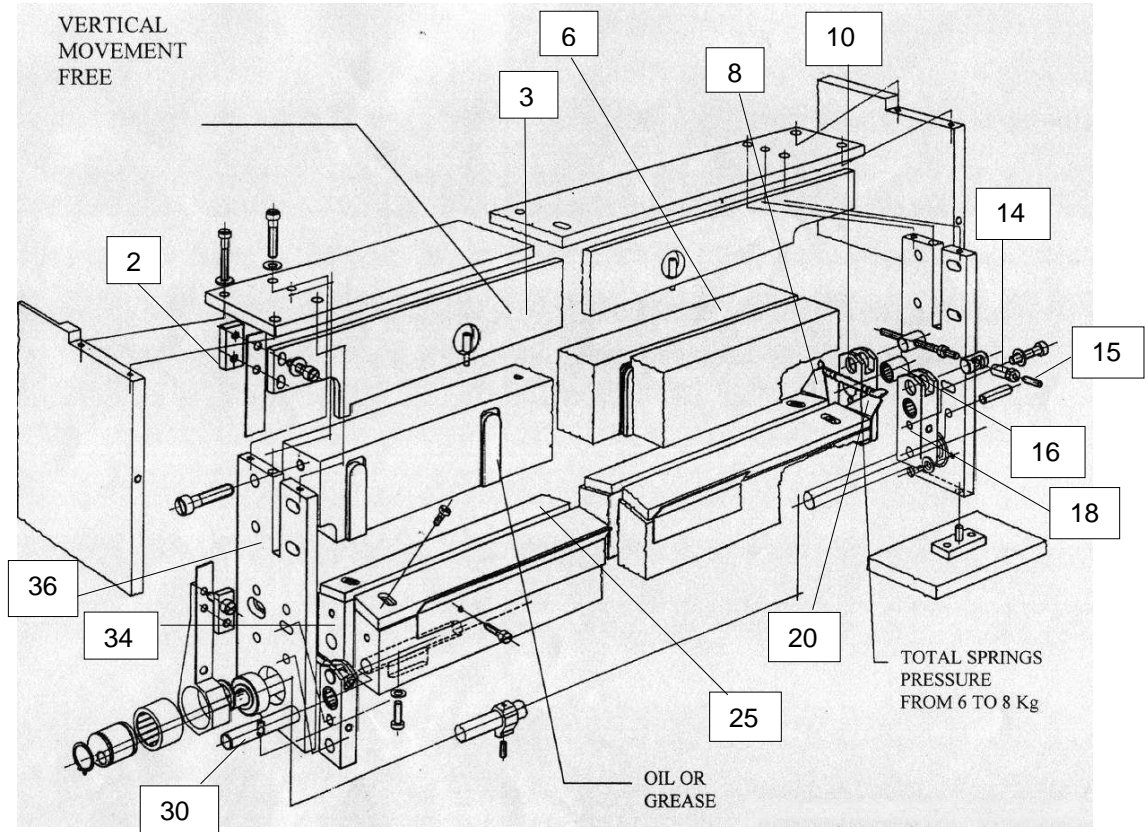


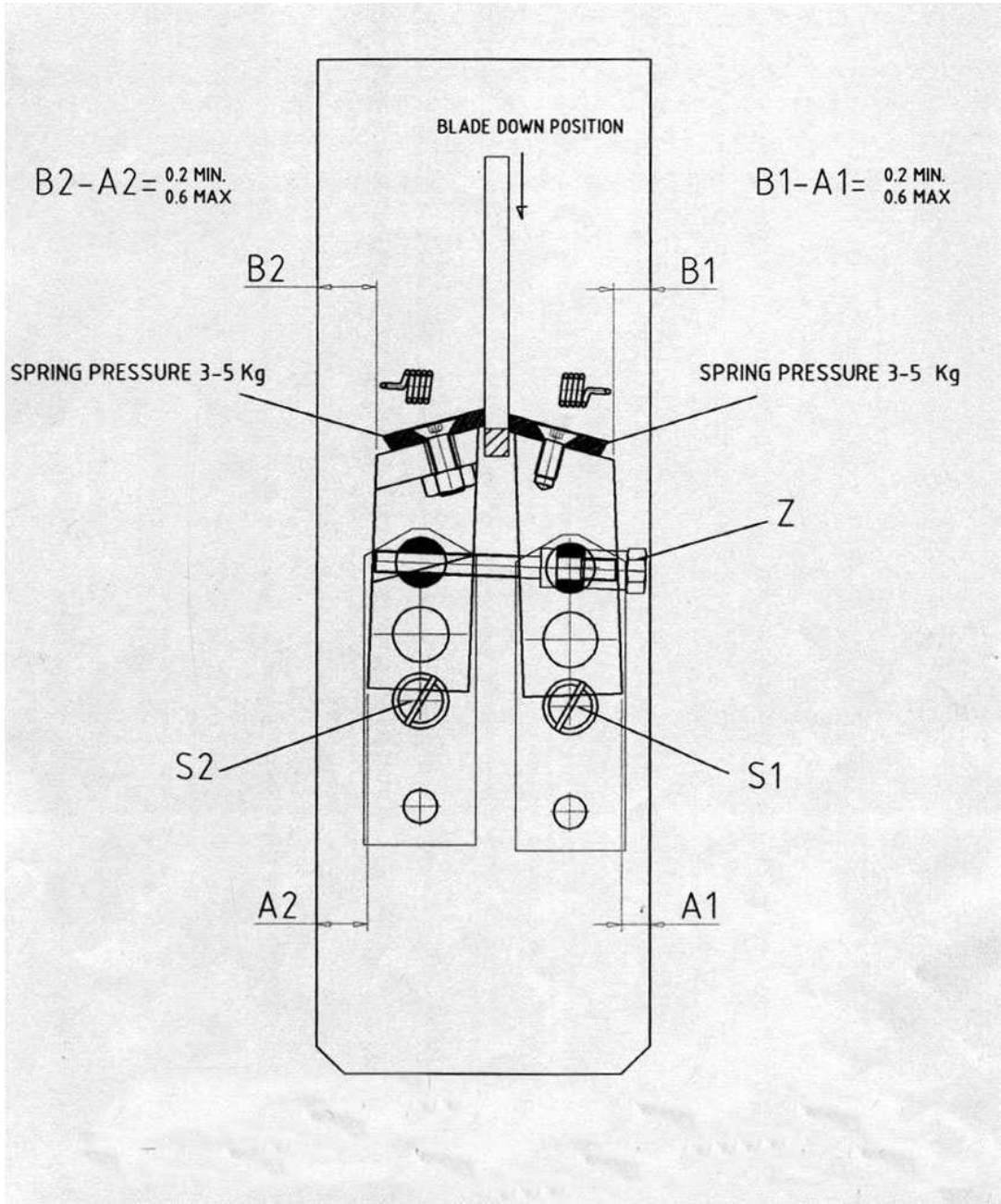
<p style="text-align: center;">CARTRIDGE SETUP 18" VERTICAL BLADE CARTRIDGE</p>

- Place main blade (3) onto rear main block (6). Insert four cap head screws (two each side), through main block flexible coupling, into plate (2) and nip up.
- Place front block onto blade and insert screws. Tap block onto main blade and check for movement between back and front block. With very little movement, tighten up screws on block and main blade, checking again for movement.
- To set rear blade, place rear blade (25) onto rear blade holder (34) and nip up three countersunk screws. Check from edge of blade with straight edge. By using carbon paper and hand pressure only, cut over full length to check for straightness of blade. Tighten up screws.
- To set front blade, use the same procedure as rear.
- Insert rear blade holder into cassette by pulling out dowels (30) through angle block (10) and roller bearing (16) into side plates (36). Rear holder should be lower than front by 1 mm.
- To set angle of rear blade, lock up right hand front angle block (18) and adjust angle to 1 degree by rotating screws (15).
- To adjust shear angle, lock up left hand front angle block (18). Apply hand pressure to holder and adjust screw (15) until blade will cut carbon paper the full length and lock up rear angle blocks (18).
- To set front blade, loosen front angle blocks and use the same procedure as rear.
- To adjust angles use screws (14).
- To set pressure on blades adjust spring retainers (8 and 20): out for more pressure and in for less.
- Set blades to cut on as little pressure as possible.

**CARTRIDGE SETUP
18" VERTICAL BLADE CARTRIDGE**

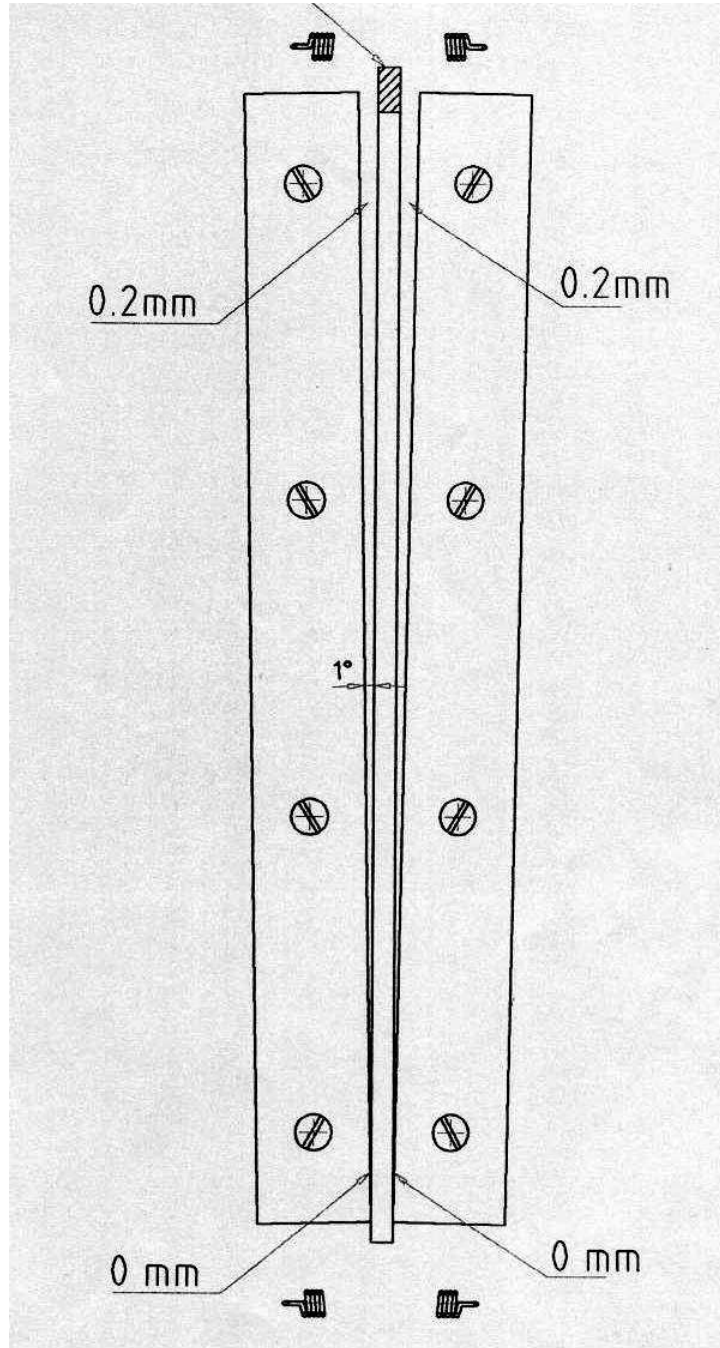


**CARTRIDGE SETUP
18" VERTICAL BLADE CARTRIDGE**



To set A1/B1 unlock S1 and turn Z then lock S1
 To set A2/B2 unlock S2 and turn Z then lock S2

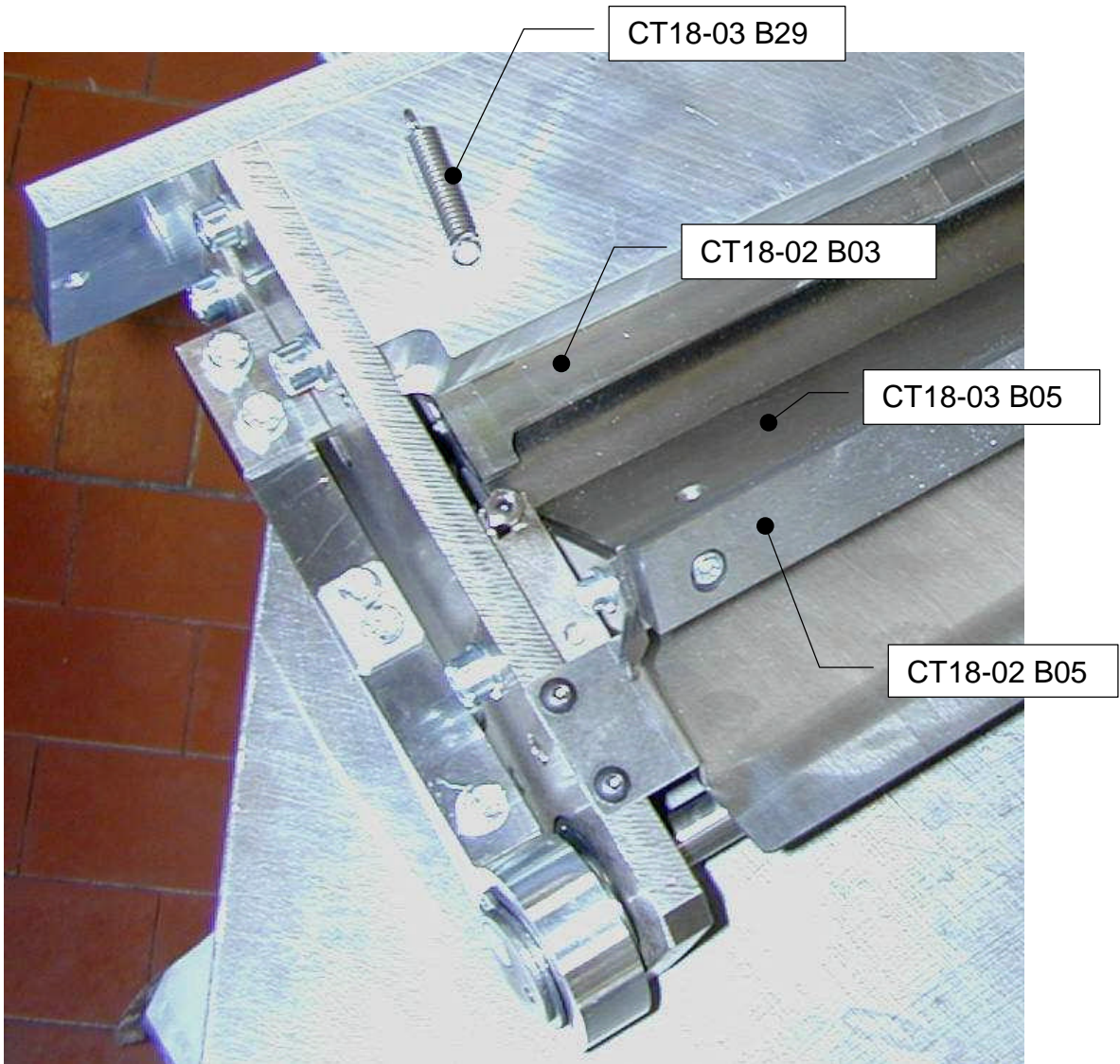
**CARTRIDGE SETUP
18" VERTICAL BLADE CARTRIDGE**



Upper blade in lower position

**CARTRIDGE SETUP
18" VERTICAL BLADE CARTRIDGE**

SPARE PARTS



**CARTRIDGE SETUP
18" VERTICAL BLADE CARTRIDGE**

