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Warning: This kind of machine is allowed to cut printed paper, books or soft leathers only. It is forbidden to cut any metal sheets or other hard objects which do harm to the machine quality.



Children must not operate this machine.



Do not reach beneath the blade.



Do not extract or transport the materials or blade without protection.



Do not cut hard materials or materials which may splinter.



Paper clips or hard materials will damage the cutting blade.

Note: Please read this manual carefully before use the 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 injury, only professional operator is allowed to operate this machine(children or non-professional operators are forbidden to use). When you use or maintenance these machines, please pay high attention to safety cautions below:



Handling and Placement

As the machine is heavy, please handle it carefully and put it horizontally on the clean ground.



Power

The power source should be steady 380V/220V+10 % , 50Hz, 2.5-3.5KW. Machine may 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 work efficiency.



Ground connection

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



Power overload

Please do not connect many electric equipment at one socket. It is dangerous and may cause fire or electric shock.



Maintenance

Must turn off the power and remove the power plug before you clean or maintenance the machine.



Waterproof

Prevent water or other liquid flow into machine inner side.



Must use socket with ground wire connected.



Air safety switch, non-professional person is not allowed to open, avoid dangerous.



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



Omron PLC control box, non-professional person must not open it.

Content

Warning	1
Safety Cautions	3
Chapter I Safety cautions before installation	6
1. Check machine	6
2. Settlement of the machine.....	6
3. Environmental conditions.....	6
4. Special suggestion.....	7
Chapter II Brief instruction of the paper cutter	8
1. Parts description.....	8
2. Performance features.....	8
3. Principal technical parameter.....	9
4. Operating button and panel.....	9
4-1 Operating button and functions	9
4-2 Program-control and Touch screen.....	10
Chapter III Basic operation and adjustment	12
1. Basic operation.....	12
1-1 Turn on the machine.....	12
1-2 H67P/H80P operation instruction.....	12
2. Basic adjustment.....	13
2-1 Dimension check and adjustment.....	13
2-2 Cutting blade adjustment.....	13
2-3 Blade replacement.....	14
2-4 Cutting stick adjustment.....	15
2-5 Clamping pressure adjustment.....	15
2-6 Hydraulic system troubleshooting.....	15
Chapter IV Lubrication and maintenance	16
1. Lubrication.....	16
2. Maintenance.....	16
Chapter V General failures and troubleshoot	17

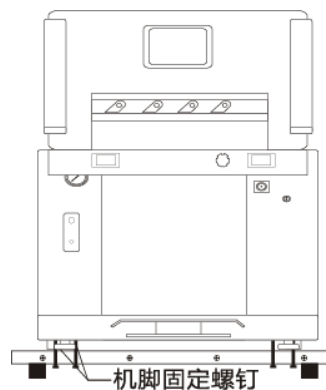
1. Check machine

When you open the package of the machine, firstly please check the machine with relevant accessories. Please contact the dealer if there is any damage or shortage.

- ① Machine 1 set
- ② Operation Manual 1 set
- ③ Tool 1 set
- ④ Maintenance warrant 1 piece
- ⑤ Cutting blade 1 piece
- ⑥ Cutting stick 1 piece
- ⑦ Discharge blade rod 2 pieces

2. Settlement of the machine

⑧ Open the wooden case, take out the machine's packaging and discharge fixed screws on the base plate of the main machine; The hydraulic machine should be unloaded by forklift.



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

3. Environmental conditions

- The machine should be placed in clean working environment, keep away from direct sunlight and wind;
- Temperature of the operating environment: 10-30°C, can not higher than 32°C;
- Humidity level of the operating environment: 50-80%;
- Power supply: 380V/220V+10%, 50-60Hz, 2.5-3.5KW;
- Connect the ground wire correctly.

4. Special suggestions



Remember only one professional operator is allowed to work on the machine;



When your hands or other things into the cutting area, turn off the power immediately;



Two hands operation is needed;



Please do not disassembly infrared safety cover;



When replace cutting blade, you should firmly comply with the blade replace instruction;



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

Chapter II Brief instruction of the paper cutter

1. Parts description



2. Performance features

- ◆ Hydraulic cut and hydraulic paper clamp separately;
- ◆ Heavy duty complete strong design;
- ◆ Air table;
- ◆ Adjustable clamp pressure from 200 – 20,000 N;
- ◆ 100 programs with 32 steps each;
- ◆ 10 inch touch screen full color display;
- ◆ Industrial infrared safety guard;
- ◆ Omron PLC control box;
- ◆ Slotless paper table with ball rollers;
- ◆ AC Servo Motor;
- ◆ Double guide back gauge;
- ◆ Power switch with key lock;
- ◆ Efficient foot pedal;
- ◆ Easy set up and maintenance;

3. Principal technical parameter

	SF-H67P	SF-H80P
Max cut width (mm)	670	800
Min cut depth (mm)	30	
Max cut height (mm)	80	
Cut accuracy (mm)	0.2	
Clamp and cut system	Hydraulic + Foot pedal	
Back gauge control	Programmable	
Air table	Yes	
Display mode	LED touch screen	
Safety protection	CE safety beam	
Power supply	220V/380V, 50-60Hz, 2.5Kw	380V, 50-60Hz, 3.5Kw
Dimension (W*D*H)	1250x1560x1670mm	1730x1760x1350mm
Net weight (kg)	690	790
Gross weight (kg)	750	850

4. Operating button and panel

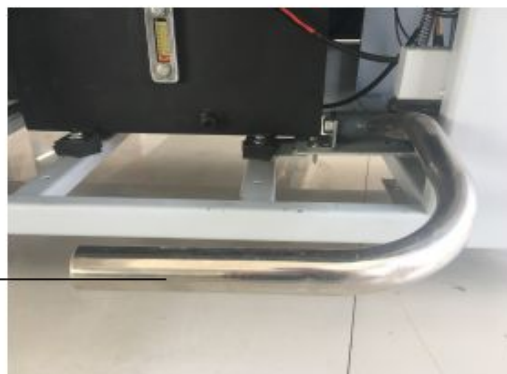
4-1 Operating button and functions

Working platform



Paper cutting button
Two hands operation
is needed

Efficient foot pedal
for pressing paper



4-1-1 Operate figure for cutting

⑨ Wired up, turn the power switch “ON”. Screen and cut position light work, back gauge reset automatically, which means the machine is ready for working.

Operate Way: Stand in front of the machine, with both hands pressing two CUT Buttons at same time. (or downward the foot pedal for clamping make sure cutting position is accurate, then cut the papers) As shown:



4-2 Program-control and Touch screen



4-2-1 Touch screen

1. Numerical mode

Enter the number you want, press “ENTER”, the back gauge will go to the position you want and machine gets to cut, for example, if you want to cut a length of 270.50, enter the number 270.5 in the touch screen and press “ENTER” will make the back gauge go to this dimension and ready for work.

2. Program mode:

100 programs , with 32 steps each. On touch screen, it is production number, production model, number of segments. For A3 paper, you can set the first step to be 297, press “ENTER” to confirm, then set the second step to be 422, press “ENTER” to confirm, for the third step to be 420, press “ENTER” to confirm, select 3 in the numbers of segments. It means this production you have 3 lengths can be set, then press “ENTER” to get machine to cut. In program mode, there is a PUSH key, when it is available, the machine will push the paper 10 cm forwards after each cut (for customers to take out the paper easily). To cancel the function, press the PUSH key then it will be invalid.

3. Section mode

4 parameters to be set: the max length, first length, the second length and third length.

Set the max length same with current size.

After setting the max length, another three lengths can be set: for example, the first one is 10mm, second one is 20mm, the third one is 25mm. As it is, the machine can cut one by one until the paper left is less than 30mm(Minimum cut depth ia 30mm), the back gauge will be back to the original position you set and gets to do next cuts repeatedly. It means the cutter will cut the papers for 10mm, 20mm, 25mm step by step repeated.

4-2-2 System setting

1. Cutting depth

When customers want to cut, if there is one or two papers in the bottom can not be cut completely, you can adjust the cutting depth, there are totally 30 positions to be set, each one means 0.5mm cutting depth. The bigger number set, the deeper cutting does.

2. Original position (Start position) set



When the paper cut dimension is different from the display dimensions, you can adjust the number to fix it, restart the machine after it is done.

For example, the cut paper dimension is 110 mm, while it shows 120 mm on the display. Then we adjust the Original position (Start position) value, it may show 24.5 for example, we need to add 10 mm, set the Original position (Start position) value to 34.5. When the cut paper is 120 mm and display shows 110 mm, set the Original position (Start position) value to 14.5.

4-2-3 Exchange between mm and inch

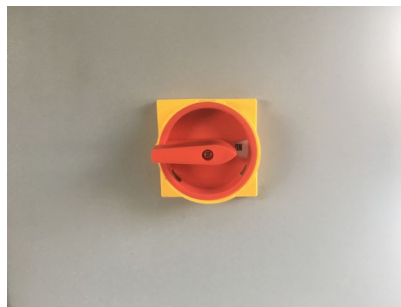
In display, when the paper size is 152.5mm, press the number for inch, same way for change from inch to mm.

Chapter III Basic operation and adjustment

1. Basic operation

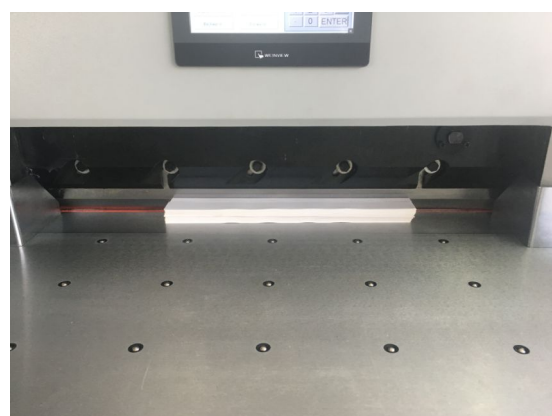
1-1 Turn on the machine

- ◆ Make sure there is nothing else but the papers to be cut, clean the machine firstly;
- ◆ Plug the machine to socket for 380V/220V +/- 10%, 50Hz, 4Kw;
- ◆ Turn on the electric control, turn the main power to “ON” position, screen is on, light of the machine is on, means it is ready for work.



1-2 SF-H67P/H80P Operation Manual

- 1) Electronic wheel use. Clockwise rotation makes the back gauge move forwards. Anticlockwise rotation makes the back gauge move backwards. The accuracy can reach 0.1 mm.
- 2) When put the paper or books on the machine, make sure they are tidy and aligned against the left side of the machine and scale.



3) After the cut size confirmed and paper put in the right position, downward the foot pedal, clamp the papers, both two hands on the cut buttons to start cutting. Or you don't have to use the foot pedal, only to press the cut buttons with two hands to start the clamp and cut automatically. If you find anything wrong, release the cut bottom to stop the clamp and blade, press only clamp back switch to make the clamp up, make sure everything is right then cut.



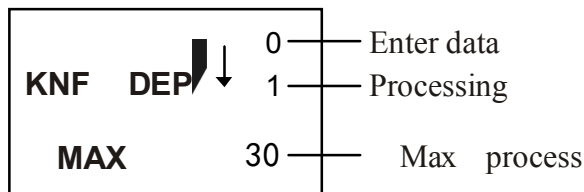
4) When finishing cut, press “PUSH” key to push the papers or books out(if you have set push function it will be done automatically after every cut), then a cut is completed.

2. Basic Adjustment

2-1 Dimension check and adjustment (within +/- 5mm)

2-2 Cutting blade adjustment

A◆ Enter the system setting mode: it will show blade depth adjustment, back gauge start position amendment.

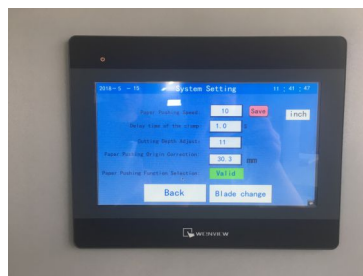


(1) Tap system set button on the screen to enter into the setting mode

(2) Tap button for cutting depth adjustment

(3) Make the processing after confirmed

B◆ Turn to blade change, as follows



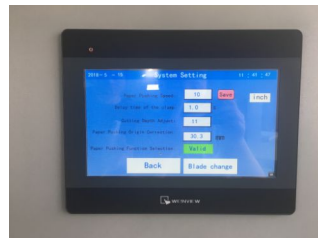
- ◆ Enter data in the blank of “Cutting Depth Adjust”. 30 positions to be set, each one means 0.5mm cutting depth.
- ◆ After fixed well, take another one piece paper to test, until the paper can be cut completely.
- ◆ Then press and hold “Back” 3s for new cut.

Three functions:

1. Blade depth adjustment: When the last sheet can not be cut completely, this function can be choose, there are 30 number to adjust with max adjust depth can be 10 mm.
2. Blade start position set: When the real cut dimension is not same with dimension the screen display, we need to amend the start position. Enter this interface. For example, when real dimension is 99.50mm, while display dimension is 100.00mm, and the back gauge start position is 5.00mm, then we set the back gauge start position to 5.50mm. After it backs, turn off the machine wait 3 second, then turn on the machine, the back gauge will update the new start position accordingly.
3. Back gauge pushing function: When the back gauge pushing function is in validation in the digital control mode, after each cutting step, the back gauge move forward 100 mm automatically. Tap the validated button on the screen one time, to cancel the function.

2-3 Blade change (Be more careful to operate)

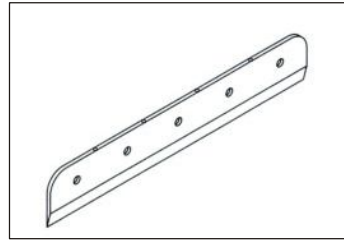
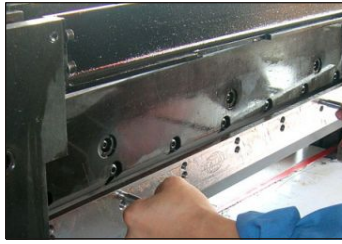
- ◆ Go to “System Setting” as follows, press “Blade change”



- ◆ Press cut buttons, the blade comes down;
- ◆ Release two open notched fasten screw(see 1) on the blade carrier;



- ◆ Take off the fasten screws, except No 2 screw;
- ◆ Press cut buttons, blade rises, revolve two screws clockwise, take off other fasten screws including No 2;
- ◆ Revolve the two screw stems anticlockwise for half circle, then take out the blade. Please wear gloves or use cotton cloth to wrap the blade to avoid being hurt;

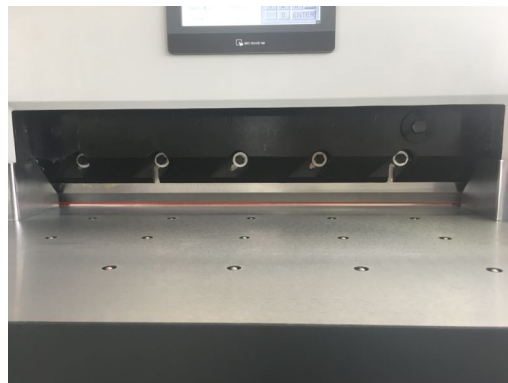


- ◆ Be careful when taking a new blade out. The blade cutter pointing must not be to the body. When installing the blade, screw up the screw stems. Set the blade on the blade carrier, use screw strip to fasten and fix up, then adjust it according to cutting depth adjustment method.
- ◆ Do blade sharpening in a professional factory.

Note: Cutting thick paper or pasteboard frequently will make the blade dull. Prepare one replacement on hand. Be careful when change the blade.

2-4 Cutting stick adjustment

- ◆ One cutter stick can be used for 8 times;
- ◆ Adjust or change the stick if deep slash;
- ◆ Reinstall the stick flat on cutting desk after taken out;
- ◆ Set cutter stick lean to the left side;



Note: Adjust blade after changing cutter stick for service life.

2-5 Pressure adjustment

- ◆ Press cut switches with both two hands, the clamp will be down to compress the paper, showing pressure in the pressure meter. Standard pressure is: 30KG/CM²~50KG/CM².
- ◆ Clockwise rotation, higher pressure; anticlockwise rotation, lower pressure.



- ◆ New pressure will be show after press clamp or cut buttons

2-6 Hydraulic system troubleshooting

1. System noisy after starting the machine
 - 1) Lack of oil, add 32# or 46# hydraulic oil
 - 2) Oil filter blocks, clean up the oil filter
2. Under pressure
 - 1) Check connect joints of the hydraulic system to avoid leak.
 - 2) Abnormal electrical motor or wrong voltage.

Chapter IV Lubrication and maintenance

1. Lubrication

Check machine every month. Open the cover plate, clean and fasten parts and oil in moving parts. Don't drop oil on electric circuit or electronic components.

2. Maintenance

- 1) Before work, Keep machine clean to avoid hard objects to damage the blade. Don't cut book with staples.
- 2) Work done, clean machine, remove debris, wax cutting blade and cut off the power.

Chapter V General failures and troubleshoot

Error	Phenomenon	Troubleshoot
No power	Indicate light doesn't bright	1. Check the power socket 2. Check the switch 3. Check the power wire
Motor capacitor is damaged	Abnormal pressure or motor sound	Change the capacitor
Large error in paper cutting	Cut paper is not neat	Displacement of block gauge, loosen the fastening screws, with straightedge to adjust the angle of scale and pushing cardboard, fixed screws again.
Blade won't go back to the top position or continuous work up and down	Button is invalid, continuous up and down	1. Displacement or damaged of the blade carrier limit sensor. 2. PLC is damaged.
Touch screen is abnormal	Power supply button is invalid	Check the touch screen, PLC and electronic parts
Parts of the numerical circuit is damaged	No movement of the back gauge	1. Check the stepper motor and driver 2. Check the PLC
	Button is invalid and can not cut	1. Check the security photoelectric 2. Check the PLC
	Can cut, but blade can not go back to the to position	1. Check the top blade carrier limit sensor. 2. Check the PLC
	Can cut, but cutting depth can't be adjusted	1. Check the bottom blade carrier limit sensor. 2. Check the PLC
	Clamp can't be in the normal position	1. Check the top clamp limit sensor 2. Check the PLC
	Can cut, but back gauge is abnormal	1. Check the rear limit sensor of the back gauge 2. Check the PLC