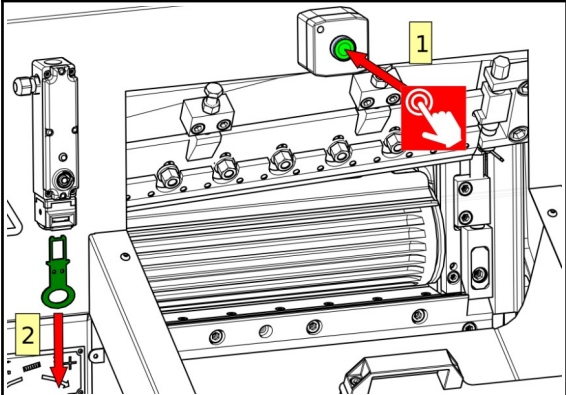
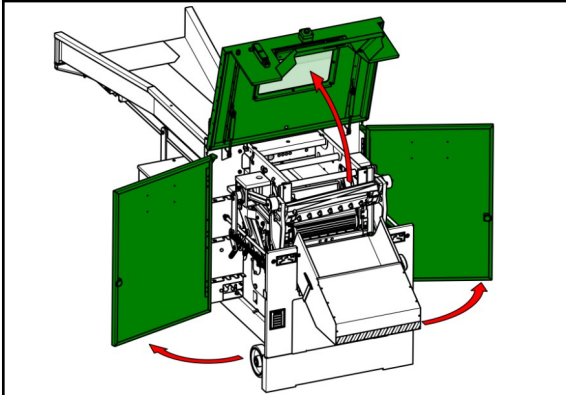
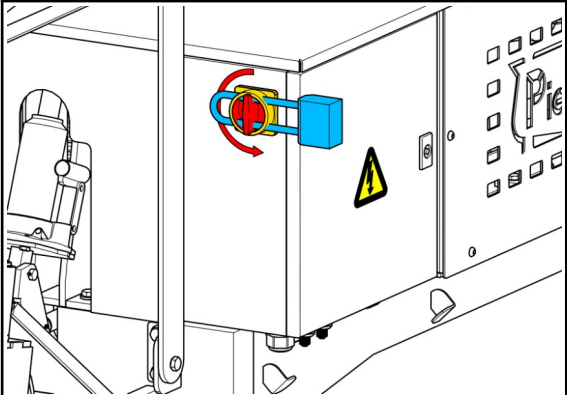

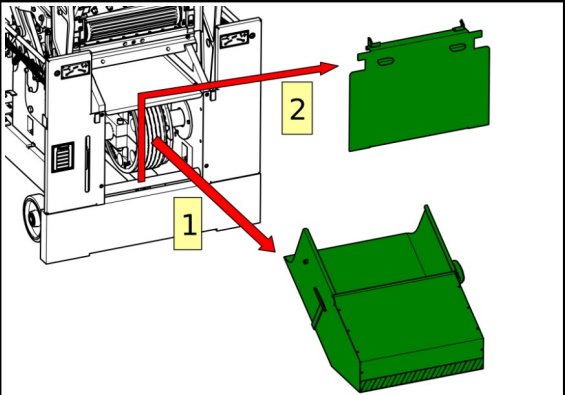
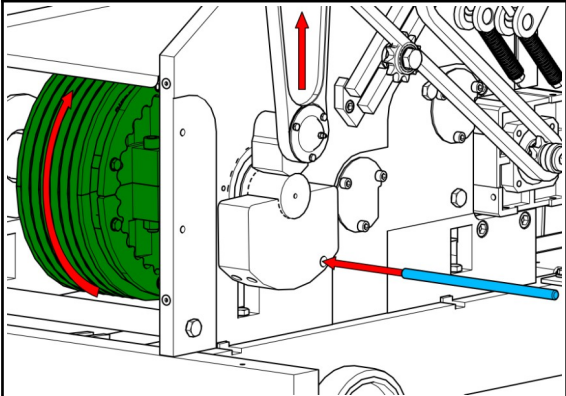
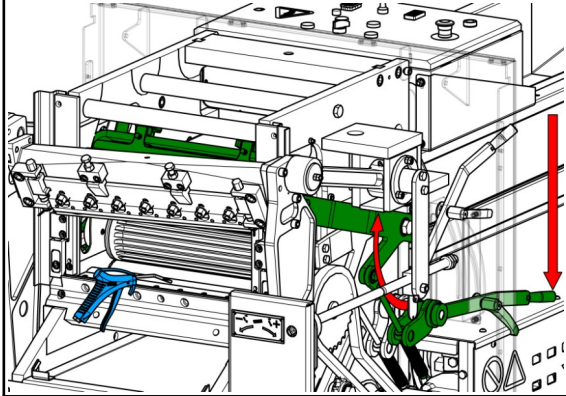
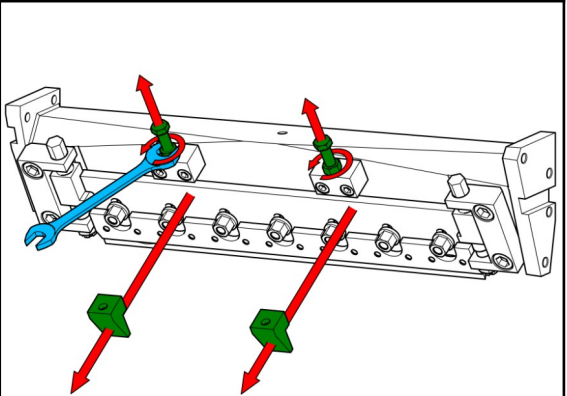
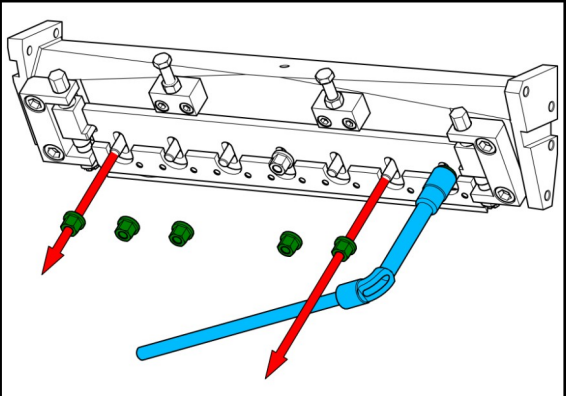
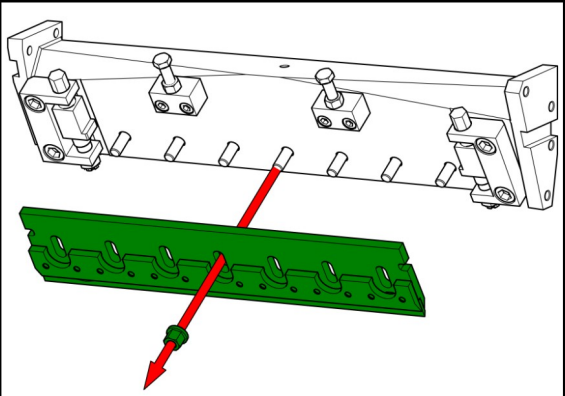
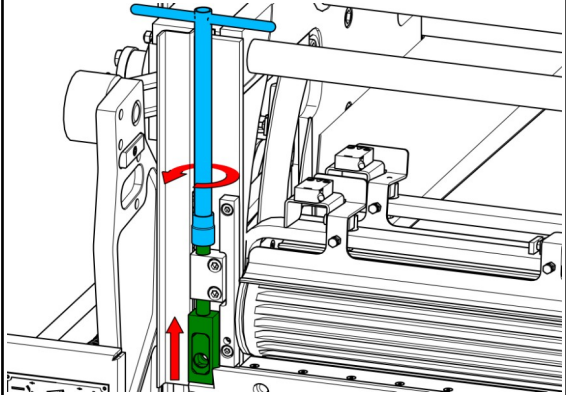
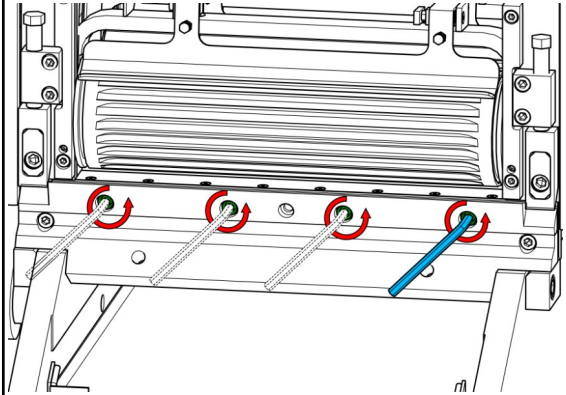
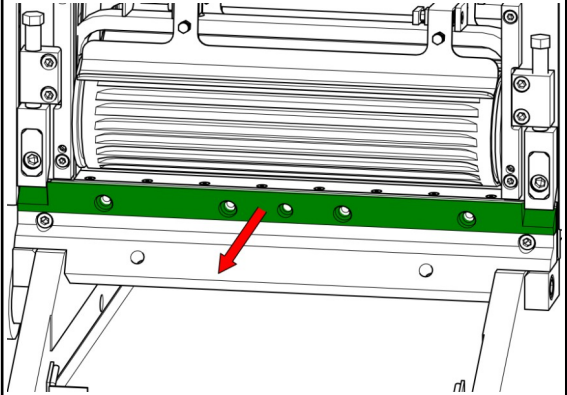
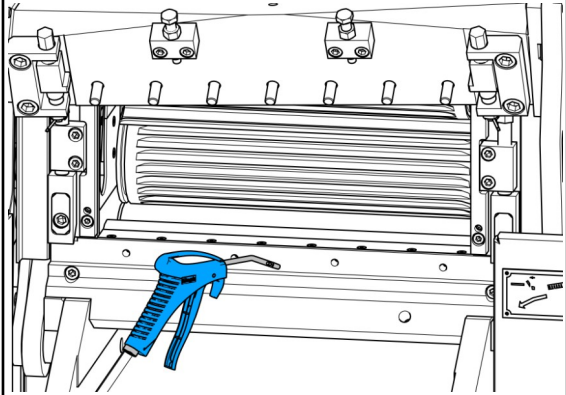
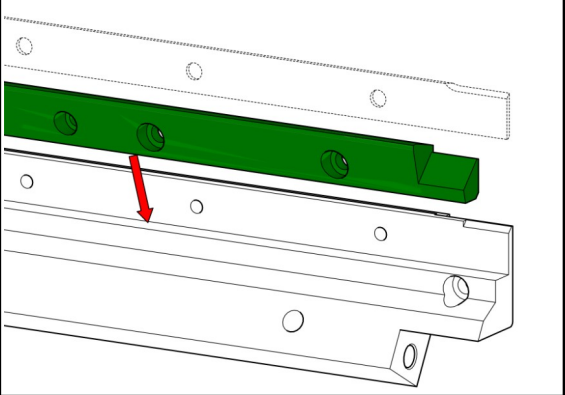
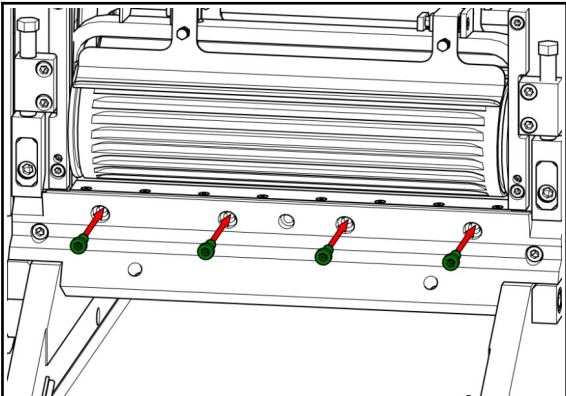
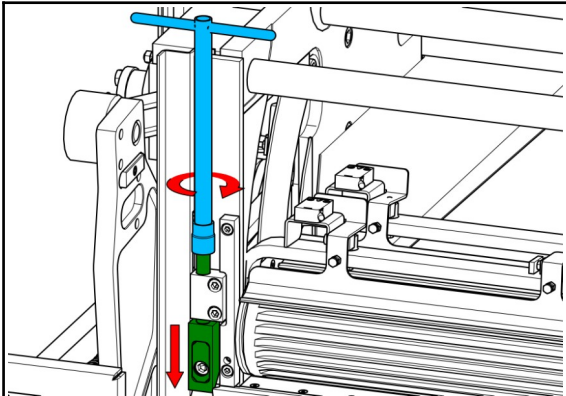
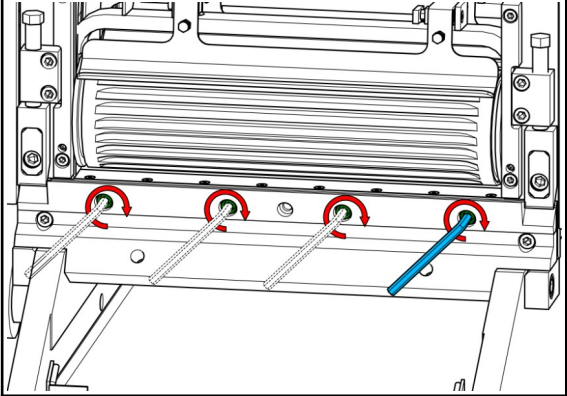
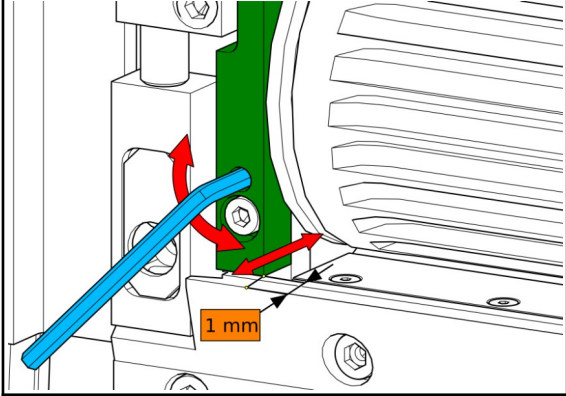
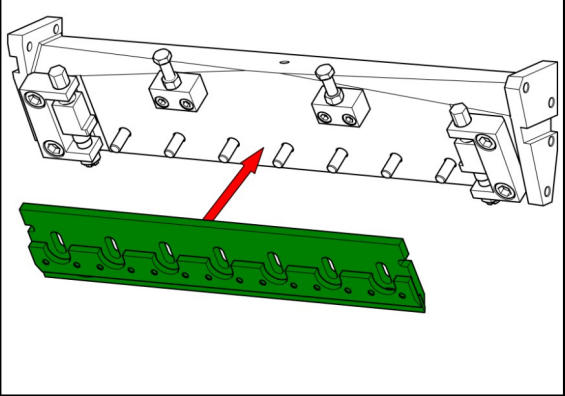
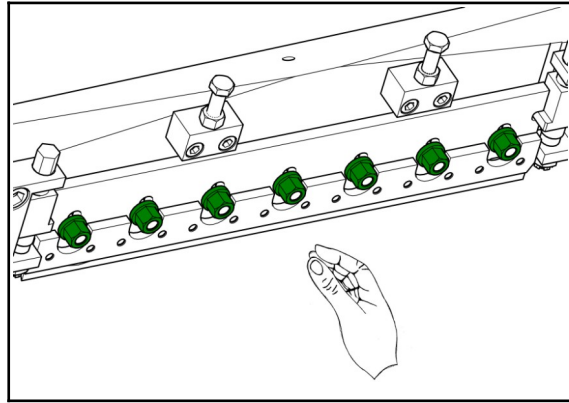
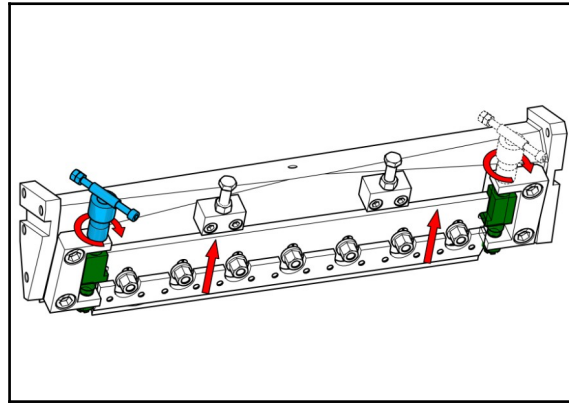


<p>1 Unlock and remove the safety key.</p> 	<p>2 Lift up the front cover and open the large side doors.</p> 	<p>3 Turn off the power supply at the disconnecting switch and fasten one padlock.</p> 	<p>4 Put suitable gloves.</p> 	<p>5 Remove the exit chute and the central front guard.</p> 
<p>6 Position the cutting system in the upper position and block it with the safety bar.</p> 	<p>7 Lift the front roll and block it. Clean the machine and its workspace.</p> 	<p>8 Remove the mobile knife thrust blocks.</p> 	<p>9 Remove the nuts except the center one.</p> 	<p>10 Maintain the mobile knife, remove the center nut, remove the knife.</p> 
<p>11 Loosen the screws and move the clamps upwards.</p> 	<p>12 Remove the 4 fixing screws of the fixed knife.</p> 	<p>13 Remove the fixed knife.</p> 	<p>14 Clean the location of the knives, if necessary with sand paper.</p> 	<p>15 Fit the new fixed knife with some shims if necessary.</p> 
<p>16 Place the 4 fixing screws of the fixed knife without tightening them.</p> 	<p>17 Tighten the 2 clamps.</p> 	<p>18 Tighten the 4 fixing screws of the fixed knife.</p> 	<p>19 Adjust the 2 material guides ± 1 mm away from the edge of the fixed knife.</p> 	<p>20 Place the mobile knife on the blade holder.</p> 

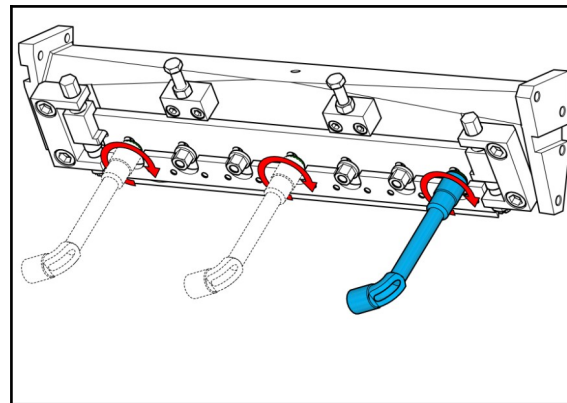
21 Tighten the nuts by hand.



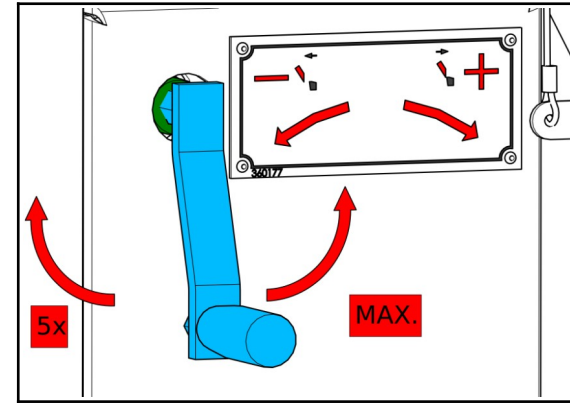
22 Turn the adjusting screws to position the knife at its highest point on the blade holder.



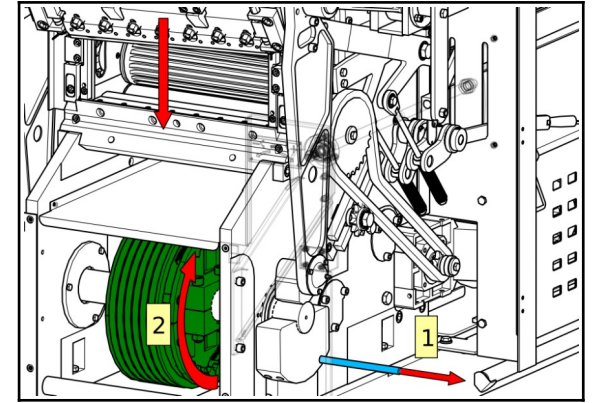
23 Slightly tighten the center nut and the 2 outer nuts.



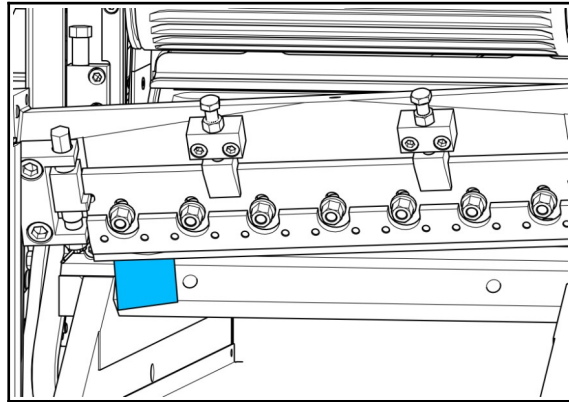
24 Turn the adjusting rods completely in the - direction then 5 turns in the + direction.



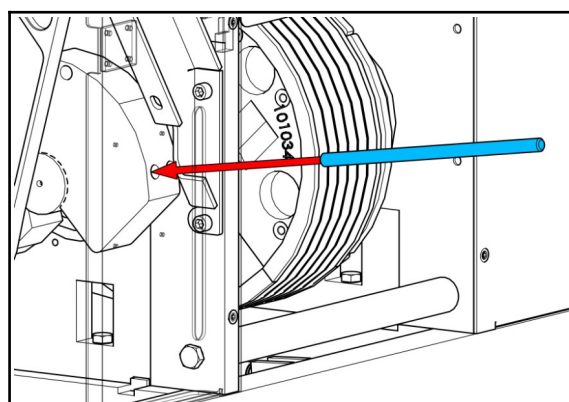
25 Remove the safety bar. Turn the wheel to place the blade holder to the low position.



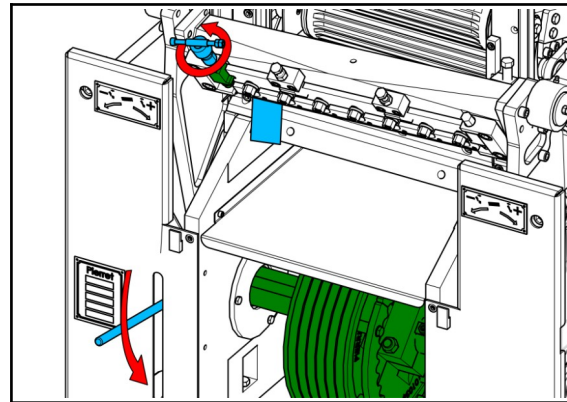
26 Fold a piece of paper in 8 plies and place it at the left side intersection of the knives.



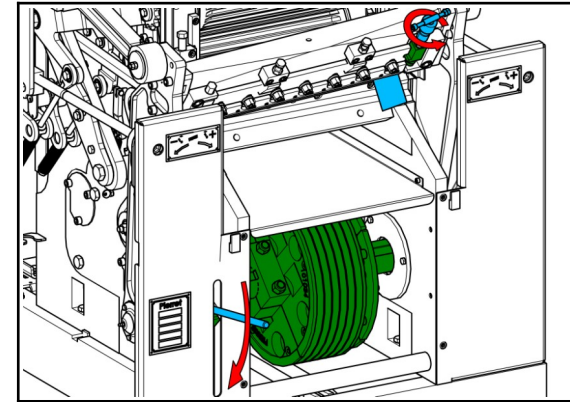
27 Insert the bar into the left side crankshaft.



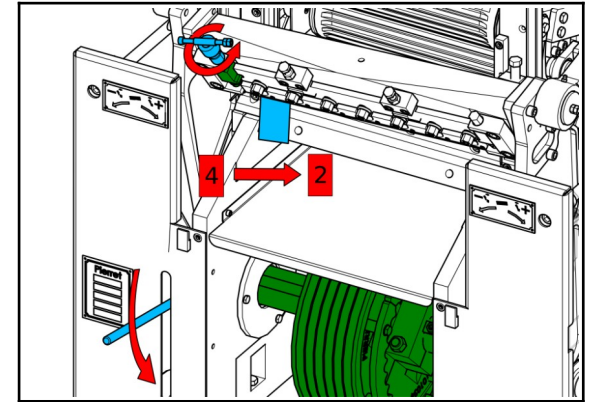
28 Operate the bar. Turn the left side adjusting screw until the papers are pinched.



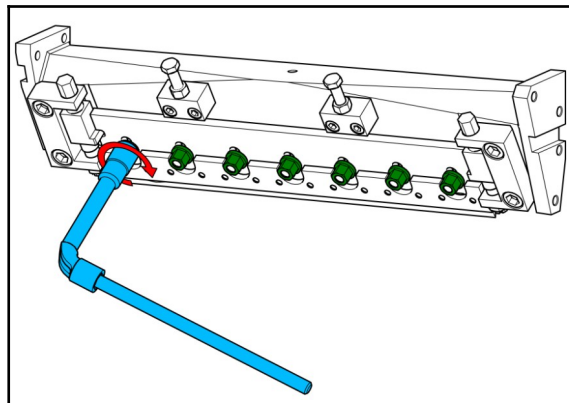
29 Repeat the process to the right side.



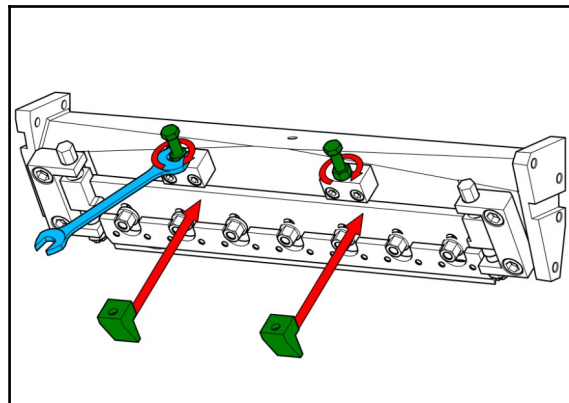
30 Repeat the adjustment on the left and right side with 4 then 2 papers.



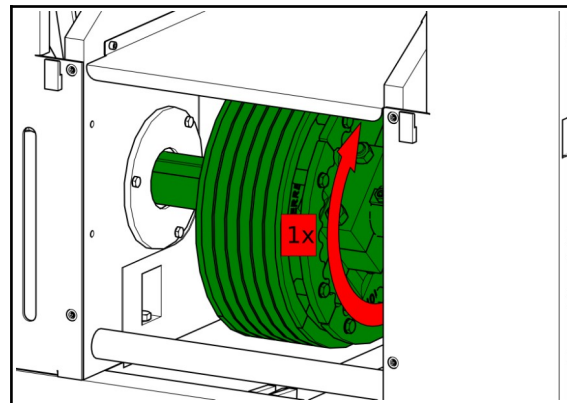
31 Tighten the nuts firmly (135 Nm).



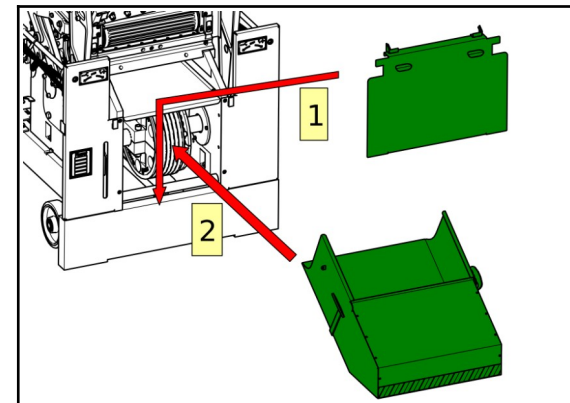
32 Place the stops of the mobile knife. Tighten slightly the screws and lock the nuts.



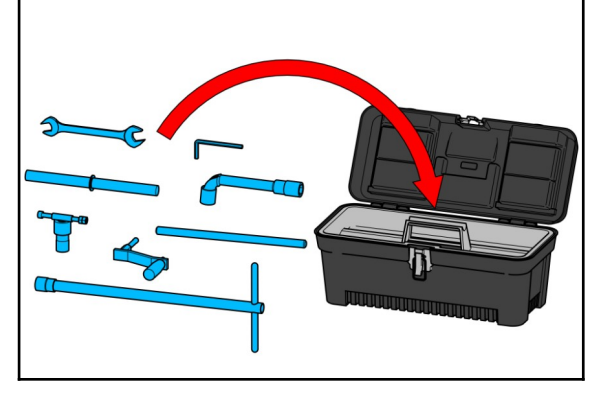
33 Do manually one full turn of the cutting system (arrow direction).



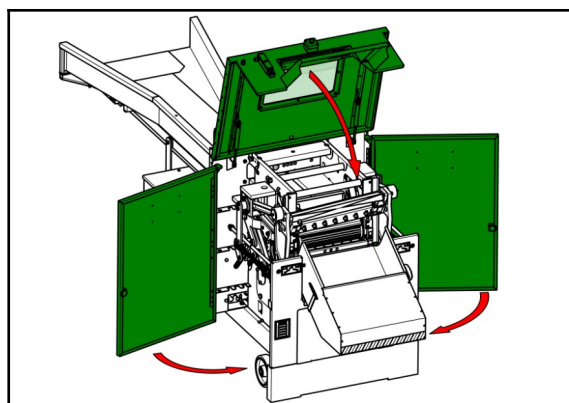
34 Put back the front guard and the exit chute.



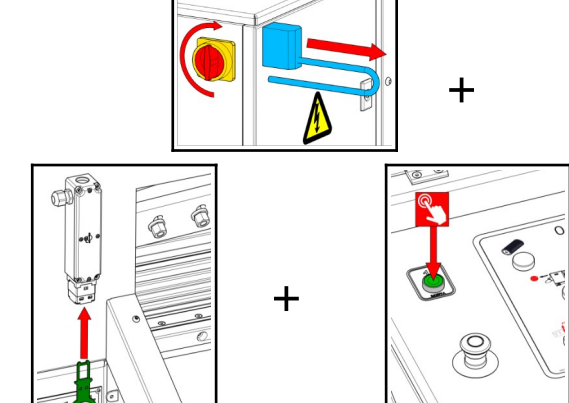
35 Put the tools in the toolbox.



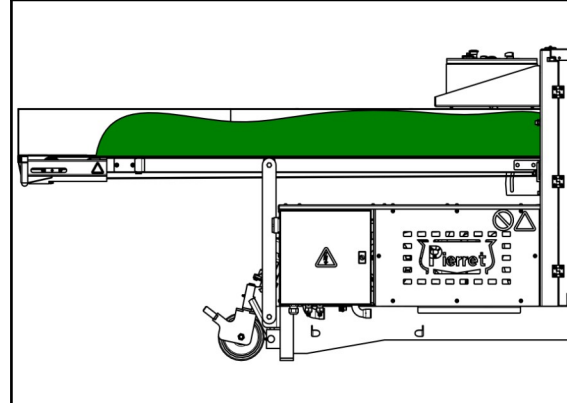
36 Close the large side doors. Lower the front cover.



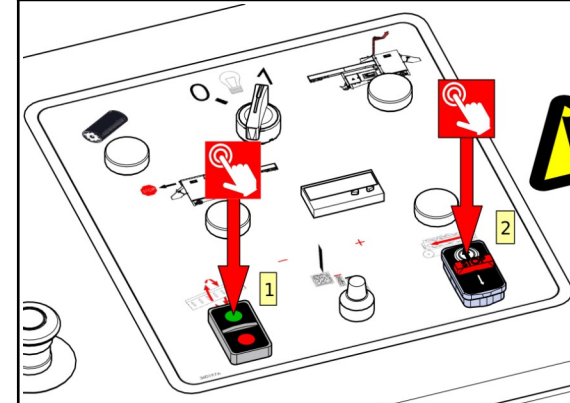
37 Put the machine in working order.



38 Place some material over the whole width of the feeding belt.



39 Start the cutting system and the feeding system.



40 Turn the adjusting rods in the + direction to obtain a clean cut.

