

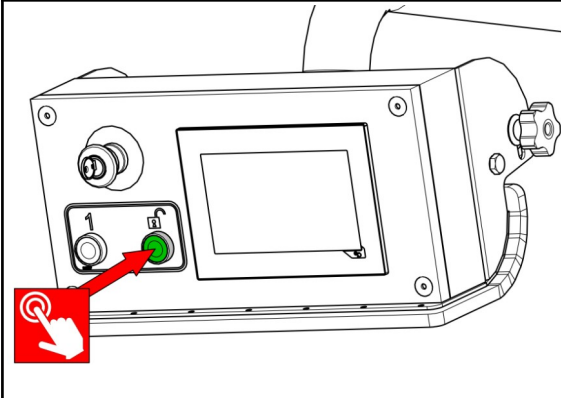
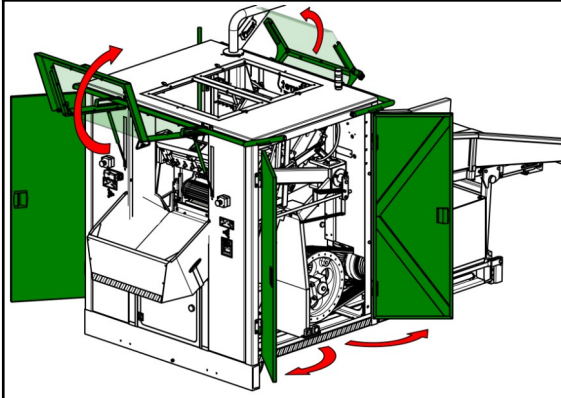
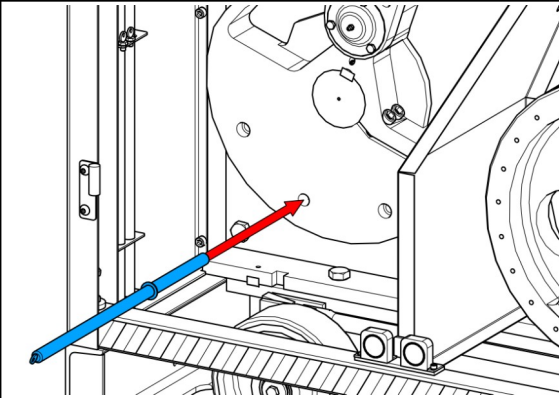
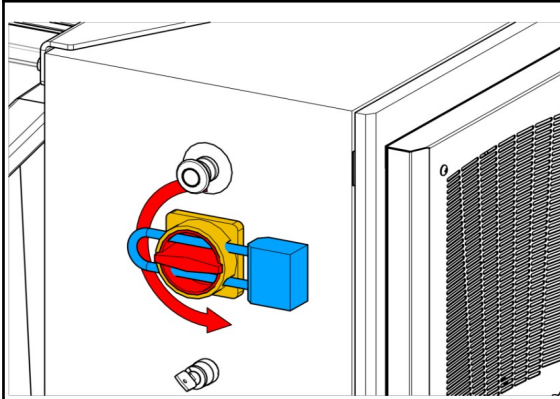

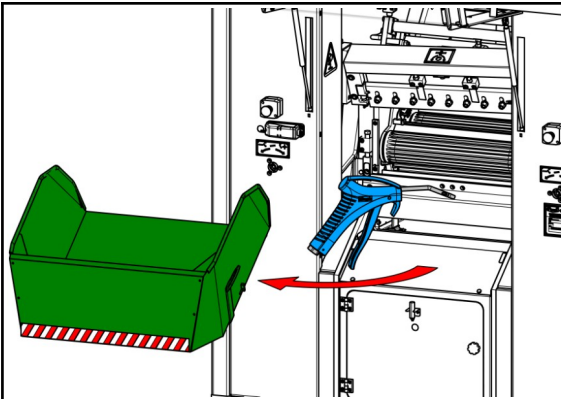
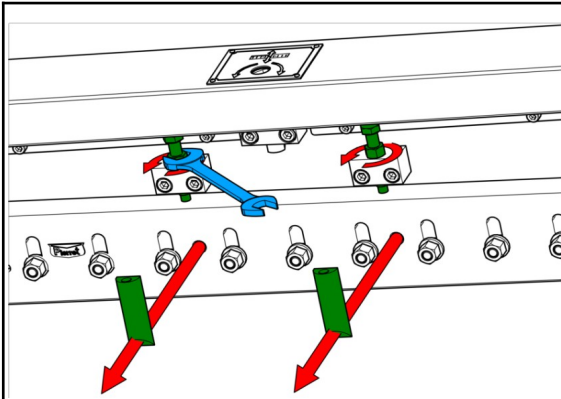
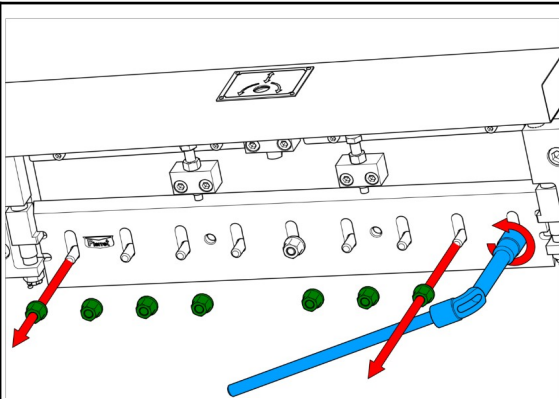
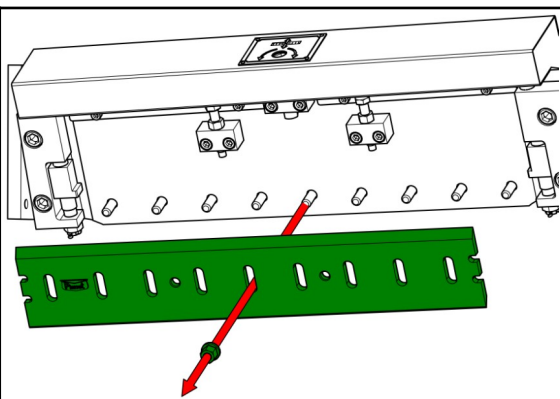
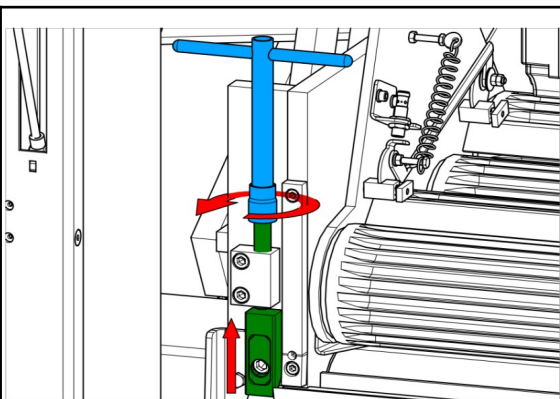
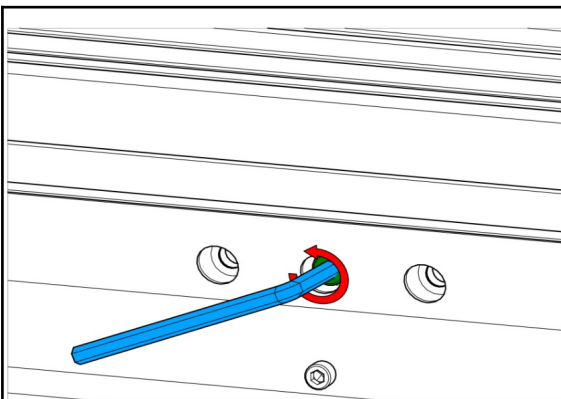
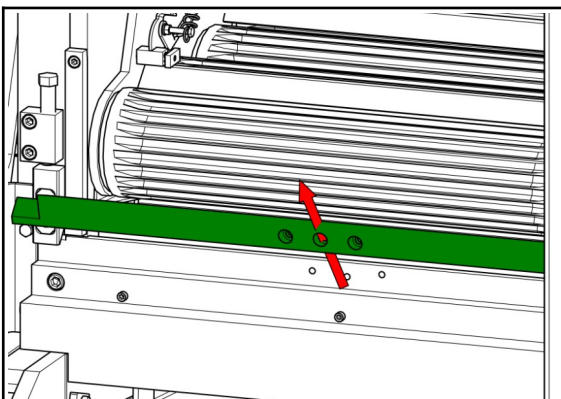
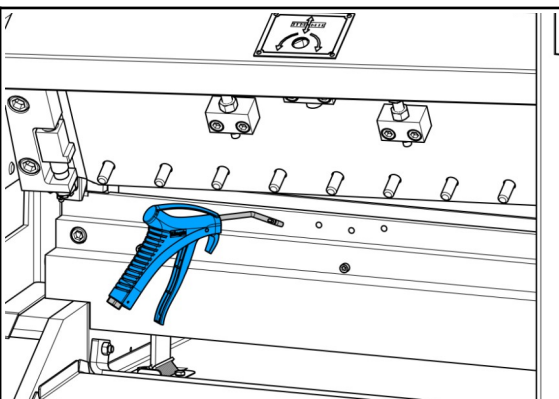
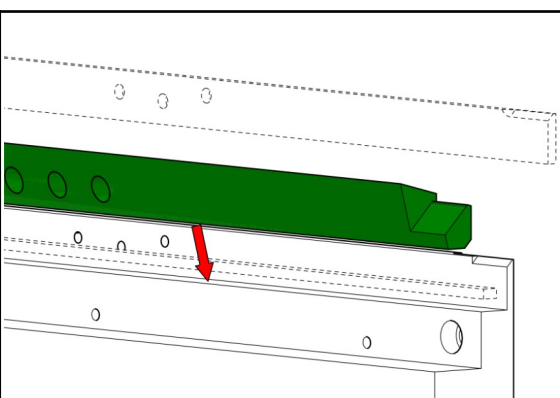
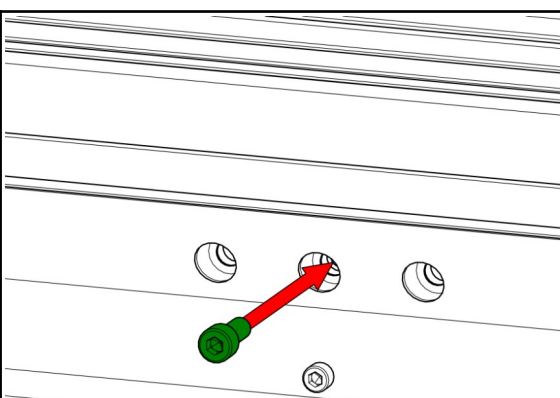
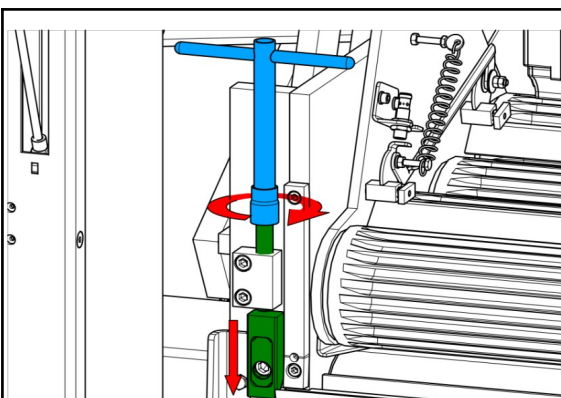
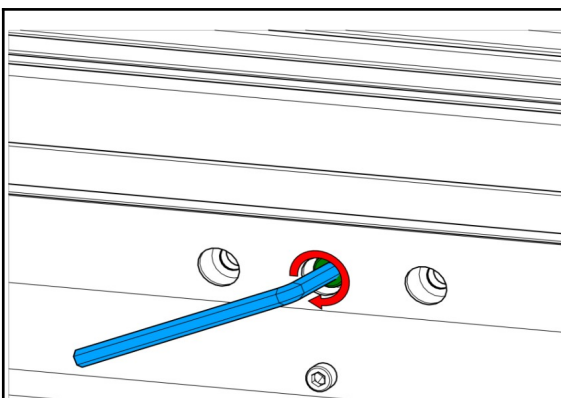
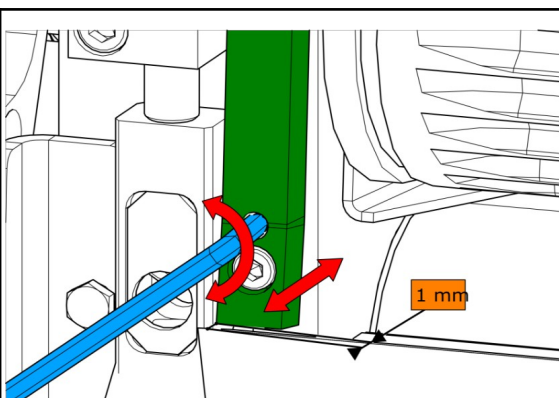
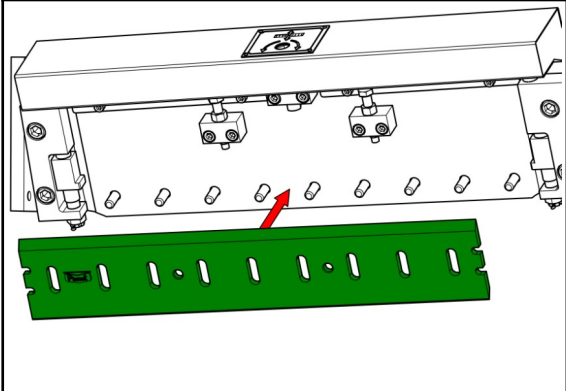
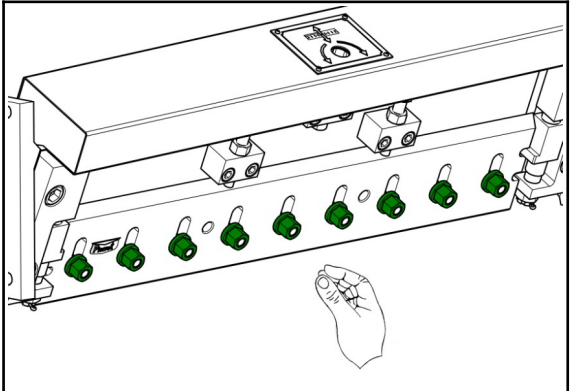
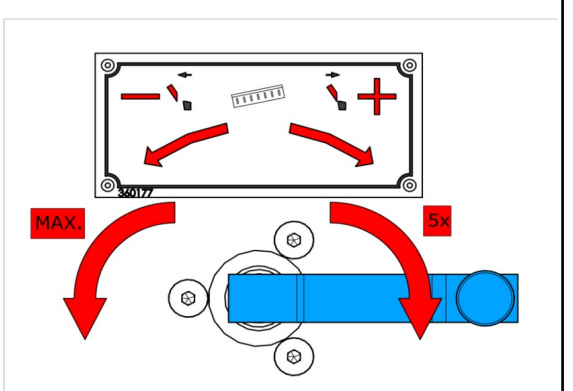
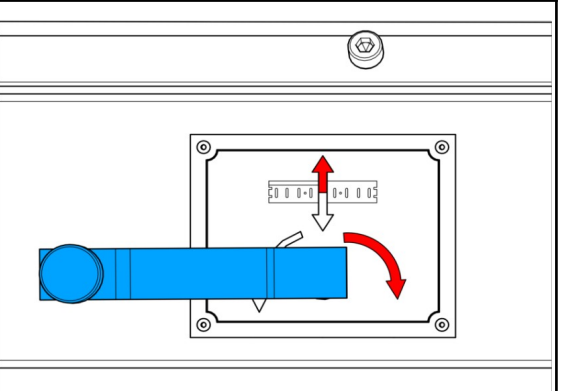
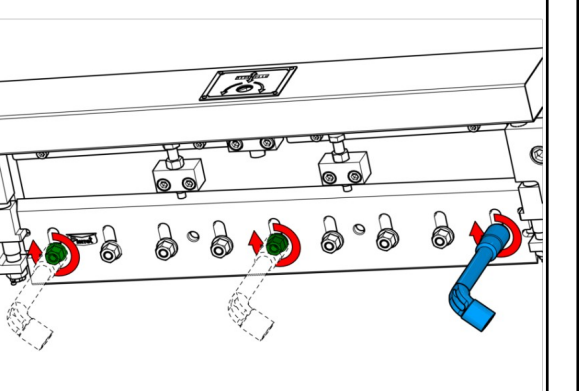
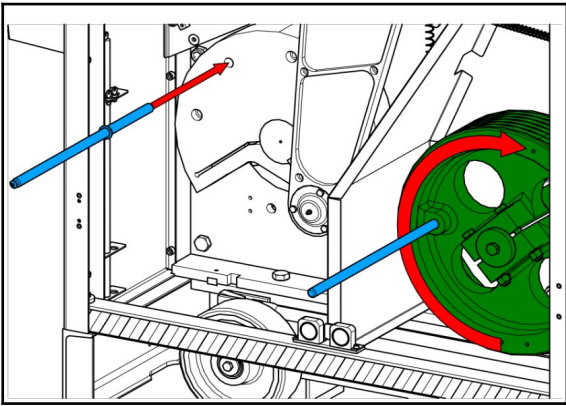
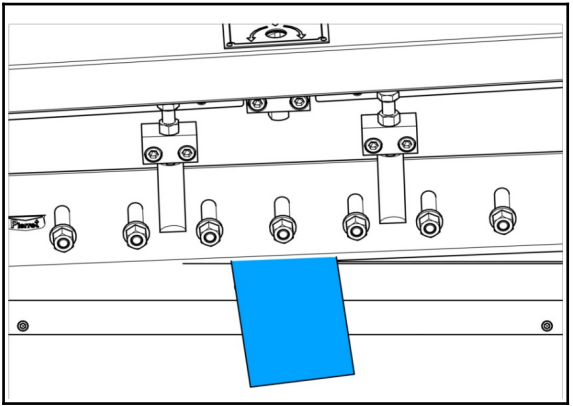
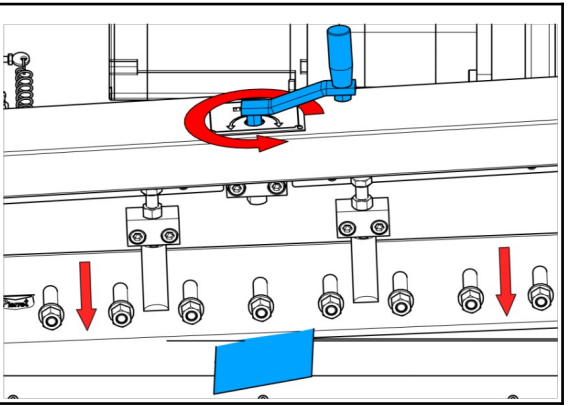
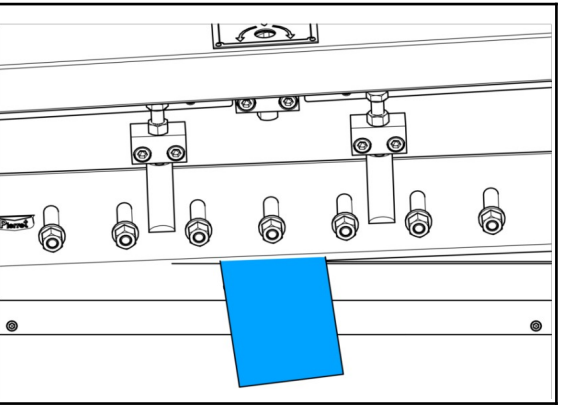
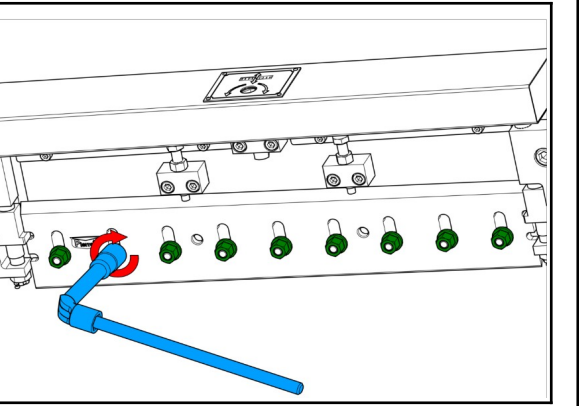
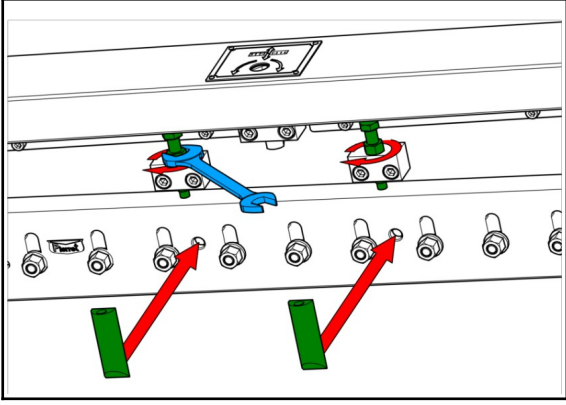
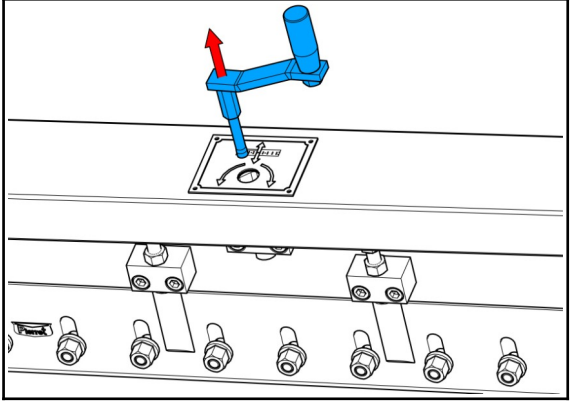
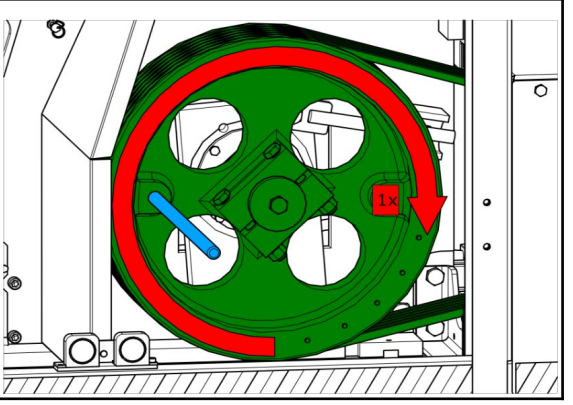
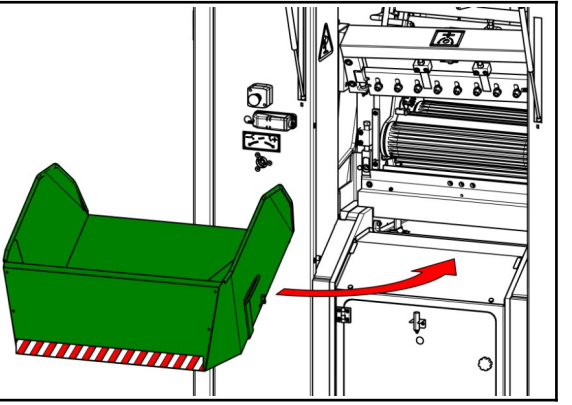
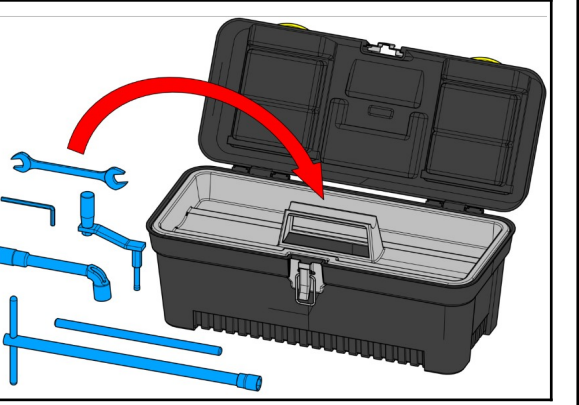
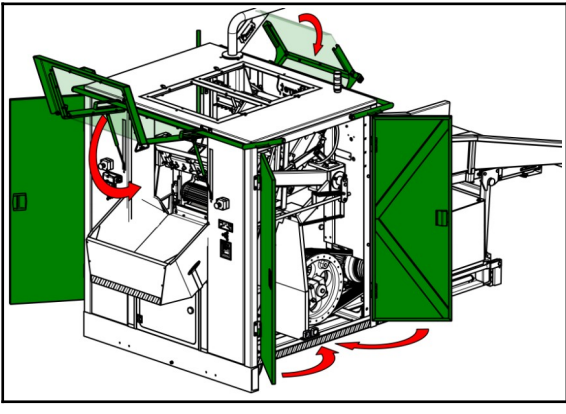
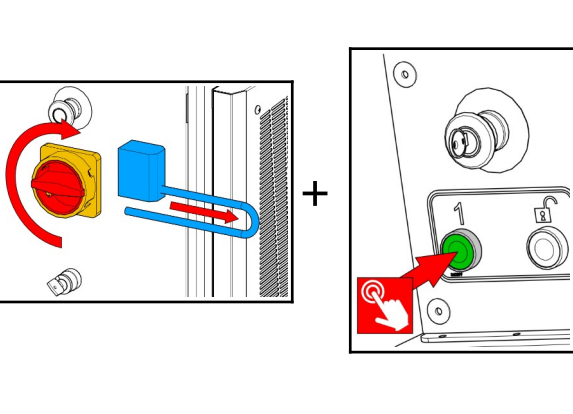
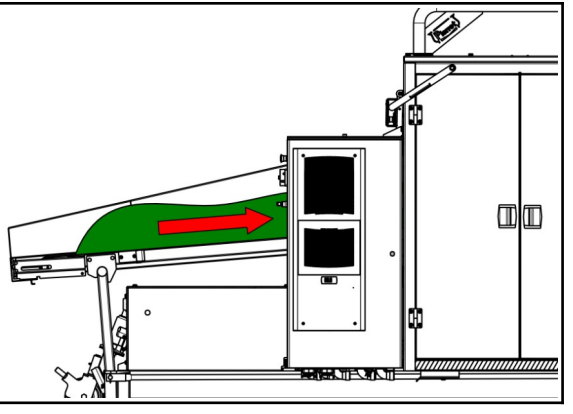
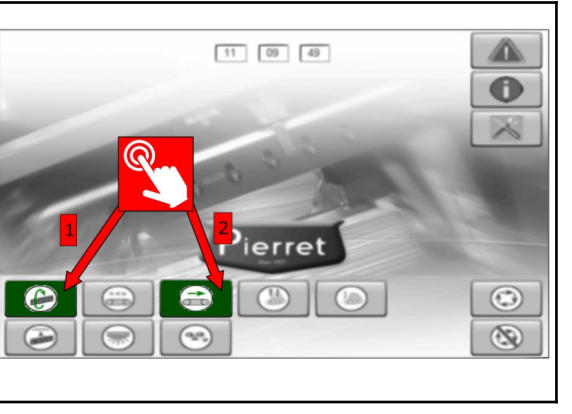
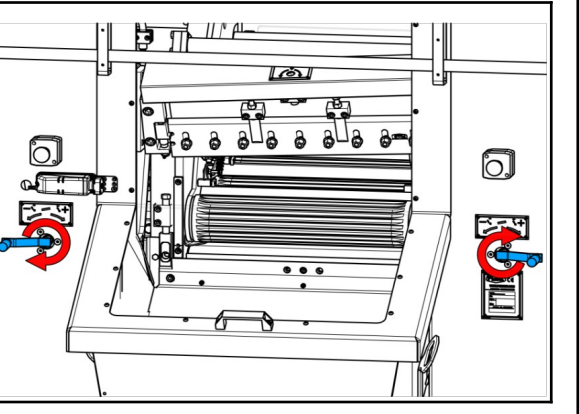


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| <p>1 Position the blade holder in the upper position.</p>  | <p>2 Position the driving unit in the upper position.</p>  | <p>3 Release the safety locking device.</p>  | <p>4 Lift up the front and rear cover. Open the large side doors.</p>  | <p>5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

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| <p>21 Place the mobile knife on the blade holder (PIERRET logo in the right way).</p>  | <p>22 Tighten the nuts by hand.</p>  | <p>23 Turn the adjusting rods completely in the – direction then 5 turns in the + direction.</p>  | <p>24 Place the knife in its upper position by using the crank handle.</p>  | <p>25 Slightly tighten the center nut and the 2 outer nuts.</p>  |
| <p>26 Place the blade holder into the adjusting position and put the safety bar.</p>  | <p>27 Fold a piece of paper in 8 plies and place it at the intersection of the knives.</p>  | <p>28 Turn the crank handle until the papers are pinched.</p>  | <p>29 Repeat the process with 4 papers.</p>  | <p>30 Tighten the nuts firmly (135 Nm).</p>  |
| <p>31 Place the stops of the mobile knife – tighten slightly.</p>  | <p>32 Remove the crank handle from the blade holder.</p>  | <p>33 Do manually one full turn of the cutting system (arrow direction).</p>  | <p>34 Put back the exit chute.</p>  | <p>35 Put the tools in the toolbox.</p>  |
| <p>36 Close the large side doors . Lower the front and rear cover.</p>  | <p>37 Put the machine in working order.</p>  | <p>38 Place some material over the whole width of the feeding belt.</p>  | <p>39 Start the cutting system and the feeding system.</p>  | <p>40 Turn the adjusting rods in the + direction to obtain a clean cut .</p>  |