't meet required standard, the blade needs to be changed. Your work will go smoothly if you always have one replacement standly. When you need to change blade, you must operate according to the steps of blade change instruction.

※ Note: To avoid any injury, you must be the more careful when you change the blade.

## 2-9 Cutting stick adjustment

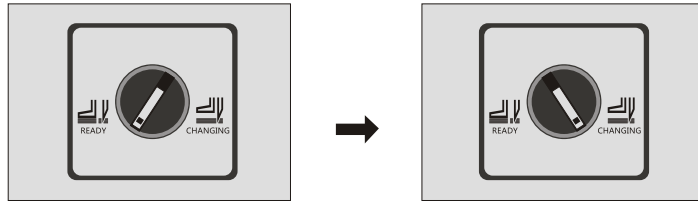
- ◆ One knife shim can be used for 8 times;
- ◆ When slash on the shim is too deep, you should adjust or change knife strip;
- ◆ Knife shim can be took out by screw which should be assembled onto the cutting desk flatly when it needs to be set back; Knife shim should lean to the left side ;



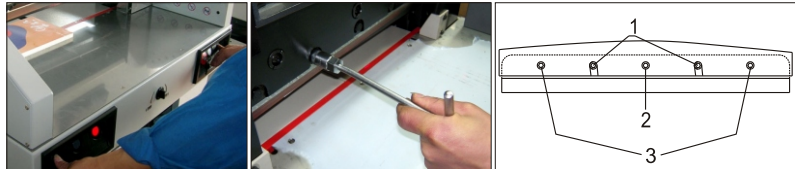
※ Note: When knife shim is being changed, the blade itself also needs to be adjusted. If the blade cuts too deep, the knife shim will be damaged easily, and the blade also will abrade rapidly.

## 2-8 Blade replacement (Be careful to operate)

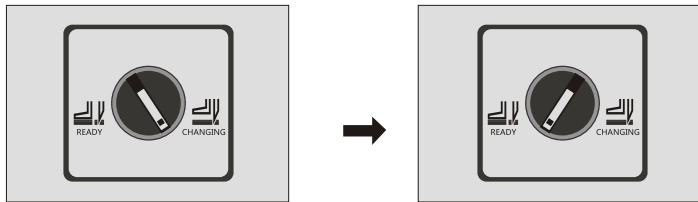
- ◆ Rotate the switch to change blade state, show as photo:



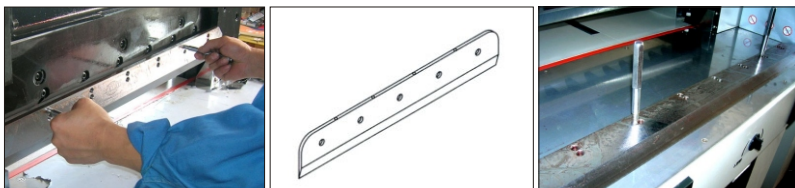
- ◆ Press the cut buttons and cut by both your hands.
- ◆ Loosen the screws 1 on the blade carrier.



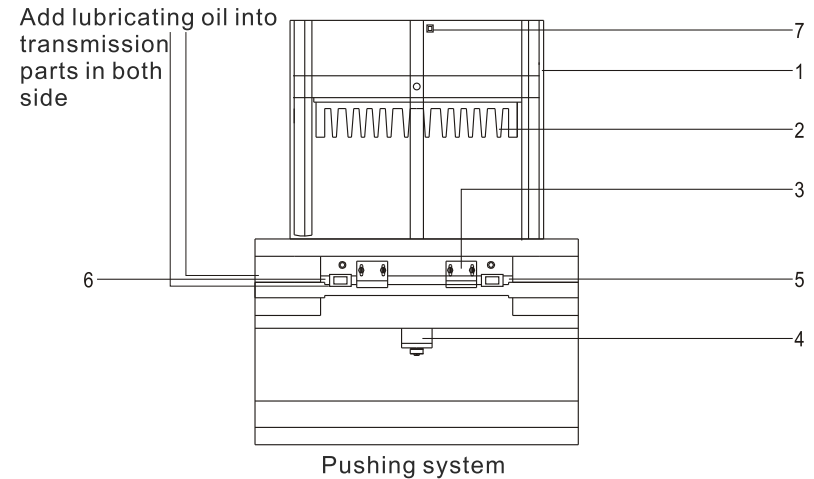
- ◆ Take off others screws on the blade carrier except the screw 2
- ◆ Change the blade change switch to normal state and install the blade. Then fasten the screws 1 clockwise. And take off other screws and screw 2, pay attention to the blade in case of sliding.



- ◆ Take off the blade with the gloves after you loosen the screws and wrap the blade with cotton cloth and put into the case in order not to be hurt.



- ◆ Take out a new blade (be careful to the blade). When you install the blade, you should screw up the screw stems, and set the blade on the blade carrier, and fasten according to the cutting depth adjustment method.



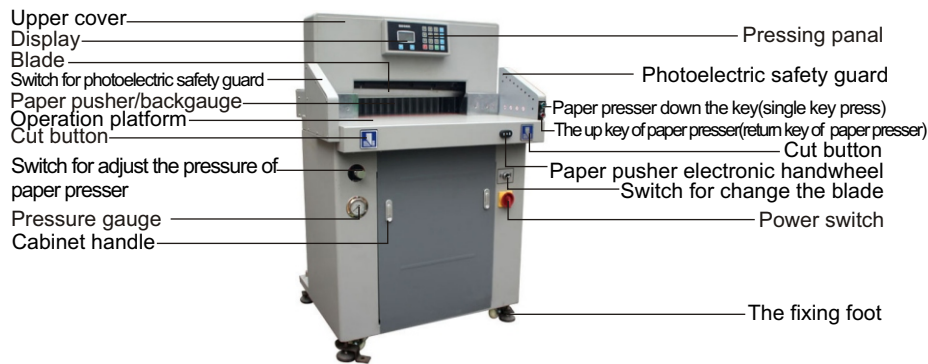
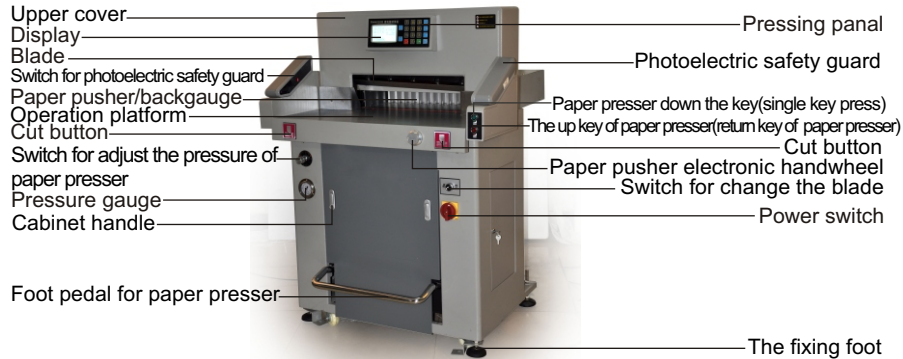
Number	Name	Specifications
1	Double guide rail	Pushing guide
2	Paperpusher (Backgauge)	Pushing paper
3	Optical line	Indicate the cutting position
4	Stepping motor	Drive paper pusher
5	Limit sensor	Pressing up limit sensor
6	Limit sensor	Blade carrier up limit sensor
7	Adjust sensor	Paper pusher limit adjust sensor

## 2)、Performance features

- Double-hydraulic motive power system design, imported main motor with strong power, imported hydraulic valve parts to ensure the quality
- Inclined blade cutting patented, easy to cut thick paper.
- Oscillating oil cylinder patented technology to make power balanced and working stable.
- Gap of cutter saddle can be adjustable, improving cutting precision  $\pm 0.2\text{mm}$  to make machine work in a long service time.
- Double guide rod pushing design to ensure pushing precision
- Outer fine adjustment of cutter depth design, outer adjustment, easy and convenient (only for HC series)
- Balance adjustment design for machine, easy to move and convenient to adjust the balance of machine
- Fashionable appearance design with patented, easy design, exquisite workmanship, detachable design, being applied to graphic printing office (only for program-control 560HP and 670HP)
- Human design platform for putting books, easy to put and take books on the platform of machine, save space
- Two row hole for blade to increase the times of using and reduce the cost
- Intelligent program-control, LCD display, optimization and updating program, pressing time, cutting time and calibrating spot of pushing size can be set at will. Self-check function, malfunction code display function, count function, 99 programs can be set for program series, each program 7 cuts.
- Infrared grating protective circuit design, to guarantee safety with front infrared grating safety photoelectricity protection and rear protective cover according to CE standard
- Optical cutting line; infrared laser indicating line

## 2、 R/P Series paper cutter machine

### 1)、 Parts description

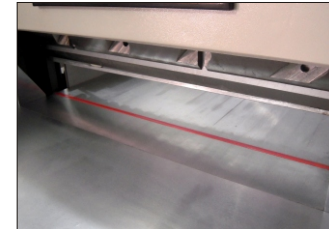


## 2)、 Charactoristics

- |  |   |
|--|---|
| <ul style="list-style-type: none"> <li>■ <b>Integral heavy frame design</b><br/>Heavy frame design, precise processing technology and paper cutting precision comply with professional level</li> <li>■ <b>Hard chromium plating table design</b><br/>(only for R series)<br/>Hard chromium plating work table, alternative durability high support table</li> <li>■ <b>Blade carrier hanging structure device (patent technology)</b><br/>Blade carrier hanging structure which breakthrough the traditional slippery tank and the rolling type paper cutting movement way, completely solve the problem of sliding channel and wheel.</li> <li>■ <b>Mechanical pedal paper presser device</b><br/>(only for R series)<br/>Proofread the position of paper presser. It's easy, reliable and secure to operate with CE safety standard.</li> </ul> | <ul style="list-style-type: none"> <li>■ <b>Infrared safety protection and securer</b><br/>Infrared security protection in the front work area, shield safety protection in the rear</li> <li>■ <b>Pushing paper screw clearance adjustable device (patent technology)</b><br/>Screw clearance adjustable structure, thick guide bar to ensure paper pushing precision</li> <li>■ <b>Low voltage electrical control system</b><br/>Low voltage electrical control circuit design, high safety</li> <li>■ <b>Pushing paper platform without slot design</b><br/>Improve the intensity of pushing paper platform, increase the stability of the machine and prolong the life of the machine.</li> </ul> |
|--|---|

## 2-4 Cutting stick adjustment

- ◆ One knife shim can be used for 8 times;
- ◆ When slash on the shim is too deep, you should adjust or change blade stick;
- ◆ Knife shim can be taken out by screw, and should be assembled onto the cutting desk flatly when it needs to be installed; Bladeshim should lean to the left side, then re-push the front brace plate;



※ Note: When knife shim has been changed, the blade itself also needs to be adjusted. If the blade cuts too deep, the knife shim will be damaged easily, and the blade also will abrade rapidly.

## 2-5 Adjust the pressure

- ◆ Press both cutting buttons, when the paper presser come to press the paper, the standard pressure should be  $40\text{KG}/\text{CM}^2 \sim 50\text{KG}/\text{CM}^2$ .
- ◆ Turn the switch to adjust the pressure. Clockwise turning is to add the pressure, anticlockwise turning is to reduce the pressure.
- ◆ Press both cutting buttons again to check the pressure.



## 2-6 Blade lock (only for R series)

- ◆ If error E-7 occurred, please open the above cover to check whether the blade lock sensor is good. When pressing cutter button, please check whether the sensor is sucked. After stopping cutting, please check whether the blade lock sensor is open.



## 2-7、 Solution for the error of hydraulic system

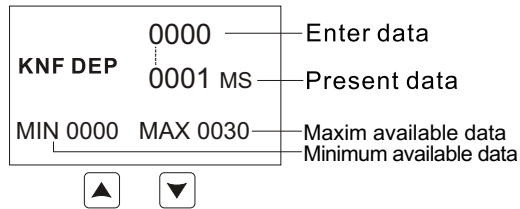
- 1、 Big systematic noise after starting
  - (1)、 Oil shortage, please add 32# or 46# hydraulic oil;
  - (2)、 oil filter jam, please clean it
- 2、 pressure shortage
  - (1)、 The hydraulic control system of each connection leaks
  - (2)、 The motor is abnormal or the voltage is not suit to the machine.

## 2-3 R/P series cutting blade adjustment

### 2-1 The adjustment of cutting size deviation(adjustment range $\pm 5$ mm)

### 2-2 The adjustment of the blade depth

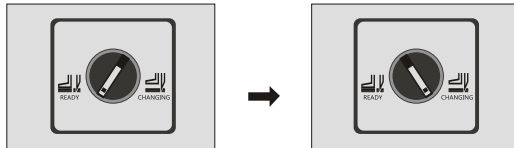
- A ♦ Adjust the blade depth vernier device(the adjustment of the depth range $\pm 5$ mm) or change to another side of the stick



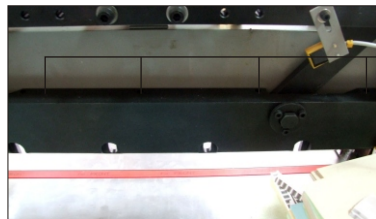
- 1) press FUN+6 on the panel(firstly loosen the button 6, then FUN button), then you will see the picture above.
- 2) Press the up and down key to increase and decrease the level of the blade.
- 3) Operate after confirmed
- 4)Quit after you press FUN

- B ♦ Change blade switch:

Change the blade switch from the normal state to the changing state.



- ♦ After both hands press the cutter buttons,the blade will come down.
- ♦ When the blade can not cut off the last piece of paper, the top knife screws need to be adjusted. We usually adjust the depth of the blade to make the paper cut completely until the blade cut into the cutting stick about 0.3-0.05mm. If the last piece of paper still can not be cut completely after fine adjust the cutting lade depth, you can adjust the top knife screws again if you need.



- ♦ After changing the knife switch from the changing state to the normal state, you can put on the blade .

## 3、Parameter

### 1)、Parameter for numeri cal-control series

Specification / Model	480HC	560HC	670HC
Max. cutting width(mm)	480	560	670
Min. cutting width(mm)	30		
cutting thickness(mm)	60	80	
Pressing & Cutting system	Hydraulic		
Pushing mode	Numerical-control		
Display mode	Digital		
Safety protection	infrared photoelectric protection		
power supply	1.7KW/220V/50Hz 1.7KW/110V/60Hz	3.1KW/220V/50Hz 3.1KW/110V/60Hz	
Machine measurement (H*D*W)	950X800X1270mm	1130X895X1290mm	1310X990X1290mm
Net Weight	380 kg	430 kg	480 kg

### 2) P arameter for program-control series

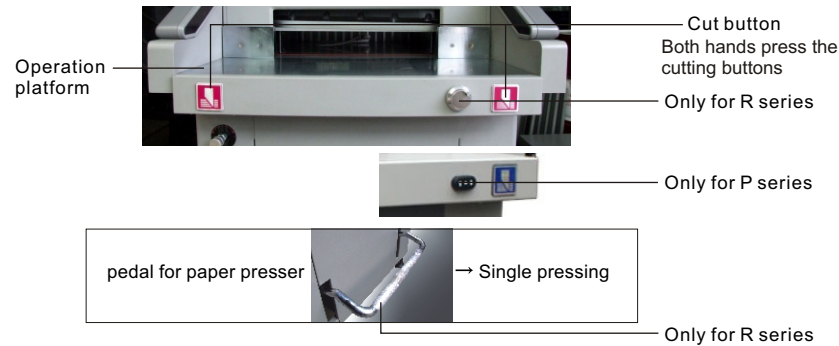
Specification / Model	480HP	560HP	670HP
Max. cutting width(mm)	480	560	670
Min. cutting width(mm)	30		
cutting thickness(mm)	60	80	
Pressing & Cutting system	Hydraulic		
Pushing mode	Numerical-control		
Display mode	LCD		
Safety protection	Infrared photoelectric protection		
power supply	1.7KW/220V/50Hz 1.7KW/110V/60Hz	3.1KW/220V/50Hz 3.1KW/110V/60Hz	
Machine measurement (H*D*W)	950X800X1270mm	1130X895X1290mm	1310X990X1290mm
Net Weight	380 kg	430 kg	480 kg

### 3). Parameter for program-control series

Model	H520R/P	H670R/P	H720R
Max. cutting width(mm)	520	670	720
Min. cutting width(mm)	30		
Cutting thickness(mm)	80		
Cutting precision(mm)	±0.2		
Pressing & Cutting system	Hydraulic+pedal (only for R series)		
Pushing mode	Program control + manual		
Display mode	LCD		
Safety protection	infrared photoelectric protection		
Power supply	220V(110V)/50Hz(60Hz) 1.8~3.0KW		
Dimension(H*D*W)	1280X1010X1430mm	1400X1150X1460mm	1550X1200X1460mm
Net Weight (appr.)	400 kg	450 kg	500 kg

### 4 . Operating buttons and panel

#### 4-1 operating buttons and function instruction for R/P series



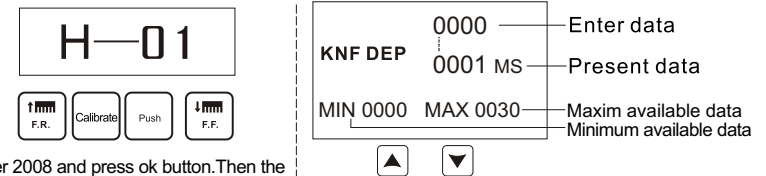
#### 4-1-1 Operate figure for cutting

Power on, display shows company name and total cuts, lights are on. It means the machine is on now. Then the power light shines, the machine can be operated. The right method of using this machine like this: Stand in front of the machine, press left and right CUT buttons at the same time to make machine work (show in Figure)



### 2-2 480HC/HP cutting blade adjustment

- ◆ Cut off the electricity power;
- ◆ First of all, fine adjust the cutting blade depth( adjust depth range about 5mm)or exchange the cutting side of stick.



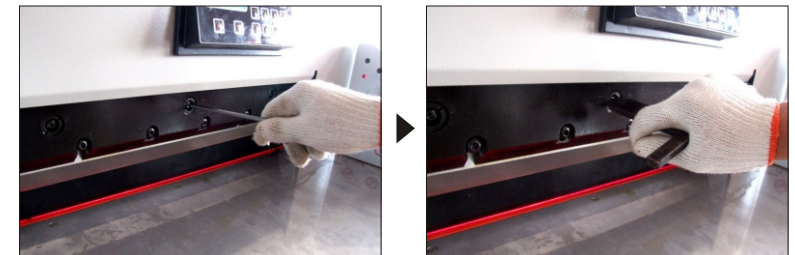
- 1)Enter 2008 and press ok button. Then the pusher will stop. H-01~30 will appear if you press the button of pusher for 5 seconds. It has 30 levels.
  - 2)push the up and down keys to increase and decrease the depth of the blade.
  - 3)you can quit after you confirmed
- Adjust blade for numerical-control machine

- 1)press FUN+6 on the panel (firstly loosen the button 6, then FUN button), then you will see the picture above.
  - 2)Press the up and down key to increase and decrease the level of the blade.
  - 3)Operate after confirmed
  - 4)Quit after you press FUN
- Adjust blade for program-control machine

- ◆ If the last paper still can not be cut completely after fine adjustment the cutting blade depth. Adjust the balanced screw of cutting blade depth once more. Disassemble retaining M10 screws on the blade carrier which fixed blade (5 screws for 480 series, 6 screws for 560 series, 8 screws for 670 series)



- ◆ Adjust the depth of blade to make the paper cut completely until the blade cuts into the cutting stick about 0.3-0.5 mm;

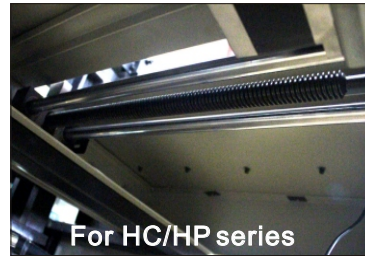
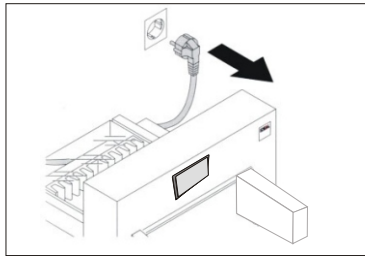


- ◆ Tighten up M10 fasten screws on blade carrier and start the machine. Press + RESET with two hands at the same time. Paper presser and blade reset.
- ◆ Choose one piece of paper to have a try. If it can not be cut completely, you can re-adjust according to the above processes.

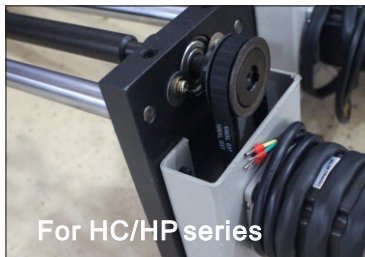
## 2、 Basic adjustment for HC/HP/R/P series

### 2-1 Dimension check and adjustment

- ◆ Cut off the electricity power;
- ◆ Unload the back cover plate. Check whether there is any other matters block the guiding rod;



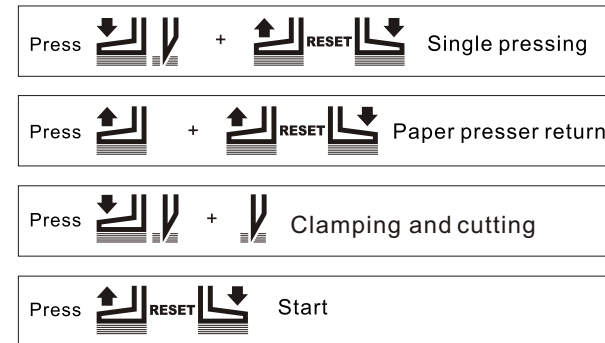
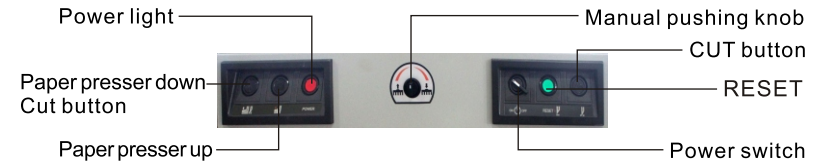
- ◆ Unload the back baseplate. Check whether stepping motor and synchronous belt are fixed normally or not;



- ◆ Adjust the sensor on the screw, and you can move it back and forth until digital display dimension matches measuring scale dimension, then lock the retaining screw firmly.

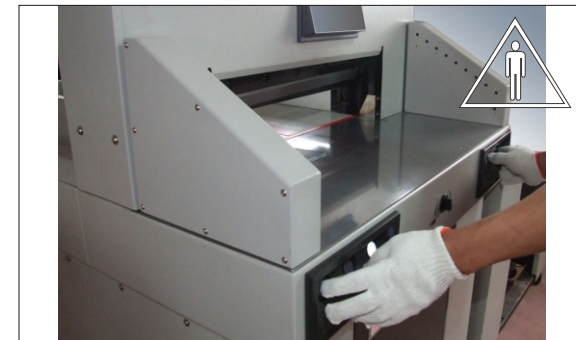


### 4-2 operating buttons and function instruction for HC/HP series

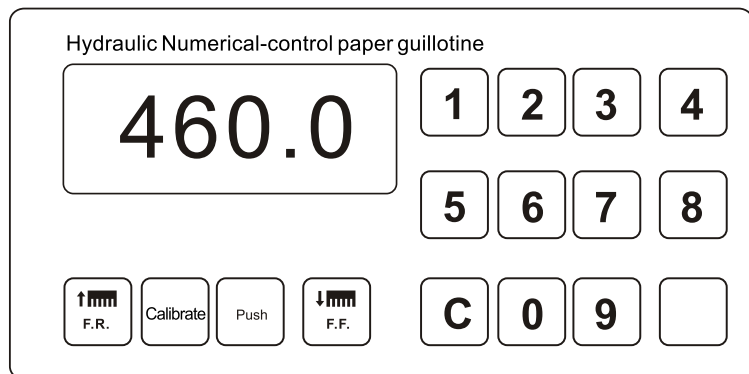


#### 4-1-1 Operate figure for cutting

Turn the protective switch to 'ON' position then power on. The machine comes into electrify. (If switching to 'OFF' position, the power is turned off.)  
If the power light shines, the machine can be operated. The right method of using this machine like this: Stand in front of the machine, press left and right CUT button at the same time to make machine work (show in Figure)

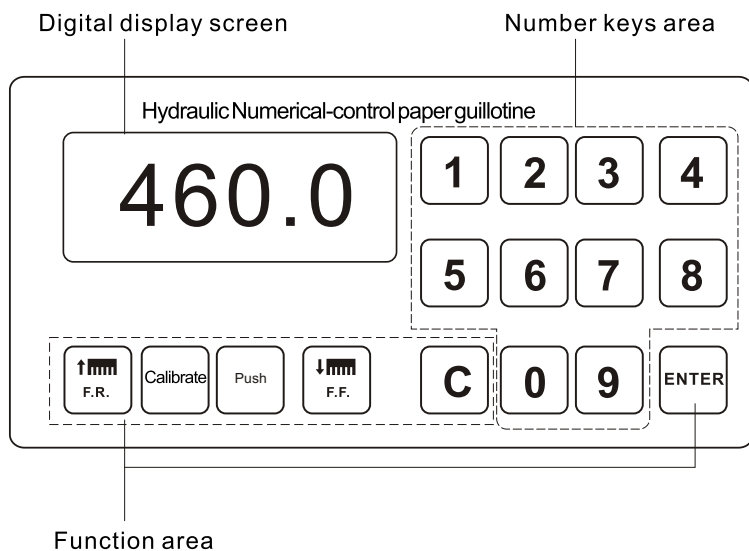


### 4-3 HC Numerical-control series Display screen functions instruction



- C Modify and clear data    Push Pushing    Adjust backgauge reset and calibration
- ENTER Confirm entering and backgauge move    F.R. backgauge move backwards
- 460.0 Cutting size    F.F. Backgagemoveforward    1 Number key

Note: Every time you enter data, you must add 0 more digit at the end to get accurate data. For example, you want to cut 460mm, you should enter 4600, then press ok. If you enter 0460, the finished cut size will be 46mm after you press ok.



Start to cut after the size is entered. Press two CUT buttons at the same time.

After that, the paper presser and blade come down, if you find the paper is Unparallel, stop pressing two CUT button, and press + RESET to make paper presser and blade return. After you confirmed the paper is put right, then press two CUT button to finish cutting completely.



- 4 ) Different result are in different modes . i ) In the manual mode state, press pushing after finishing cutting, backgauge will push paper or books automatically.
- ii ) In the automatic mode state, if you set pushing automatically after cutting, backgauge will push automatically. If you do not set pushing automatically after cutting, backgauge also will push paper or books automatically and get into next data after finishing cutting if you press the pushing button
- lii ) In the divide mode state, after first cutting, backgauge will push second divide size. The rest will be done in the same manner until the paper is cut completely.
- 5 ) Repeat above operation if cutting should be continued.
- 6 ) If the last paper can't be cut completely, please adjust it following the method of blade adjustment .



2 ) Put the books or paper right to cut, then make the books or paper lean to the left .

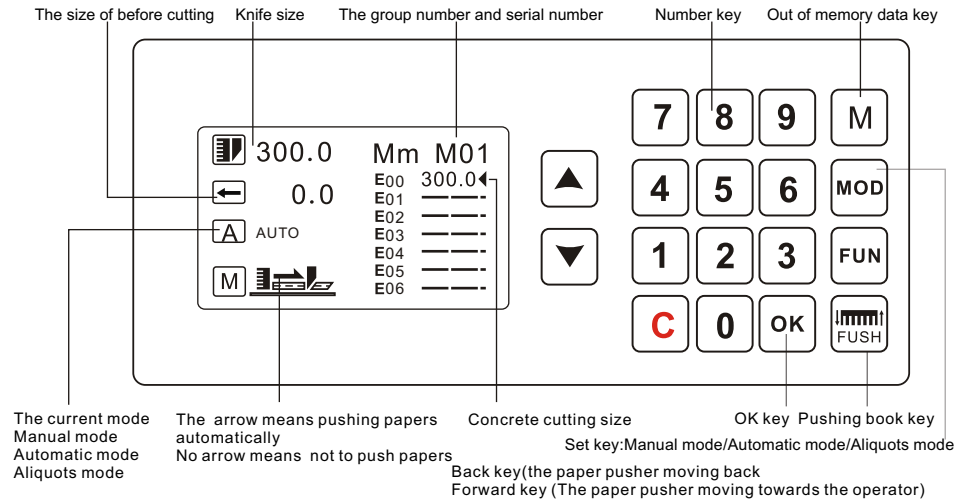


3 ) Start to cut after the size is confirmed. Press RESET ( green button ) firstly to make motor running, then pressing two CUT buttons at the same time. After that, the paper presser and blade come down, if finding the paper is not straight, please stop pressing two CUT buttons, and press + to make paper presser and blade return. After you confirmed the paper is put right, then press two CUT buttons to finish cutting completely.

Press + Clamping before cutting (Finish cutting)

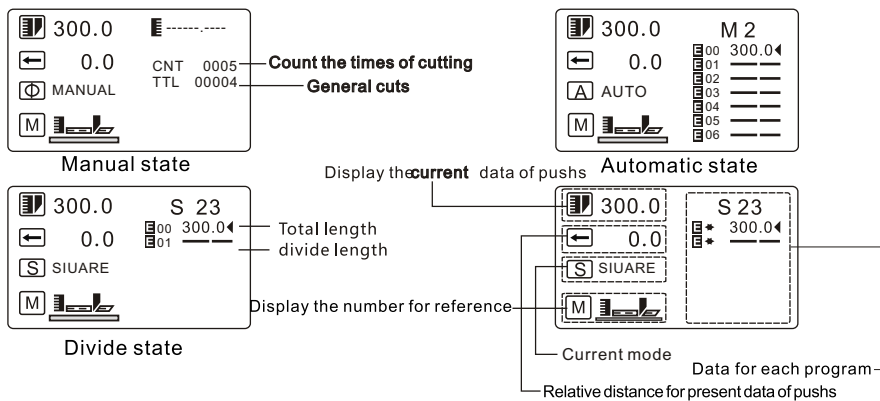


#### 4-4 HP/R/P program-control series display and functions introduction

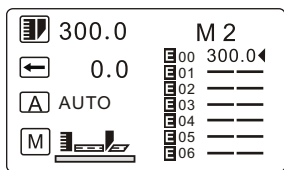


- Confirm entering, saving and backgauge moving
- Out storage data
- Eject mode and reset
- Modify and clear data
- Mode for switching
- Forward & Back/Select key
- Number key
- Function key
- Press M key and display stored data, and getting into automatic mode. Press M key without loosing, you can modify and select groups in M area from 0-100 with entering number in M area or switching steps up and down until the cursor shines.
- Press MOD button to switch among manual, automatic and divide mode. You can enter manual mode with pressing any number if current mode is automatic or divide. Press C to get into modify mode. Then press ok to save data and exit.
- + Getting into screen of fine adjustment for cutting blade
- Press RESET button and loose it at once, the backgauge enter automatically. If pressing the RESET in 2 seconds, the backgauge will reset.

Note: Every time you enter data, you must add 0 more digits at the end to get accurate data. For example, you want to cut 460mm, you should enter 4600, then press ok. If you enter 0460, the finished cut size will be 46mm after you press ok.



### Setting the parameters of machine



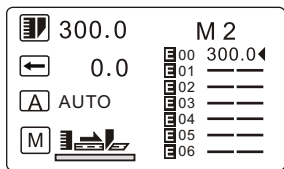
When changing the parameters, press the MOD key to switch to automatic mode firstly. After long pressing the button, the setting size state which is deselected will appear on the display and the parameters can be modified. Press the forward/backward key to select the parameter that needed to be modified in which position directly input

the correct size. After modifying the parameters, press the OK key and the program will automatically enter into the next data. When you press the OK key, the data can be saved. When deselected state disappeared from the settings and the program will automatically jump into the premier data that has been setted.

### Setting function

FUN+1	Push papers automatically	FUN+2	Metric conversion
FUN+6	Adjust the blade depth	FUN+7	Adjust the pressing time
FUN+8	Adjust the size of compensation	FUN+10	The min size
FUN+11	The max size	FUN+14	The aging test (All machines are tested well by our engineers.)

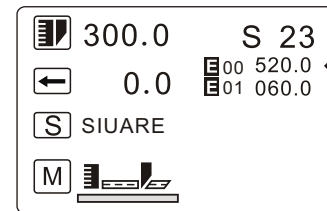
### The setting of pushing book or not pushing book



When you change the parameters, press MOD key to switch to the mode you need firstly in which the program can set to push papers or not push papers. Press the push key for a while to set pushing paper or not pushing papers. If an arrow appears, it means to push papers. If not, it says not to push papers.

After entering into the divide mode, the group data 00 & 01 can be seen. The 00 group data represents the total length of cutting paper. The 01 group data represents the equal cutting size. For example, the total length of 520mm needs to be cut equally by the length of 60mm. So the 00 group data is 520 and the 01 group data is 60.



When changing the 00 group data, long press C key, the modified size state which is deselected will appear on the display and the group data can be modified. Select group of data needing to be modified in which position directly input the correct size 5200 by switch up & down key. After finishing modifying the data, press the OK key and the setted data are saved well at the same time the deselected state disappear and turn to the next group data. Input the data 600 and long press OK key and the current two datas are saved in the same way. (If you don't press the OK key for a while, the setted data before won't be saved.) And the paper presser moves to the position of 5200mm. It shows as the following left picture.

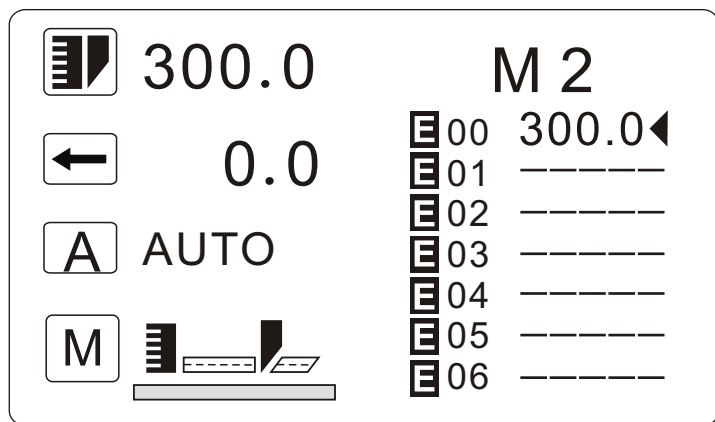


Put the paper or books on the right to cut, then make the paper or books lean to the left front guide.



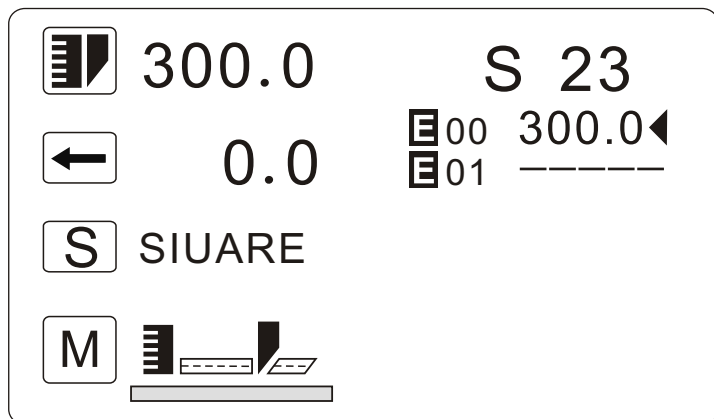
Remarks: In divide mode the key of pushing books doesn't work even if the mode of pushing papers has been set.

and set cutting size 285mm, press **M** or **OK** to save, then set next designate data. The rest can be done in the same manner. After finishing setting, change key to select 285.0 and press **OK** to make paper pusher move to M1 285mm position automatically. Select **FUSH**, display **A** , That means the backgauge won't push paper or books after cutting. Press **FUSH** once time and display **A** . That means the backgauge will push paper or books automatically after cutting.



### III )、 Divide mode

Press **MOD** to get into **S** divide mode. Press **C** button to clear and set overall size 285mm. Press **C** to clear and set divide size 50mm, then press **ENTER** to make backgauge move to overall size 285mm position.



Note: In divide mode, **FUSH** the pushing function is invalid.

## Chapter III Basic operation

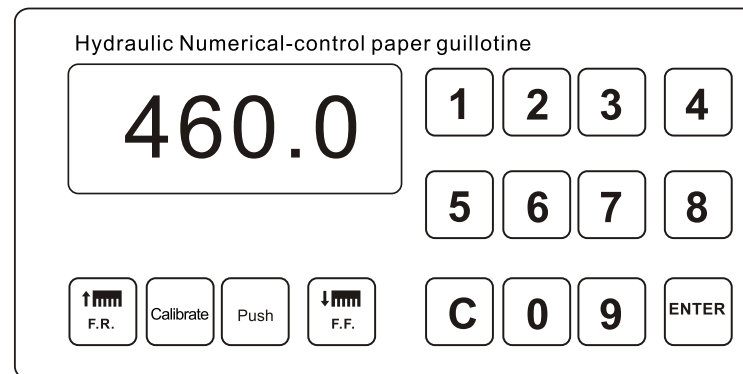
### 1、 Basic operations

#### 1-1 Start the machine

- ◆ Before operating the machine, please review contents described before carefully. Then remove the things on the machine and clean the machine.
- ◆ Insert the power plug into AC220V.50Hz/60Hz.4Kw socket.
- ◆ Turn the protective switch to On position. Digital display screen or crystal display shines, indicative line lights. The machine can be operated after backgauge is calibrated automatically.

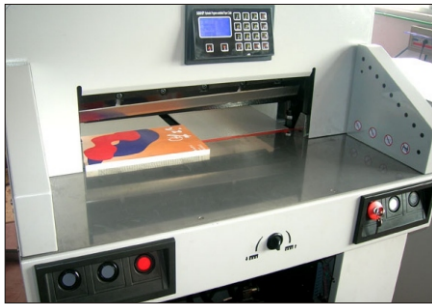


#### 1-2 480HC/560HC/670HC operation instruction

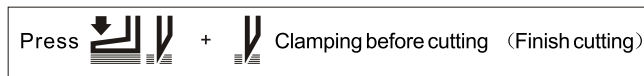


- 1 ) Assuming 460mm is present cut size, if you want to cut size of 210mm, and then enter 2100 in the control panel. Press **OK** ( If you enter wrong data, you can press **C** key to delete and modify the size ) and the backgauge will move 210mm position. There are two more methods to set size. One method like this: Press **F.R.** and **F.F.** to make the backgauge move forward and backward to 210mm, the size of the scale should be same as the size displayed on the screen. The other method is to rotate the manual knob to make the backgauge move 210mm. Backgauge move 0.1mm backwards each rotation. This method is used fine adjustment. If the size is big difference, you'd better use the first method or enter number in the display screen.

- 2 ) Put the books or paper right to cut, then make the books or paper lean to the left .



- 3 ) Start to cut after the size is confirmed. Press RESET ( green button ) firstly to make motor running, then pressing two CUT buttons at the same time. After that, the paper presser and blade come down, if finding the paper is not straight, please stop pressing two CUT buttons, and press + + RESET to make paper presser and blade return. After you confirmed the paper is put right, then press two CUT buttons to finish cutting completely.

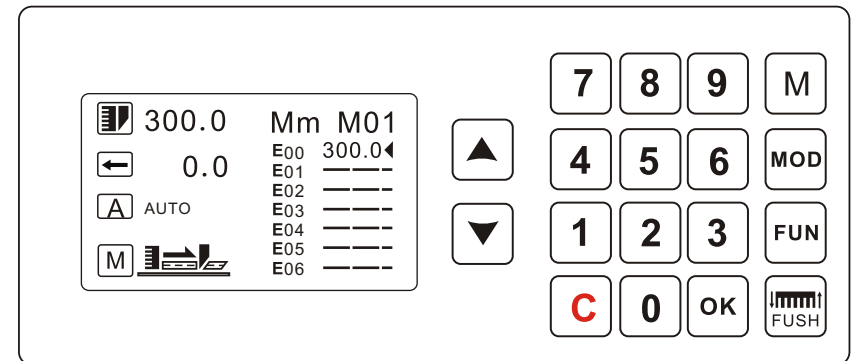


- 4 ) Then press OK button, the paper or books will be pushed automatically.  
 5 ) Repeat above operation if cutting should be continued.  
 6 ) If the last paper can't be cut completely, please adjust it following the method of blade adjustment .

Note: 1. If the size on the scale is not same as the digital display, please press Calibrate button to adjust or adjust follow the ' method of size adjustment

2. The display screen will display E-1 if something covers the photoelectricity protection area or other objects in the working area and warn, all the buttons won't work.

### 1-3 HP/R/P program-control series operation instruction



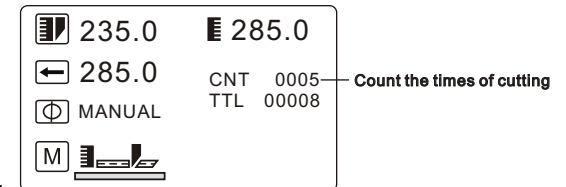
- 1 ) There are three pushing modes in programming paper guillotine. Now we take 285mm for example to push paper.

#### I ) 、 Manual mode



Manual mode is with priority. As long as rotating the knob with hand, the mode will be switched into manual state and display whatever mode it is in before . When in divide and automatic mode state, only press MOD to switch into manual mode state automatically.

- ◆ Rotate the knob clockwise. Backgauge will move in the direction shown by the arrow , Backgauge move 0.1mm each rotation. It moves quicker and quicker if keeping pressing the knob
- ◆ Rotate the knob anticlockwise. Backgauge will move in the direction shown by the arrow . Backgauge move 0.1mm each rotation. It moves quicker and quicker if you keep pressing the knob
- ◆ Assuming present backgauge is in 300mm position, it moves 0.1mm each rotation until getting the position of 285mm. The crystal display screen show:



#### II ) 、 Automatic mode

Press MOD to get into automatic mode (A) and LCD displays seven blank data ( there are 100 groups, 7 groups each blank. ) Press M without losing, enter number until the cursor shines. Select groups by switching . For example, press M without losing, then enter 23 until cursor shines. Press M or OK to select this group data or blank data, or switch or to get M23. If there is only dotted line there, press C to enter data.