

CR-55 Cornerounder®

USER'S MANUAL



*Before operating this equipment, please read these instructions completely and keep these operating instructions for future reference.*

Serial Number: \_\_\_\_\_  
Date of Purchase: \_\_\_\_\_  
Dealer: \_\_\_\_\_  
Address: \_\_\_\_\_  
\_\_\_\_\_  
Telephone Number: \_\_\_\_\_

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# 2 - Safety

## 2.1 - Safety Instructions

- All operators must read and understand the Users Manual including all safety instructions before using this equipment. Failure to fully understand the safety instructions can result in personal injury. If after reading the manual you are still uncertain about use, please contact the dealer from whom you purchased the machine for assistance. If you need contact information for a Service Technician nearest you please call 585-436-1934.
- SAFETY OF THIS EQUIPMENT IS THE RESPONSIBILITY OF THE USER(S).
- Please read and follow all warning labels on your machine.
- Keep hands clear while operating machine.
- THIS MACHINE IS DESIGNED FOR ONE PERSON OPERATION. Never operate the machine with more than one person.

# 1 - Introduction

## 1.1 - Your New CR-55

- Thank you for your purchase of the CR-55 Cornerounder®.
- We ask that you take a moment to fill in the serial number and other information on the front cover of the manual. Please keep this manual as a reference for future use.
- For parts and service, please contact the Lassco-Wizer Dealer from whom you purchased the machine. If you require assistance in locating a Lassco-Wizer Dealer please contact our customer service department at 585-436-1934. Please have the model of your machine and the serial number when you call.
- If you wish to write to us, send correspondence to:

Lassco-Wizer  
Attn: Customer Service  
485 Hague Street  
Rochester, NY 14606

## 1.2 - Shipping Damage Inspection

- Remove the machine from the carton and inspect for any shipping damage. If any damage is present, report the damage to the carrier immediately; failure to do so may void any warranties.

- KEEP CHILDREN AWAY. All visitors should be kept a safe distance from the work area.
- USE RIGHT MACHINE. Don't force tool or attachment to do a job for which it was not designed.
- MAINTAIN MACHINE WITH CARE. Keep tools sharp and clean for best and safest performance. Follow instructions for maintaining and changing accessories.
- NEVER STAND ON MACHINE. Serious injury could occur if the machine is tipped.
- CHECK DAMAGED PARTS. Before further use of the machine, a part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function--check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

## 2 - Safety

### 2.2 - Warning Labels

#### English



**⚠ WARNING**  
Moving parts can  
crush and cut  
Keep hands clear  
while operating  
machine.

#### French

#### **⚠ AVERTISSEMENT**

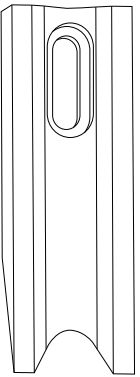
Les pieces mobiles peuvent  
écraser et couper.  
Éloignez les mains lorsque  
vous opérez cette machine.

## 3 - Setting Up Your Machine

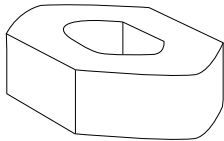
### 3.1 - Loose Items Inventory

- Please remove and inspect the following items:

Blade (2)



Die (1)



HEX-18:  
Hex Wrench 1/8" (1)



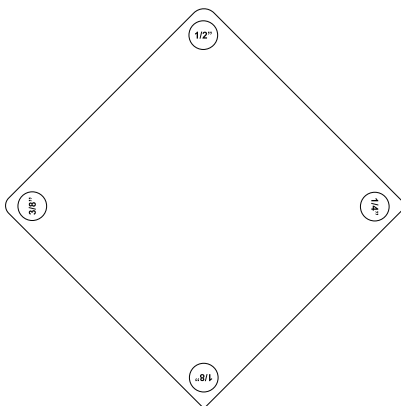
HEX-316:  
Hex Wrench 3/16" (1)



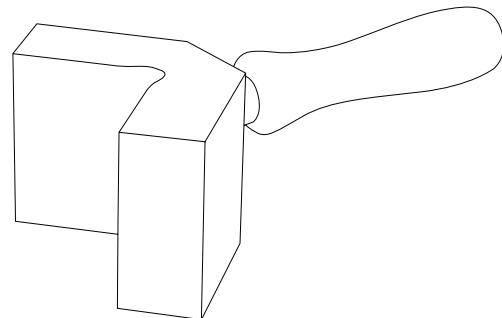
HEX-532:  
Hex Wrench 5/32" (1)



CR-AG:  
Alignment Guide (1)



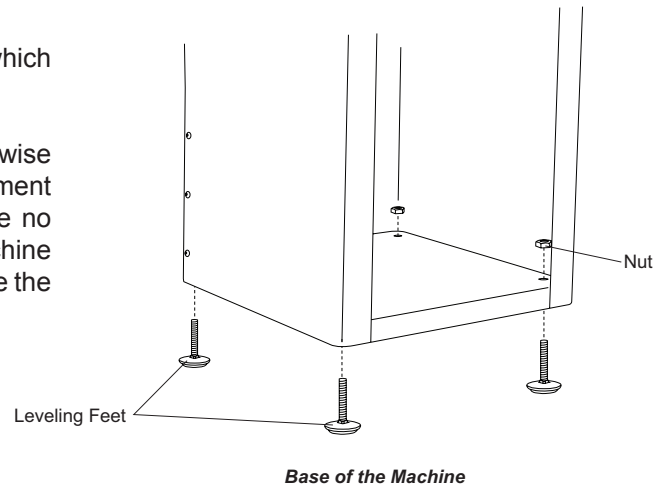
CR55-PB:  
Right Angle Push Block (1)



## 3 - Setting Up Your Machine

### 3.2 - Installing the Leveling Feet

- 3.2.1** Set the machine down in its desired location and determine if the machine is level, making sure that it does NOT rock in any direction. If it does, determine which Leveling Feet need to be adjusted and whether they need to be adjusted up or down.
- 3.2.2** If adjustment is needed, start by loosening the four (4) nuts which are accessed through the rear of the machine.
- 3.2.3** Next adjust the four (4) Leveling Feet by screwing them clockwise to raise the or counter-clockwise to lower. After each adjustment set the machine down completely to verify that the machine no longer rocks. Continue adjustment as needed until the machine sits securely in place. Tighten the four (4) nuts down to secure the position of the Leveling Feet.

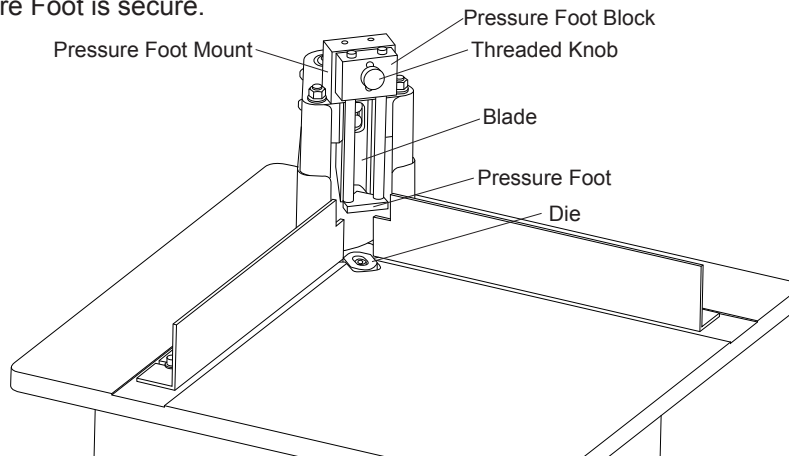


### 3.3 - Installing the Blade and Die

- 3.3.1** Remove the Pressure Foot assembly from the Pressure Foot Mount by unscrewing the threaded knob on the front of the Pressure Foot Block. Pull the Pressure Foot Block straight out away from the machine to remove.
- 3.3.2** Using the 5/32" Hex Wrench, remove the two(2) hex screws for the Blade and the one(1) hex screw for the Die.
- 3.3.3** Insert the desired Blade in its position making sure the blade is positioned all the way up in the Blade Holder. Tighten down the two(2) hex screws for the Blade until it is secure.
- 3.3.4** Insert the new corresponding Die facing the new Blade. Replace the hex screw for the Die but do not tighten completely.

***The Blade must not come down on the Die, this will cause damage***

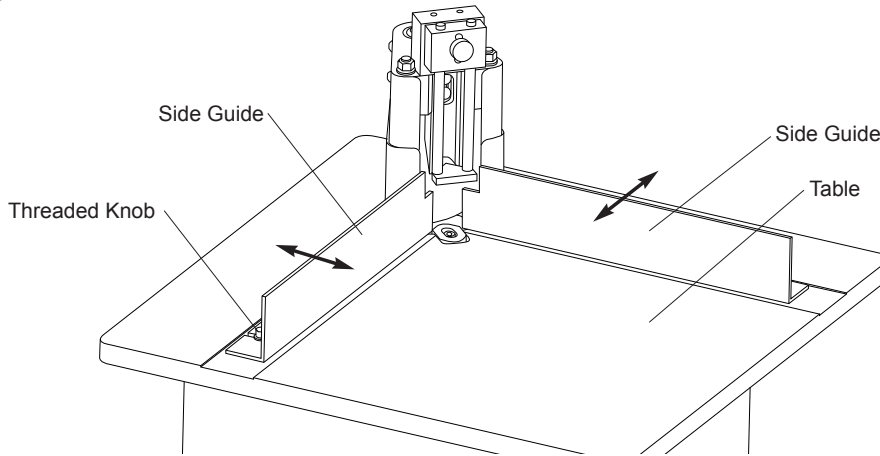
- 3.3.5** Press down on the Foot Pedal bringing the Blade all the way down. Position the Die so that it fits tightly against the Blade. Tighten down the Hex Screw for the Die until it is secure.
- 3.3.6** Reattach the Pressure Foot by sliding the Pressure Foot Block back into place noting the holes in the Pressure Foot Block must align with the two(2) pins on the Pressure Foot Mount. Insert the threaded knob and tighten down until the Pressure Foot is secure.



## 3 - Setting Up Your Machine

### 3.4 - Adjusting the Side Guides

- 3.4.1** It may be necessary at times to adjust either one or both of the Side Guides due to misalignment with the Blade.
- 3.4.2** To Adjust the Side Guides, loosen the three 1/4-20 X 3/4" Socket Head Cap Screws located on both Side Guides with the 3/16 Hex Wrench (HX-316). Using the Alignment Guide (CR-AG) provided and place it on the table making sure to line it up with the side guides so that they are aligned with the Die. It is necessary to use the foot pedal to bring the Blade down and confirm that the Alignment Guide is aligned with the edges of the blade.
- 3.4.3** When the Side Guides are positioned as desired, tighten down the Socket Head Cap Screws until the Side Guides are secure.

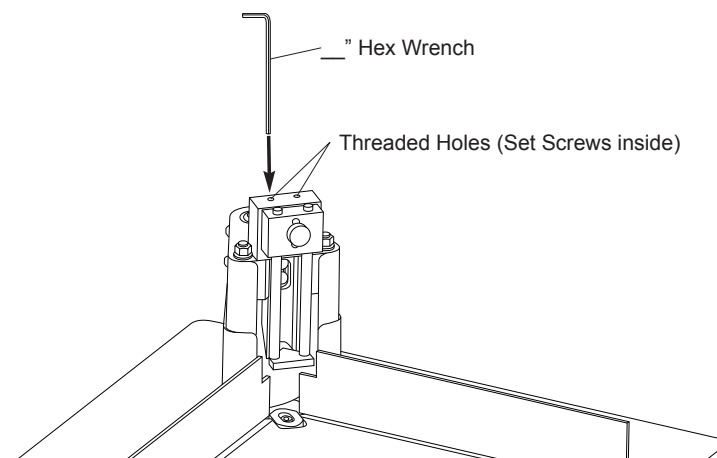


### 3.5 - Adjusting the Height of the Blade

- 3.5.1** The blades for the CR-55 may dull over time and can be sharpened. To accommodate the fact that sharpening the blades will change the overall length of the blade, there are two(2) set screws to adjust the height of the blade located in the Pressure Foot Mount. These set screws can be accessed from the two(2) threaded holes in the top of the Pressure Foot Mount.

***IT IS ONLY NECESSARY TO MAKE THIS ADJUSTMENT IF THE BLADE HAS BEEN SHARPENED***

- 3.5.2** Insert the Blade into the Blade Holder and secure but do not tighten the the two(2) hex screws. Insert the 1/8" Hex Wrench (HX-18) provided into the Threaded Holes in the top of the Pressure Foot Mount, engage the Set Screws, and turn clockwise to lower the overall height of the Blade. Turn clockwise until the bottom of the Blade sits just higher than the Pressure Foot. Tighten down the Blade. Test the full motion of the blade by stepping on the foot pedal, to ensure that the Blade comes down past the top of the Die.



## 4 - Operation

### 4.1 - Corner Rounding Operation

- 4.1.1** Place the product you are cutting onto the Metal Top Plate and push it into the corner aligning it with the Two(2) Side guides.
- 4.1.2** Press down firmly to prevent the product from sliding out of the corner. We recommend using the Right Angle Push Block (CR55-PB) provided, if your product allows, to help hold the product in place while cutting.
- 4.1.3** Press down firmly on the foot pedal until it stops to insure that the blade has travelled all the way down cutting through the entire stack. Please note that this machine can handle up to a maximum of 2" of product. This amount will vary depending on what you are cutting. Please test on scrap.
- 4.1.4** Keeping your foot firmly on the Foot Pedal lift and allow the pedal to return to the upright position. **DO NOT** remove your foot from the pedal as this can cause injury.

### 4.2 - Chip Removal

- 4.2.1** Place a waste bin or a disposable basket underneath the Chip Chute on the rear of the machine. This will catch the chips as they are cut and slide down the Chip Chute. Empty as needed.

### 4.3 - Tips on Cutting

- 4.3.1** Occasionally, the bottom sheet may not cut. If this occurs, place a piece of card stock underneath the stack you are cutting. This will give support to the product you are cutting.
- 4.3.2** When cutting business cards or other small sizes, the bottom card may slide forward. Try either cutting a smaller stack, place a piece of card stock underneath the stack, or both.
- 4.3.3** We recommend using the included Right Angle Push Block (CR55-PB) when cutting business cards or other small size product to help prevent push back.

## 5 - Maintenance

### 5.1 - Safety



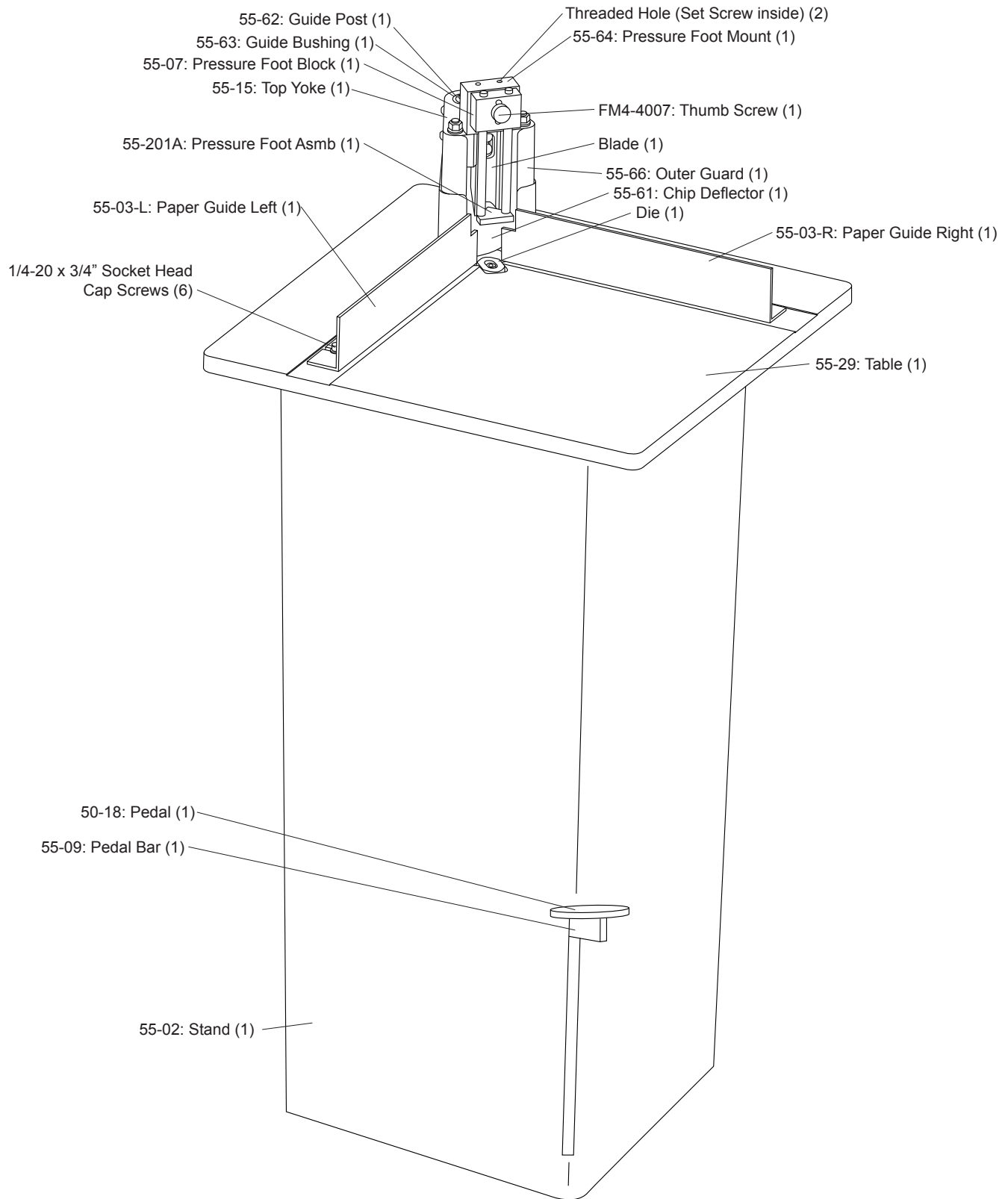
***KEEP HANDS CLEAR WHILE PERFORMING MAINTENANCE ON THIS MACHINE.  
MOVING PARTS CAN CRUSH AND CUT.***

### 5.2 - Annual Lubrication

- 5.2.1** Lightly oil the two(2) Yoke Slide Rods where they enter the adapter ring approximately every two(2) weeks or as needed depending on use.

# 6 - Parts Diagram

## 6.1 - Parts Diagram



# 6 - Parts Diagram

## 6.1 - Parts Diagram

