



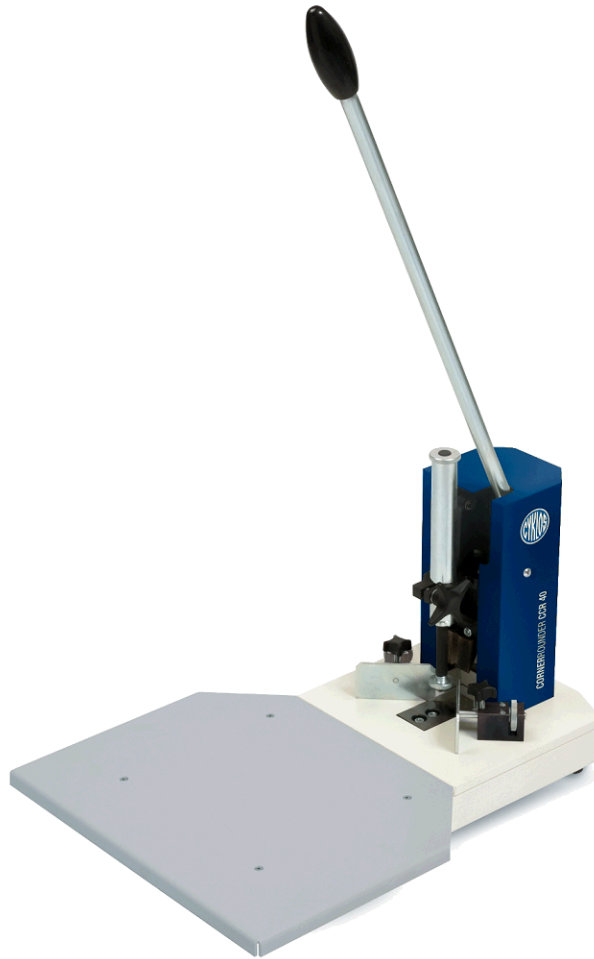
Operating Manual

Issue No.

1

No. of sheets

5



Corner Rounding Machine CCR 40

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1 Identification

Type marking:	CCR 40
Manufacturer:	VD Cyklos Choltice 533 61 Choltice Czech Republic

2 Specifications

The machine is designed for the manual rounding of paper sheets, of A3, A4 and A5 size, with a radius of R6, 9, 12 or 18 or for the cutting of paper corners with a direct tool at an angle of 45° and with a maximum length of 28mm. The maximum height of inserted sheets to be adjusted is 40mm.

The rounding machine is designed to cut standard office paper or paper with similar physical-chemical properties.

3 Parameters

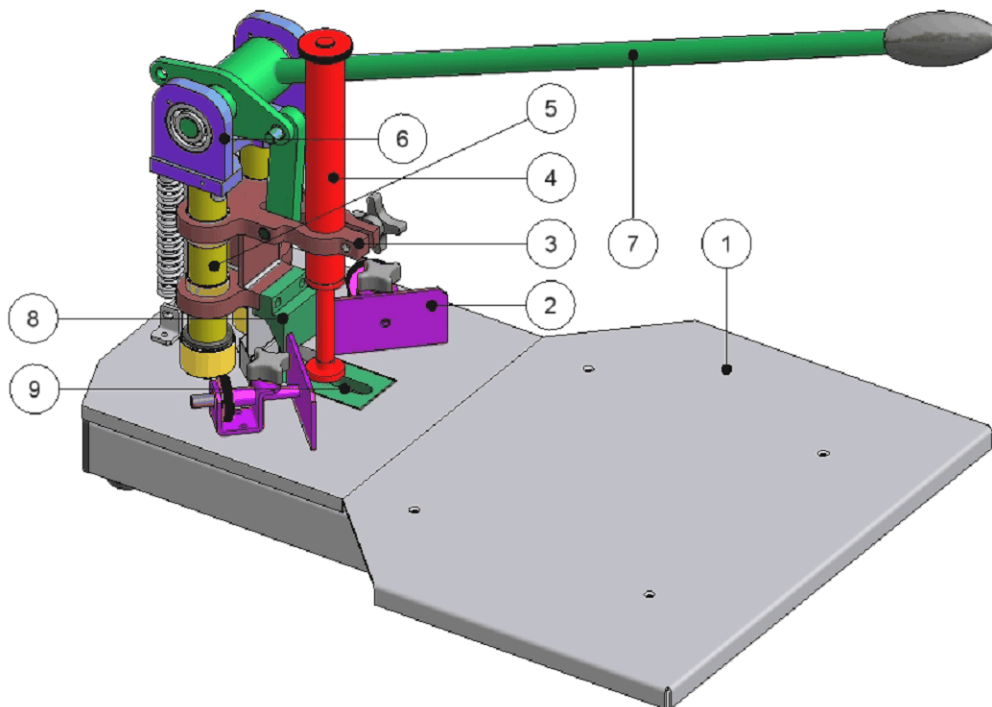
a) Sheet size	A3, A4, A5
b) Tools used	R4, R6, R9, R12, R18 and T28mm
c) Feed board capacity	max. sheet stack height: 40mm
d) Space requirements	length = 700mm width = 400mm height = 800mm
e) Transport size	length = 540mm width = 400mm height = 380mm
f) Paper basis weight	80 - 400g/m ²
g) Machine weight	16.5kg

4 Prohibited operations

- h) The machine is designed only for the cutting of the paper specified in the parameters section and of a plastic foil.
- i) It is prohibited to cut metal foils, tin sheets or similar materials.
- j) The machine can be operated only in closed, covered areas (e.g. offices, workshops).
- k) It is prohibited to use the machine outdoors.
- l) It is prohibited to use the machine in the event that its operation is not continuous and smooth.
- m) The machine can be operated only if it is covered and none of its parts is missing.
- n) The machine can be attended only by a person familiar with its operation.

5 Main machine parts

1. board
2. stop
3. slide
4. holder
5. slide guide
6. pin holder with lever
7. pin with lever
8. tool – upper part
9. tool – lower part



6 Operating instructions

6.1 Preparing the machine for use

- a) Read all instructions carefully before starting work on the machine.
- b) After unpacking the machine screw on the hand crank – position 7.
- c) Insert the holder into the slide clamp. Screw a base on the clamp and then tighten the holder with a shaped bolt in a required position.
- d) To reduce the risk of injuries, never use the machine near children.
- e) It is prohibited to perform any work under the machine cover and to put one's fingers inside the thrust screw and blades area while the machine is working (paper cutting).
- f) If the machine's operation gets interrupted or stuck, or if its operation requires inappropriate efforts, stop working and check the technical condition of the machine.

6.2 Paper introduction

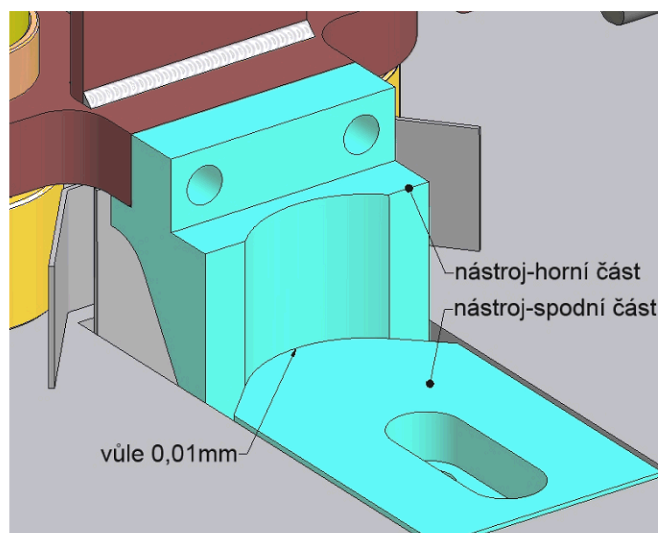
Introduce paper sheets between the stops in position 2. The stops must be adjusted co-linearly (parallel) to the lower blade's edge. The fine adjustment of the stops is completed after by means of a milled nut releasing arrestment screws.

6.3 Adjustment of paper down-pressure, position 4

Adjust the holder so that it imposes sufficient pressure on paper even before cutting begins; i.e. about 5mm before a cutting position. Then tighten the holder properly in the clamp by turning the shaped screw towards the slide.

6.4 Tool assembly and maintenance

- Remove impurities from the bearing surfaces of the rounding machine's tools.
- Mount the upper part of the tool in the slide using screws, position 3 (The tool must lean on the upper edge.) For easier handling, remove the holder from the assembly.
- Hold the lever in its lower position (the bottom dead center of the slide). Attach the bottom part of the tool to the upper part and tighten it with two screws – this will set a shear clearance (T-squares have to be moved apart when inserting the lower tool.).
- Test the shear without using force. During shearing there **must not** be any contact between tools and the set clearance of the tools must be secured along the whole cutting length of the tool. See the picture.



Vůle Clearance 0.01 mm

Nástroj – horní část ... Tool – upper part

Nástroj – spodní část ... Tool – lower part

6.5 Paper cutting

The radius of the cut sheet must be symmetrical, its sharp edges must be free of frays in the transition area between the sheet edge and the radius. Make sure that the whole stack of sheets touches the stop, otherwise the rounding of all sheets cannot be guaranteed.

6.6 Removal of defects

- The cut sheet is frayed:
Check the blades for their sharpness as well as the clearance between both tools.
- The cut corner is not symmetrical and its edges are sharp:
Preset the stops co-linearly (parallel) to the lower tool's edges.
- The machine does not run continuously, gets stuck and is sluggish:
Check the knife blades and the clearance between both tools. Check all moving parts under the cover and the slide guide, or all slide bearings. The slide should be practically free of radial play where it meets with the guide. The seizing of antifriction bearings is not expected.

Note: *During every new machine setting make sure that there is no collision or contact between the upper and lower tools.*

6.7 Cover dismounting

The cover can be dismounted only if work on the machine has been finished. When resuming work the cover must be reattached and fastened.

7 Machine maintenance

Check the clearance between the slider's roll bent bearings and the guide and the draw rod once a month.

Clean the guide of roll bent bearings (columns) of solid impurities (dust and the like) once a month.

8 Machine disposal

When the machine's service life expires the machine can be liquidated together with communal waste. First, the machine is dismantled, its metal, plastic, rubber or non-metal parts are sorted and returned to appropriate salvage points for further recycling.

Machine parts are not made of dangerous materials. Therefore, their liquidation by a specialized company is not required.

Waste categories:

20 01 39 Plastics

20 01 40 Metals