



P4505 Guillotine Operation Manual



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1. Safety Rules

The machine has many safety features which make it a safe to operate. Regardless of your experience, safety instructions must be read carefully, completely understood, and applied to your daily work habits. If you do not understand or are confused by certain safety instructions presented in this manual, discuss them with your supervisor. Machine setup, cleanup, and maintenance operation will vary. Therefore, it is essential all employees to practice safe work habits. **SAFE WORK HABITS PREVENT INJURIES.** The main rule to follow is to **ALWAYS** make sure the main drive is **STOPPED** and **LOCKEDOUT** when performing setup, cleanup, adjustment and maintenance operations.

The safety precautions in this manual provide guidelines for the protection and for that of fellow workers.

1.1 Precautions

Before any maintenance is performed on the machine, switch off all sources of electrical; do not operate the equipment when panels and safety covers are not in place. Failure to observe this warning could result in personal injury.

1.2 Avoid Accidents

Most accidents are caused by the failure of some individual to follow simple and fundamental safety rules and precautions. For this reason, most accidents can be prevented by recognizing the real cause and doing something about it before the accident occurs. With any machinery, a careful and trained operator is the best insurance against an accident.

1.3 Safety Issues & General Safety Rules

DO	DO NOT
1. Read and understand this manual before attempting to operate or service the machine.	1. Do not attempt to operate or service the machine without reading and understanding this manual.
2. Be familiar with the machine safety rules and practices.	2. Do not remove the safety devices.
3. Warn others of an intended action that may endanger them.	3. Do not clean or lubricate moving parts of a machine that is running.
4. Perform lubrication and oiling of the machine only when power is off.	4. Do not unauthorized persons to operate the machinery.
5. Verify that all guards are installed before operating the machine.	5. Do not place tools on a machine that is running.
6. When working on electrical	6. Do not reach into the machine to make

equipment, power must be shut off to all circuits before any work is attempted. Individual switches must be opened and the equipment circuits tested to make sure there is no power.	adjustments while it is running.
7. Be sure all operators are aware of all areas and operations that require extra safety measures.	7. Do not allow horseplay in the work area

1.4 AC Supply

1.4.1 Voltage steady state voltage: 0.9 to 1.1 of nominal voltage.

1.4.2 Frequency 0.99 to 1.01 of nominal frequency continuously; 0.98 to 1.02 for short time.

1.4.3 Harmonics distortion not exceeding 10% of the total r.m.s. voltage between live conductors for the sum of the 2nd through to the 5th harmonic.

1.4.4 Voltage Interruption Supply interrupted or at zero voltage for not more than 3ms at any random time in the supply cycle with more than 1 s between successive interruptions.

1.4.5 Voltage dips not exceeding 20% of the peak voltage of the supply for more than one cycle with more than 1 s between successive dips.

1.5 General Physical Environments

1.5.1 The minimum requirement for all electrical equipment is correct operation between air temperature of +5° C and +35° C.

1.5.2 Electrical equipment is capable of operating correctly when the relative humidity does not exceeding 50% at a maximum temperature of +45° C.

1.5.3 Electrical equipment is capable of operating correctly at altitude up to 1000m.

1.5.4 Electrical equipment is designed to withstand to protect against the effects of transportation, and storage temperature within a range of -25° C to +55° C and for short periods not exceeding 24 hours at up to +70° C.

1.5.5 Avoid exposing to vibration environment.

1.5.6 Avoid exposing to direct sunlight or heat rays.

1.5.7 Have to connect to the factory grounding system correctly.

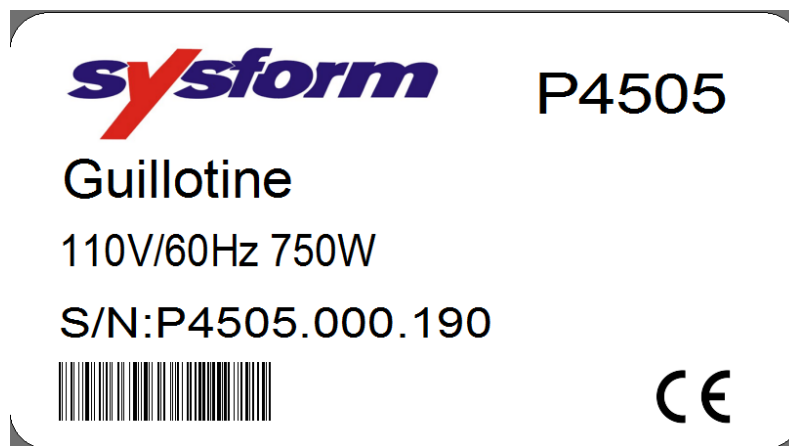
1.5.8 Away from electric magnetic interference source sites, such welding, discharge machine.

2.Specifications

Specification	P4505
Cutting Width	17.72"
Cutting Height	1.97"
Narrow Cut	1.57"
Power Supply	110VAC, 50/60Hz, 8A
Dimensions (H x W x D)	42.91" x 31.50" x 26.38"
Weight	198.4lbs

Note: A dedicated AC power line is required.

3.Name Plate



4. Accessories

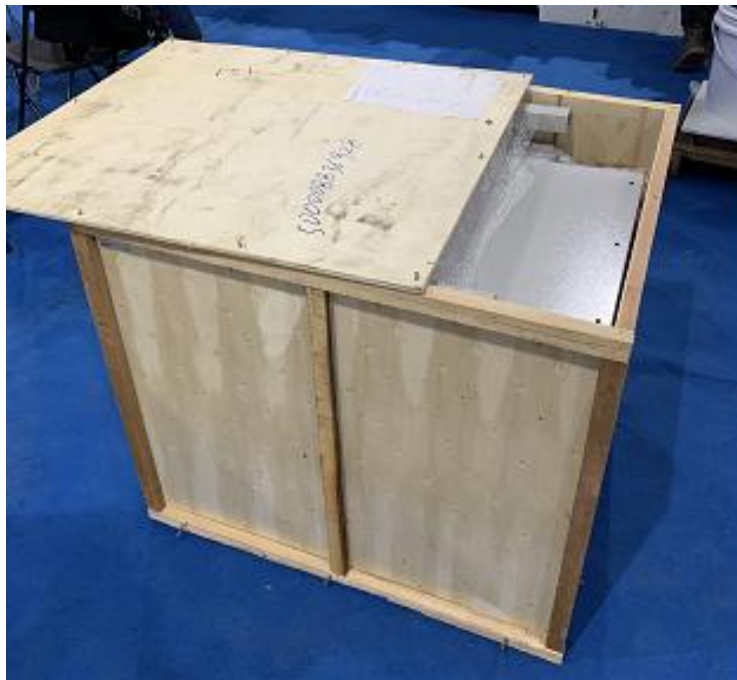
4.1 Blade Replacement Tool.



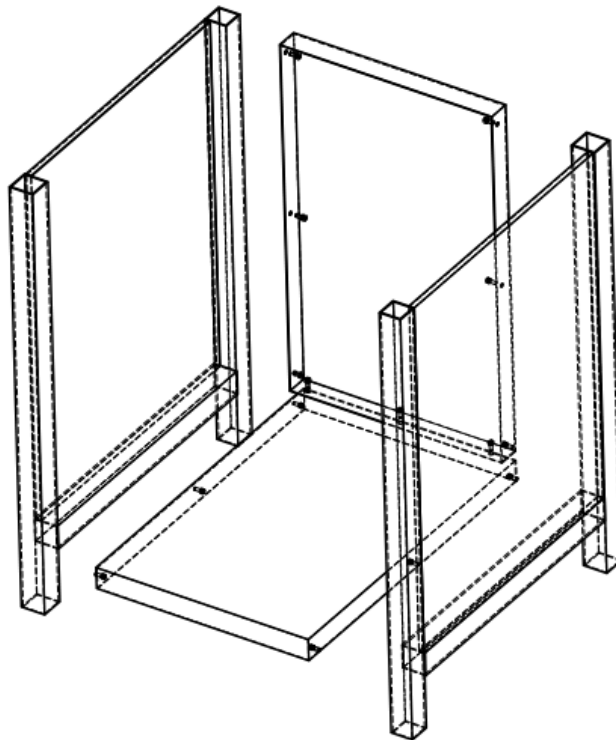
5. Installation

5.1 Cabinet installation

5.1.1 Remove the top cover of the wooden case to take all parts for the cabinet out.



5.1.2 Install the cabinet referring to the illustration.



5.2 Loosen all screws around the bottom of the wooden case then take away the cover to access the main body of the machine.



5.3 Two people at least put the machine onto the cabinet.



5.4 Install the door to the cabinet.







6. Key Components



7. Control Panel and Function Keys





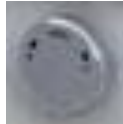
Function Key	Function
	Back gauge goes backward. Press it once and the back gauge will go 0.1 unit length. Press it and hold all the time and the back gauge will go faster and faster continuously.
	Back gauge goes forward. Press it once and the back gauge will go 0.1 unit length. Press it and hold all the time and the back gauge will go faster and faster continuously.
	Clamp & Blade reset to the top position
	Back gauge eject the sheets out then goes back to the origin position

8. Reset The Back Gauge

8.1 Switch on the circuit breaker behind of the left of the machine then switch on the main power switch. The back gauge will go to last position automatically.

9. Cutting Procedure


9.1 Manual Cut


9.1.1 Use the buttons   or the hand wheel  to bring the back gauge to the desired position.

9.1.2 Load the sheets against back gauge.


9.1.3 Press 2-hand cutting buttons until the sheet pile is fully cut.

9.1.4 Release two cutting buttons

9.1.5 After sheets have been cut, press  to eject the sheets out. Back gauge will be back to the origin position.

9.1.6 To set the auto eject function: press  and hold until the machine beeps then release the button. After setting this function the sheets will be ejected out automatically for each cut. To cancel the auto eject function, repeat this setting procedure.

9.2 Setting Size Cut

9.2.1 Enter the length from keypad, then press  to bring the back gauge to the desired length.

9.2.2 Load the sheets against back gauge.


9.2.3 Press 2-hand cutting buttons until the sheet pile is fully cut.

9.2.4 Release two cutting buttons

9.2.5 Auto eject function: See above 9.1.6.

10. CM and Inches Exchange



10.1 Key in “111.2” Press  and hold until the machine beeps then release the button.

10.2 Restart the machine.

11. Cutting Depth Adjustment

If the last sheets can't be cut completely,

11.1 Put 1 paper covering the cutting stick.

11.2 Use 2-hand cutting button to bring the blade down. Release the left hand as soon as the blade cut into the paper then switch off machine.

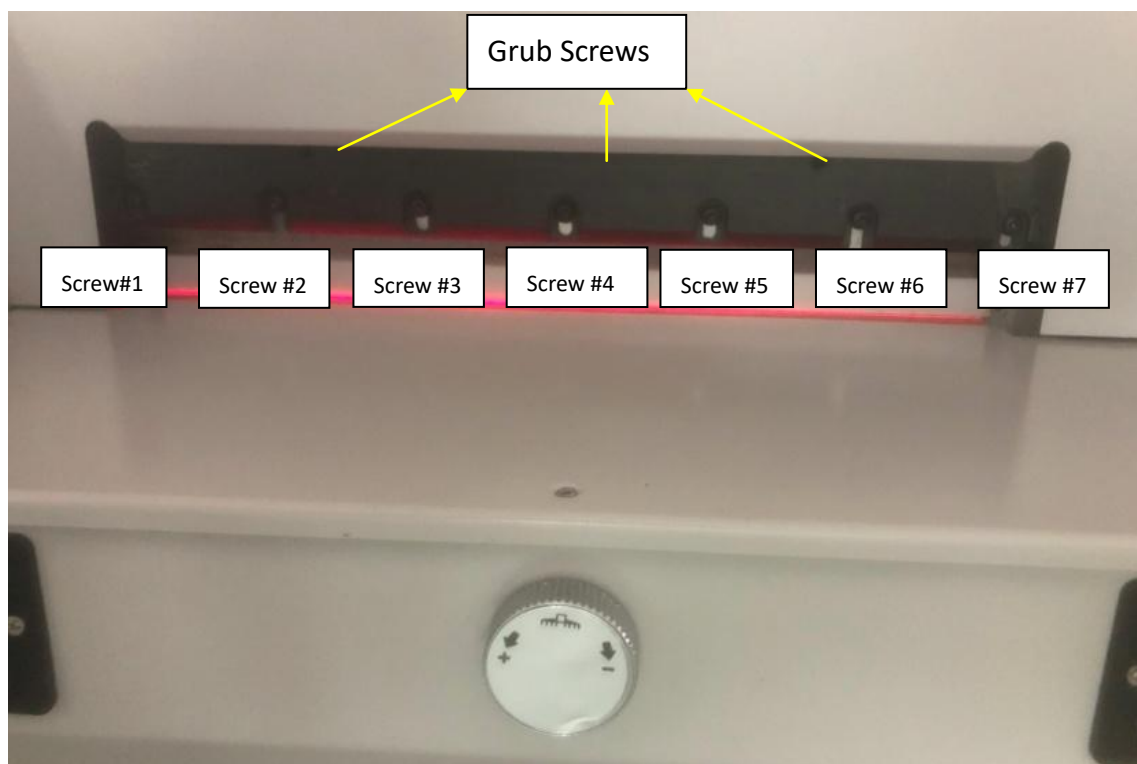
11.3 Loosen 7 screws a little bit from the knife carrier. (refer to below 12 photo)

11.4 Turn the 3 grub screws clockwise from the top of knife carrier to let the blade cut the paper through evenly.

11.5 Fasten the knife 7 screws tightly and secure.

11.6 Switch on the machine.

12. Cutting Blade Replacement



12.1 Use 2-hand cutting button to bring the blade down. Release the left hand as soon as the blade cut into the stick then switch off machine.

12.2 Rotate the 3 grub screws counterclockwise to disengage it with blade.

- 12.3 Use 2-hand cutting button to bring the blade down. Release the left hand as soon as let far right #7-screw exposes then switch off machine.
- 12.4 Remove screw #7.
- 12.5 Remove the #2 and #6 two screws.
- 12.6 Screw blade replacement tools onto blade screw holes #2 and #6 tightly.
- 12.7 Remove screw #1, #3 and #5.
- 12.8 Loosen the blade replacement tools and remove the blade from blade carrier.
- 12.9 Install blade replacement tools onto the new blade mounting hole #2 and #6 half way in.
- 12.10 Install new blade onto blade carrier and fasten blade replacement tools.
- 12.11 Fasten screw #1,#3,#5 and #7 half way in.
- 12.12 Remove blade replacement tools.
- 12.13 Fasten screw #2 and #6 half way in.
- 12.14 Place 1 paper covering the cutting stick.
- 12.15 Use 2-hand cutting button to bring the blade down. Release the left hand as soon as the blade cut into the paper then switch off machine.
- 12.16 Fasten screw #7 half way in.
- 12.17 Turn the 3 grub screw on the top of blade carrier clockwise to let the blade cut the paper through evenly.
- 12.18 Fasten #1,#2, #3, #4,#5,#6 and #7 screw tight and secure.
- 12.19 Switch on the machine.

13.Cutting Stick Replacement

- 13.1 While blade is on home position, switch main power off.
- 13.2 Turn the cutting stick around, the stick can be used 8 times, each surface can use 2 times.

Attention: Consider adjusting the blade perfect position when changing a new cutting stick (refer to 11)