## SPECIFICATIONS

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### A. Name of machine parts

- **Power switch**
- **Auto/Manual select button**
- **Emergency stop**
- **Reverse/Manual start select button**
- **Adjust button for safety protector**
- **Front plate**
- **Right side guide**
- **Left side guide**
- **Standard work desk (12.6"X11.8")**
- **Standard work desk (12.6"X11.8")**
- **Upper blade**
- **Machine serial number**
- **Scrap box**
- **Foot switch socket**
- **Feed adjustment for lower blade pad**
- **Feed button for lower blade pad**
- **Tool box**
- **Foot switch socket**
B. Safety instructions  (Before setting up the machine, carefully read all the manual)

⚠ Make sure the outlet with the correct volgate 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 (3 radius upper blades, 1 straight blade, total 4 kinds)

AD6-K13-5 Upper blade Size: R 1/8"
AD6-K16 Upper blade Size: R 1/4"
AD6-K10 Upper blade Size: R 3/8"
AD6-C15 Straight blade Size: 5/8"

② Lower blade pads (straight blade can be with any kinds of lower blade pad)

AD6-K13-1 Lower blade pad Size: R 1/8"
AD6-K16 Lower blade pad Size: R 1/4"
AD6-K10-2 Lower blade pad Size: R 3/8"

Parts list

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* Standard hardware parts
H. Electronic control system (110V)

① Electrical drawing

D. Standard parts & accessories (total 8 parts)

- Standard work desk - 1 pc
  Size: 12.6" x 11.8"
- Left and right side guide - each 1 pc
- Tool and scrap box - each 1 pc
- Maintenance tool:
  1. Cross-head and flat-head screwdriver - each 1 pc
  2. T-type hex wrench (5, 5.5, 6) - each 1 pc
  3. Hex wrench (1.5, 2.5, 3/4) - each 1 pc
  4. File (44) - 5 pcs
- Operational manual - 1 book
- 1 1/4" upper blade - 1 pc
- 1 1/4" lower blade pad - 10 pcs
- 1 1/4" blade base - 1 set
- Safety protector - 1 set

E. Optional parts & accessories (total 8 parts)

- L-guide
- Straight blade
  Size: 5/8"
- Straight blade base
- Upper blade
  Size: 1/8", 1/4", 3/8"
- Blade base
  Size: 1/8", 1/4", 3/8"
- Lower blade pad
  Size: 1/8", 1/4", 3/8"
- Calibrate gauge
- 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.

   - 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 shows the 2 holes are for right side guide hole, ② shown the reference line for the right side guide place and adjust the reference.

   - 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.

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

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

   - 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.
G. Maintenance

1. Changing fuse and discharge capacitor

- Replace the fuse.
- Unplug the power cord.
- Take flat-head screwdriver, pry-open the hole as picture shown outward, pull out the fuse holder by another hand.
- 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.
- Use the flat-head screwdriver pry open the cover of the terminal blocks.
- 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.
- 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)

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

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.

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

Before operation, 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 PS50-PS51.

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)

Put one sheet of paper close to right and left side guide.(Keep finger out of safety protector) Stop 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.)
2. Right and left side guide adjustment
   a. Without calibrate gauge

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

   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.

4. 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.

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d. Changing the straight blade C15

1. Turn off power and release the front plate.
2. Use left hand 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 front plate. 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 4 pcs of fixing screw, make sure screws fasten tightly.
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.
2. Take 2.5mm hex wrench to loose 2 pcs of fixed screws.

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

b. Changing the lower blade pad
(3 upper blade with 3 lower blade; Ex: K6 lower blade with K6 upper blade)

1. Install the front plate.
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 front plate.
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)

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.

3 Changing blades
a. Changing the upper blade

1. Turn off the power.
2. Remove the front plate.
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 locking)

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

As drawing shown left cut is too little need to move outward (to left) of left side guide.
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.
2. Take 2.5mm hex wrench to loose 2 pcs of fixed screws.

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

b. Changing the lower blade pad
(3 upper blade with 3 lower blade; Ex: K6 lower blade with K6 upper blade)

1. Install the front plate.
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 front plate.
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)

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

3 Changing blades
a. Changing the upper blade

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

Caution: T-type blade is sharp, do not touch with fingers.
As shown use left hand two fingers 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 pins as arrow shown. Take 2.5mm T-type hex wrench to lock the 4 pcs screw. (Please check again for well locking)
2. Right and left side guide adjustment

a. Without calibrate gauge

- Cut is too much need to adjust

Above shown the right side cut is too much need to move inward of left paper guide.

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.

(4) 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.

d. Changing the straight blade C15

1. Turn off power and release the front plate.
2. Use left hand 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 front plate. The C15 blade is now complete.
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 meets 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 M8 junction of the screw, and use flat-head screwdriver to hold the M8 junction of the screw, then move both screwdriver to touch. At same moment will have sparks 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
  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.

- Gear protector
  1. 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.
  2. As shown is the cam track for lubrication, take few lubricant by flat-head screwdriver and spread lubricant on both sides of cam track.

- As shown is the foot switch.
  1. Turn the operation mode to auto. (For manual mode, leave the upper blade slightly off the top position, and stop 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)

- As shown is the foot switch.
  1. Release the fixed button of lower blade pad counter-clockwise.
  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 forward to press.
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.

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 screws(size: M6×8).

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.

2. Lubrication

PB4/P115 is shown how to lubricating for blade pad system
① Remove the left and right side guide and work desk.
② Lubricate the movement blade pad feeding device.

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

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)

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.
H. Electronic control system (110V)

1. Electrical drawing

D. Standard parts & accessories (total 8 parts)
- Standard work desk - 1 pc
  Size: 12.6" x 11.8"
- Left and right side guide - each 1 pc
- Tool and scrap box - each 1 pc
- Maintenance tool:
  1. Cross-hex flat-head screwdriver wrench - each 1 pc
  2. T-handle wrench (3/5/3) - each 1 pc
  3. Hex wrench (1/5/2/2/3/3/4) - each 1 pc
  4. File (64 mm) - 5 pcs
- Operational manual - 1 book
- 1/4" upper blade - 1 pc
- 1/4" lower blade pad - 10 pcs
- 1/4" blade base - 1 set
- Safety protector - 1 set

E. Optional parts & accessories (total 8 parts)
- L guide
- Straight blade
  Size: 5/8" (1/8", 1/4", 3/8"
- Straight blade base
- Upper blade
  Size: 1/8", 1/4", 3/8"
- Blade base
  Size: 1/8", 1/4", 3/8"
- Lower blade pad
  Size: 1/8", 1/4", 3/8"
- Calibrate gauge
- Oil stone
  Size: 6" x 2" x 1"
Position chart
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* Standard hardware parts
Parts of structure: Main shaft system and Lower blade system

Main shaft system

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

We reserve the right to change the design.
B. Safety instructions (Before setting up the machine, carefully read all the manual)

⚠️ Make sure the outlet with the correct voltate 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 (3 radius upper blades, 1 straight blade, total 4 kinds)

- AD6-K13 Upper blade Size: R 1/8”
- AD6-K15 Upper blade Size: R 3/8”
- AD6-C15 Straight blade Size: 5/8”

2. Lower blade pads (straight blade can be with any kinds of lower blade pad)

- AD6-K9-2 Lower blade pad Size: R 1/4”
- AD6-K10-2 Lower blade pad Size: R 3/8”

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* Standard hardware parts
### Screws and other standard hardware parts list

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### A. Name of machine parts

- **Power switch**
- **Auto/Manual select button**
- **Emergency stop**
- **Reverse/Manual start select button**
- **Adjust button for safety protector**
- **Right side guide**
- **Left side guide**
- **Lower blade pad**
- **Standard work desk (12.6"x11.8")**
- **Upper blade**
- **Scrap box**
- **Foot switch socket**
- **Feed adjustment for lower blade pad**
- **Tool box**
- **Foot switch socket**
- **Machine serial number**
- **Power socket**
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<td>Steel ball</td>
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<td>108</td>
<td>Hex flat head screws</td>
<td>M4X6L</td>
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<tr>
<td>109</td>
<td>Location pin</td>
<td>Ø4X6L</td>
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## ELECTRIC CORNER Rounding MACHINE

### OPERATIONAL MANUAL

<table>
<thead>
<tr>
<th>Item No.</th>
<th>AD-6</th>
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<tbody>
<tr>
<td><strong>SPECIFICATIONS</strong></td>
<td></td>
</tr>
<tr>
<td><strong>Four Kinds of Blades</strong></td>
<td>Radius</td>
</tr>
<tr>
<td></td>
<td>Straight</td>
</tr>
<tr>
<td><strong>Cutting Capacity</strong></td>
<td>23.6&quot; (600 sheets)</td>
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<tr>
<td><strong>Cutting Speed</strong></td>
<td>46 rpm</td>
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<tr>
<td><strong>Dimensions</strong></td>
<td>24.6&quot;(W) X 12.6&quot;(D) X 17.5&quot;(H)</td>
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<tr>
<td><strong>Weight / Volumn</strong></td>
<td>103 lbs / 3.14 CbFt</td>
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<tr>
<td><strong>Power</strong></td>
<td>110vac</td>
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<tr>
<td><strong>Motor</strong></td>
<td>100 W</td>
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