

## How to change radius die set on S-500 Corner Cutter

### Changing blade

**(Warning: Sharp knife. Be careful during replacement.)**

- Switch the machine off.
- Remove the clamp.
- Remove the left and right side lays.
- Loosen the two lower die fixing screws.
- Take away the lower die.
- Loosen the four fixing plate screws.
- Replace a new upper blade back into the original position and make sure screws fasten tightly.
- Switch the machine on then press the inching button to have the upper blade cut down to the lowest point.
- Put the lower die into the working desk, and setting two screws.
- As shown in the photo, right hand pushes the lower die to press the upper blade slightly then fasten two screws.
- After replacing the blade, the side lays must be recalibrated.



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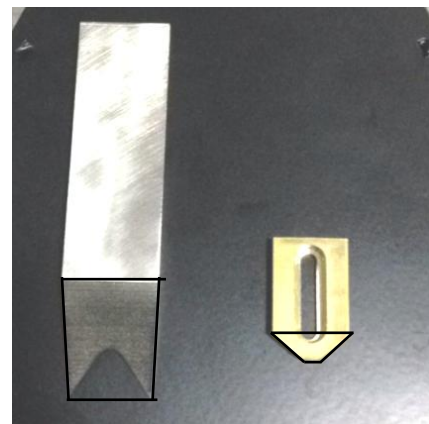
### Calibration for side lays

- Switch the machine on then press the inching button to have the upper blade cut down to the lowest point.
- Place the calibration gauge onto the working table. Push it to let its angle press the upper blade with no gap.
- Push the left and right side lays to close the left and right edges of the calibration gauge then fasten their fixing screws.



### Sharpening blade and die

- Sharpen the upper blade and the lower die, grind the plane shown at the arrowed place and remove 0.1mm per time.
- One sharpening process can sustain for over 10,000 cuts, but still depending on the operation and the materials.



### Lubrication

- Refuel lubricant every 30 days for using frequently, for not often use every 90 days.
- Switch the machine off, unplug the power cord.
- Remove the cover, lubricate sliding motion mechanism.
- Adjust sliding gap every 90 days for using frequently, for not often use every 180 days.
- Loosen the two screws of lower die, loosen the two screws of left sliding bar then let the sliding bar clamp the upper blade carrier slightly then fasten their screws.
- Attention, the blade must be recalibrated after adjustment.

