

Akiles Diamond 7 Heavy Duty Electric Corner Rounding Machine

Instruction Manual



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Akiles Diamond 7

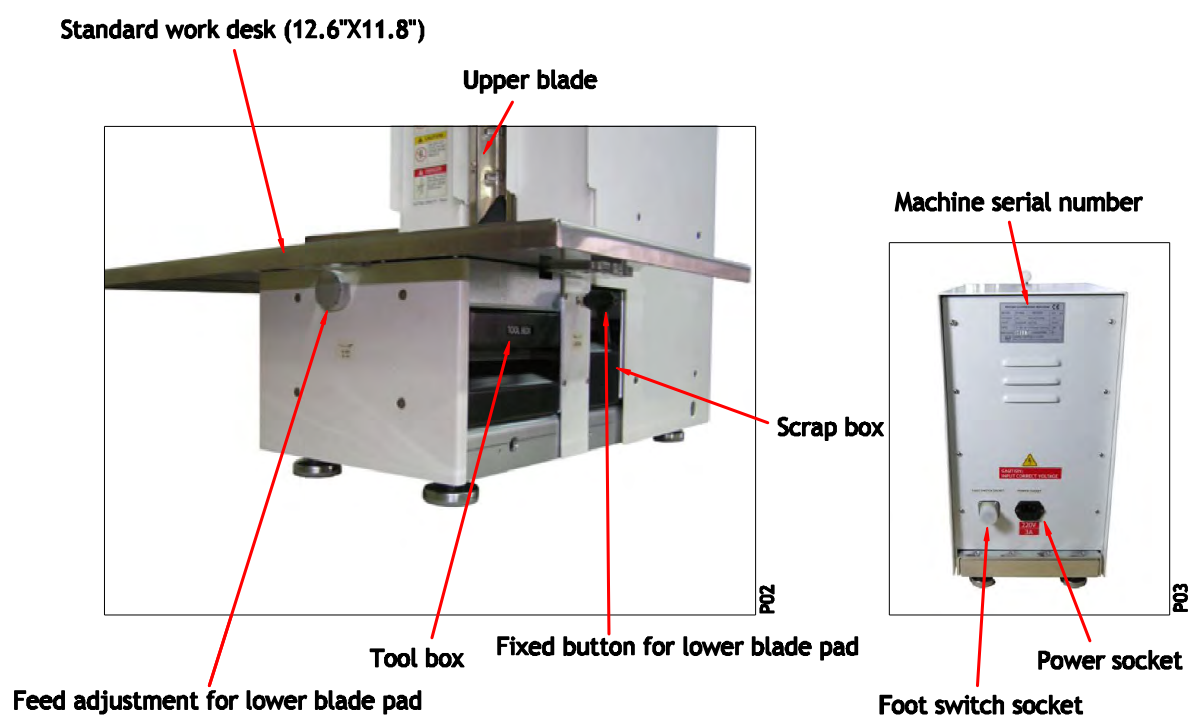
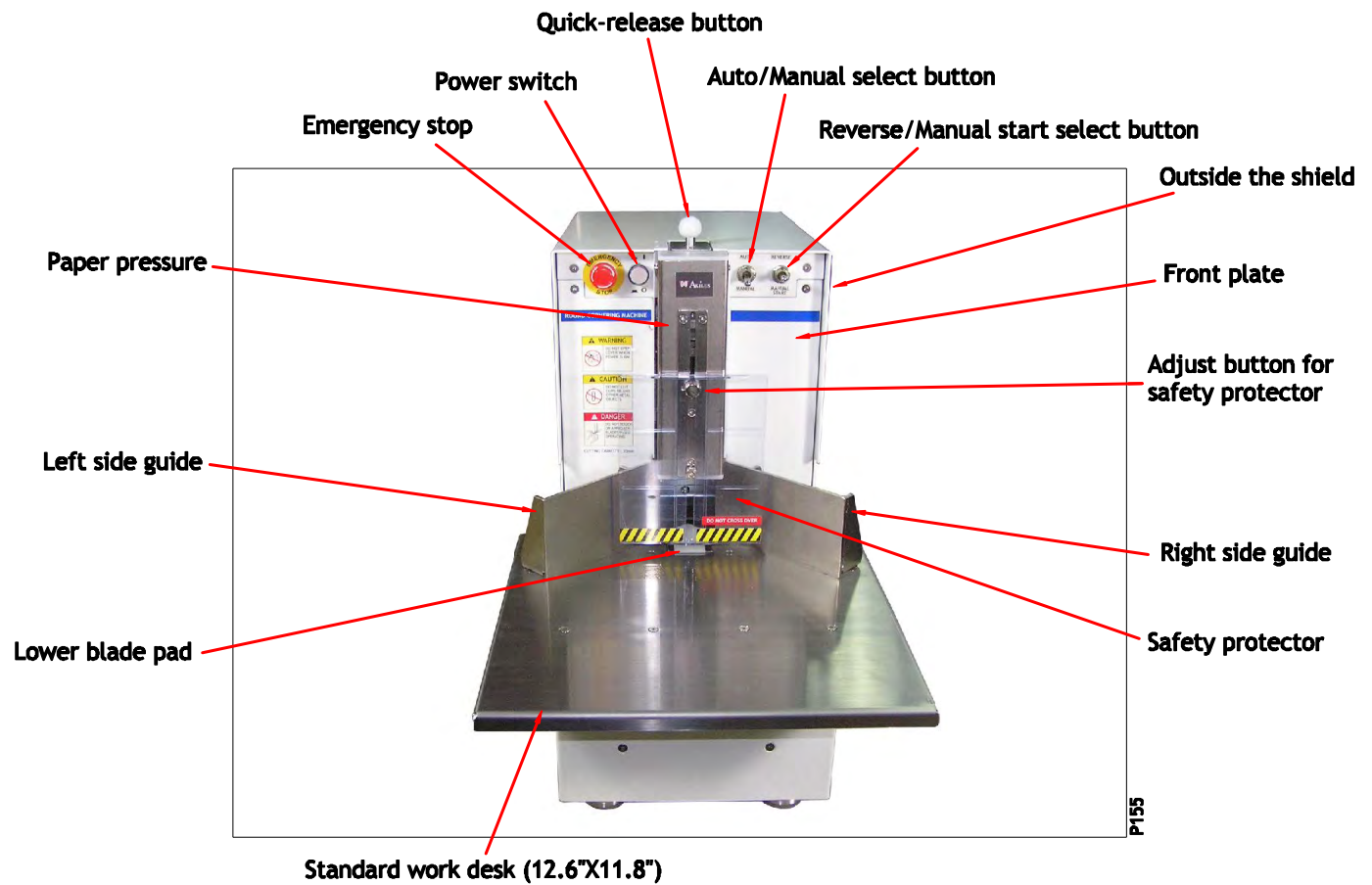
Operation Manual



ITEM NO.: AD-7

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A. Name of machine parts

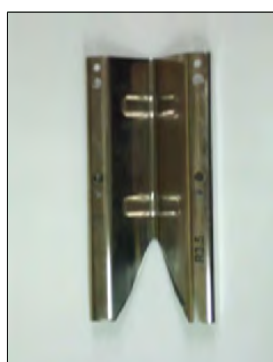


B. Safety instructions (Before setting up the machine, carefully read all the manual)

	Make sure the outlet with the correct voltage and type
	Blade is sharp, non-operator please keep away from machine.
	Do not put fingers into the safety protector during operating time.
	Do not cut staples, paper clips and other metal objects.
	Always turn off power when changing blade.
	Always turn off power when work completed.

C. All kinds of blade

① Upper blades (5 radius upper blades, 1 straight blade, 1 half moon blade, total 7 kinds)



AD7-K3.5
Upper blade
Size: R 1/8"



AD7-K6
Upper blade
Size: R 1/4"



AD7-K10
Upper blade
Size: R 3/8"



AD7-K13
Upper blade
Size: R 1/2"



AD7-K16
Upper blade
Size: R 5/8"



AD7-C15
Straight blade
Size: 5/8"



AD7-D21
Half moon blade
Size: $\varnothing$ 13/16"

② Lower blade pads (straight and half moon blades can be with any kinds of lower blade pad)



AD7-K3.5-2
Lower blade pad
Size: R 1/8"



AD7-K6-2
Lower blade pad
Size: R 1/4"



AD7-K10-2
Lower blade pad
Size: R 3/8"

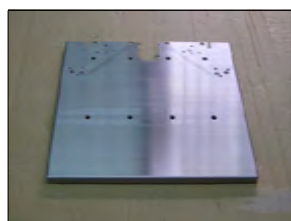


AD7-K13-2
Lower blade pad
Size: R 1/2"



AD7-K16-2
Lower blade pad
Size: R 5/8"

D. Standard parts & accessories (total 8 parts)



Standard work desk - 1 pc
Size: 12.6"(W)X 11.8"(L)



Left and right side guide - each 1 pc



Tool and scrap box - each 1 pc



Maintenance tools:
1. Cross-head and flat-head screwdriver - each 1 pc
2. T-type hex wrench (2.5,3) - each 1 pc
3. Hex wrench (1.5/2/2.5/3/4) - each 1 pc
4. Fuse (7A) - 5 pcs



Maintenance screw set
1. Round-head hex screw(M4X8) - 5 pcs
2. Flat-head hex screw(M4X8) - 10 pcs
3. Truss-head cross screw(M4X8) - 5 pcs
4. Socket-head hex screw(M4X12) - 4 pcs
5. Washers (Ø4X2t) - 4 pcs



Operational manual - 1 book



1. 1/4" upper blade - 1 pc
2. 1/4" lower blade pad - 10 pcs
3. 1/4" blade base - 1 set

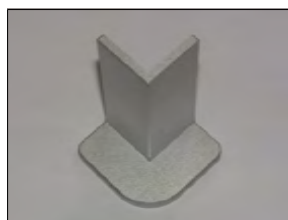


Paper pressure - 1 set

E. Optional parts & accessories (total 13 parts)



Large work desk
Size: 19.7"(W)X 11.8"(L)



L guide



Straight blade
Size: 5/8"



Straight blade base



Upper blade
Size: 1/8", 1/4", 3/8", 1/2", 5/8"



Blade base
Size: 1/8", 1/4", 3/8", 1/2", 5/8"



Lower blade pad
Size: 1/8", 1/4", 3/8", 1/2", 5/8"



Half moon blade
Size: 13/16"



Calibrate gauge



Micro paper guide set



Half moon blade regulator



Constant force spring



Oil stone
Size: 8" X 2" X 1"

F. Machine operation

CAUTION: Before operating machine, carefully read all the manual

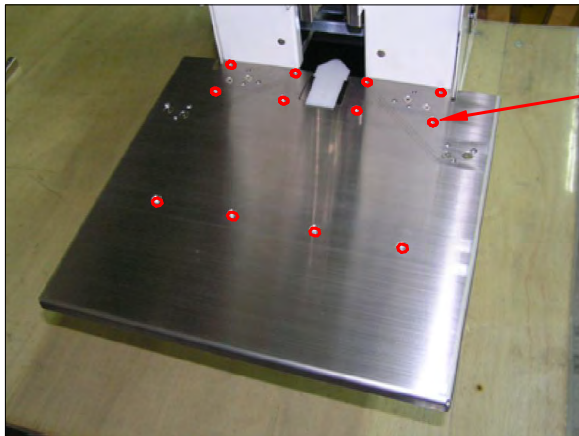
① Installation and cutting test



Place machine on top of a sturdy work table.



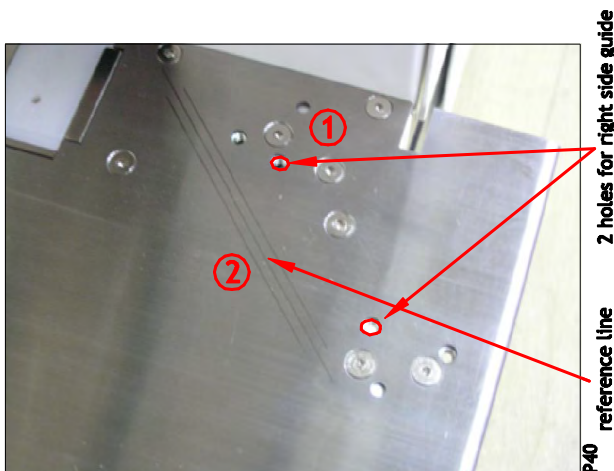
1. Pull forward to release the paper pressure from quick-release button.
2. Hold the paper pressure, downward to the end and pull out the paper pressure, then release the quick-release button.



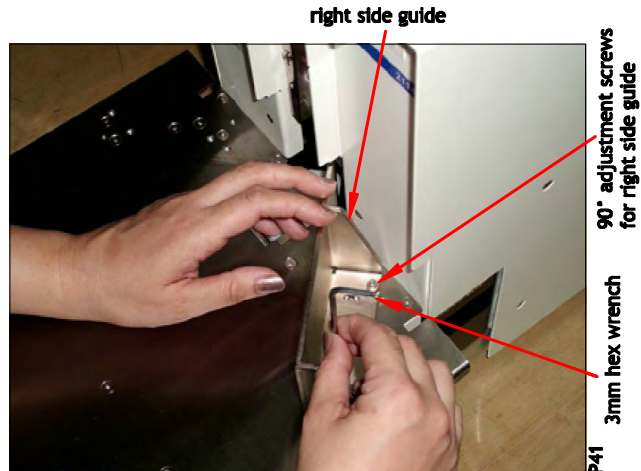
Place the work desk onto the machine as shown. Align the machine screw holes to the 12 mounting holes as arrows indicate.



Take the 2.5mm hex wrench, fasten the 12 pcs flat-head hex screw(size: M4x8).



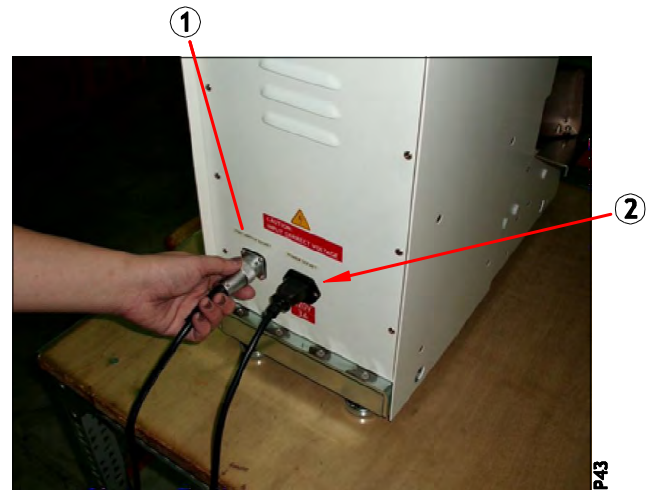
As arrow ① shown the 2 holes are for right side guide hole.
② shown the reference line for the right side guide place and adjust the reference.



Place front edge of the right side guide on the central reference line, target the 2-hole shown in P40 on the fixed holes.
Use 3mm hex wrench lock the M4X12 socket-head hex screw. Fixed left side guide same as above.

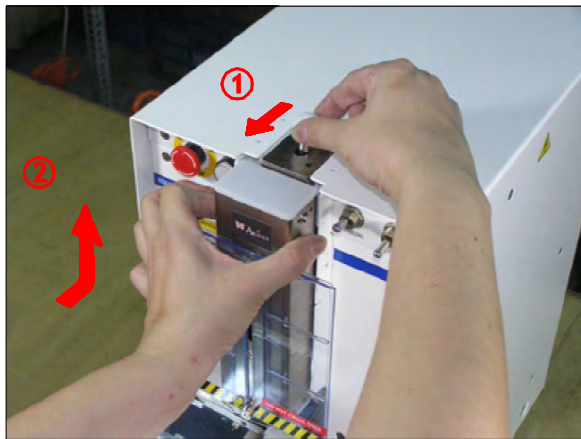


Above figure show the ready position for right and left side guide.



(Attention: Make sure the correct voltage)

Plug foot switch cord ① into the socket, then power cord ② into the socket.



1. Pull forward to release the paper pressure from quick-release button.
2. Hold the paper pressure, will be two positioning pins into the two holes, upward push to the top and then release the quick-release button for auto-lock paper pressure.



Loosen the adjust button of safety protector, move it down to the bottom and lock it. Keep the safety protector and work desk minimum clearance 3/8".



1. Turn on the power switch motor is standby, the light is on but motor not rotation.
2. Turn the operation mode to manual.
3. Push-down manual start button, push-down to start release to stop motor, make upper blade slowly down intermittently touch the lower blade pad, check blade if ready for working. (blade has been calibrate by original)



1. Turn the operation mode to auto. (for manual mode, leave the upper blade slightly off the top position, and step on the foot switch to start)
2. Test with the foot switch see if normal operation. (push-down the switch to finishing a cycle, release the foot switch then start again)



P48

Put one sheet of paper close to right and left side guide. (Keep finger out of safety protector) Step the foot switch for cutting testing. (When the upper blade to rise up, if heard a sharp noise. Can be add a little lubricating oil on upper blade's flank then dried to resolve the noise.)



P49

Check if the corner rounder is tidy or any cutting edge remain. If yes, make a new lower blade pad cutting is requested. How to operate as shown P50~P51.



P50

1. Release the fixed button of lower blade pad counterclockwise.
2. Fixed button can be pulled out and turn around to change position. Adjusted to the best position between scrap box and tool box.
3. To lock, hold the handle while rotating clockwise and inward to press.

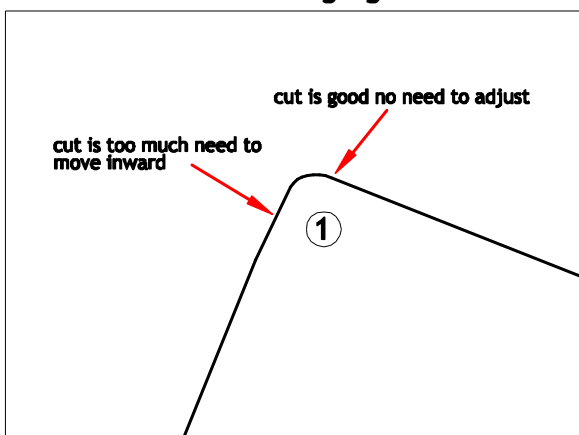


P51

Turn counterclockwise one section of feed adjustment as shown, the lower blade pad will move 0.125mm. (one time one section can get better incision) Then lock the fixed button and try cutting again, if the situation remains the same, please repeat P50~P51. (a lower blade pad can be use 80 sections)

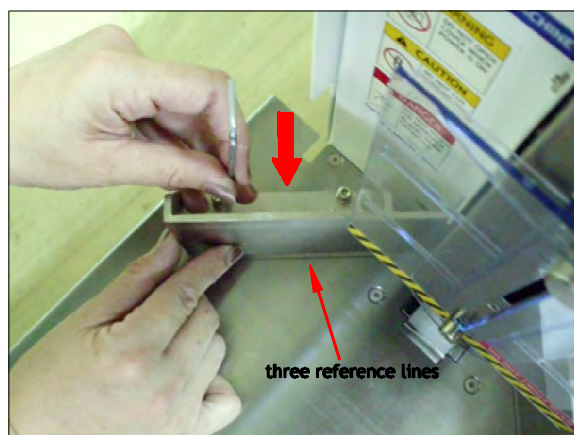
② Right and left side guide adjustment

a. Without calibrate gauge



D01

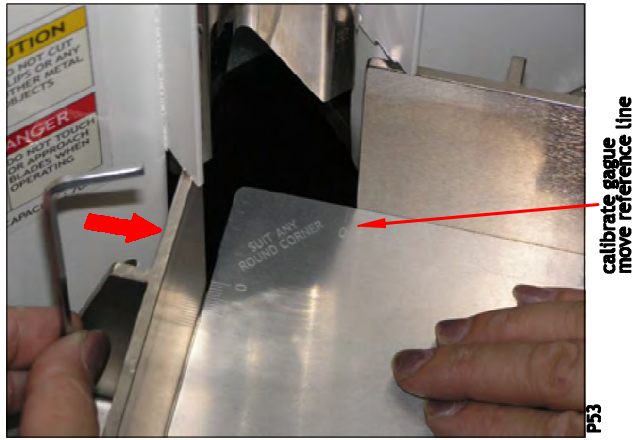
Above shown the right side cut is good no need to adjust. Left side cut is too much need to move inward of left side guide.



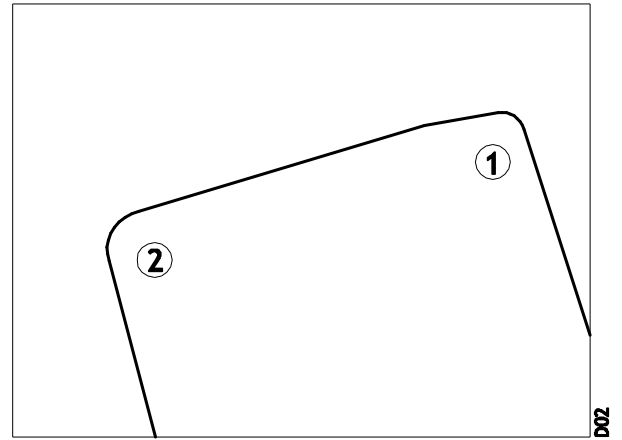
P52

Release 2 fixed screw on left side guide. Refer the three lines on work desk, ① arrow is the direction of inward movement, keep front edge of the left side guide and reference line are parallel then fixed it for once cutting. If the situation remains the same, please repeat above procedures unit get perfect corner rounder.

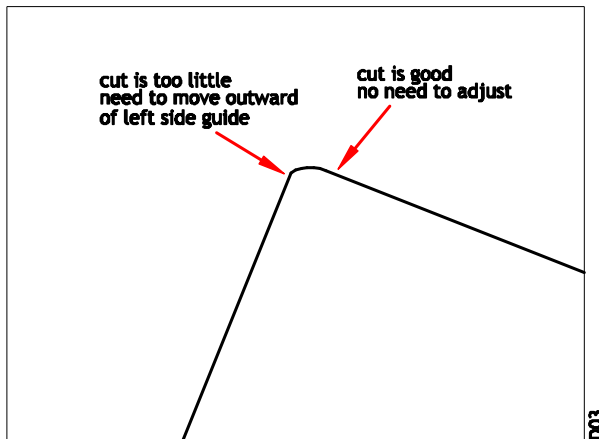
b. With calibrate gauge



Keep calibrate gauge close to right and left side guide. Check the relative position between calibrate gauge and right side guide, micro adjustment the calibrate gauge to right as red arrow shown. Hold the gauge with right hand and loosen the 2 pcs fixed screw of left side guide by left hand, then move the left side guide close to calibrate gauge and fixed tightly.



As drawing ① shown the left cut is too much need to adjust left side guide to right. Drawing ② is the perfect cutting after adjustment.



As drawing shown left cut is too little need to move outward (to left) of left side guide.

③ Changing blades

a. Changing the upper blade



1. Turn off the power.
2. Remove the paper pressure.
3. Take 2.5mm T-type hex wrench, counterclockwise loosen 4 pcs of fixed screw.



Caution: V-type blade is sharp, do not touch with fingers.

As shown use left hand two finders hold on bottom of upper blade, and hold the top with right hand index finger, slow-shake to remove the blade out.

Same as above take a new blade, aligned and press inward to the 2 locating pin as arrow shown. Take 2.5mm T-type hex wrench to look the 4 pcs screw. (Please check again for well looking)

For changing R13 & R16 radius upper blade, same works as changing straight blade C15. Please refer page 10 the photo P64, screw tightly with 2 pcs of M4X12 screws.

b. Changing the lower blade pad

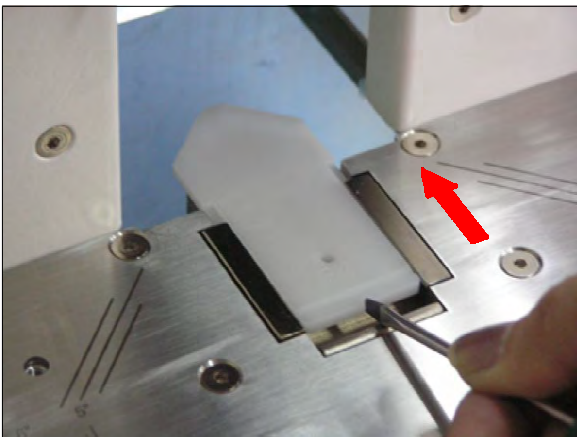
(5 upper blade with 5 lower blade pad; Ex: K6 lower blade pad with K6 upper blade)



Turn off the power, release the fixed button of lower blade pad counterclockwise.



As photo shown, rotate the feed adjustment in a clockwise to the end.

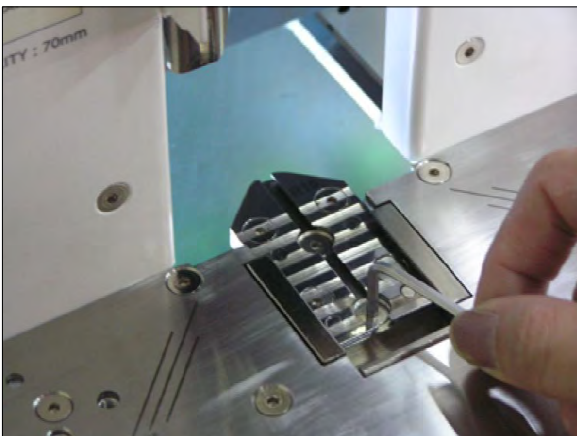


Take screwdriver to get bottom-under the lower blade pad, forward the pad to scrap box.



Take short-side of 3mm hex wrench and push inside to new lower blade pad hole for fixing(as shown), then take hex wrench align to the guider and push down until touch to the end. Then take the hex wrench out and lock the fixed button of lower blade pad.

c. Changing the blade base



Attention: Turn off the power first

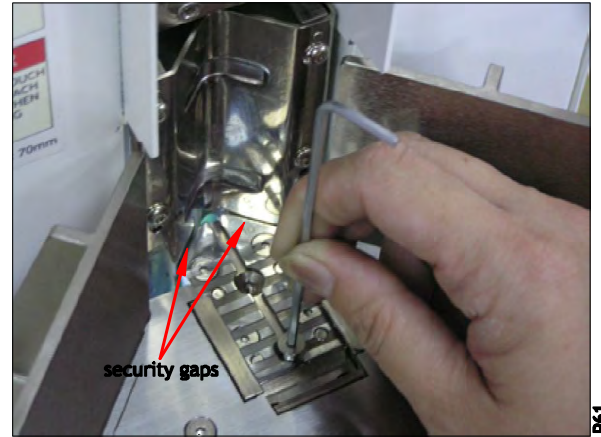
1. Blade base corresponding to upper blade, Ex:
K6 blade base use for K6 upper blade.
K16 blade base use for K16 upper blade.
2. Take 2.5mm hex wrench to loose 2 pcs of fixed screws.



Use finger push and forward the blade base to scrap box and take the base out.



Take the new base, install the base plate from the front and pull back to the end, not lock now.



1. Install the paper pressure.
2. Turn on the power and keep manual button, Use manual start button operation and stop upper blade on lowest point.
3. Turn off the power and remove the paper pressure.
4. Push and forward the blade base align with fixed hole. Check if enough security gaps between upper blade and blade base before fixing. (Please check again for well locking)

d. Changing the half moon blade D21



1. Turn off the power and release the paper pressure.
2. Note the sharp blade, put the white plastic protector before changing.
3. Use left hand's finger hold the white protector, and right hand's finger hold the D21 above, aligned and press inward to the 2 locating pin.



Take 2.5mm T-type hex wrench to fix the 4 screws, make sure screws fasten tightly. Remove the white protector and replace the paper pressure. The D21 blade is now complete.

e. Changing the straight blade C15

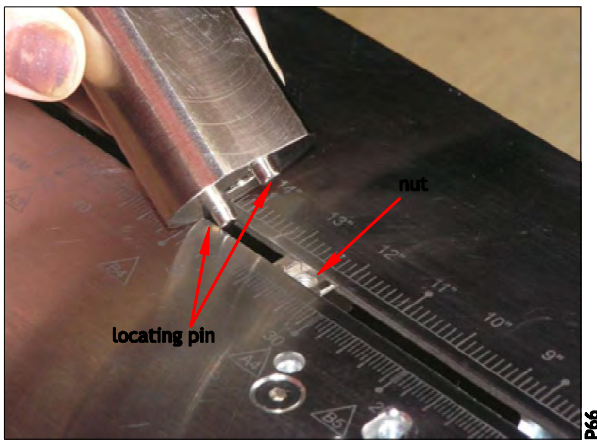


1. Turn off power and release the paper pressure.
2. Use left hand's hold upward the white protector to the base and close to the positioning plate, right hand take 3mm T-type hex wrench and screw tightly the 2 pcs of M4X16 screws, make sure fasten tightly.
3. Remove the white protector, and replace paper pressure. The C15 blade is now complete.

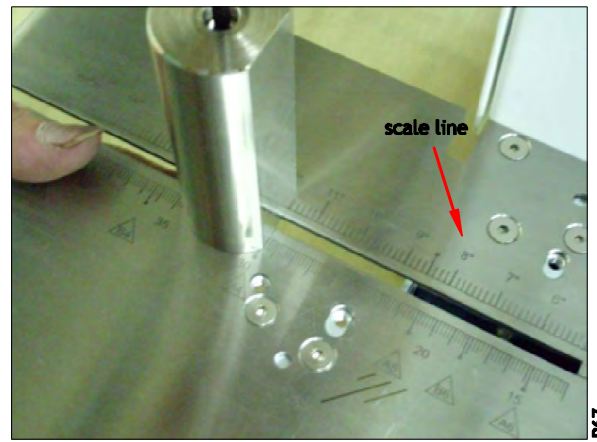


1. Picture shown how to change new C15 blade.
2. First, put on the white protector on used blade, take 2.5mm T-type hex wrench to remove the 4 pcs fixing screws.
3. Same, put on the white protector on new blade before changing. Replace it on blade base then fasten 4 pcs of fixing screw, make sure screws fasten tightly.

④ How to adjust the D21 regulator (Must comply with the large work desk)



Put the nut from the back side of large work desk, Put the regulator into slot hole in desk as picture shown align the nut.
Take 3mm hex wrench and screw tightly the M4X75L screw.



For adjust the regulator, suggest to refer the scale line of the large work desk to move the position. Slightly loosen the screw, you can easily move it.



Once the D21 blade and regulator install to proper position, put the paper on desk and move paper close to the front plate and left side, till paper touch to the regulator. (Caution! Fingers do not exceed the safety protector) One hand slightly press the paper and start to cut. Safe distance between safety protector and paper is 5mm.

⑤ How to use the "L" guide

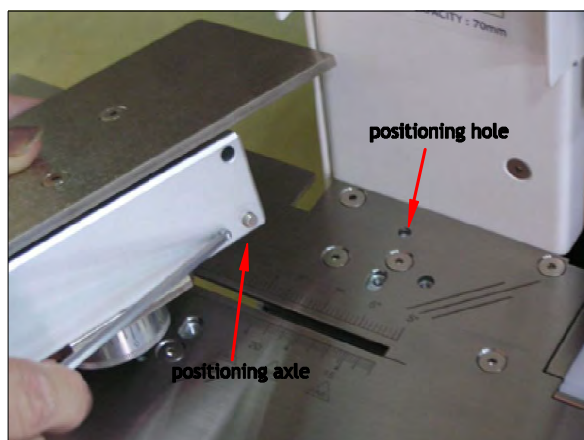


Adjust the safety protector and keep stack of paper about 5mm height distance, fix the adjust button.



Put the "L" guide on table, use "L" guide left and right edges to tap the stack of paper in parallel till paper is neatly. At the same time, make sure "L" guide close to the outside corner of the paper. Right hand fingers hold "L" guide at the bottom(as shown), slightly press the "L" guide let it close to the paper for cutting.

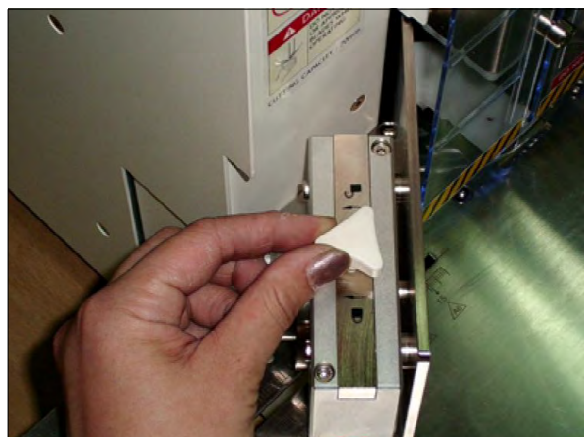
⑥ How to use the micro paper guide (Standard and large work desk can be used)



There are 2 pcs of positioning axle on the bottom of left/right micro paper guide, install the 2 pcs of positioning axle to fixing positioning hole on work desk.



Fasten the micro paper guide with 2 pcs of M4X50L screws by 3mm hex wrench.



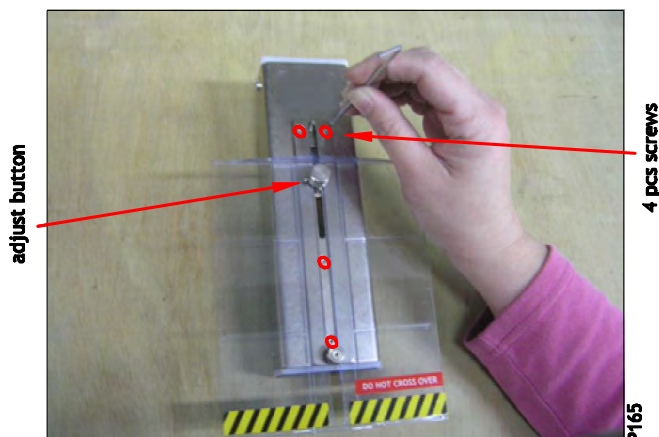
To adjust the micro paper guide, first release the white-head screw as shown.



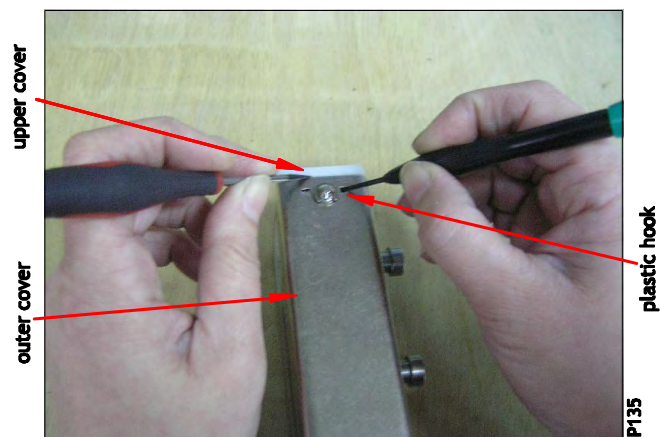
As shown turn scale button, the counterclockwise move to forward and clockwise to backward. Each rotation a grid movement is 0.02mm, available movement is total 6mm length. Once the movement is done, lock-tight the white-head screw.

⑦ Spring replacement for paper pressure

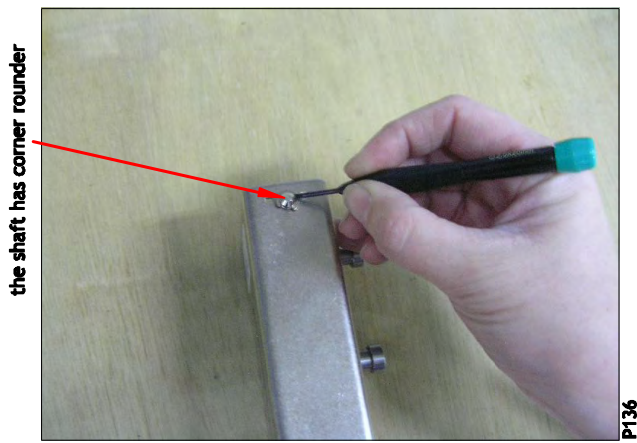
a. Discharge the old spring (P134~P140)



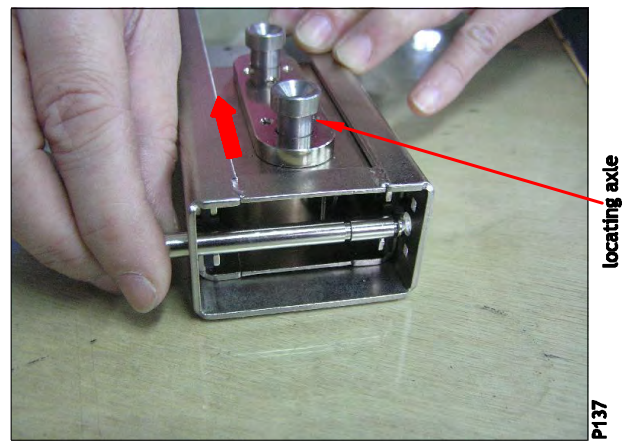
1. Release the 4 pcs screws by 2mm hex wrench as arrow shown.
2. Hold the adjust button, pull out whole set of safety protector from the outer cover.



1. Take 2 pcs small flat-head screwdriver, insert one driver to the small hole, press down the plastic hook as shown, and insert another driver to the upper cover among the outer cover and pry the upper cover.
2. Remove the bottom cover is same as upper cover.



1. Use small flat-head screwdriver and insert to small hole of E-ring, pull outward and remove the E-ring. (Remove one side the shaft has corner rounder)



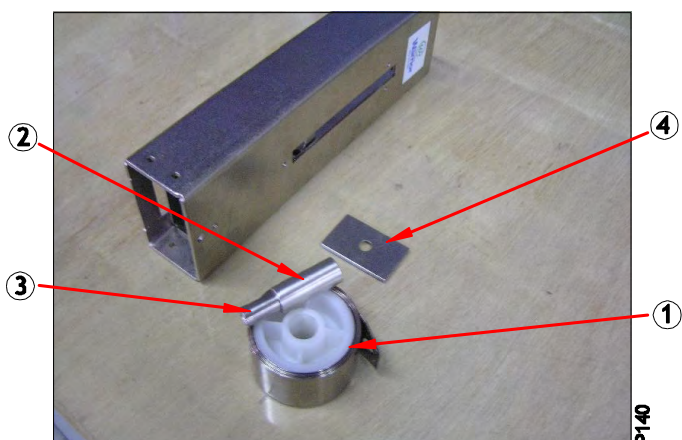
1. If the spring is broken, take out from the shaft directly.
2. If spring is worthless, use one hand hold the locating axle and slightly pull open as arrow shown, another hand take out the shaft.



1. Use 2.5mm hex wrench release fixing screws for spring washer.



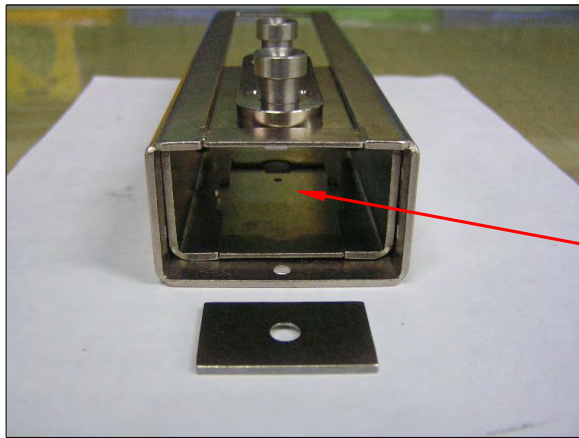
1. Left hand finger insert into the outer cover hole and push outward the spring as shown, right hand hold the spring and pull it outward. (inside the spring still have other spare parts, do not tilt the outer cover but straighten for easier take the spring out)



As shown are all the spare parts for spring after discharge.

- ① Constant force spring
- ② Sleeve
- ③ Spring shaft
- ④ Washer

b. Spring replacement (P141~P150)



square hole

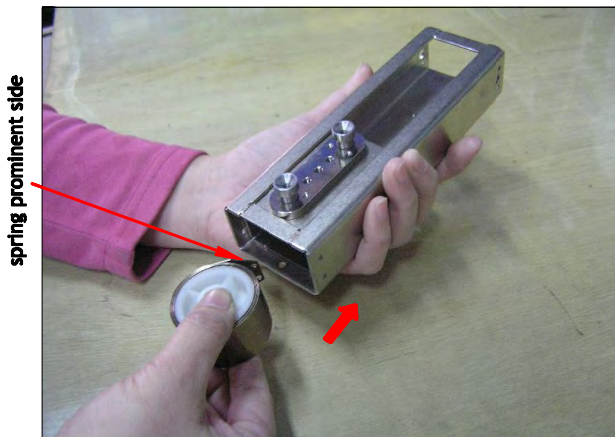
P141

1. Push the inner cover to the bottom, refer P142 for correct direction. As right photo ① shown the outer cover shaft hole is on upper direction.
2. Replace the spring washer into the square hole as arrow indicated. (do not put the spring washer at the reverse side.)



P142

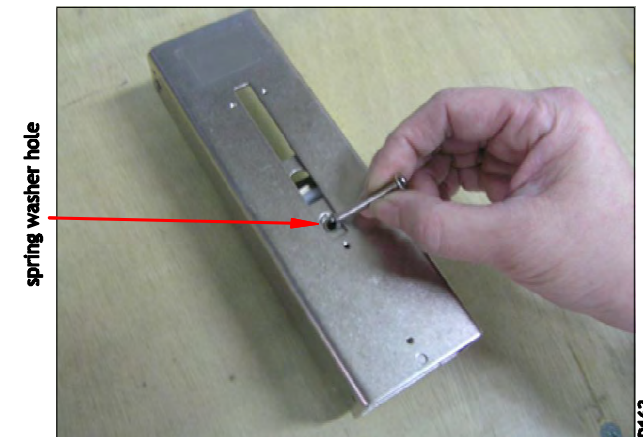
1. Replace the spring axle and sleeve to the new spring center hole, please refer above photo ② to install the spring for right direction.



spring prominent side

P143

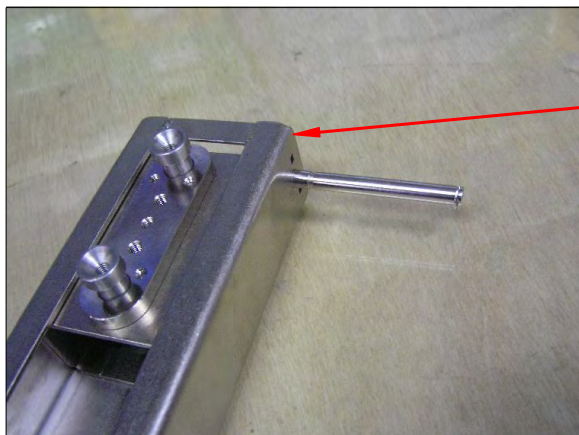
1. Left hand hold the outer cover, right hand take the ready new spring set and install to inner cover. Be careful keep the spring prominent side at the left.
2. Be careful the spring fixed gasket fall down, and prevent the spring sleeve and axle exposed from spring set for proper installation.



spring washer hole

P162

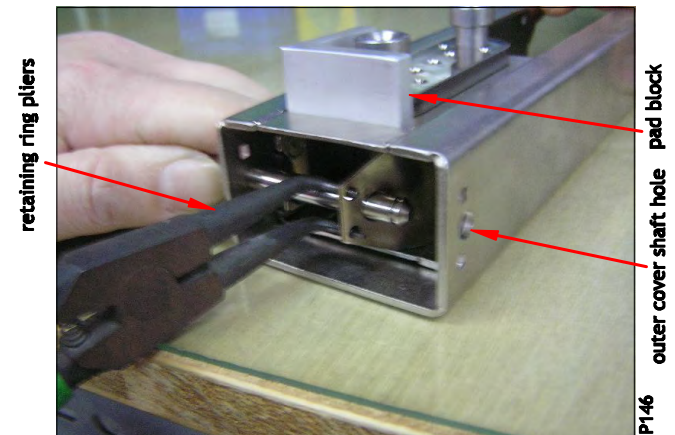
1. Turn the outer cover to front side, driven the spring from the top and makes spring washer hole meet the outer cover hole.
2. Replace the fixing screw and fasten tightly.



top of the outer cover

P145

1. Remove the inner cover to the top, insert the spring axle a little as shown direction. (contrary insert is prohibit)



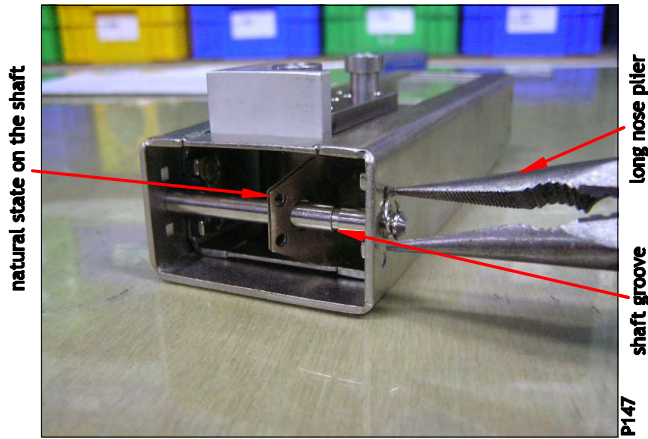
retaining ring pliers

pad block

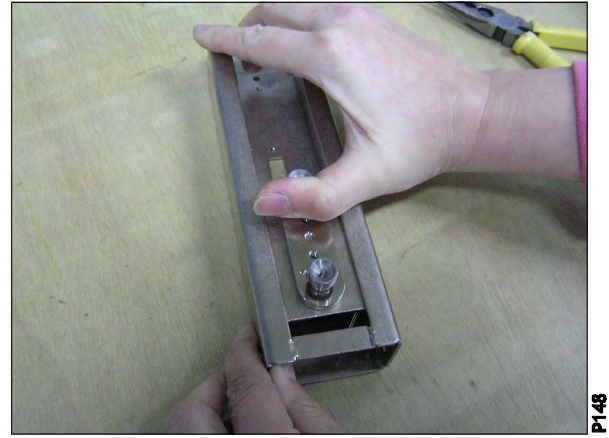
outer cover shaft hole

P146

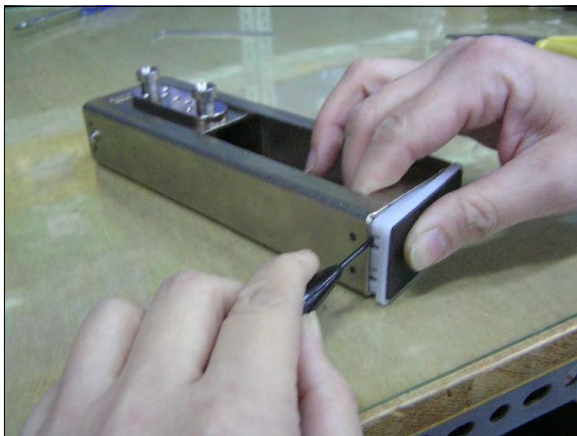
1. Find a pad block put on the inner cover (4mm above thickness) as arrow shown.
2. Use retaining ring pliers to insert the 2 small holes on the spring, ask another person to hold the outer cover, pull the spring let shaft pass through the hole and hold the spring until the shaft go through to another side shaft hole.



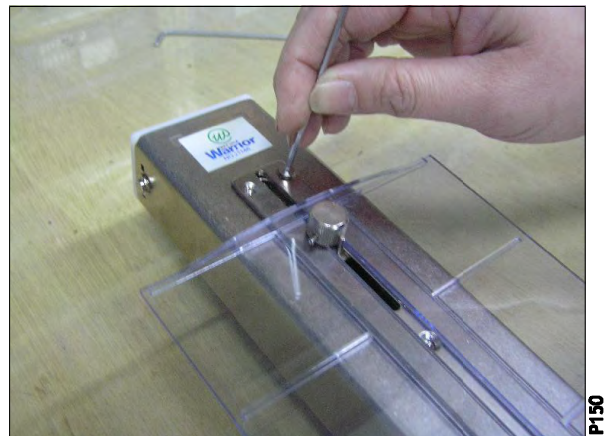
1. Take the removed E-ring hook onto the shaft groove as shown, and replace it by long-nose plier.
2. Be careful hanging the spring natural state on the shaft, do not hook the spring on shaft groove.



1. left hand hold the outer cover, and right hand hold the locating axle and slightly pull the spring see if works up and down smoothly.
2. If can not move, need to discharge and re-assembly and test again.



1. Pack back the black rubber bottom cover by flat-head screwdriver and push close tightly.
2. As above and then loaded upper cover.



1. Finally, install the safety protector and tighten the 4 screws.

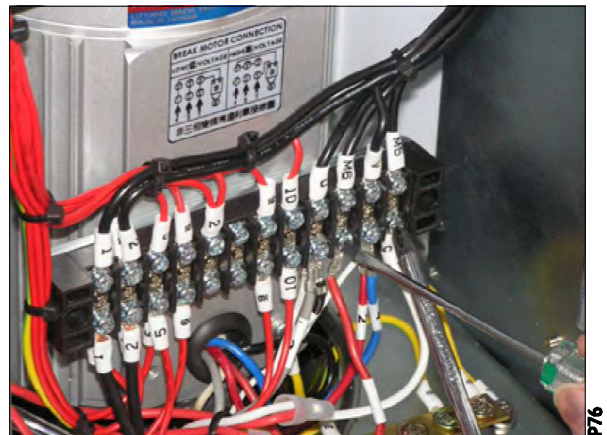
G. Maintenance

① Changing fuse and discharge capacitor



Replace the fuse

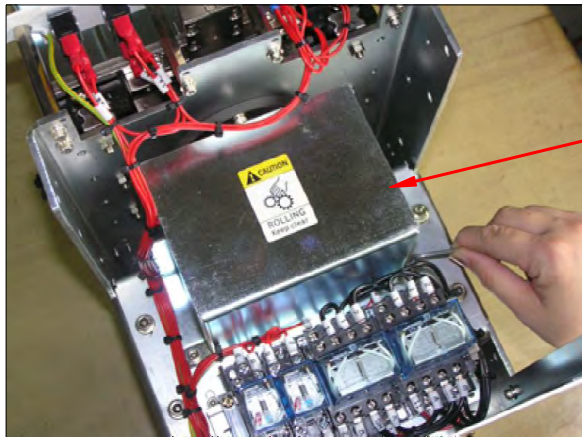
1. Unplug the power cord.
2. Take flat-head screwdriver, pry-open the hole as picture shown outward, pull out the fuse holder by another hand.
3. Remove the damaged fuse and replace a new one that meet the specification, then re-plug the power cord for using.



Before disassembly the circuit, user must to discharge the capacitor's surplus electricity. And pay attention fingers do not to touch the metal part when using the screwdriver.

1. Use the flat-head screwdriver pry open the cover of the terminal blocks.
2. Use the cross-head screwdriver to hold the M5 junction of the screw, and use flat-head screwdriver to hold the M6 junction of the screw, then move both screwdriver to touch. At same moment will have sparkles caused from the touch.
3. After disassembly, replace the cover of the terminal blocks.

② Lubrication applying (Refuel lubricant every 30 days for using frequently.
for not often use every 90 days)

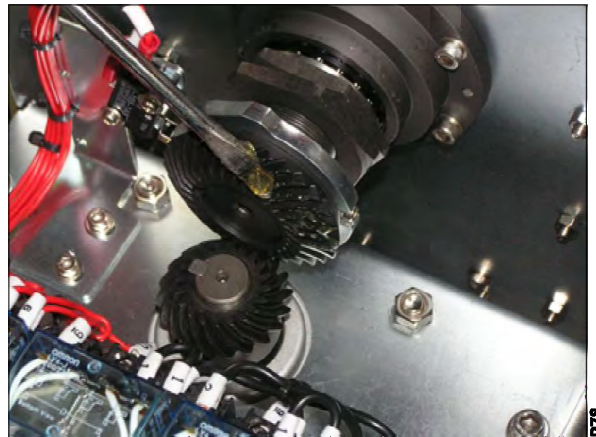


gear protector cover

P77

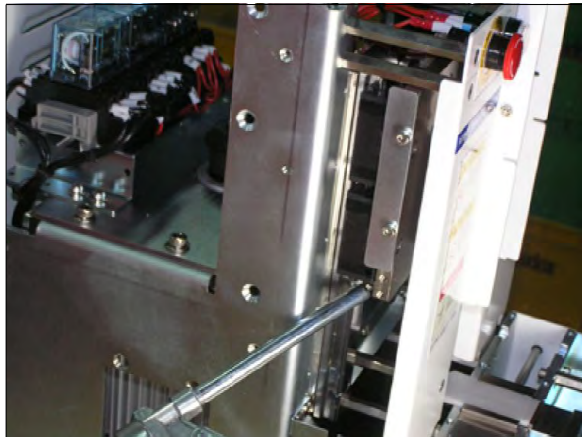
P77~P80 show how to lubricate the main structure.

1. Turn off power, unplug the power cord.
2. Remove the 10 pcs screw of outside the shield, both hands hold the shield and move upward slowly.
3. As shown remove the 2 pcs screw on gear protector cover.
4. Move the gear protector upward slowly.



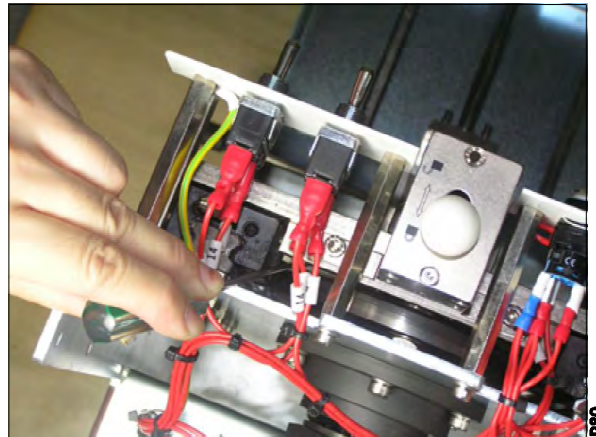
P78

As shown smear a little grease lubricant on bevel gear, then covered the gear protector cover by the 2 pcs fixing screws and fasten tightly.



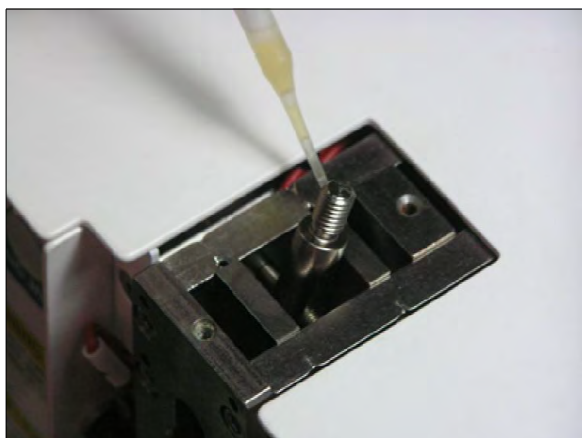
P79

As shown is the lubricating linear slider(2 sliders each left and right), carefully press a little grease lubricant by grease nozzle into the sliders.



P80

As shown is the cam track for lubrication, take few lubricant by flat-head screwdriver and spread lubricant on both sides of cam track.



P81

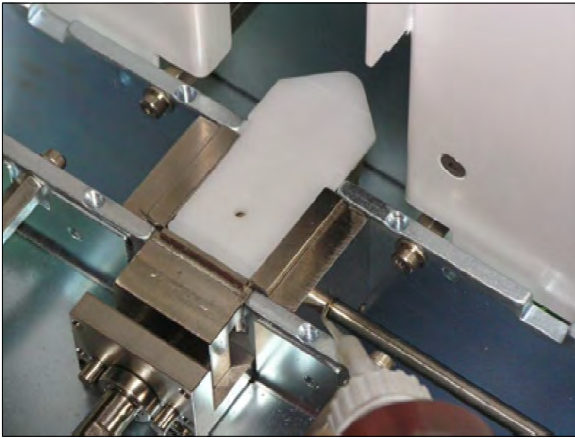
P81~P82 show how to lubricate the paper pressure. First, discharge the paper pressure.

1. Counterclockwise rotation the white-ball.
2. Take 2mm hex wrench to release the 2 pcs fixing screws which under white-ball, then remove the cover.
3. As shown apply a little lubricant on the whole activities parts.
4. Reinstall the cover and the white-ball.



P82

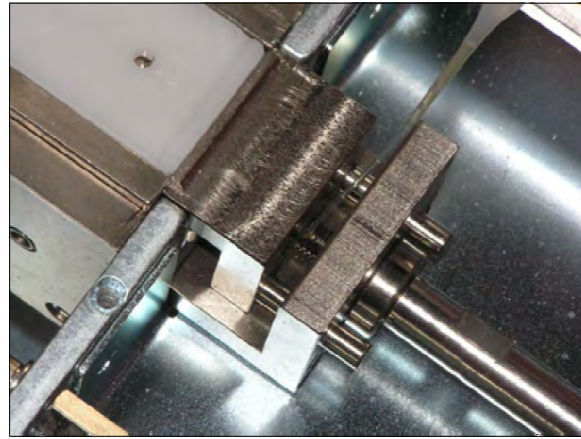
Take few lubricant by flat-head screwdriver, spread to sliding surface up and down as shown for smooth movement.



P83

P83-P84 is shown how to lubricating for lower blade pad system.

1. Discharge the paper pressure.
2. Remove the left and right side guide and work desk.
3. Lubricate the movement blade pad feeding device.



P84

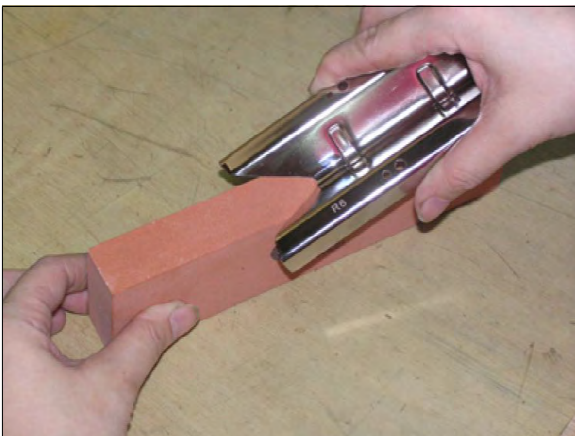
As shown lubricate the feeding thread and shaft, apply with a little lubrication while rotating.



P85

As shown when the scrap box accumulated up to seven full please empty the scrap, in order to prevent the risk when upper blade work down cutting.

③ Blade sharpened(K3.5/K6/K10 upper blades and straight blade are all available to sharpen by oil stone)



P86

Blade is sharp, do not touch with finger.

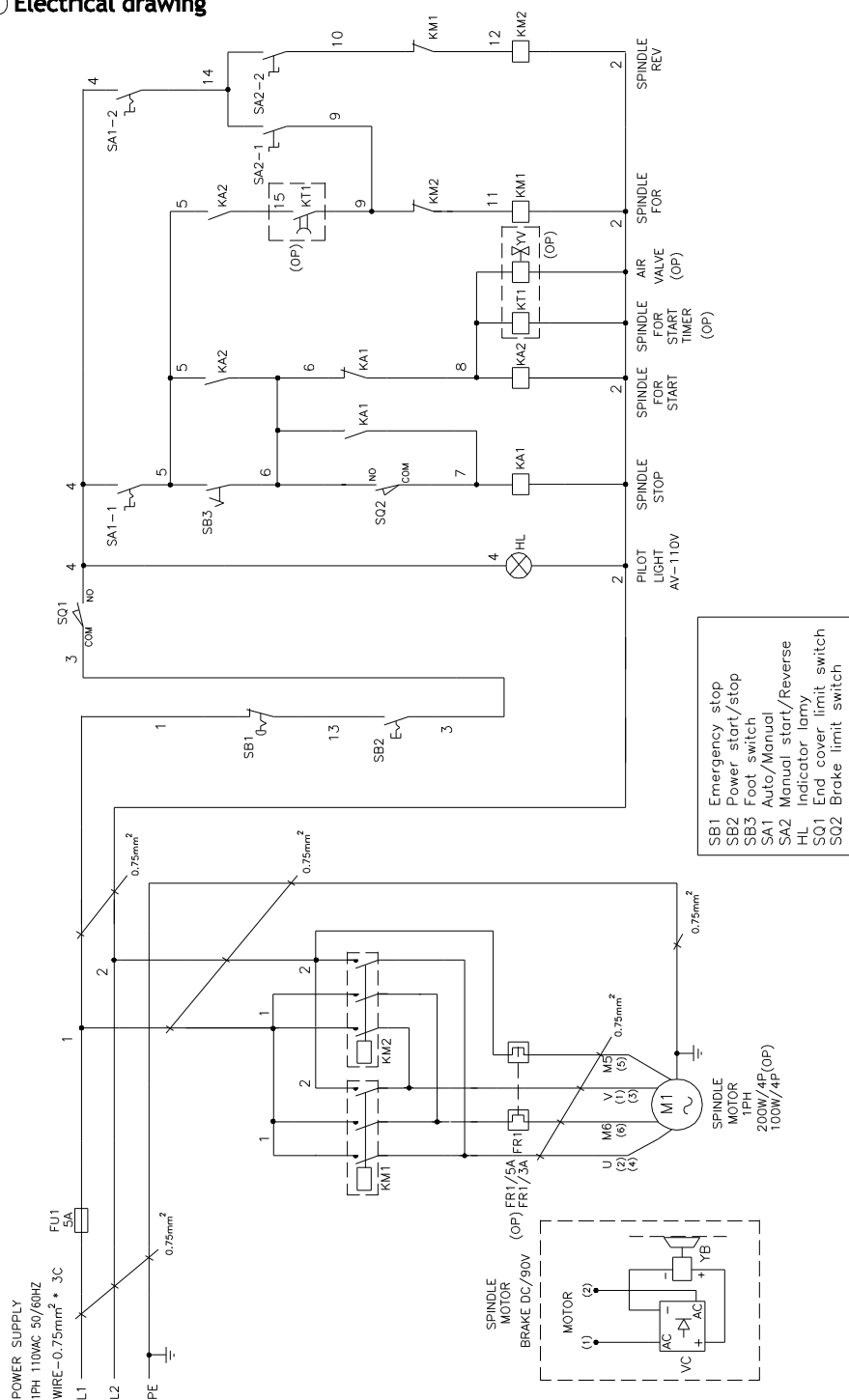
As shown put radius V-shaped blade on the oil stone. Add a little lubricate on the oil stone, smooth moves back and forth sharpened blade.

For straight blade, same operation as radius blade.

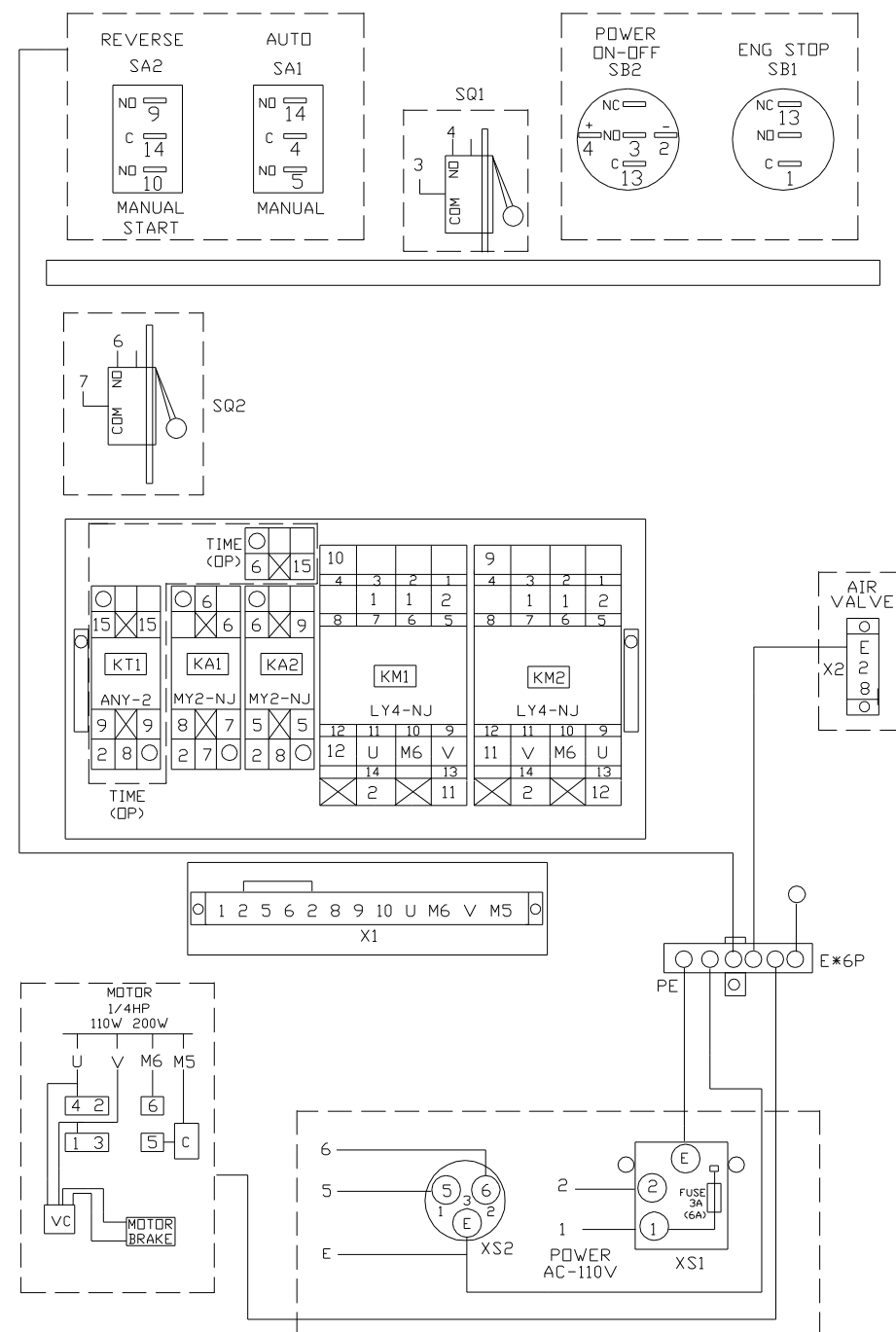
For half moon blade and K13 & K16 upper blades, sharpen by machine is recommend.

H. Electronic control system (110V)

① Electrical drawing



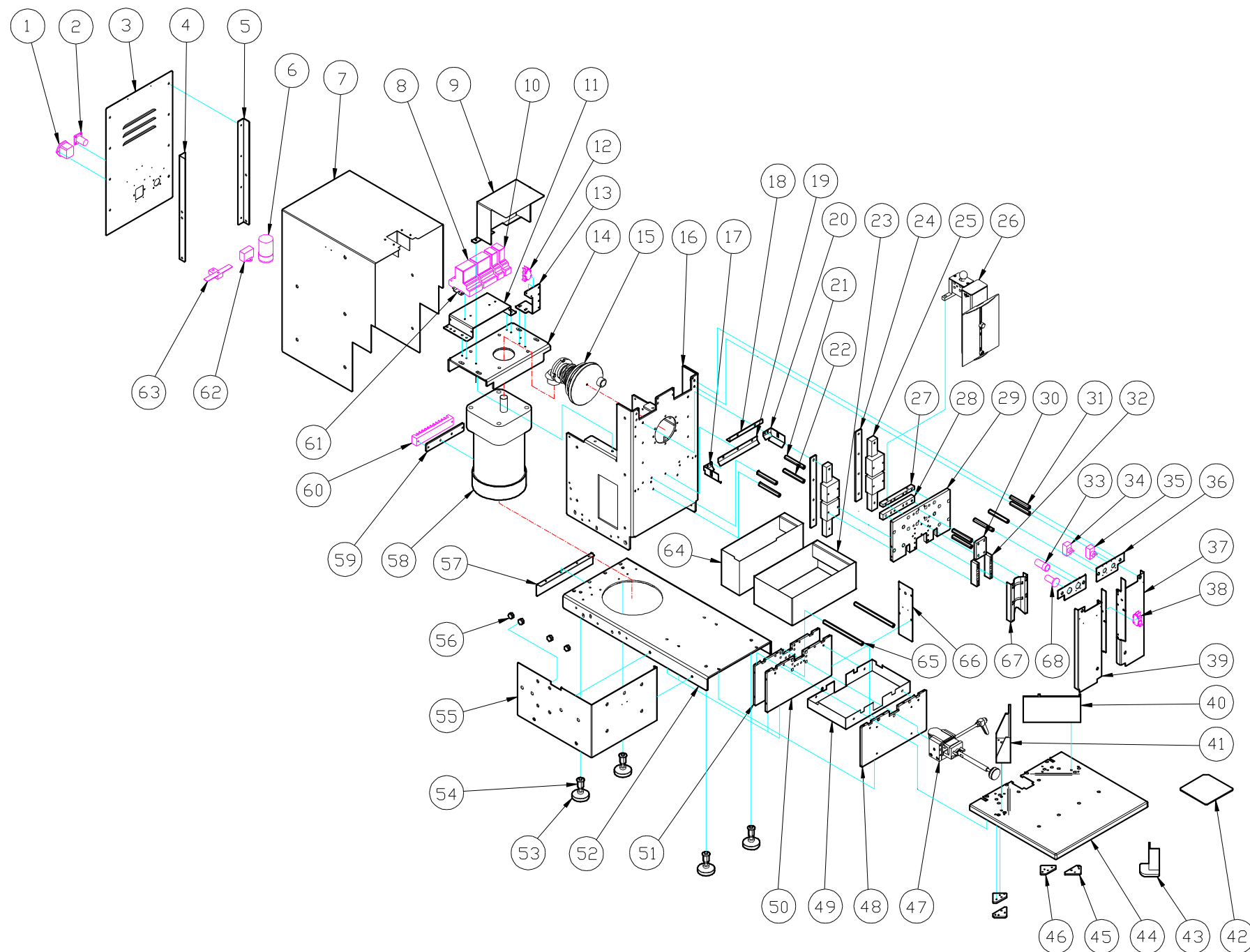
② Position chart



After service will request below information:
 1. Model number
 2. Machine serial number (marked behind on machine)
 3. Parts number, name and quantity

I. Diagram and parts list

① Machine main structure



Parts list

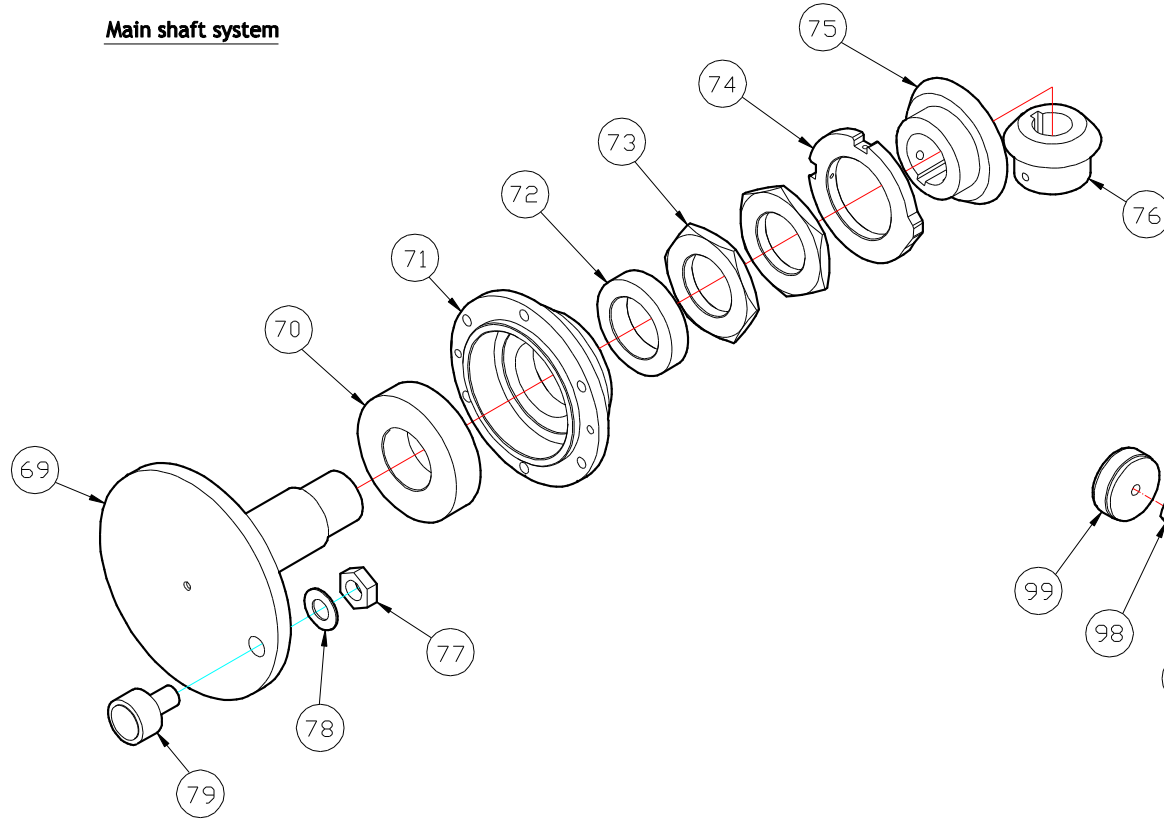
No.	Description	Diagram no.	Q'ty	No.	Description	Diagram no.	Q'ty
1	Power socket	#	1	36	Control parts plate	D14-01	2
2	Foot switch socket	#	1	37	Right front plate	D14-04	1
3	Back plate	D03-03	1	38	End cover limits switch	#	1
4	Right back fixing plate	D03-04	1	39	Left front plate	D14-03	1
5	Left back fixing plate	D03-05	1	40	Right side guide	D02-05	1
6	Condenser	#	1	41	Left side guide	D02-04	1
7	Outside the shield	D13-02	1	42	Calibrate gauge	D02-06	1
8	Large relay	#	2	43	L guide	D02-07	1
9	Gear protector cover	D04-08	1	44	Standard work desk	D15-01	1
10	Small relay	#	2	45	Back pad	D02-02	2
11	Relay base	D04-02	1	46	Front pad	D02-03	2
12	Brake limits switch	#	1	47	Lower blade system	Followed by details	
13	LS fixing plate	D04-01	1	48	Back structural plate	D05-03	1
14	Motor base	D04-03	1	49	Inner shutter	D03-01	1
15	Main shaft system	Followed by details		50	Middle structural plate	D05-02	1
16	Main structural	D02-01-1	1	51	Front structural plate	D05-01	1
17	Left scrap plate	D01-03	1	52	Main base	D01-01	1
18	Upper scrap plate	D01-02	1	53	Adjustable leg-glides	D01-06	4
19	Middle scrap plate	D01-05	1	54	Adjustable nut	D01-08	4
20	Right scrap plate	D01-04	1	55	Left cover	D03-02	1
21	Middle fixing axle	D14-10	2	56	Magnet seat	D07-11	4
22	Lower fixing axle	D14-07	2	57	Back shutter	D01-10	1
23	Tool box	D04-06	1	58	Motor (200W)	#	1
24	LG washer	D04-07	2	59	Terminal blocks seat	D04-09	1
25	Linear guideway	#	2	60	Terminal blocks	#	1
26	Paper pressure system	Followed by details		61	Relay guide seat	D04-10	1
27	CF upper guide	D07-13	1	62	Rectifier	#	1
28	CF lower guide	D07-14	1	63	Earth copper plate	#	1
29	Main slide seat	D07-01	1	64	Scrap box	D04-05	1
30	Limiting board	D07-15	1	65	Reinforcement axle	D14-09	2
31	Upper fixing axle	D14-06	6	66	Right cover	D03-06	1
32	Blade base	D07-08	2	67	Upper blade (R6)	D09-11	1
33	Power switch	#	1	68	Emergency stop switch	#	1
34	Function switch	#	1				
35	Manual start switch	#	1				

Standard hardware parts

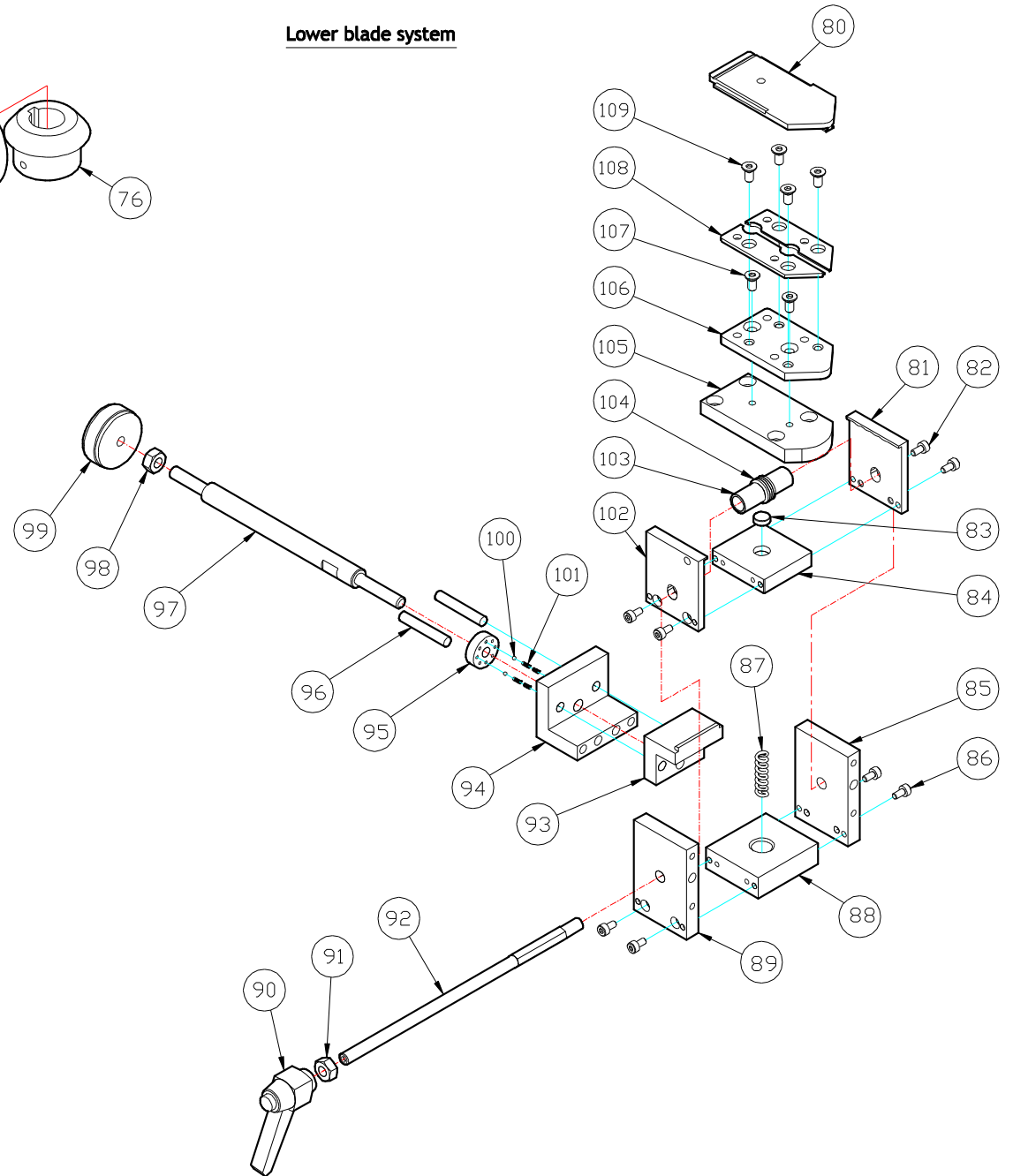
② Parts of structure: Main shaft system and Lower blade system

After service will request below information:
 1. Model number
 2. Machine serial number (marked behind on machine)
 3. Parts number, name and quantity

Main shaft system



Lower blade system



Parts list

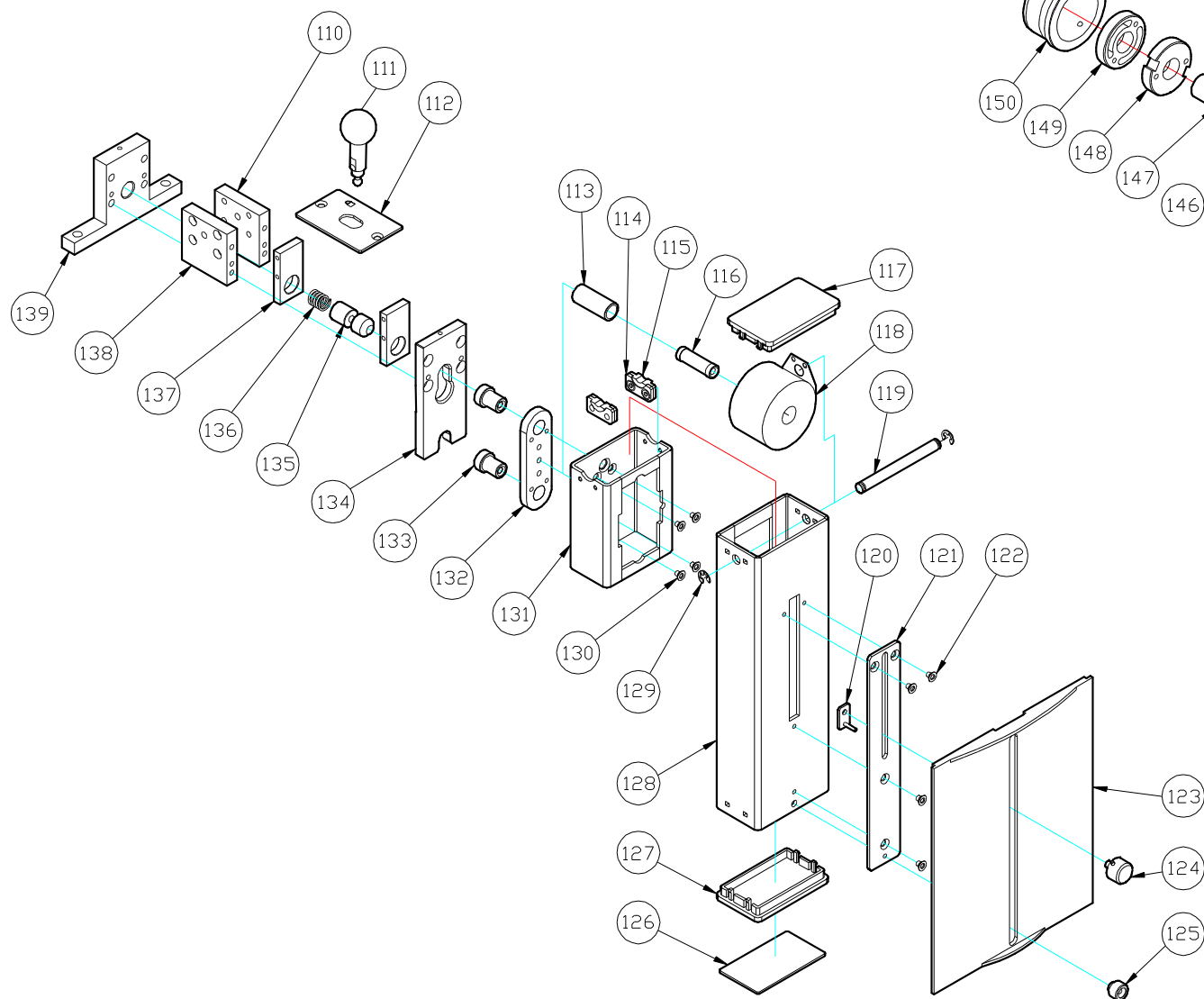
No.	Description	Diagram no.	Q'ty	No.	Description	Diagram no.	Q'ty
69	Main shaft	D07-05	1	104	Cam	D06-06	4
70	Angular contact ball bearing	# (7206)	1	105	Baseboard	D05-04	1
71	Main shaft seat	D07-06	1	106	Blade base	D05-13 (R6)	1
72	Thrust bearing	# (51106)	1	107	Setscrew	# (M4X10L)	2
73	Fixing nut	D07-10	2	108	Blade fastening plate	D05-18	2
74	Control ring	D07-09	1	109	Setscrew	# (M4X6L)	4
75	Large bevel gear	D07-16	1				
76	Small bevel gear	D07-18	1				
77	Nut	D07-21	1				
78	Washer	D07-20	1				
79	Cam followers	# (CFH10)	1				
80	Lower blade pad	D05-08 (R6)	1				
81	Left fastening plate	D06-01	1				
82	Setscrew	# (M3X6L)	4				
83	Cam washer	D06-16	1				
84	Cam baseboard	D06-03	1				
85	Left outer plate	D06-04	1				
86	Setscrew	# (M3X10L)	4				
87	Return spring	D06-10-1	1				
88	Baseboard	D06-05	1				
89	Right outer plate	D06-04	1				
90	Locking handle	D06-15	1				
91	Nut	# (M6)	1				
92	Cam shaft	D06-09	1				
93	Push plate	D06-12	1				
94	Feed base	D06-11	1				
95	Positioning plate	D06-14	1				
96	Slideway	D06-17	2				
97	Feed shaft	D06-13	1				
98	Nut	# (M6)	1				
99	Feed knob	D06-08	1				
100	Steel ball	# (Ø3)	4				
101	Spring	MP-19	4				
102	Right fastening plate	D06-02	1				
103	Shrink-ring	D06-07	2				

Standard hardware parts

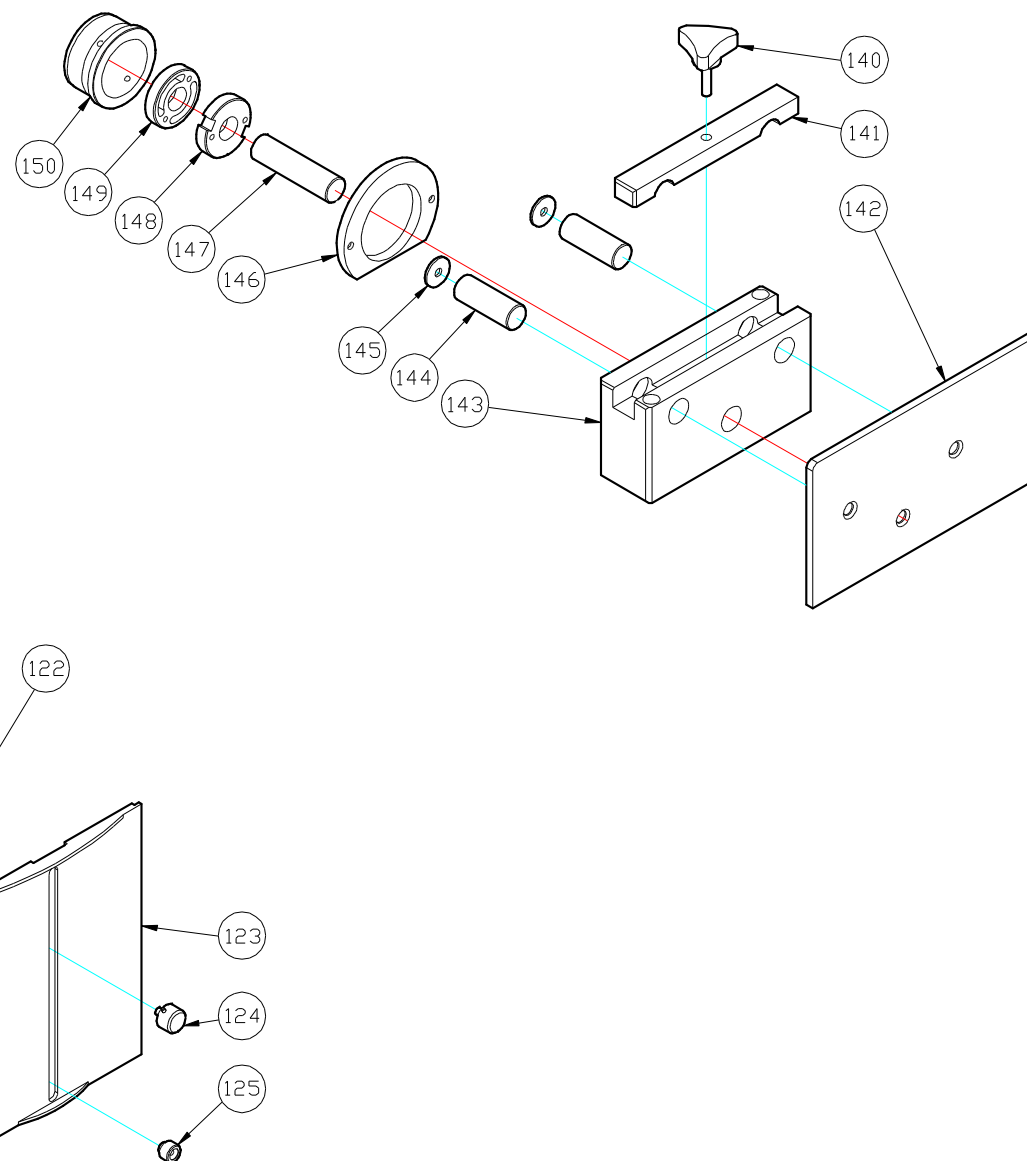
③ Parts of structure: Paper pressure system and Micro adjustment paper guide system

After service will request below information:
 1. Model number
 2. Machine serial number (marked behind on machine)
 3. Parts number, name and quantity

Paper pressure system



Micro adjustment paper guide system



Parts list

No.	Description	Diagram no.	Q'ty	No.	Description	Diagram no.	Q'ty
110	Right side plate	D10-09	1	145	Washer	D12-12	4
111	Quick-release button	D10-17	1	146	Fixing seat	D12-10	2
112	Upper plate	D10-10	1	147	Micro adjustment screw	D12-06	2
113	Sleeve	D10-21	1	148	Front adjusting nut	D12-07	2
114	Fixing plate	D10-24	2	149	Back adjusting nut	D12-08	2
115	Silencing pad	D10-25	2	150	Scale ring	D12-09	2
116	Spring shaft	D10-16	1				
117	Upper cover	D10-14	1				
118	Constant force spring	D10-19	1				
119	Hanging spring shaft	D10-15	1				
120	Slide block	D16-03	1				
121	Slideway	D16-02	1				
122	Setscrew	# (M3X3.8L)	4				
123	Safety protector	D16-01	1				
124	adjust button	D16-04	1				
125	Location axle	D16-06	1				
126	Rubber gasket	D10-23	1				
127	Lower cover	D10-13	1				
128	Outer cover	D10-01	1				
129	E-ring	# (E4)	2				
130	Setscrew	# (M3X6L)	4				
131	Inner cover	D10-02	1				
132	Space plate	D10-06	1				
133	Locating axle	D10-20	2				
134	Quick-release front plate	D10-04	1				
135	Slide shaft	D10-18	1				
136	Locking spring	D06-10-2	1				
137	Inner plate	D10-05	2				
138	Left side plate	D10-08	1				
139	Main plate	D10-03	1				
140	Setscrew	D12-13	2				
141	Pressplate	D12-05	2				
142	Panel board	D12-02-1 (L) D12-02-2 (R)	1 1				
143	Base	D12-01-1 (L) D12-01-2 (R)	1 1				
144	Guideway shaft	D12-11	4				

Standard hardware parts

④ Screws and other standard hardware parts list

No.	Hardware description	Specifications	Q'ty	No.	Hardware description	Specifications	Q'ty
1	Hex flat head screws	M3X10L	2	41	Hex socket head screws	M4X16L	2
2	Hex button head screws	M3X8L	4		Washers	Ø4X2t	2
3	Hex button head screws	M4X8L	8	44	Hex flat head screws	M4X8L	12
4	Hex socket head screws	M4X6L	2	45	Hex flat head screws	M3X10L	4
5	Hex socket head screws	M4X6L	2	46	Hex flat head screws	M3X10L	4
6	Hex socket head screws	M4X6L	2	48	Hex socket head screws	M4X12L	2
7	Hex flat head screws	M4X8L	10	49	Hex socket head screws	M4X6L	4
9	Hex socket head screws	M4X8L	2	50	Hex socket head screws	M4X12L	2
11	Hex socket head screws	M4X8L	4	51	Hex socket head screws	M4X12L	2
12	Cross round head screws	M3X16L	2	54	Washers	Ø8x2t	4
13	Hex socket head screws	M4X6L	2	55	Hex flat head screws	M4X8L	10
14	Hex socket head screws	M6X20L	4	57	Hex flat head screws	M4X8L	4
	Washers	Ø6X2t	4	58	Hex socket head screws	M8X25L	4
	Hex nuts	M6	4		Washers	Ø8x2t	4
16	Hex socket head screws	M5X10L	8		Hex nuts	M8	4
	Location pins	Ø5x10L	2	59	Cross round head screws	13/16" X 3/8" L	2
17	Cross round head screws	M4X8L	2	60	Hex socket head screws	M4X10L	2
18	Hex socket head screws	M4X8L	2	61	Hex socket head screws	M4X8L	2
19	Cross round head screws	M4X8L	3	62	Hex socket head screws	M4X12L	1
20	Cross round head screws	M4X8L	2	63	Hex socket head screws	M5X10L	1
21	Hex socket head screws	M4X12L	2	65	Hex socket head screws	M4X12L	2
22	Hex socket head screws	M4X12L	2		Hex socket head screws	M4X8L	2
25	Hex socket head screws	M5X25L	8	66	Hex flat head screws	M3X10L	4
27	Hex socket head screws	M5X12L	4	67	Hex button head screws	M4X8L	4
	Location pins	Ø5X16L	2	70	Angular contact ball bearing	7206	1
28	Hex socket head screws	M5X12L	4	71	Hex socket head screws	M5X12L	6
	Location pins	Ø5X16L	2		Location pins	Ø4X10L	2
29	Hex socket head screws	M5X10L	8	72	Thrust bearing	51106	1
30	Hex socket head screws	M4X16L	4	74	Hex socket head screws	M3X8L	2
31	Hex socket head screws	M4X12L	6	75	Hex headless screws	M5X8L	2
32	Hex socket head screws	M4X20L	6		Square keys	5X20L	1
	Location pins	Ø3X10L	6	76	Hex socket head screws	M5X8L	2
36	Hex flat head screws	M4X8L	4		Square keys	5X20L	1
37	Hex flat head screws	M4X8L	2	79	Cam followers	CFH10	1
38	Cross round head screws	M3X20L	2	81	Hex socket head screws	M3X8L	2
	Hex nuts	M3	2		Location pins	Ø3X10L	2
39	Hex flat head screws	M4X8L	2	85	Hex socket head screws	M3X12L	2
40	Hex socket head screws	M4X16L	2		Hex socket head screws	M4X8L	2
	Washers	Ø4X2t	2		Hex socket head screws	M4X12L	2

No.	Hardware description	Specifications	Q'ty	No.	Hardware description	Specifications	Q'ty
85	Location pins	Ø3X12L	2				
	Location pins	Ø5X12L	2				
89	Hex socket head screws	M3X12L	2				
	Hex socket head screws	M4X8L	2				
	Hex socket head screws	M4X12L	2				
	Location pins	Ø3X12L	2				
	Location pins	Ø5X12L	2				
93	Location pins	Ø5X28L	2				
94	Hex socket head screws	M4X28L	2				
	Location pins	Ø5X10L	2				
95	Steel ball	Ø3	4				
102	Hex socket head screws	M3X8L	2				
	Location pins	Ø3X10L	2				
105	Hex socket head screws	M4X10L	4				
106	Hex flat head screws	M4X10L	2				
108	Hex flat head screws	M4X6L	4				
	Location pins	Ø4X6L	4				
110	Hex socket head screws	M4X12L	2				
112	Hex flat head screws	M3X6L	2				
114	Hex flat head screws	M3X5.5L	4				
118	Hex flat head screws	M4X34L	1				
119	E-ring	Ø4	2				
121	Hex flat head screws	M3X3.8L	4				
132	Hex flat head screws	M3X6L	4				
133	Hex flat head screws	M4X10L	2				
134	Hex socket head screws	M4X8L	4				
137	Hex socket head screws	M3X8L	8				
138	Hex socket head screws	M4X12L	2				
	Hex socket head screws	M4X29L	1				
139	Hex socket head screws	M5X16L	2				
142	Hex flat head screws	M4X10L	6				
143	Hex socket head screws	M4X50L	4				
146	Hex socket head screws	M3X8L	4				
149	Hex socket head screws	M3X12L	4				
150	Hex headless screws	M3X6L	4				

SPECIFICATIONS

Item No.	AD-7					
Seven Kinds of Blades	Radius	1/8"	1/4"	3/8"	1/2"	5/8"
	Half Moon	diameter 13/16"	Straight		length 5/8"	
Cutting Capacity	27.56" (700 sheets)					
Cutting Speed	46 rpm					
Dimensions	24.6"(W) X 12.6"(D) X 17.5"(H)					
Weight / Volumn	110 lbs / 3.14 CbFt					
Power	110vac	Single-Phase (50~60Hz)				
Motor	200 W					