

Preface

Thank you for your choice of our Electric Programmed Paper Cutter series. We will provide good quality and reliable after-sale service on the basis of original products. Our research and development engineers combined advantages of products at home and abroad, and finally developed new model machines with new advantages. It owns high technology, precise construction design, and elegant appearance with the security control part and improved cutting precision to get high work efficiency. It can be broadly used in printing shop and official usage. It is the most ideal cutting equipment which well complies with official automatic system.

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) to use or maintain these machines, please pay high attention to safety cautions below:

- 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.

Settlement position

Pay attention to safety in the process of handling and place it in a clean environment in a balanced manner.

Please connect with the power source correctly in accordance with the specification. the power source should be steady AC220V, 50HZ. , and the machine will run irregularly if the voltage is too higher or too low. We suggest you use alternating current (AC) power source with steady voltage to improve your work efficiency.

For safety, you should use electric supply socket with ground wire connected. Don't connect too many electric equipment at the socket. It is dangerous and easy to cause fire or electric shock.

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

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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 machine ,prolong service life of the machine.

I 、 Safety caution

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 company if there is any damage or shortage.

● 1 set of main engine	● 1 set of chassis	● 1 instruction manual
● 1 set of tools	● 4 screws for tool removal	● 1 Certificate
● 1 blade and 1 power line	● 1 warranty certificate	

2. Machine installation

◆ Open the wooden crate ,take out the machine casing and discharge the fixed screws on the base plate of the main machine;

◆ The machine casing needs to be assembled completely, and the screws should be fixed firmly.

3.Environmental conditions

◆ The machine should be placed in clean working environment, keep away from direct sunlight and wind.

◆ Temperature of operating environment :10–30℃, should not exceed 32 ℃ ;

◆ Humidity level of the operating environment: 50–80%

◆ Working power source of cutting line: 220V ± 10%; 50HZ; 2KW;

◆ Connect the ground wire correctly.

4.Special suggestions

◆ Remember only one professional operator is allowed to operate the machine;

◆ When you cut ,you should operate buttons by both of 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;

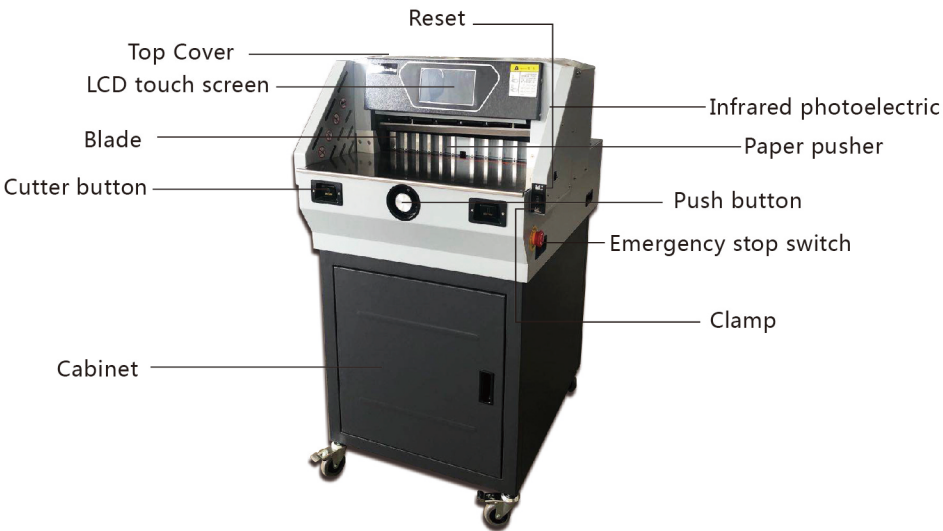
◆ When you change blades, you should strictly abide the blade changing instruction;

◆ You are not allowed to re-equip the construction and circuit of the machine by yourself.



II 、 Introduction to paper cutter

1、 Parts description



2. Principal technical parameter

Model	DT460	DT498
Max cutting length(mm)	460	490
Min cutting length(mm)	30	30
Cutting thickness(mm)	80	80
Cutting precision(mm)	±0.3	±0.3
Clamping mode	Electric	Electric
Display	7.0" touch screen	7.0" touch screen
Power	220V(110V) 50HZ(60HZ) ,1.3KW	220V(110V) 50HZ(60HZ) ,1.3KW
Weight	about 160KG	about 170KG
Machine size(L*D*H) mm	1015X770X1250	1015X770X1250

3. Operation panel.

Operation diagram of paper cutter.

Turn on the power supply, turn on the air switch, turn on the emergency stop knob switch, and the machine will be powered on. the paper pusher resets into the working state. The correct way to operate the machine is: the person stands in the front of the machine, facing the paper cutter, the left hand controls the button on the left, and the right hand controls the button on the right, as shown in the picture.



III 、 Basic operation and adjustment

1. basic operation

◆Power on

Before starting the machine, check whether there are other articles on the machine, and clean them up;

Turn on the power supply;

Turn the electrical protection switch to the "on" position, turn on the power switch, the NC screen / LCD screen will display, the position indicator line will be on, and the paper pusher will be automatically calibrated, indicating that the power is normal.



◆ Touch screen paper guillotine operating instructions

1) There are three modes for pushing paper, With the size 285mm as blew:



a. Manual mode

Please press Manual to switch to the Manual model, as picture. There are two ways for entering size. One way is to use the electric handlewheel (but it is very slowly, as the handlewheel is only to fine tune. This way is discouraged.) the second is press 360 (as blew size), and clear it, The second ways is to input 2850 and enter icon, the backgauge go to the position of 285.0mm



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 entered. then pressing two CUT buttons at same time ,After that, the clammer come down. When something goes wrong, stop pressing two CUT button, and press  +  the clammer and blade go back to the top. After confirming the paper is right, press two cut buttons to finish cutting.

After the cutting is completed, the paper pusher pushes the book out (automatic push cutting is set).The whole cutting process is completed. To continue other cuts, you only need to repeat the above steps.



b. Segmentation mode

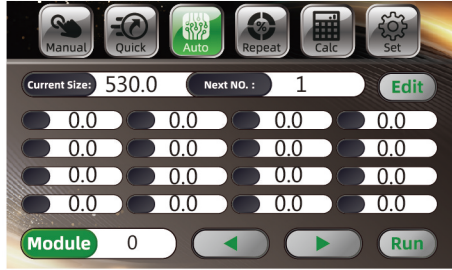
Click to switch to bisection mode, click OK, and the paper pusher is automatically pushed to the first size.When you need to edit the dimensions, click on the programming mode to enter the first set of programming modes, as shown in the figure.Need to modify data, click Edit, click divide Edit, switch divide Edit, switch Dialog Box, modify data, confirm return.



Push in the cut paper or book and place it on the left to align with the ruler Start to cut after the size is entered.Press RESET buttons first,then pressing two CUT buttons at same time .After that,the Paper press come down.When something goes wrong,stop pressing two CUT button,and press the Paper press and blade go back to the top.After confirming the paper is right, press two cut buttons to finish cutting. After the first cutting , the backguage move to next size automatically. Continue to press cutting button , to finish cutting in order of setting.

◆ Auto mode operating instructions

Click Auto into auto mode, it is a lot of date as blew picture. And Click  to turn page. If need to change the date ,edit it in the Auto edit interface. Click  to turn page or change groups as picture .

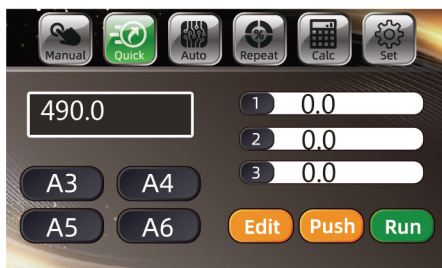


After set and confirm size, put the paper or book place on the left and cut it



◆ Quick mode

Click the Quick , Conversion to the quick mode, it appear to some Common standard size.Click the size that you need. the backguage automatic push to the size as picture.



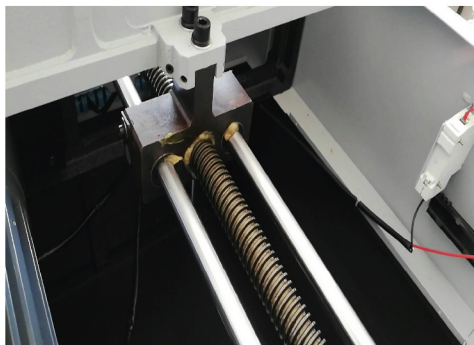
If need to edit the common standard size , click Quick edit mode, enter the modify interface. After modifying , click as picture.



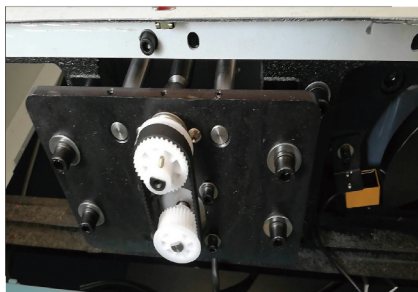
2. Basic regulation

◆Size correction adjustment

If you find that the size is wrong, turn off the machine first, and press the reset key after start up, if there is any problem, do as follows; cut off the power supply, remove the machine cover, and check whether there is any foreign body stuck on the transmission screw.



Check the stepper motor, remove the front cover, synchronize the pulley and whether the synchronization is fixed properly; adjust the limit plate on the nut, which can be adjusted back and forth until the display size matches the ruler, and then lock the fixing screw.



◆Cutter adjustment

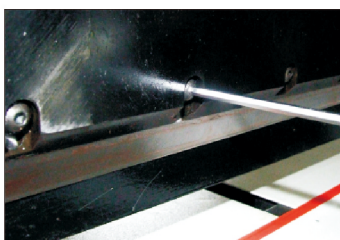
First adjust the cutter depth fine-tuning device (adjust the depth range 5mm or so) or change the cutting surface of the blade; deepen clockwise and shoal anticlockwise.



If adjusting the cutter depth fine-tuning cannot cut off a piece of paper, you can only adjust the cutter depth balance screw; remove the fixing screws at both ends of the upper cover and remove the upper cover.



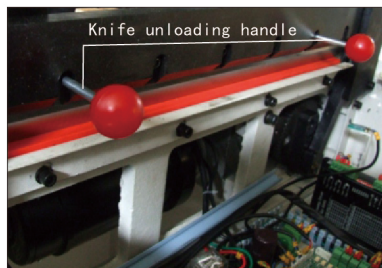
Loosen the locking screws of the 7 M6 blades fixed on the knife holder, and adjust the blade depth at the upper end of the tool holder to adjust the balance screws. Generally, it is appropriate to adjust the cutter to cut into the knife pad 0.5mm.



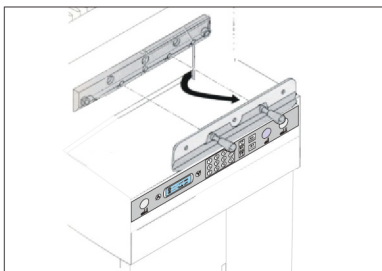
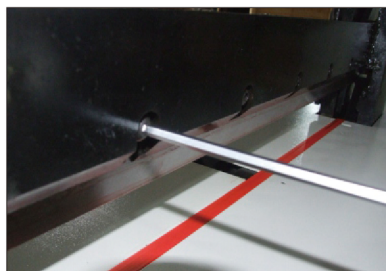
Tighten the locking screw on the tool holder, cover and fix it; use a piece of paper to try cutting, if the cutting is continuous, you can re-adjust according to the above steps.

◆ Blade replacement (please follow the steps carefully)

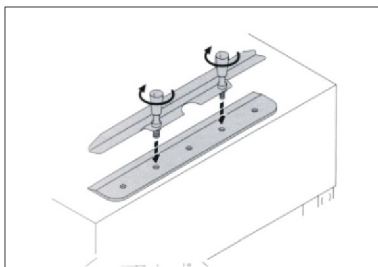
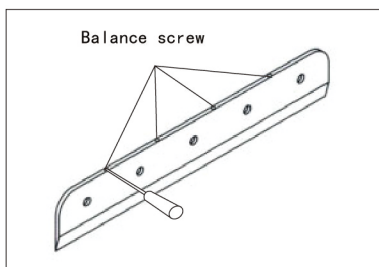
Open the upper cover; loosen and remove the locking screws with openings on the tool holder, screw the two cutter screws into the opening holes in a clockwise direction and secure the locking

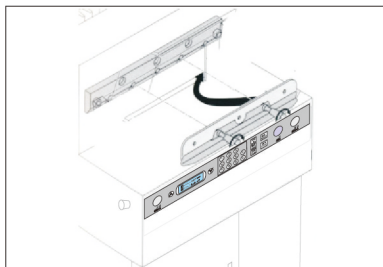


Remove the other locking screws from the tool holder; turn the two cutter screws half a turn counterclockwise and remove the blade downwards. Please wear gloves or wrap the blade in cloth and put it into the knife box to avoid scratches.



Take out a new blade, pay attention to safety, the blade is facing outward, before installing the blade, please loosen the blade at the upper end of the knife holder on the knife holder, tighten and fix it with screws in turn, and then adjust according to the cutter depth adjustment method.



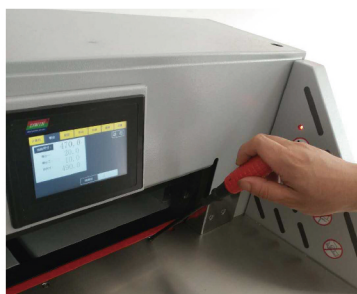


After the blade is packed, please go to a professional knife sharpening unit to ensure the grinding quality.

Note: a blunt knife cannot cut paper correctly, and thick paper or cardboard is often cut. It's easy to blunt the blade. If it is found that the quality and accuracy of the cutting can not be found in the place of this cutter. When the set standard is consistent, the blade must be replaced and a replacement blade must be kept in hand at all times. It can make the work go smoothly. When you need to change the blade, be sure to change it according to the blade. The steps described are correct. In order to avoid injury, the replacement of the blade must be handled carefully and carefully, and safety must be paid attention to.

◆ Blade adjustment.

The blade has 4 sides, each side can be used twice, can be recycled 8 times to find that the blade is too deep, it is necessary to adjust or replace the blade; replace the blade, there are semicircular concave holes on both sides of the blade, and use a screwdriver to insert and pry out the blade.

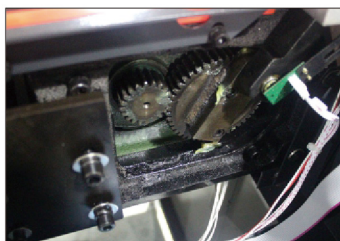
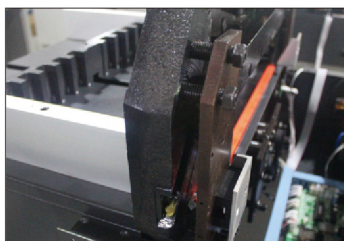
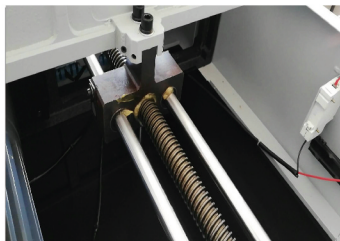
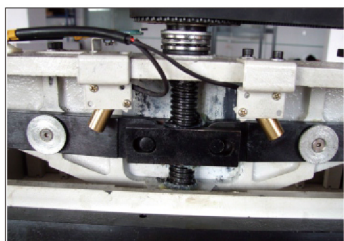
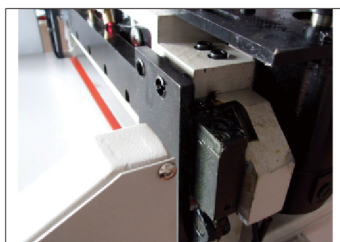
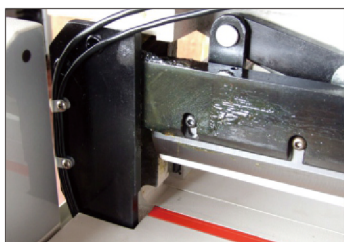


Note: when the blade is changed, the blade itself must be adjusted; if the blade is eaten too deep, it is not only easy to damage the blade, but also

IV. Lubrication and maintenance

1. Lubrication

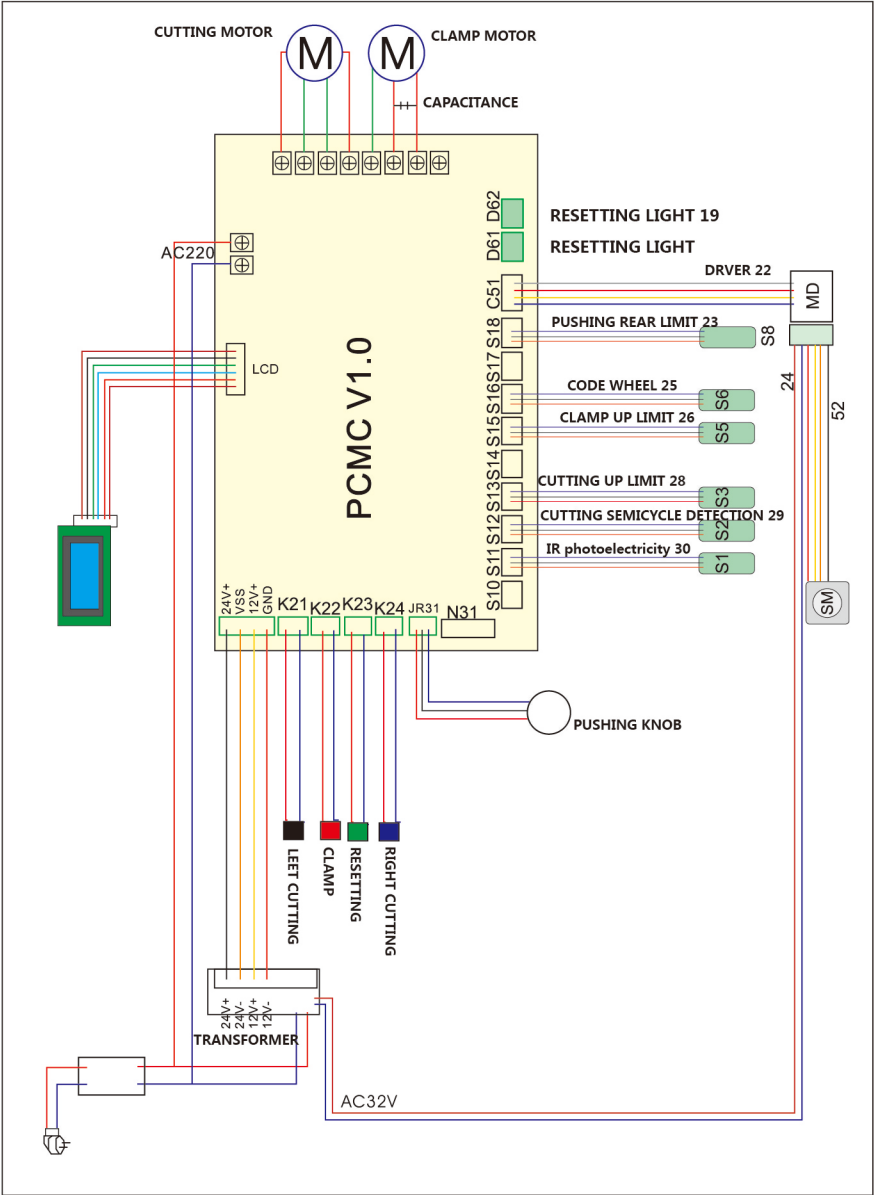
The machine should open the cover every month, check the cleaning, fasten the parts and lubricate the transmission parts once a month. Please be careful to avoid dripping lubricating oil on electrical circuits or electronic components when refueling; in order to avoid failure.



2. Maintenance

When working, it is forbidden to put non-cutting objects on the machine, so as to prevent hard objects from entering the knife and damaging the cutter. Bound books should avoid bringing staples into the cutting area so as not to damage the cutter. After the work is finished every day, wipe the machine, remove debris, and cut off the power supply.

3.Attached drawings



V .Common error and elimination

Error	Phenomena	Solution
Paper cutting is not even or the cutting size is not accurate	The cutting paper is unparallel and has large deviation	Remove the backgauge position offset and loosen the fastening screw to adjust the angle of pushing board.
The blade can not reset or works up and down continuously	All the button is invalid and can not control the blade	1. The sensor's position moves or was damaged. 2.The main board has been damaged
The window can't display or display wrong or can't	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	1. Check the flash 2. Check the control panel
Alarm for displaying E-2	Cut normally,but blade can't return to the original position.	1.Check limit sensor on the blade shelf 2.Check the control panel
Alarm for displaying E-4	Press shelf return abnormal	1.Check limit sensor on the press shelf 2.Check the mainboard
Alarm for displaying E-5	Pressing is abnormal	1.Check pressing motor code-wheel sensor 2.Check the mainboard
Alarm for displaying E-6	Cut normally,but paper pusher pusher can't limit and adjust	1. Check pressing motor backward calibration sensor 2. Check the mainboard

E-1: Photo-electric protection

E-2: error for cutter motor code-wheel sensor

E-4: error for pressing upper limit sensor

E-5: error for pressing motor code-wheel sensor

E-6: error for reset sensor

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 Supply the service of installation ,adjustment,operation,training, periodic maintenance, elimination of error in normal operation and repair.
 - ② Supply to change parts damaged in moral operation,maintain motor and circuit for one year:knife shim and blade belong to expendable supplies,so they are excluded form the maintenance scope.
3. Maintenance should be undertake by the local sales agency.
4. We won' t undertaken 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.