

OPERATION MANUAL



All specifications and information concerning products are subject to change without notice Edition 3,201711.01



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Foreword

Thank you for choosing paper cutter. Please read this manual carefully which can ensure correct operation.

We rely on powerful technical force and many years experience to develop paper cutter. We carry out strict quality control from designing and developing to purchasing material and producing. It reflects fully the aim of “doing better and better, customers’ satisfaction” in our company. Our products have its characteristics of beautiful figuration, high efficiency, easy operation and favorable price.

Safety Precaution

Your safety, as well as the safety of others, is important. Before your install or use the machine, ready and follow all the safety notices carefully in this chapter. In this instruction manual, and on the machine, you will find important safety notice related to the use of the product. Observe all the safety information provided. Read all of the instruction for further use. Also make sure you have been fully trained before operating.

Location: The machine must be placed on sturdy level floor surface.

Electrical Supply: Connect to the correct electrical supply according to the name card











Grounding: For the safe, make sure that the machine is grounded.

Overload: Do not connect many machines to one plug. Overload could result in fire, personal injury or death.

Cleaning: Power off the machine and pull up the plug before cleaning.



The following warnings are found on the equipment

| | | | |
|---|---|---|---|
|  | Warning! Before you install or use the electric paper cutter, read and follow all the safety notices carefully |  | Only trained adult allowed to operate the machine |
|  | Must grounded! Connect the machine to the pointed power voltage, and make sure the socket is well grounded. |  | Prohibited to cut metal, hard and fragile object. Unless it will damage the blade. |
|  | Opening the machine expose you to hazardous voltage, which and seriously hurt or kill you. There are no user serviceable parts inside. Refer to qualified service |  | Sharpen the blade each 3000cuts. Sharpening blade can guarantee cut quality and extend machine life.。 |
|  | Unqualified person forbidden to repair, change, or add any part to the machine. |  | Only qualified service man can replace the blade. Stock and remove the blade in blade box. |
|  | Sharpen blade. Do not touch it with your hand or fingers. |  | Before every work, please firstly check if the safety device works well. |



| NO. | Other cautions |
|-----|---|
| 1. | After power on, press RESET to initialize the machine |
| 2. | During Auto cut security level reduces, pay more attention to operation. |
| 3. | Regularly lubricate the running mechanical parts ! |
| 4. | Hold the base or lift screw to remove the machine. Failure to observe this caution could result in damage to the machine. |
| 5. | Before every work or blade replacement, please firstly check if the safety device works well. |
| 6. | Place or take the paper only when the blade and clamp stop at HOME/UP position. |

Series Precise Paper Cutter

Model


Power AC220V±10% ☐ AC110V±10% ☐

Supply 50Hz ☐ 60Hz ☐

Power 1200W ☐ 1300W ☐

1600W ☐ 2300W ☐

The patent product countefeits must investigated

 Make sure to connect the power to the earth safely; Don't disassemble the machine at random; Connect the power card to a single phase socket.

Warning





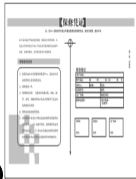
| | |
|-----------------|--|
| Machine Number | |
| Production Date | |

CE



1、Unpack and check

After unpack, respect the machine accord to below list. If any managed or missed item, please contact the local distributor or our company.

| | | | | | | | |
|---|----------------|----|---|----|--|----|---|
| 1 | Machine.....1 | 3 | Operation manual (saved in T-screen).....1 | 5 | Guarantee certificate.....1 | | |
| 2 | Tool bag.....1 | 4 | Knock tooling.....1 | 6 | | | |
|  | | 2) |  | 3) |  | 4) |  |
| | | 5) |  | | | | |

Reminding: Before you install or use the machine, read and follow the manual for better performance.

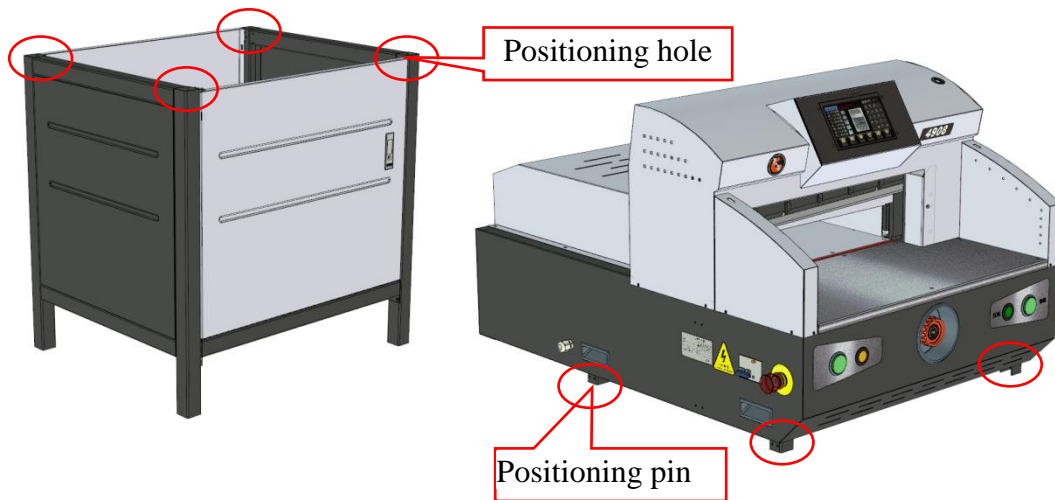
Save the package and plastic bag for further use. Plastic bags must be keep out of reach of children.



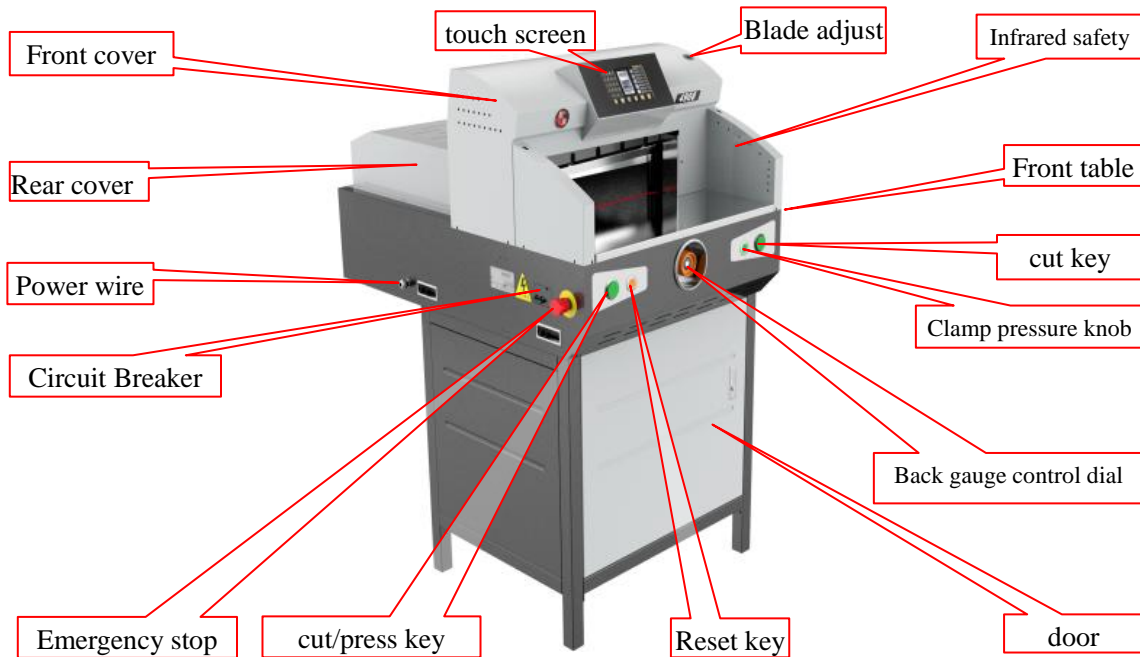
2. Installation

2.1 Ensure the floor is stable and flat surface capable of supporting the weight of the machine.

2.2 Install the machine, then lift the four positioning pins aimed to the four positioning holes above the machine.




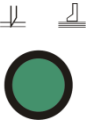


3.Part Name: Before use the machine, make sure you know it well.



4. Technical Parameter :

| Model | 4608 | 4908 | 520 | Note |
|--------------------------|----------------------------------|----------------------------------|-----------------------------------|---|
| Max cut size(mm) | 460*490 | 490*490 | 520*520 | |
| Max cut height(mm) | 80 | 80 | 80 | |
| Min cut size(mm) | 30 | 30 | 30 | |
| Back gauge accuracy(mm) | ±0.1 | ±0.1 | ±0.1 | |
| Cut accuracy (mm) | ±0.4 | ±0.4 | ±0.4 | |
| Float ball table | ✓ | ✓ | ✓ | |
| Press | Electrical | Electrical | Electrical | |
| Cut | Electrical | Electrical | Electrical | |
| Display | 7 inch touch screen | 7 inch touch screen | 10.2inch touch screen | |
| Programs | ✓ | ✓ | ✓ | |
| Arithmetic | ✓ | ✓ | ✓ | |
| motor/speed | V8.2: 3m/m V9.2: 7m/m | V8.2: 3m/m V9.2: 7m/m | V8.2: 3m/m V9.2: 7m/m | parameter set: speed1=3m/m speed2=7m/m |
| Power supply/consumption | 220V(110V)±10% 50Hz(60Hz)800W | 220V(110V)±10% 50Hz(60Hz)800W | 220V(110V)±10% 50Hz(60Hz)1300W | |
| Machine size(mm) | 1020×780×1325 | 1020×780×1325 | 1050×810×1325 | |
| Machine weight(Kg) | about170 | about175 | about 190 | |



| | |
|---|---|
|  | <p>5.2 Emergency stop: Turn Emergency Stop clockwise, power on. Press down this button when emergency happens to shut the power to protect the machine and operator. Note: This button only used under emergency situation, not ON/OFF switch.</p> |
|  | <p>5.3 Cut / press key: The public key of cut & press should be used with cut key or press key to realize cutting and pressing.</p> |
|  | <p>5.4 Reset key: This button resets the Blade and Back Gauge to the default position. When the machine is initially turned ON, the Reset button must be pressed before the blade will cycle.</p> |
|  | <p>5.5 Press key: Press “the public key of cut &press and press key, the clamp pressure paper. When loose the one or two keys, it stop pressing.</p> |





5.6 Cut key: Press “cut /press and cut key,the machine will press paper first and then cut paper. When you loosen the one or two keys on pressing and cutting procedure, the blade will come back to the top position.



5.7 Back Gauge Control Dial: Used to move the back gauge. Turn left to move forward or right to move backward. Continuously holding in one direction will move the back gauge more quickly for large adjustments. Potentiometer stops at 0 position, the back gauge stop.



5.8 Infrared Safety Walls: The side walls on the working table contain infrared sensors which prevent the machine from operating when the sensors are obstructed. If an obstruction occurs, and alarm sounds and the cut and clamp functions will not operate.



5.9 Setting up and Functions

Turn on power, on the screen shows as below, Touch Reset enter the home page, the machine finds home position and stops, if the blade or clamp is not at home position, the machine runs resetting.



5.10 Menu on Screen

The screenshot shows a control interface for a machine. It includes a list of segments with their respective values, a central image of the machine with a red line indicating the blade position, a numeric keypad, and various function buttons. Red lines connect labels to specific elements on the screen.

Labels and their corresponding elements:

- Choose Mode:001,002,003,004**: Points to the 'Program: 001' header.
- Choose segment No.**: Points to the segment list on the left.
- Cut size input**: Points to the '01' segment value '490.00'.
- Push/Do not Push**: Points to the '02' segment value '480.00'.
- In front of blade**: Points to the '03' segment value '30.00'.
- Page Up**: Points to the '04' segment value '50.00'.
- Page Down**: Points to the '05' segment value '100.00'.
- Manual Push**: Points to the '06' segment value '260.00'.
- Execute Auto cut**: Points to the '07' segment value '50.00'.
- Auto Cut(optional)**: Points to the '08' segment value '60.00'.
- Alarm,Reminding**: Points to the 'Infrared sensor obstructed' warning.
- Reference value front of blade manual input value front of blade**: Points to the 'Reference before blade' label on the machine image.
- Back gauge position, manual input Value behind blade**: Points to the '99999' display.
- Blade changing remind times**: Points to the 'clock' icon.
- clock**: Points to the '2016/3/22 23:22:11' display.
- Number 0-9**: Points to the numeric keypad.
- + - × ÷ operation**: Points to the operation buttons on the keypad.
- Delete segment value (long press delete line), also work with value front of blade**: Points to the 'Delete' button on the keypad.
- Insert line**: Points to the 'Insert' button on the keypad.
- In front of/behind blade**: Points to the 'In front/behind' button on the keypad.
- Enter**: Points to the 'Enter' button on the keypad.
- Home Page**: Points to the 'Home' button at the bottom.
- Calculator**: Points to the 'Calculator' button at the bottom.
- Sep Up**: Points to the 'Sep Up' button at the bottom.
- Help**: Points to the 'Help' button at the bottom.
- Save**: Points to the 'Save' button at the bottom.
- Select**: Points to the 'Select' button at the bottom.

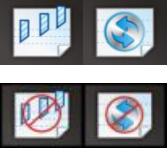



















Machine Image Labels:

- Auto cut! Caution!**: Points to the red warning text.
- Infrared sensor obstructed**: Points to the red warning text.
- Reference before blade**: Points to the red line on the machine image.

Navigation Buttons:

- Up Arrow**: Points to the green up arrow button.
- Down Arrow**: Points to the green down arrow button.
- Refresh**: Points to the circular refresh button.

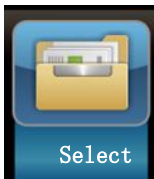
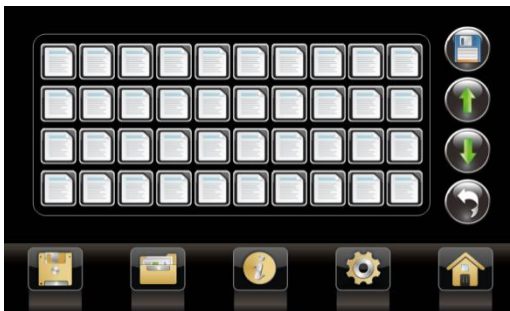
5.11 Control keys' function

| | |
|---|---|
| <p>Manual</p> <p>Equal divide:***</p> <p>Program:***</p> <p>Memory:***</p>  | <p>Mode switch: Manual, equal divide, program, memory in turn.</p> <p>Manual mode: Allow to remove the back gauge with back gauge dial, data is not stored.</p> <p>Memory mode: Allow to remove the back gauge with help of back gauge dial, data is stored in the same folder as program mode.</p> <p>Program mode: Forbidden to remove the back gauge with back gauge dial, data is stored.80X80 programs</p> <p>Equal divide mode: Forbidden to remove the back gauge with back gauge dial, data is stored.80X8 programs</p> <p>Auto cut(optional function): Under Program or equal divide mode, after set up cut size, touch-hold  for 2S till it change to , within 2S, press  for 2S till change to  (if exceed 2S then change to ), One screen displays: Risk increased during Auto Cut, if agree click ENTER to continue! Then press two CUT buttons, machine starts Auto Cut. During Auto Cut, if the infrared sensors obstructed, machine stop cutting, and need to press two CUT buttons again. Touch either   or click Mode Switch, exit from current Auto Cut mode, and change to  .</p> |
|  | <p>Push/do not push: For each program segment, it can set up push or not.  means Push after cut,  means non-push. (PS: In Auto-cut mode, no this function).</p> <p>Manual Push: Under all mode, non-cut state, when on screen displayed  or , Touch Manual Push key, the back gauge moves forwards little then back to origin position, if press this key for 2s, changes from  to , then under Manual cut mode, after each cut, the back gauge moves forwards little and back to original position again. If press  for 2s, changes from  to , then function of Auto Push after manual cut cancelled.</p> |






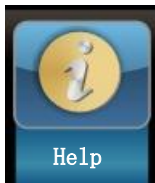
Press **SAVE** enter secondary menu. Save programs and memory data into folder No.1-80 save Equal divide data into folder for equal divide No.1-80. Press **SELET** key to select needed cut size which already saved in the folder. (see right Pic.) **PS: Saving will cover the existed data. Under manual cut mode, the Save key is void.**




Press **SELECT** enter secondary menu, select common Standard size, or with help of Save key to call the saved cut size by operator self.


Press  to escape current menu. (see right Pic.) **Under manual cut mode, the Select key is void.**





Press **HELP** key enter help interface, to browse information concerning Help, About, Count value and Contact us, press  to escape. (See right Pic.)



Press **SET UP** enter the set up interface, Browse, choose and set up Language, Self-diagnose, Size unit, Parameters, Date, Lightness of screen, and so on for setup information. Press  to escape. (See right Pic.)

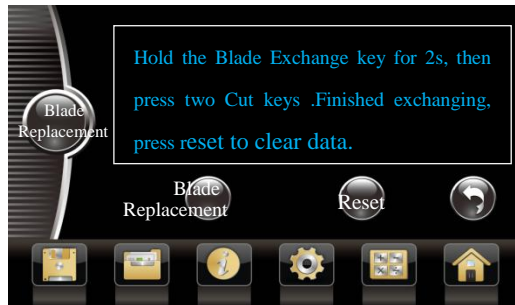






Press **SET UP**→**CHECK** enter secondary menu(see right Pic.),choose what to check, for example the sensor. Check if it works well. (PS. When check **Cut** button, after chose **Cut button**, two hands press **Cu** button, moves down, or pres **RESET**, moves up)(In new version, no check Back Gauge and Clamp button)



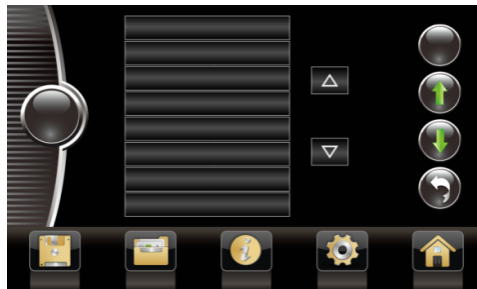
n cut cycle reach up to 3000, it will remind to replace the blade, press **Set Up**→**Blade replacement** enter to blade replacement interface (see details in P.28).(Different quality of blade different times, change parameter in SETUP interface)





Press **PARAMETER** enter the menu shown as right, set up or adjust the parameters with the up and down arrow. Press  enter next page, press  back to previous menu.

(Change will be effective only after restart the machine)



| No. | Menu | Value range | Default | No. | Menu | Value range | Default |
|-----|----------------------------------|-------------|---------|-----|------------------------------|----------------|---------|
| 1 | Pushing precision correction | ±200 | | 6 | Pressing time | 1.0—10s | 6.5s |
| 2 | Pushing zero-position correction | ±5mm | | 7 | Cutting Line Delay Time | 1—3min | 1min |
| 3 | Paper Pushing Max Size | 450-920mm | | 8 | Blade Changing Warning Times | 2500-10000 | 3000 |
| 4 | Paper Pushing Min Size | 20-50mm | 30mm | 9 | Motor of back gauge | servespeed1 /2 | 1 |
| 5 | Cutting Time | 1.0—10s | 6.5s | 10 | paper pressure set | 1—8 | 8 |
| | | | | 11 | blade position compensation | 1—9 | 2 |



6.Basic Operation

Manual

6.1 Mode: Manual Cut (No programmable) ,Click and select:

6.1.1 Manually move the Back Gauge: Turn the control dial in clockwise, the back gauge moves backward from slow to fast; turn the control dial in anti-clockwise, the back gauge moves forward from slow to fast.

6.1.2 Enter cut data: In manual mode, click **Size Behind Blade**, **Reference Front of Blade**, input the cut size, then two hands press the cut buttons to begin your job.



Size behind blade: Distance between front edge of the back gauge and blade, also the current position of the back gauge.

Reference front blade: Distance that the back gauge moves

For example: In manual mode, now the value is 480, if want the back gauge move forward 100mm, there are two ways,

1. Click input field Size behind blade, input 3,8,0 one by one, then size behind confirmed.
2. Click input field Size Front blade, input 1,0,0 one by one, then size front confirmed.

Remark: 1. In non-manual mode, it can't input data. On the screen displays current position of the back gauge.



2. Size front blade is just for reference, input the number, click enter to confirm, the back gauge moves forward accordingly. After every cut, this size clears to zero (select to clear size behind blade).










6.2 Mode: Programming (Memory cut)

6.2.1 Click Mode menu and choose **Program Mode**, click **Select** enter menu list, choose No. Of Program, then return to home page.

6.2.2 Click input field, input cut size, then click

. ( means size in front of blade. There is no

 before section 1 value. **The first size is the real size of the media**). (  are used to insert or delete line. Hold  1s to insert one line, hold  1s to delete one line. Click  to delete only digit) .  means push or do not push the paper, click it on demand.




Finish size input, two hands press CUT, the machine work from first cut to the last one in order. Finish cut, the back gauge back to Section 01 cut value position wait for next cut circle.

Remark: 1. The programs data can be saved in chosen folder.




2. Press ENTER to modify the value in each section or choose the section no. get the back gauge move.



6.2.3 Behind blade programming For example: paper size 485×400, after cut size 80×400; 150×400; 250×400, do as below

1. Click **SELET** to choose one Program then return home page.
2. In 01 section input 480.00, then click 
3. In 02 section input 400.00, then click 
4. In 03 section input 250.00, then click 
5. Click 01, the cursor stop at 01 section.
6. Press two **CUT** buttons to start cutting.

In front of blade programming For example: paper size 485×400, after cut size 80×400; 150×400; 250×400, do as below

1. Click **SELET** to choose one Program then return home page.
2. In 01 section input 480.00, then click 
3. In 02 section input ↓ 80.00, then click 
4. In 03 section input ↓ 150.00, then click 
5. Click 01, and the cursor stops at 01 section.
6. Press two **CUT** button to start cutting.

PS: In each segment, set up combination of value in front of blade and behind blade. If the date exceeds, such reminding appears: Oversized input. Correct please!

6.3 Equal divide : Click **MODE** and choose **DIVIDE**, click **SELET** to choose Program No then return to the home page. In the section No.01 input the size of media, in 02 section input ↓ +cut size, press two **CUT** buttons, the back gauge removes for setup size after each cut. After finish cutting, the back gauge return to No.01 value position.













Example1: In section 01 input 480, section 02 input ↓ 80, press two **CUT** buttons, first cut is 480, follow by each cut size (in front of blade) of 80, max 5 repeat cut cycle.

Example2: Paper size 485×400, cut to strip in size 45×400, between to cut 3mm bleed, do as follow

1. Click **SELET** to choose one Program then return home page.
2. In section 01 input 480.00;
3. In section 02 input ↓ 45.00;
4. In section input ↓ 3.00;
5. Press two **CUT** buttons

First cut 480, follow by 45, 3, 45, 3, 45, 3... until finishes. Then the back gauge return to first cut value position wait for next job.

6.4 AUTO CUT: Under **Program** or **Equal Divide** mode, after set up cut size, touch-hold  for 2s till it change to , within 2s, press  for 2s till change to  (if exceed 2s then change to ) , One screen displays: **Risk increased during Auto cut, if agree click**  **to continue!** Then press two **CUT** buttons, machine starts Auto Cut. During Auto Cut, if the infrared sensors obstructed, machine stop cutting, and need to press two CUT buttons again. Touch either   or click Mode Switch, exit from current Auto Cut mode, and change to  . After finish all cutting, the back gauge returns to position of first cut wait for next job.

Remark: A. In Auto Cut mode, the back gauge does not work automatically. Keep Children and non-operator away from machine!

B. In Program, equal divide, Auto Cut mode, the back gauge control dial does not work.



6.5 Mode: Memory **Memory:*****

Memory cut is one type of Program Cut, only the programming step is different. The computer track the Manual Cut process and save it to as Auto Cut program.

Step:6.5.1 Click mode menu and choose: **Memory:*****, Click **SELET** to choose one Program then return home page.

6.5.2 Remove the back gauge until the blade light aligns the cutting line on the paper.

Notice: Operation is same as Manual Cut. See also in P.20.

6.5.3 After cut, the computer saves the data casually, and the arrow removes to next line.

6.5.4 Repeat step 6.5.2、6.5.3, until it finishes cutting.

6.5.5 Click **SAVE**, choose one program No. to save the data, saving finished, ESC, and automatically enter PROGRAM model.

Notice: 1. Click   to insert or delete line.

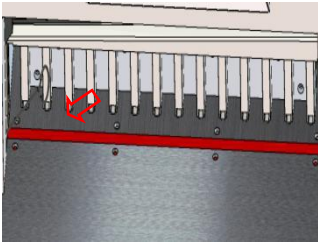
2. Data of Memory and Program mode stored in same directory menu.



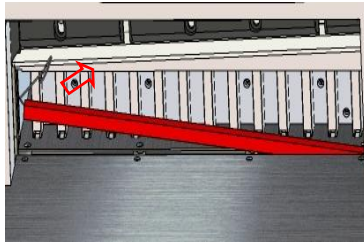
7. Cut Stick rotation and replacement

7.1. When the cut stick is badly abraded and the paper is not cleanly, either rotate or replace it. The cut stick can be rotated or replaced to provide eight cutting surface.

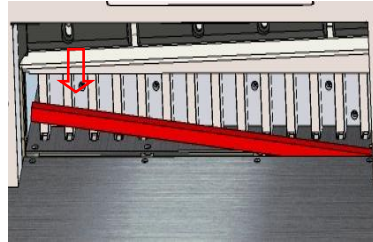
7.2. Turn the circuit breaker and switch to **OFF**. Insert the Stick Removal Tool (in the tool bag) into the hole in the end of the Cut Stick and pull up, turn the cut stick to new side then insert the stick to the groove again. See Pic.1-3 as below.



(Pic 1)



(Pic 2)



(Pic 3)



8. Blade Replacement and depth adjustment

8.1. Blade depth adjustment outsides of machine

If the Cutting Blade does not cut through the paper, the blade may need to be adjusted or the Cut Stick may need to be changed. The blade can be adjusted up to approximately 23mm (9inch). Insert the hex wrench in the blade adjustment hole and turn the screw clockwise. Rotate 45 degrees, or a Quarter turn, then check for proper cutting.

Blade Adjustment Hole



8.2. Blade depth adjustment inner machine

8.2.1 If the Cutting Blade does not cut through the paper, the blade may need to be adjusted or the Cut Stick may need to be changed.

8.2.2 If the blade is not level after installation, it needs to adjust the three screws to make the blade level.

PS: The screws can be adjusted in range of 2–3mm. After adjustment, the Cutting Blade still does not cut through the paper, the blade may need to be changed.

8.2.3 How to adjust: Stop the blade at middle position, unlock the fixing screws.

8.2.4 Then stop the blade at bottom position, adjust the depth of blade down to the Cut Stick 0.3–0.5, turn the adjusting screw to make sure the blade at level. (Cut only one paper to test the level of blade, if the blade can cut through the paper, it means the blade at level). At the end tighten the fixing screws.

PS: 1. Sharpen blade is dangerous, Caution! Only qualified technician to replace, store and remove the blade.

2. Each 3000 cut, replace or sharpen the Blade, and rotate or replace the Cut Stick.



8.3. Blade Replacement

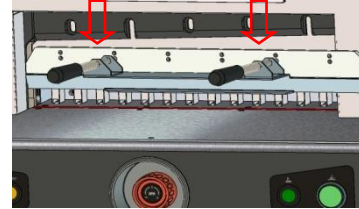
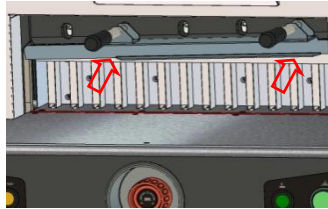
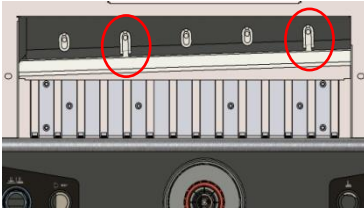
8.3.1 If the Cutting Blade does not cut through the paper, and does not cut nicely, the blade may be need to be replaced or sharpened. (Normally each 3000times of cut sharpen the blade one time, to make sure good performance).

8.3.2 Need not to remove the up housing when replace the blade, do as follow,

A) Touch SETUP→BLADE EXCHANGE (See P.18). Hold the Blade exchange key for 2s, remove the two fixing screws in the U channel.

B) Two hands press CUT, stop the blade at **middle position**, screw the blade exchange tool to the screw holes which on the U channel. Press RESET, the blade back to the home/up position.

C) Remove other screws, take out the blade with blade exchange tool, after sharpening install it back or just replace new one. Finished exchange, press **RESET** 2s to clear the date.



8.3.3 Refer to the qualified technician for service of sharpening.

8.3.4 Follow the opposite steps to install the blade back.



9. Daily Maintenance

The only maintenance required by the operator is to perform what is described in this section. Perform only the routine maintenance procedures referred to in these instructions.

9.1 Cleaning the Paper Cutter

1. Must power off the machine after work.
2. At the end of the day or project, clean up all waste and extra scraps off the working table.
3. Check if there is any oil leak
4. If the machine does not work for long time, polish it with wax.

9.2 Lubricate the machine

1. Every half month, apply lube to the lubrication section.
2. Apply lube to the machine frame and clamp slide slot. (lubricate oil)
3. Lubricate every axis of rotation (Engine oil) .
4. Be careful don't drop the oil onto wire board or electric components.



10. Trouble shooting and how to deal with it.

If trouble shooting alarms deal with it as instruction at blow:

| Alarming | Description | Cause and how to deal with it |
|-------------------|---|---|
| Cutting time out | Half cut cycle(blade moves from home position to bottom, or from bottom to home position) is about 2s,if it is over 2s, this alarming appears and the blade stops. | <p>A. No electric to Hydraulic pump motor. Possible cause: motor damaged, wiring between motor to main board fault, wiring of SSR fault, PCB fault. Please check all the parts in order.</p> <p>B. Blade solenoid does not work. Possible cause: solenoid damaged, valve element blocked, wiring fault or PCB fault. Please check all the parts in order.</p> |
| Pressing time out | Half clamp cycle(clamp moves from home position to bottom, or from bottom to home position) is about 1s,if it is over 2s, this alarming appears and the clamp stops.. | <p>A. No electric to Hydraulic pump motor. Possible cause: motor damaged, wiring between motor to main board fault, wiring of SSR fault, PCB fault. Please check all the parts in order.</p> <p>B. Clamp solenoid does not work. Possible cause: solenoid damaged, valve element blocked, wiring fault or PCB fault. Please check all the parts in order.</p> |



| Alarming | Description | Cause and how to deal with it |
|------------------------------------|---|---|
| Pushing zero-position signal error | After turn on, the back gauge reset. But if after too much time, the Zero position sensors is still active (in other words, the back gauge keeps in the sensor detection range) In such case, this alarming appears, and the clamp motor stops. | <p>A. Before turn on, the back gauge motor stop in the zero-position sensor detection range, and during the resetting, the motor does not run. Possible cause: motor damaged, wiring of motor fault, motor controller fault, or wiring between motor and controller fault, or PCB elements fault. Check all these parts in order.</p> <p>B. During resetting, the back gauge moves forwards about 2mm and stops. Possible cause: zero-position fault, magnetic strip drops out and stops nearby the sensor, or wiring of sensor fault, or PCB elements fault. Check all these parts in order.</p> <p>C. During resetting, the back gauge moves backwards to the wall, clash for 2s, and stops. The possible cause: controller fault, wiring between motor controller and PCB fault or PCB elements fault. Check all these parts in order.</p> |



| Alarming | Description | Cause and how to deal with it |
|------------------------------------|--|---|
| Pushing zero-position signal error | After turn on, the back gauge reset. But if after too much time, the Zero position sensors do not detect any signal. In such case, this alarming appears, and the clamp motor stops. | <p>A. Before turn on, the back gauge motor stop in the zero-position sensor detection range, and during the resetting, the motor does not run. Possible cause: motor damaged, wiring of motor fault, motor controller fault, or wiring between motor and controller fault, or PCB elements fault. Check all these parts in order.</p> <p>B. During resetting, the back gauge moves backwards about 2mm and stops. Possible cause: zero-position fault, magnetic strip drops out and stops nearby the sensor, or wiring of sensor fault, or PCB elements fault. Check all these parts in order.</p> <p>C. During resetting, the back gauge moves forwards to the wall, clash for 2s, and stops. The possible cause: controller fault, wiring between motor controller and PCB fault or PCB elements fault. Check all these parts in order.</p> |

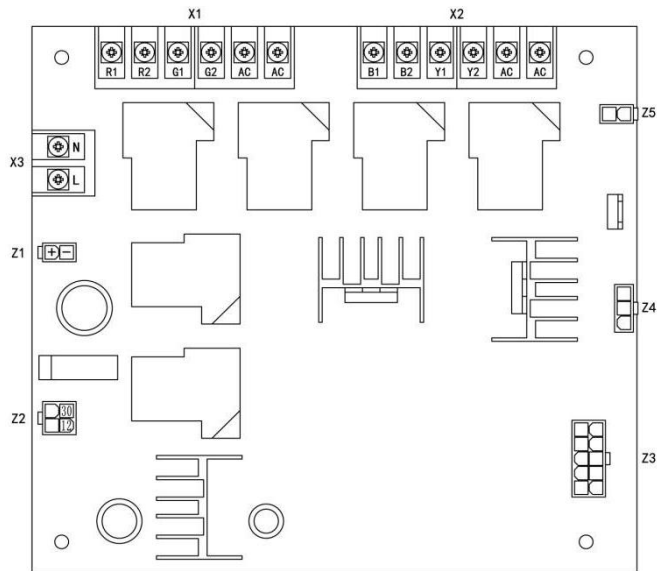


| Alarming | Description | Cause and how to deal with it |
|-------------------------|--|--|
| Light curtain activated | During Cutting and clamping, if the infrared sensors are obstructed, the blade and clamp stop. This alarming appears. | <p>A. During clamping or cutting, foreign matter enter the infrared sensor detect range.</p> <p>B. During clamping or cutting, though there is no foreign mater, but the sensors are dirty, sensitivity drops, or sensors damaged, or there is strong light disturb. Clean the sensor, remove obstruction.</p> |
| Blade lock activated | During cutting, the hook on the blade holder hooks on the blade lock. The travel switch opens and this alarming appears. | <p>A. The blade lock hooked by hook, press RESET two times, the blade holder goes up automatically.</p> <p>B. The power of electric magnet is not enough, and the hook is not open.</p> |



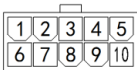




11. Explanation to wire connection


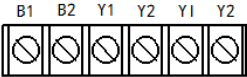

1. Power Board



EXPLANATION TO CONNECTORS ON POWER BOARD

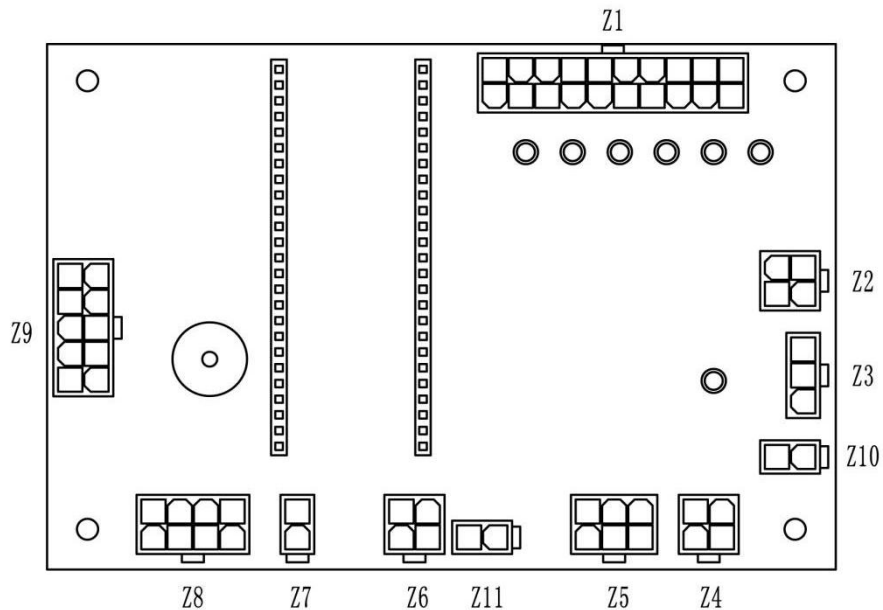
| NO. | Name | Diagram | Explanation |
|-----|------------------------------------|---|--|
| Z1 | driver power |  | 1 driver +, 2 driver +。 |
| Z2 | transformer output |  | 1、3 transformer output12v 2、4 transformer output30V。 |
| Z3 | power\main board10holes wire |  | One to one with main board |
| Z4 | blade lock |  | 1 is for zero line for blade lock, 2 is for signal of blade lock, 3 is for power of blade lock |
| Z5 | Short circuit of blade lock |  | 1、2 is for the L line of solenoid of blade lock. |





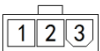
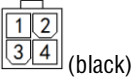

| NO. | Name | Diagram | Explanation |
|-----|---------------------------|---|--|
| X1 | cut motor wire terminal |  | <p>D.C cut motor :</p> <p>R1 to cut motor+, R2 to cut motor-, G1 to rectifier+, G2 to rectifier-, AC to rectifier AC (no different) 。</p> <p>A.C. cut motor:</p> <p>R1、R2to main winding two ends of cut motor, G1、G2to secondary winding two ends of cut motor, AC one to one parallel connect to G1,G2 (note the motor rotation direction)</p> |
| X2 | press motor wire terminal |  | <p>B1 to push motor+, B2 to push motor-, Y1 to rectifier+, Y2 to rectifier-, AC to rectifier AC (no different) 。</p> |
| X3 | power input wire terminal |  | <p>L to circuit breaker L, N to circuit breaker N。</p> |





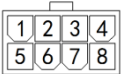
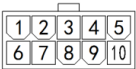


2.Explanation to connectors on main board



Explanation to connects on PCB

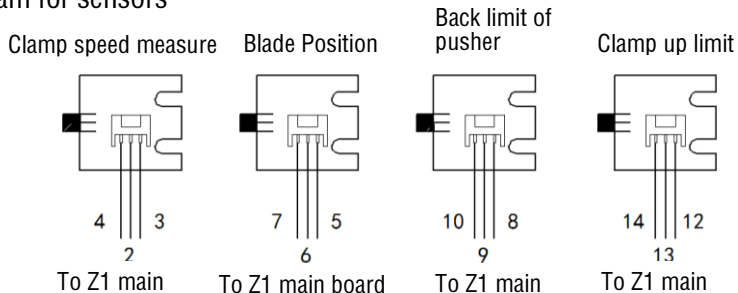
| NO. | Name | Diagram | Explanation |
|-----|-------------------|---|--|
| Z1 | 20 holes wire |  | 1,11 to blade light zero line, power line; 2,3,4 to speed measure sensor power, signal, zero line; 5,6,7 to blade Position sensor power, signal, zero line; 8,9,10 to back limit of pusher sensor power, signal, zero line; 12,13,14 to clamp up limit sensor power, signal, zero line; 15,16,17 to blade lock control power, signal, zero line; 18 is for standby; 19,20 to two ends of blade lock and reset switch. |
| Z2 | Touch screen wire |  | 1,2 to touch screen zero line and power 3,4 to DIN、DO of touch screen |
| Z3 | infrared wall |  | 1 to infrared sensors signal, 2 to infrared sensors zero line 3 to infrared sensors power |
| Z4 | 4hole socket |  (black) | 1,2,3,4 are for standby |
| Z5 | button socket |  | 1,4 to two ends of cut button, 2,5 to two ends of clamp button 3,6 are for standby |



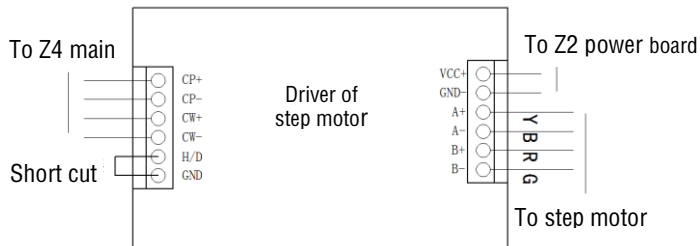
| NO. | Name | Diagram | Explanation |
|-----|-------------------|---|--|
| Z6 | Driver control |  | 1 to driver CW + , 2 to driver CP + 3 to driver CW - , 4 to driver CP - |
| Z7 | 2 hole socket |  (black) | 1,2 are for standby |
| Z8 | 8 holes button |  | 1 to common end of PUSH button , 5,6 to forward and reverse of PUSH button ; 2 is for standby ; 3,7 to two ends of RESET button ; 4,8 to two ends of CUT/CLAMP button |
| Z9 | 10 holes wire |  | One to one with 10holes wire on power board |
| Z10 | Power wire of PCB |  | 1,2 to transformer 16V. |
| Z11 | 2 hole socket |  | 1,2 are for standby。 |



3. Wiring diagram for sensors



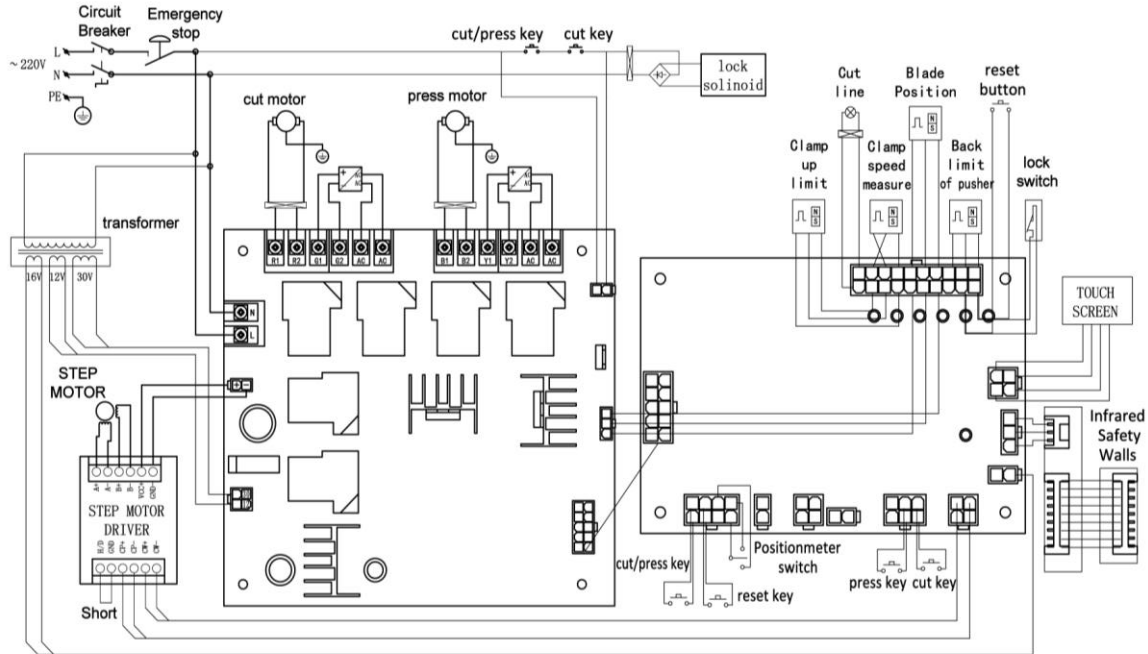
4. Wire diagram for driver



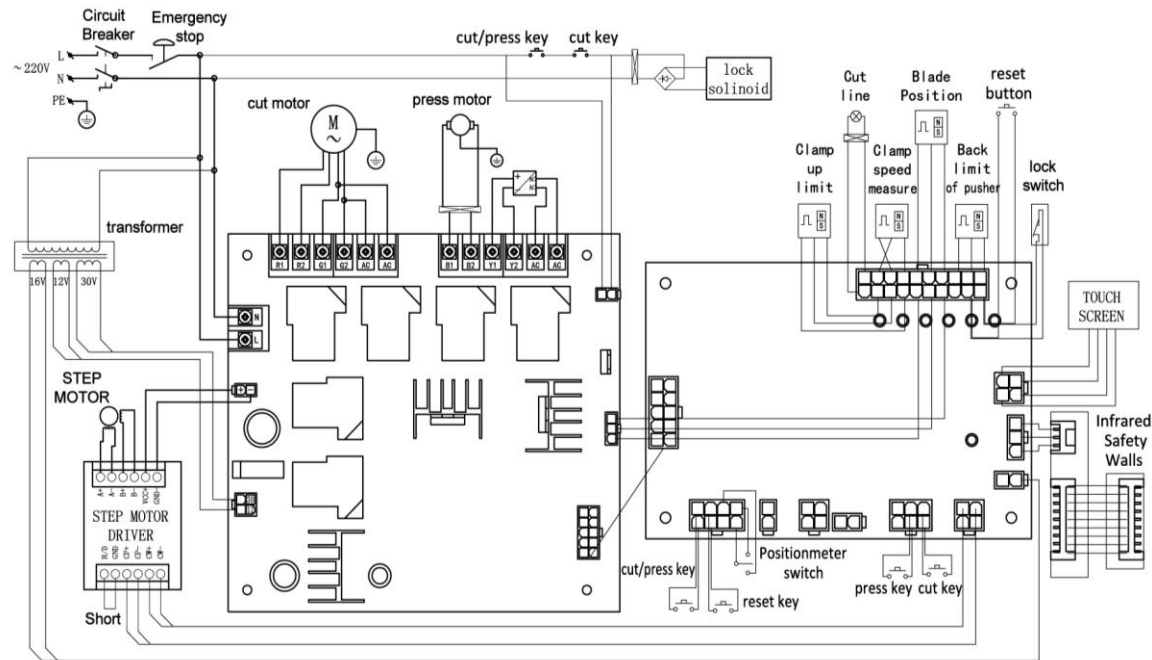
Dial-up of driver: H/D&GND short connect, code: 101



5. Wiring Diagram(D.C.Motor)



6. Wiring Diagram(A.C.motor)



E N D



Reserved Page 1



Reserved Page 2

