

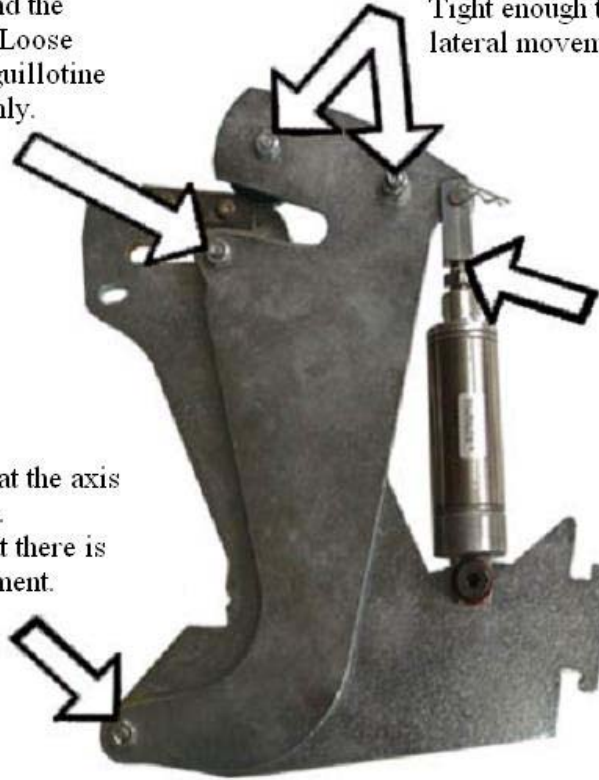
## Adjusting the Guillotine

Tight enough that there is no separation between the Cutting Blade and the Cutting Wheel. Loose enough that the guillotine can slide smoothly.

Loose enough that the Cutting Wheel can spin freely. Tight enough that there is no lateral movement.

Loose enough that the axis can rotate freely. Tight enough that there is no lateral movement.

Adjust the Clevis so that, when the cylinder arm is fully extended, the Cutting Wheel is at the end of the Cutting Blade.



**Cutting Wheel:** This should be adjusted so the wheel can spin with little force. The wheel should have very little (if any) lateral movement. To adjust properly, tighten the machine screw then back off  $\frac{1}{4}$  turn. While securing the Phillips end of the machine screw, tighten the jam nut on the other side. Spin the Cutting Wheel. If the Cutting Wheel is too tight, loosen the jam nut, turn the machine screw  $\frac{1}{8}$  turn CW, and re-tighten the jam nut. If the Cutting Wheel is too loose, loosen the jam nut, turn the machine screw  $\frac{1}{8}$  turn CCW, and re-tighten the jam nut.

**NOTE:** the Cutting Wheel should NOT have a sharp edge; it is designed to roll over the banding so that the blade will cut the banding.

**Swing Arm:** The Swing Arm should move freely back and forth with very little lateral movement. The Swing Arm, when pushed forward and released, should fall back to the starting position. To adjust properly, tighten the machine screw then back off  $\frac{1}{4}$  turn. While securing the Phillips end of the machine screw, tighten the jam nut on the other side. Manipulate the Swing Arm back and forth. If the Swing Arm is too tight, loosen

the jam nut, turn the machine screw  $\frac{1}{8}$  turn CCW and re-tighten the jam nut. If the Swing Arm is too loose, loosen the jam nut, turn the machine screw  $\frac{1}{8}$  of a turn CW, and tighten the jam nut.

**Cutting Wheel Alignment:** The Cutting Wheel should slide back and forth freely next to the Cutting Blade without putting tension on the blade. Loosen the jam nut and the flat head machine screw. Tighten the flat head machine screw until the Cutting Wheel just touches the Cutting Blade, then tighten the jam nut. Manipulate Swing Arm back and forth. Watch the contact between the blade and the Cutting Wheel. If the Cutting Wheel sticks on the blade, loosen the jam nut, turn the flat head machine screw  $\frac{1}{8}$  turn CCW, and re-tighten the jam nut. If there is a gap between the Cutting Wheel and the blade, loosen the jam nut, turn the machine screw  $\frac{1}{8}$  of a turn CW, and re-tighten the jam nut.

## EQ Specifications

Banding Material Width: up to 1"  
Banding Material Thickness: up to 1.5 mil  
Banding Material Bend Radius: up to 1.25"

Maximum Stock Width 7/8"

Recommend 1" banding for 7/8" stock  
Recommend 15/16" banding for 3/4" stock  
Recommend 7/8" banding for 5/8" stock

Temperature:  $\pm 10^{\circ}$  F

<i>Setting</i>	<i>Temperature</i>
0	0°
1	350°
2	360°
3	370°
4	380°
5	390°
6	400°
7	410°
8	420°
9	430°
10	440°