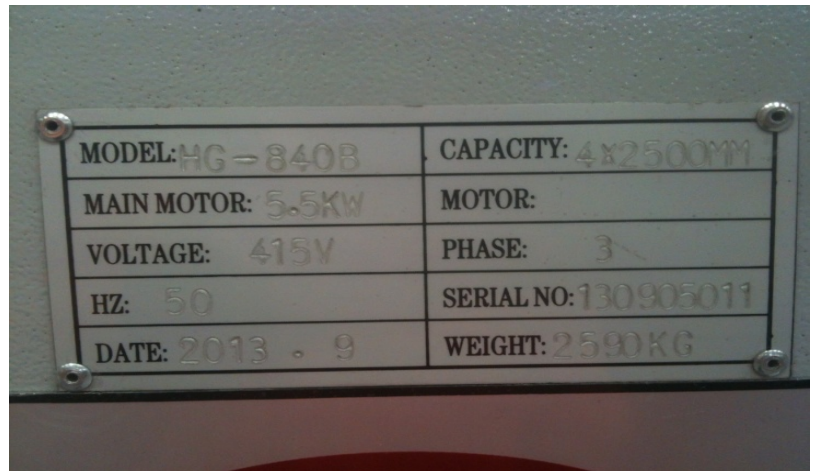


Under driven guillotine blade adjustment.

First check the maximum cutting capacity of the guillotine. The capacity is in mild steel so half the capacity for stainless steel.



MODEL: HG-840B	CAPACITY: 4x2500MM
MAIN MOTOR: 5.5KW	MOTOR:
VOLTAGE: 415V	PHASE: 3
HZ: 50	SERIAL NO: 130905011
DATE: 2013 . 9	WEIGHT: 2590KG

The blade gap on this guillotine must be set to match the material being used.

1mm material = 0.1mm blade gap, 2mm material = 0.2mm blade gap, etc.

Measure blade gap

Switch mode switch to inching so blade will hold position when foot pedal is released. Bring blade down until it just starts to cut. Isolate machine and measure blade gap. Repeat procedure at the other end of blade if correct.



Method for adjusting blade gap to cut 2mm material.

Bring blade down so it just starts to cut and isolate machine.

Loosen the four
head bolts on the side
of the machine



Use front and rear jacking bolts to set the required blade gap to suit material being cut.

If the blade gap is too big loosen the front jacking bolt and tighten the rear.

Use feeler gauge to measure gap.

Buffer- Do not adjust

Rear jacking bolt



This front adjusting bolt is also the minimum blade gap adjustment. Care must be taken when adjusting this bolt as the blades can be damaged if the blade gap is too small.



Repeat the same adjustment technique for the opposite end of the blade. Once both ends of the blade have been set return to auto operation and test cut material.