FORMAX®

Cut-True 33H
Programmable Hydraulic Guillotine Cutter

6/2026

PROGRAMMING MANUAL

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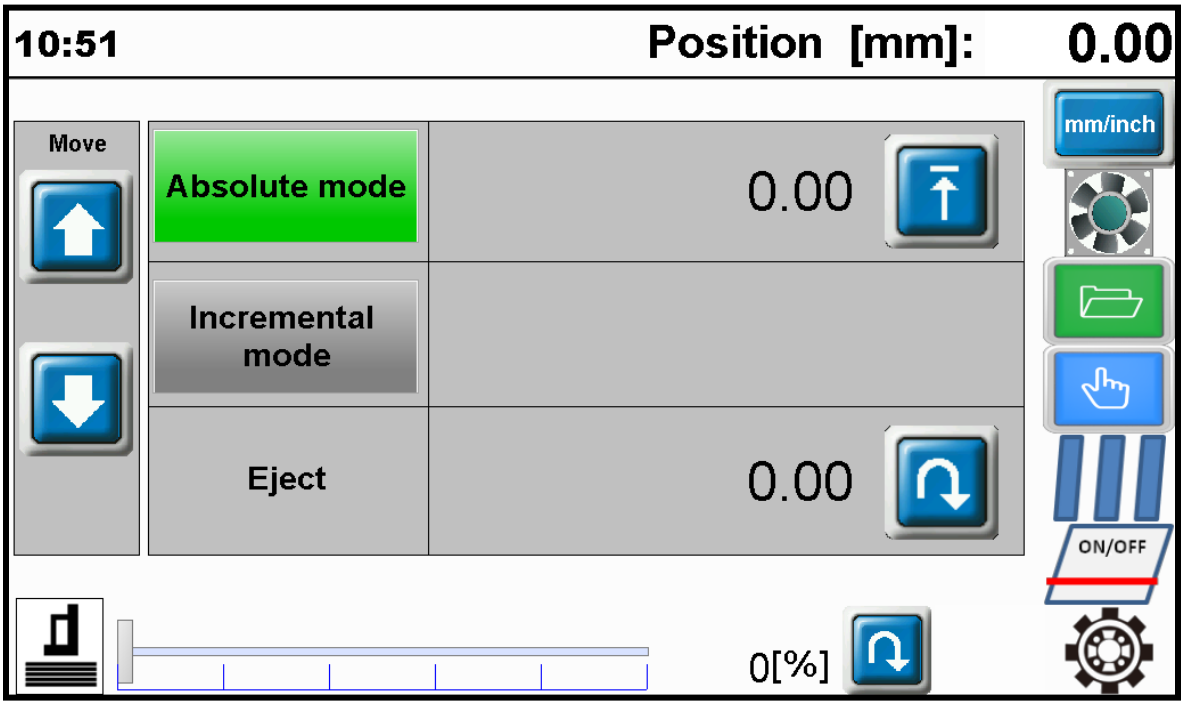
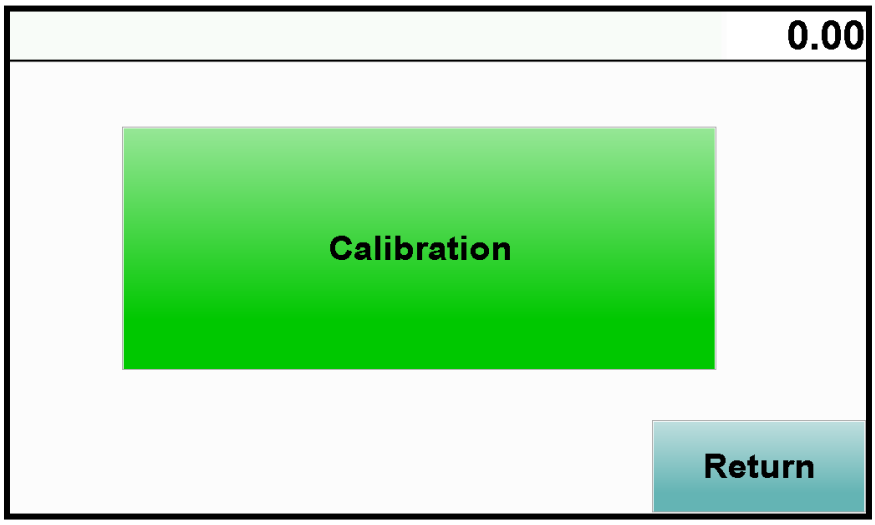


1.SWITCHING ON THE MACHINE

After switching on the cutter, the touchscreen will display the start screen.



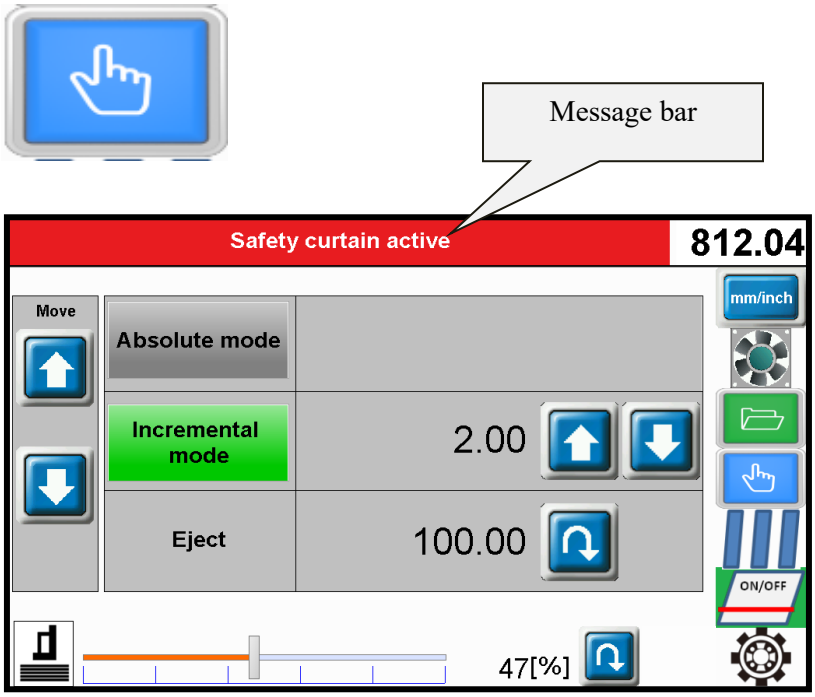
- Press the green button on the control panel to activate the machine control system.
- Pressing the screen button *"Press to calibrate"* will start the calibrating function.



During calibration, the back gauge will move to the far rear position, then move forward until the base sensor is detected. At this point, the cutting dimension – the base dimension – will be set.

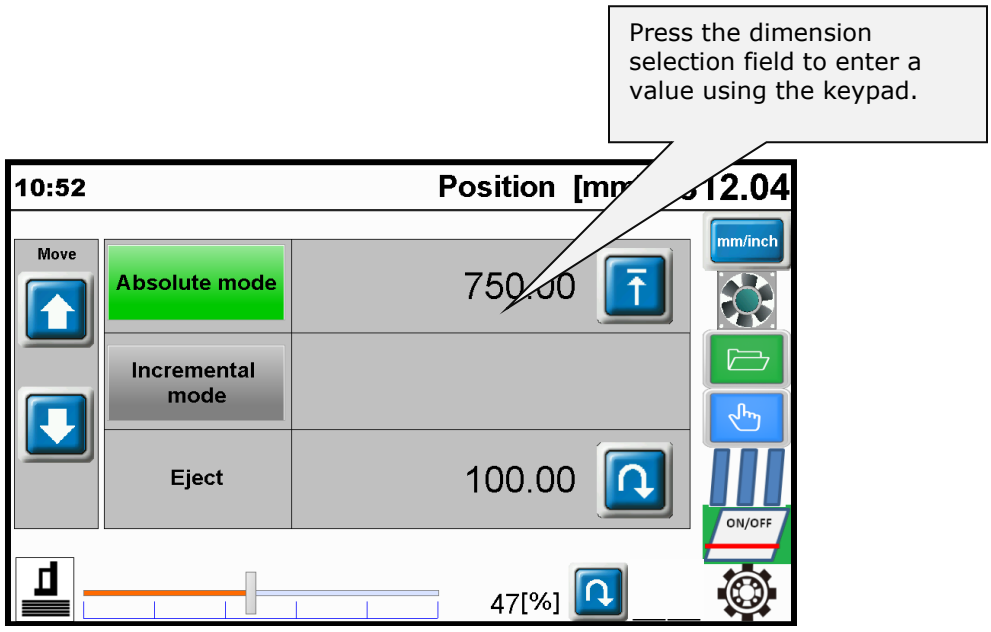
After completing the calibrating process, the **manual mode** screen will be displayed.

2.MANUAL MODE



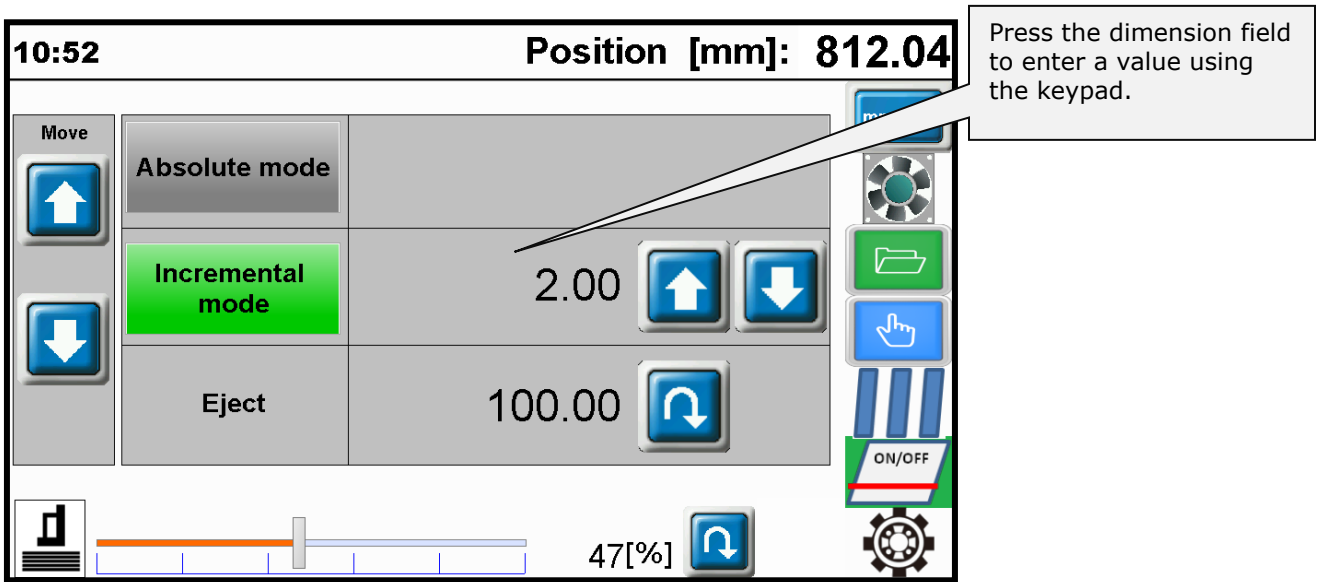
Available functions:

2.1 ABSOLUTE MODE – AUTOMATIC MOVEMENT TO THE SET DIMENSION



To enter the desired dimension, press the dimension field, then use the numeric keypad to input the value and confirm with the **ENT** button. After confirmation, the back gauge will automatically move to the set dimension.

2.2 INCREMENTAL MODE – REPEATED BACK GAUGE MOVEMENT BY THE SPECIFIED DIMENSION



To repeatedly move by the specified dimension (forward or backward), enter the desired value in the dimension field using the numeric keypad, confirm with the ENT button, then press the button  – the back gauge will move by the programmed dimension. After the movement is completed, it can be repeated by pressing the button  again. This action can be repeated multiple times.

2.3 MANUAL BACK GAUGE MOVEMENT


The back gauge can be moved manually (forward or backward) using the buttons.

2.4 PAPER EJECT

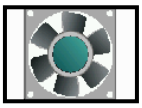

Pressing the button will move the back gauge forward by the programmed value and then return it to its previous position.

2.5 MEASURMENT UNITS



Button responsible for changing the measurement unit.

2.6 AIR TABLE (active only in machines with this equipment)


Pressing the button turns the air table blower on or off.

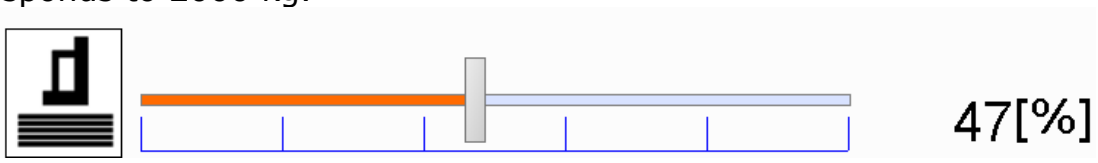
2.7 LASER CUTTING LINE



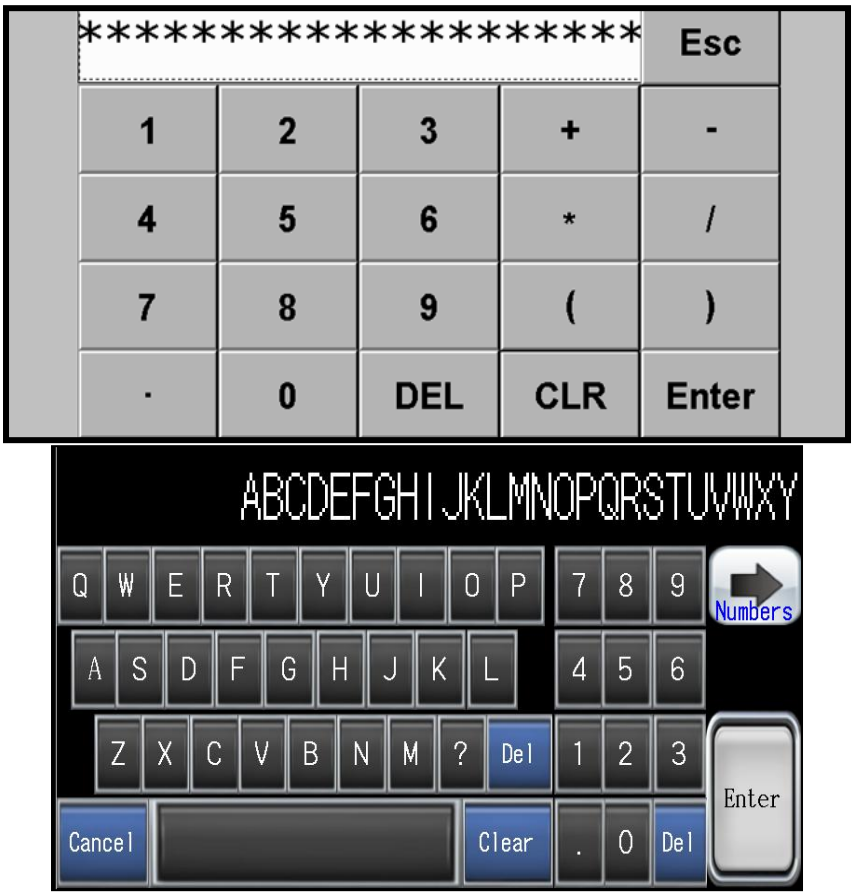
The cutting line indicator can be turned on or off using this button.

2.8 PRESSURE FORCE

By adjusting the slider from 0 to 100%, the clamping force of the hold-down beam on the material is set.
The minimum clamping force corresponds to 300 kg, and the maximum force corresponds to 2000 kg.



2.9 NUMERIC KEYPAD



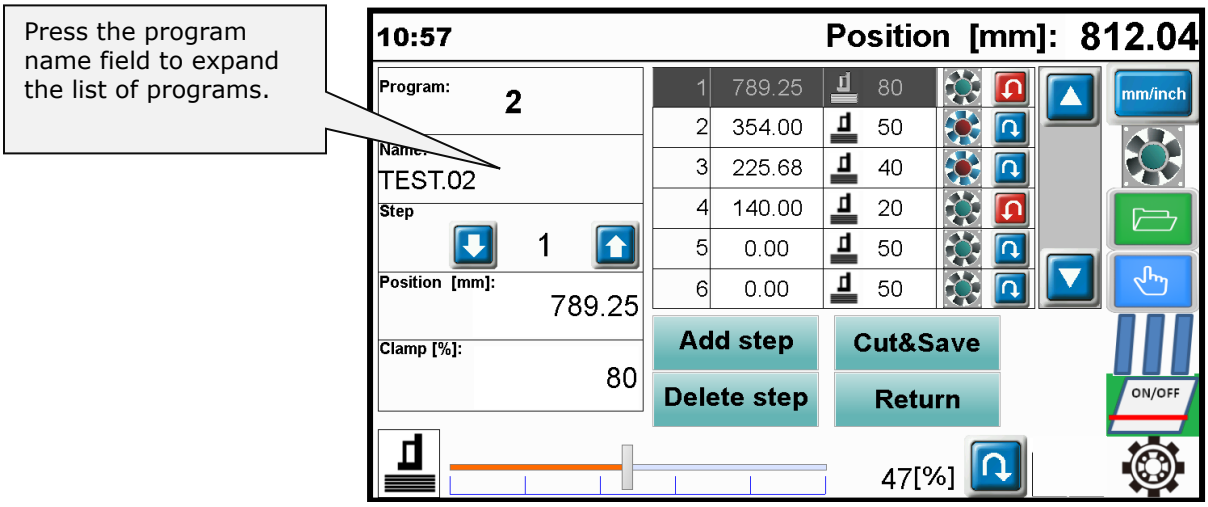
The programming screen is equipped with a calculator function (multiplication, division, addition, subtraction, and operations with parentheses).

3. AUTOMATIC MODE – PROGRAMS



This mode allows for selecting, editing, and executing programs.
It is possible to program up to 100 jobs, with 130 steps (dimensions) in each program.
For each step in a program, the ejection function, air blow, and clamping force can be programmed.

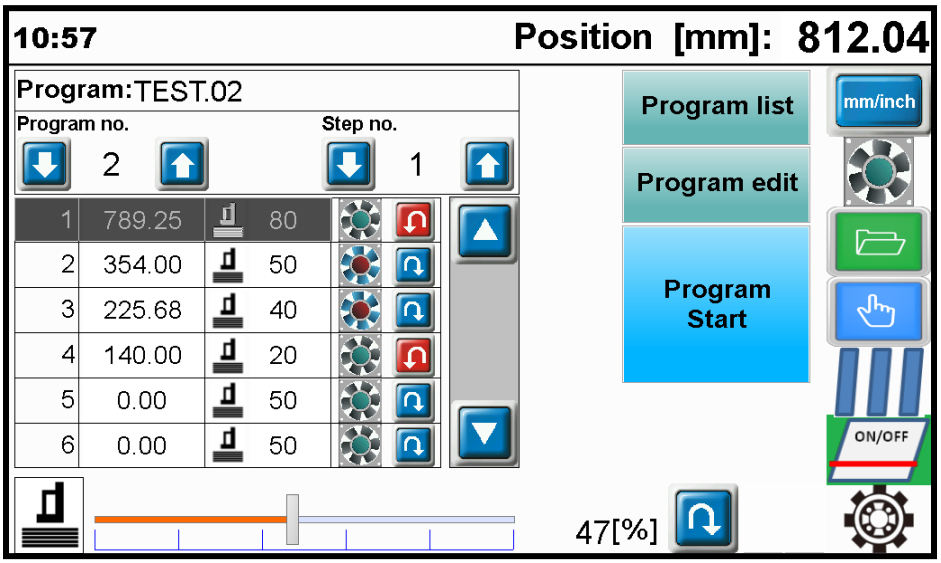
3.1 Program Selection



In this window, select which program you want to edit or execute.
A program can be selected from the list of programs, which is displayed after pressing the program name field.
Programs can also be selected using the arrow buttons or by entering the program number on the keypad after pressing the program number field.
Scrolling through the program list and the step list is done using the arrow buttons located next to each list.
When selecting a saved program, you can check the dimensions recorded in each step, displayed in the step list, using the arrow buttons. You can also see which steps have active functions such as ejection  and air table activation .

3.2 Executing a Saved Program

To execute a saved program, select the desired program and press the **PROGRAM START** button.
After pressing this button, the back gauge will move to the dimension recorded in the first step, and the following screen will be displayed:



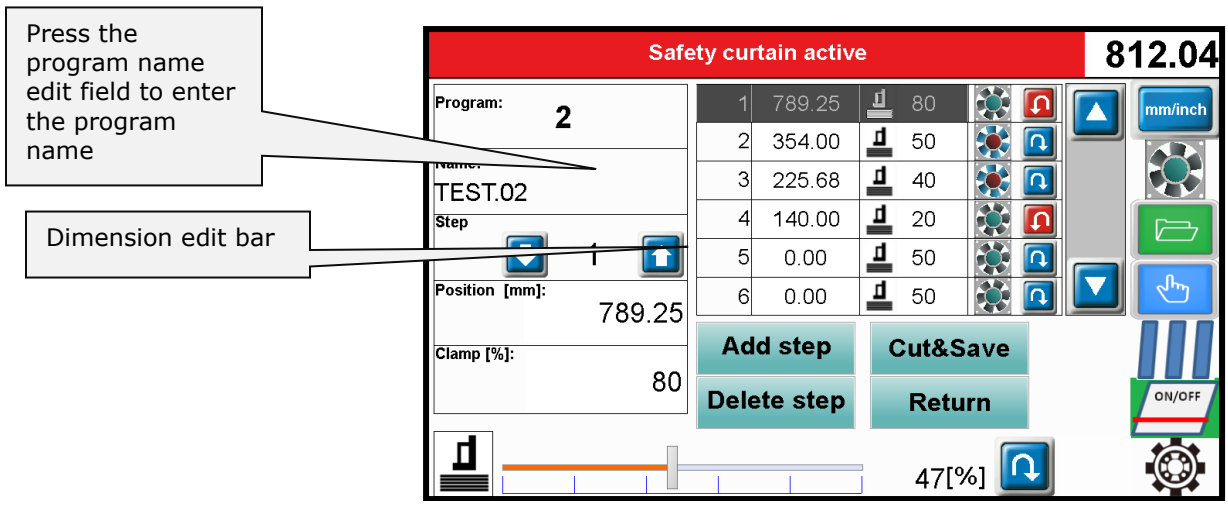
After a cut is completed, the program automatically proceeds to the next step – the back gauge moves to the dimension recorded in the following step.
After the last step of a program is completed, the back gauge automatically returns to the dimension of the first step, allowing the program to be executed again.

It is possible to skip a cut at any step by pressing the **skip** button ; the back gauge will move to the dimension of the next step without performing the cut. Pressing the  **back** button moves the back gauge to the dimension of the previous step.
To stop the program execution, press **PROGRAM STOP**.

3.3 Editing and Saving a Program

By pressing the **Program Edit** button, you can save a new selected program, modify dimensions in a saved program, change the program name, delete a specific step, and enable or disable functions such as **ejection** and **air table blow**.

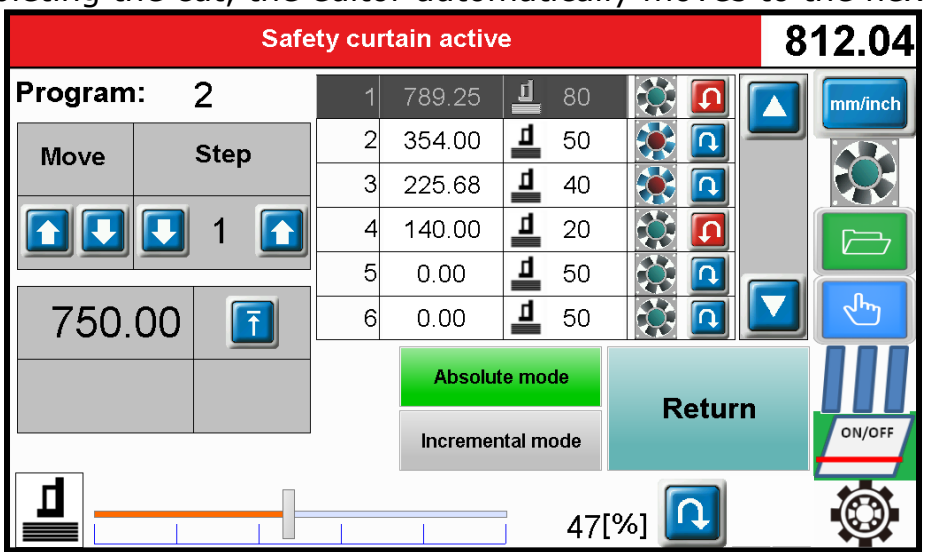
After selecting the program number and pressing the Program Edit button, the following screen is displayed.

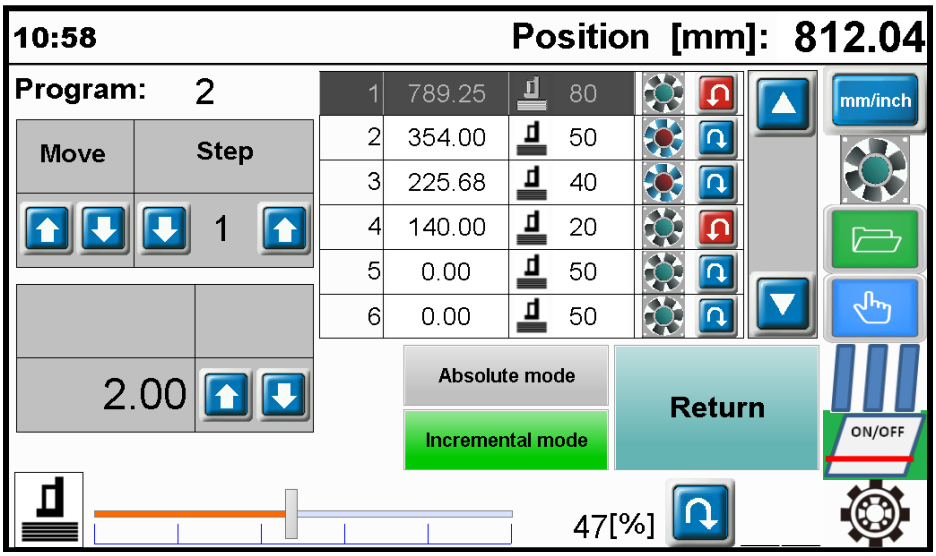


To edit the program, press the **program name edit field**.
Pressing this field gives access to the keypad, which is used to enter the program name.
After confirming the program name, the cursor automatically moves to the program's step list.
To enter a dimension value for a specific step or assign available functions to that step, press the corresponding function icon on the **dimension edit bar**.
The program is saved to memory by exiting the program edit mode using the **Back** button.

Add Step – adds a single step to the edited program
Delete Step – removes a single step from the program

3.4 Cut & Save – This function allows editing a program by moving to the desired dimension and performing a cut.
After the cut is made, the dimension is automatically saved as a step in the currently edited program.
After completing the cut, the editor automatically moves to the next step.



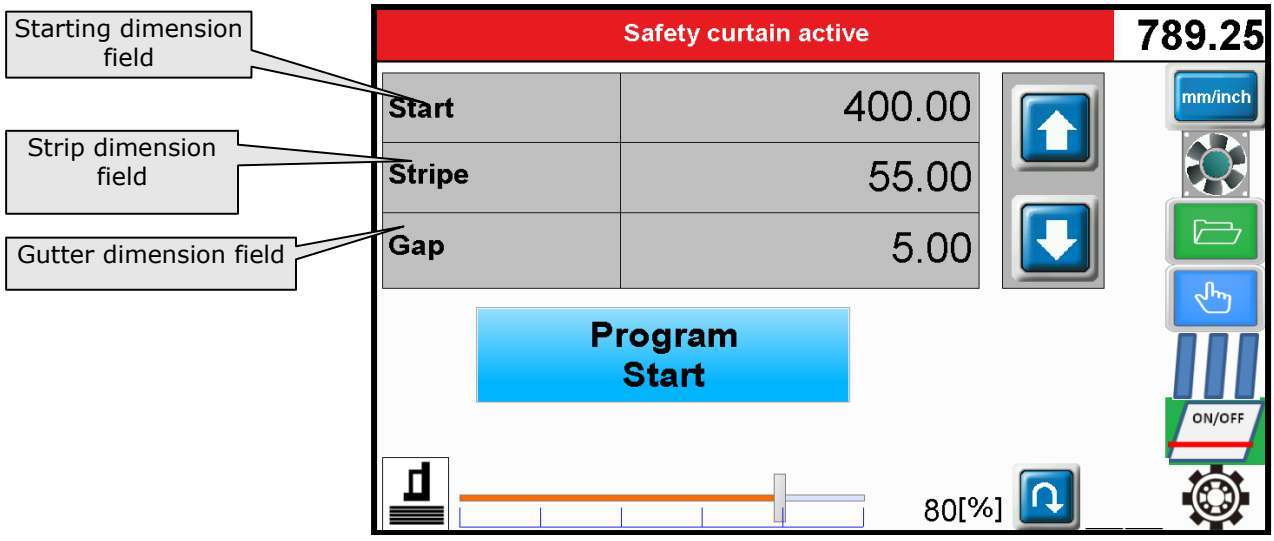


After finishing program editing using the **Cut & Save** function, pressing the **Back** button returns to the main program edit screen.

4. STRIP CUTTING, BUSINESS CARDS



– The program allows cutting with a single repeating dimension, as well as with two alternating repeating dimensions. This can be useful when cutting business cards.



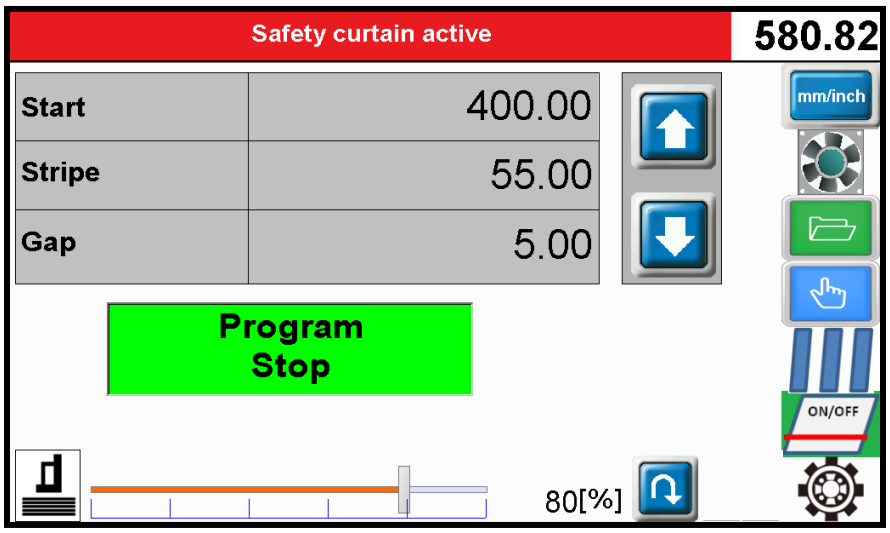
Starting dimension field – enter the value at which the first cut will be made, marking the beginning of the strip cutting cycle.

Strip dimension field – enter the value of the strip length you want to achieve.

Cut-off dimension field – if there is a gap (cut-off) between strips that needs to be removed, enter its value; if there is no cut-off, enter the strip dimension again.

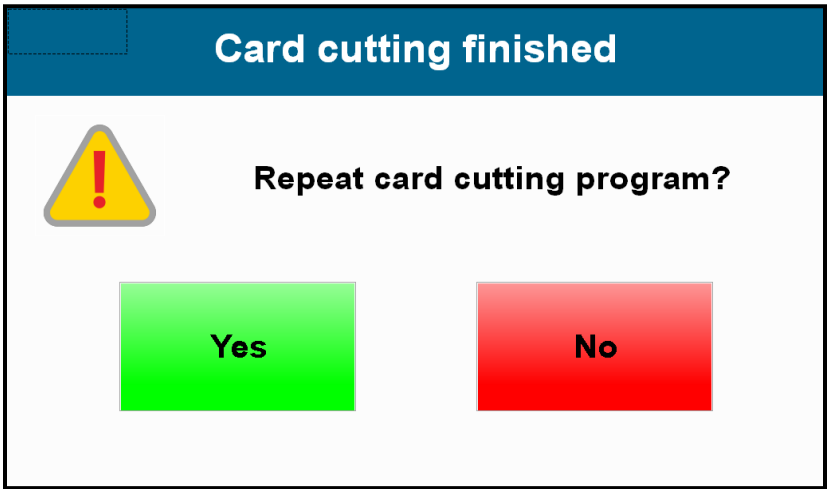
Remember to confirm each value entered on the keypad by pressing the ENT button.

After entering the dimensions in the appropriate fields, pressing the **Program Start** button will start the strip cutting function.



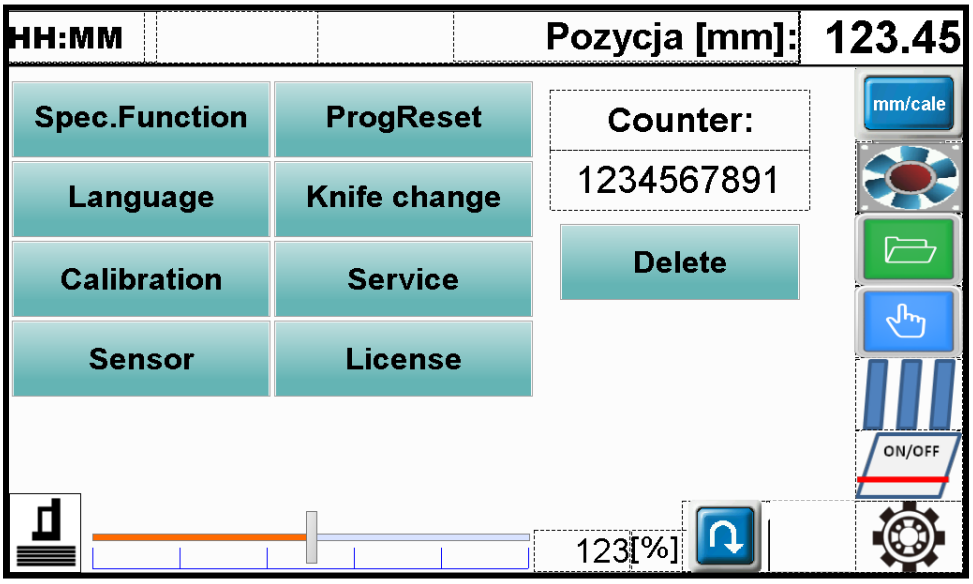
The back gauge will move to the starting dimension, and after each cut, it will automatically advance by the previously entered strip length.

It is possible to skip a cut at any step by pressing the **skip** button; the back gauge will move to the next step without cutting. Pressing the **back** button moves the back gauge to the previous step.
Pressing **Program Stop** ends the strip cutting program.
After the cycle is completed, if the remaining material is smaller than the specified strip length, a screen will appear to make a selection.

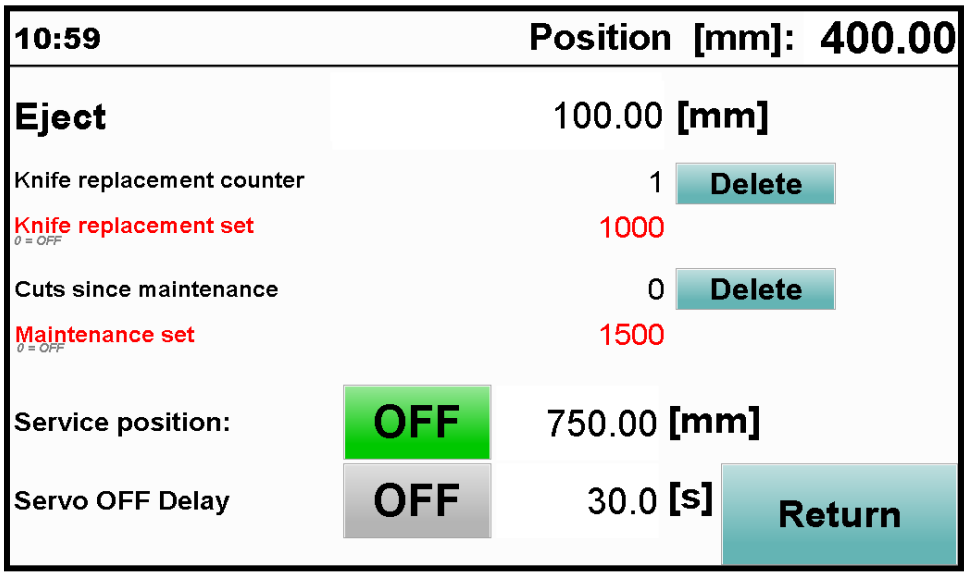


When the **YES** button is pressed, the back gauge moves to the home position to prepare for the next card cutting cycle.
When the **NO** button is pressed, the machine leaves card cutting program.

5. OPTIONS

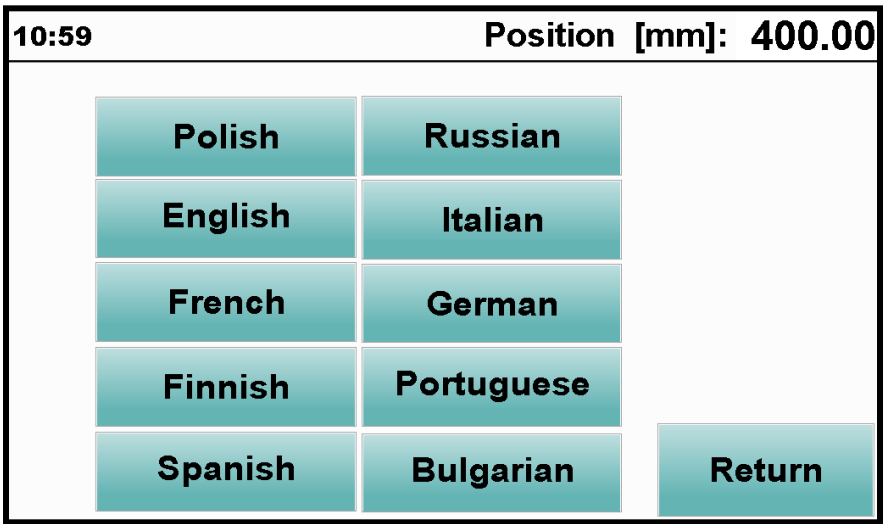


5.1 Special functions

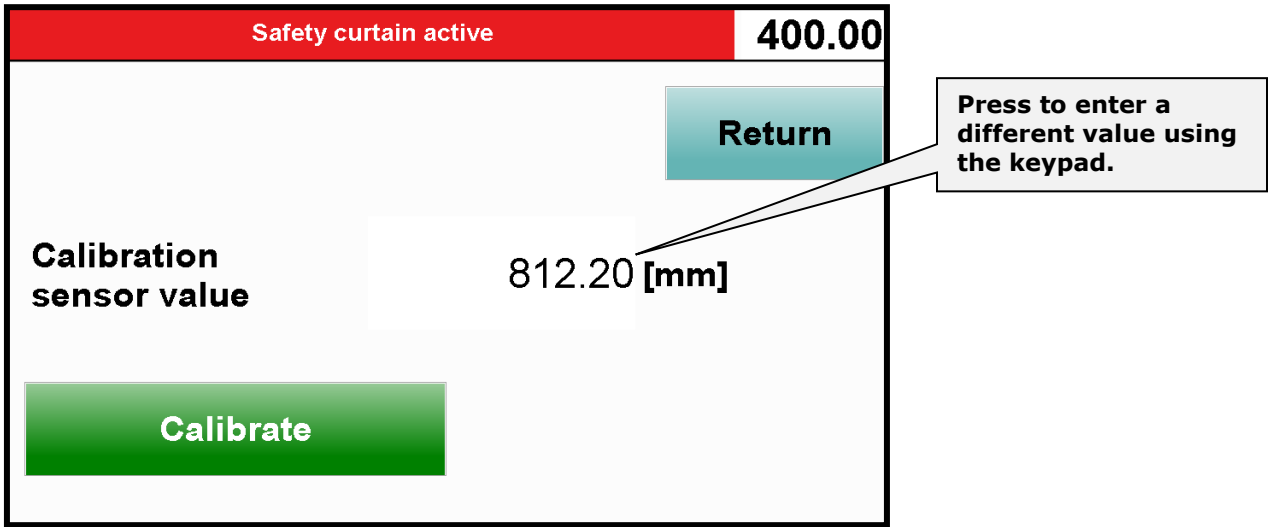


SERVICE POSITION – activating this function moves the back gauge mechanism to the service window 3 (see Fig. 50 in the guillotine operator manual), allowing access to the mechanism for maintenance.

5.2 Language – pressing the button displays a list of available languages.



5.3 Base Correction – Base dimension correction allows re-calibrating without turning off the machine and making adjustments if the dimension displayed differs from the real dimension.

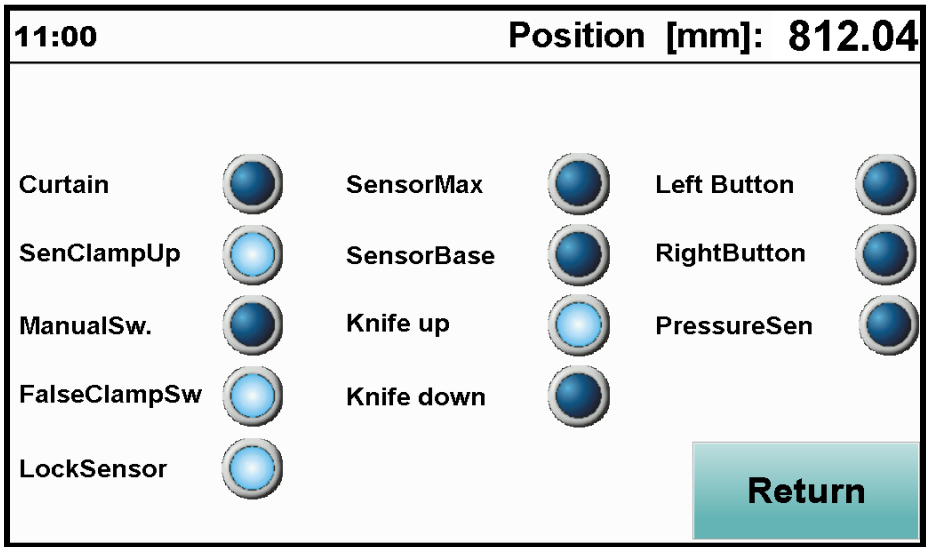


After starting the machine, measure the cut paper and compare it with the current reading on the touchscreen. If the values do not match, a correction of the base dimension must be made.
Base correction should be performed as follows:

- Set the feeding beam to a dimension, e.g., 100.0 mm.
- Cut the paper.
- Measure the actual length.
- If the measured length is, for example, 103.7 mm, increase the current base dimension by the difference between the display reading and the actual length, i.e., by 3.7 mm.
  (For example, if the base dimension is 810.0 mm, change it to 813.7 mm.)
- If the measured length is, for example, 98.4 mm, decrease the current base dimension by the difference between the display reading and the actual length, i.e., by 1.6 mm.
  (For example, if the base dimension is 810.0 mm, change it to 808.4 mm.)

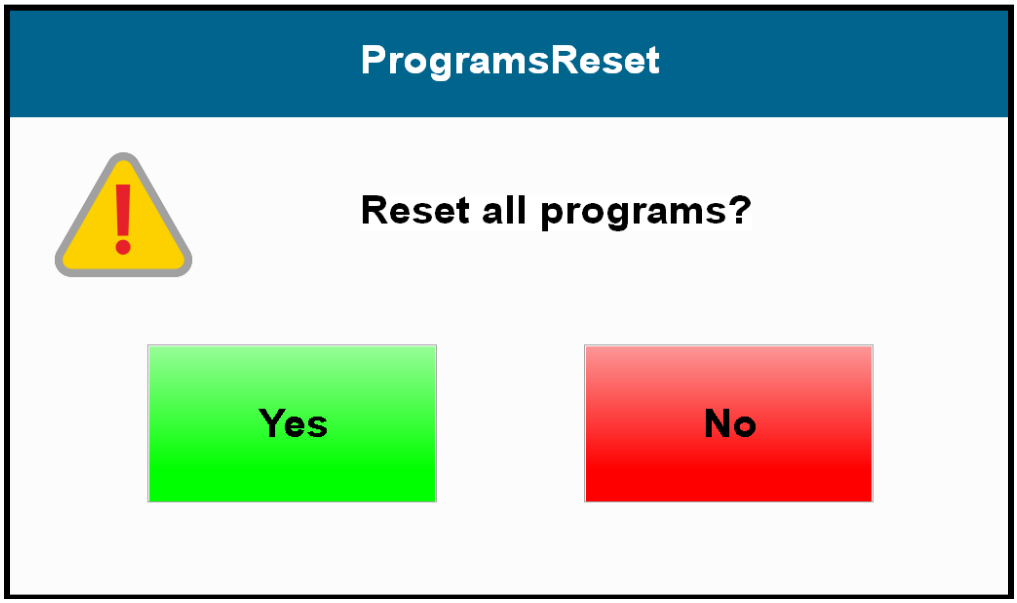
After adjusting the base dimension, press the **Home** button to save the change.

5.4 Switches

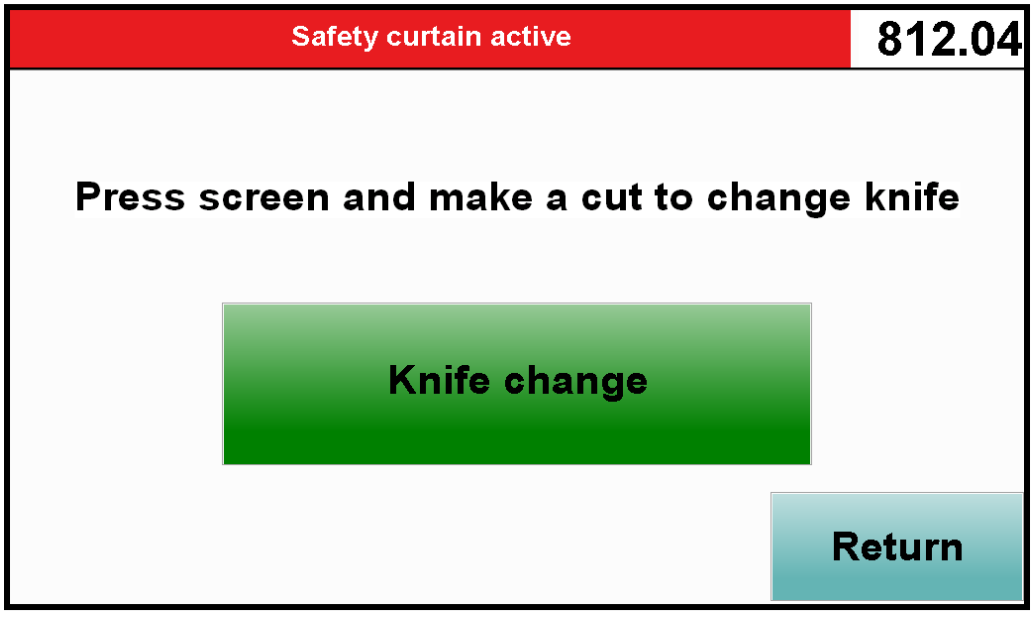


In this window, you can check the machine's control elements including inductive sensors, limit switches, buttons, and micro-switches.
A highlighted control element indicates that the element is currently active.

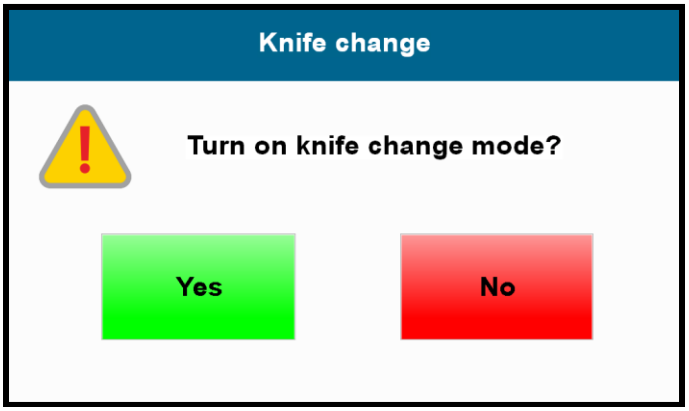
5.6 Delete Programs – program deletion
Selecting this option will delete all programs.



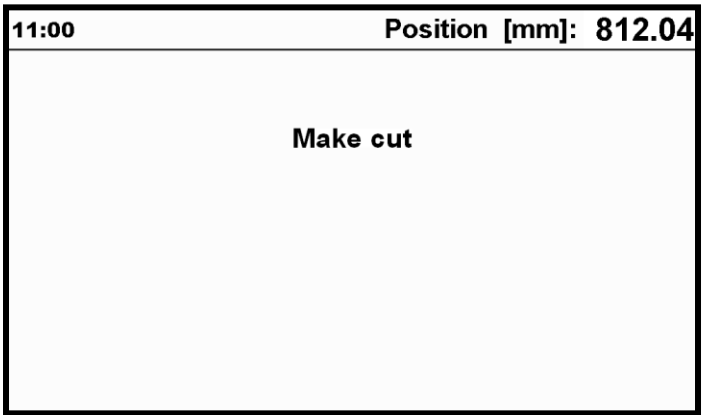
5.7 Blade Replacement – to begin blade replacement, press the Knife Change button.



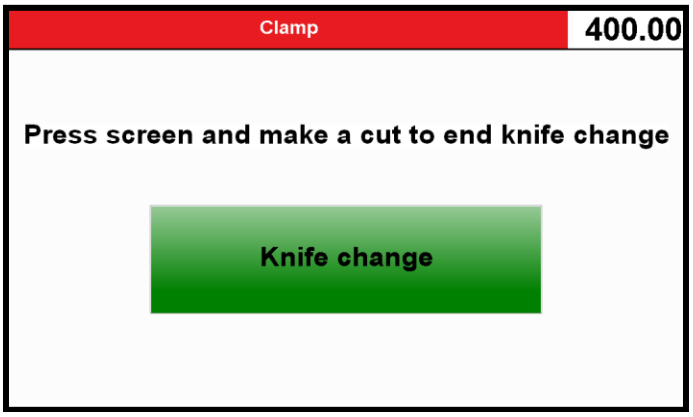
After pressing the button, a message will appear on the screen: **"Turn on knife change mode?"**



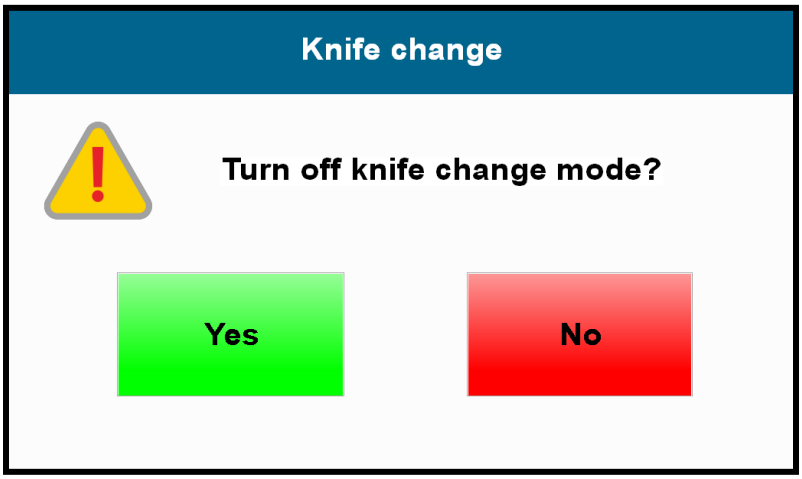
The decision must be confirmed, and the cutting sequence should be performed.



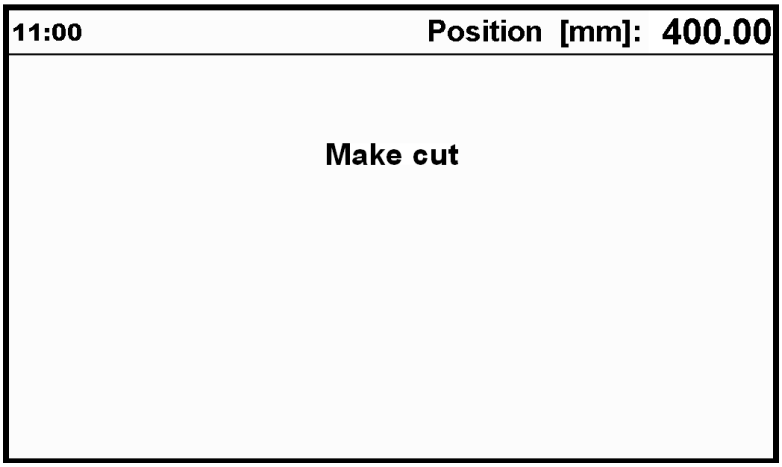
After completing the replacement, press the **Knife Change** button again on the screen.



Afterward, a message will appear**: "Turn off knife change mode?",** which completes the entire process.



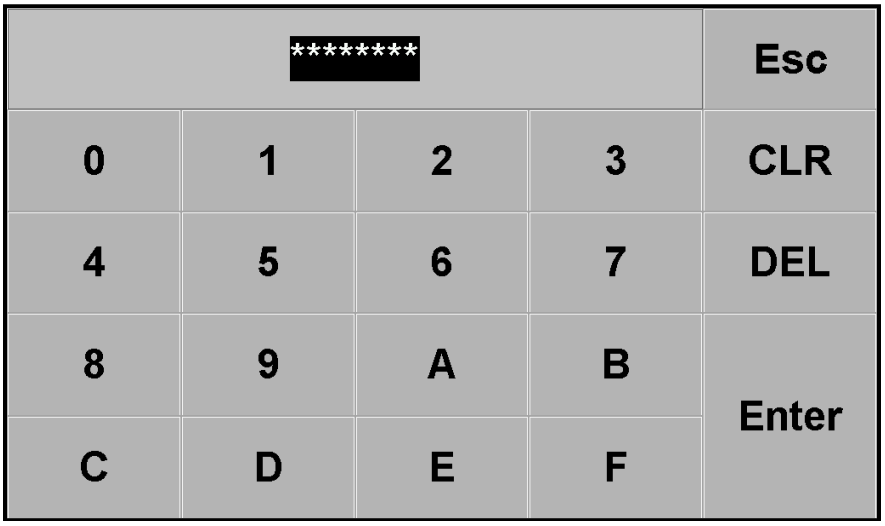
The decision must be confirmed, and the cutting sequence should be performed.



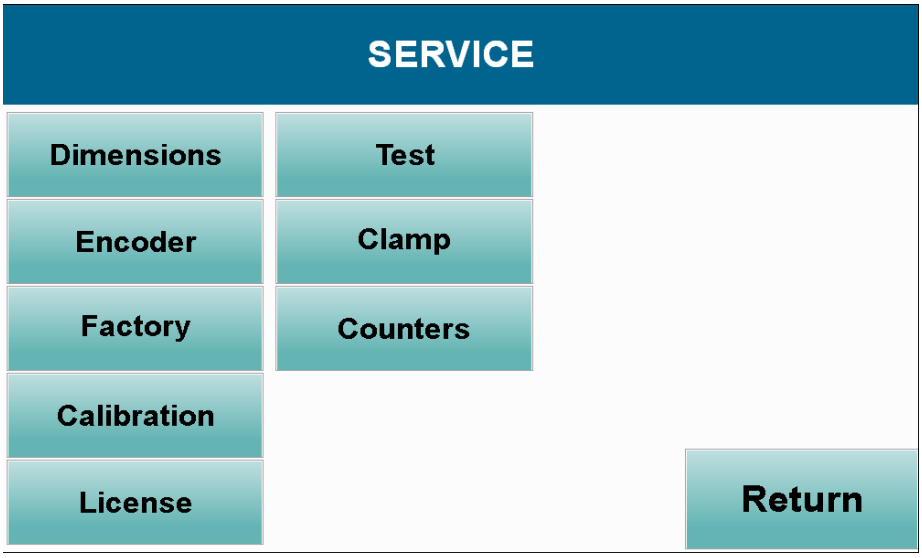
Blade replacement is completed.

5.8 Service – access to service functions

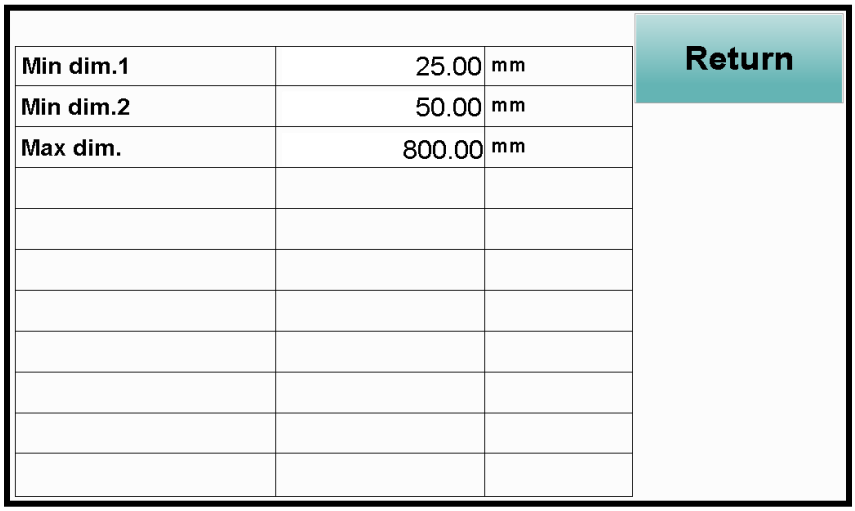
Pressing the Service button will display the keypad, where you must enter the service access 4-digit code XXXX using the operational buttons and press ENTER.



After entering the correct code, access to the service menu is granted. The code is provided for service personnel only.

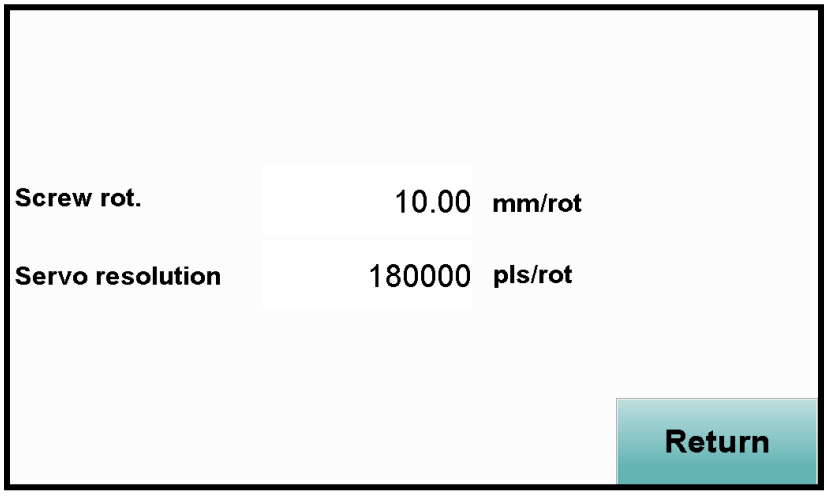


5.8.1 Service – Dimensions



- **Min. Dimension 1** – the smallest dimension available for this cutter that the back gauge can automatically reach using the programmer function (false clamp insert installed on the clamp beam).
- **Min. Dimension 2** – the smallest dimension available for this cutter that the back gauge can automatically reach using the programmer function (insert not installed on the clamp beam).
- **Max. Dimension** – the largest dimension available for this cutter that the back gauge can automatically reach using the programmer function.

5.8.2 Service – Encoder

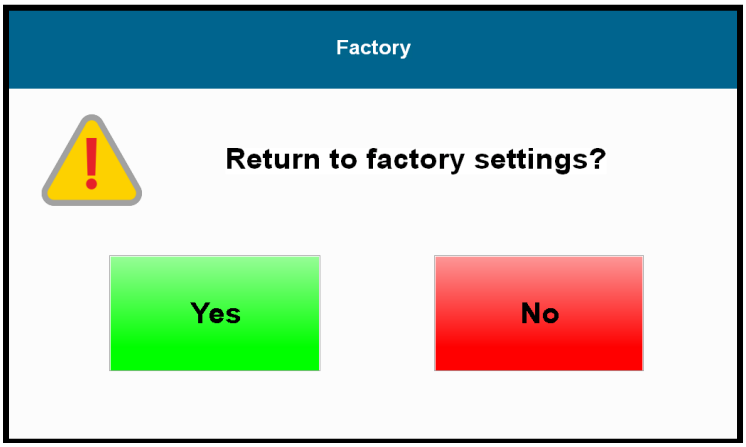


- **Screw pitch –** the number of millimeters per revolution of the screw used in the machine to move the back gauge.

- **Encoder constant –** the number of pulses per revolution of the encoder used in the machine.

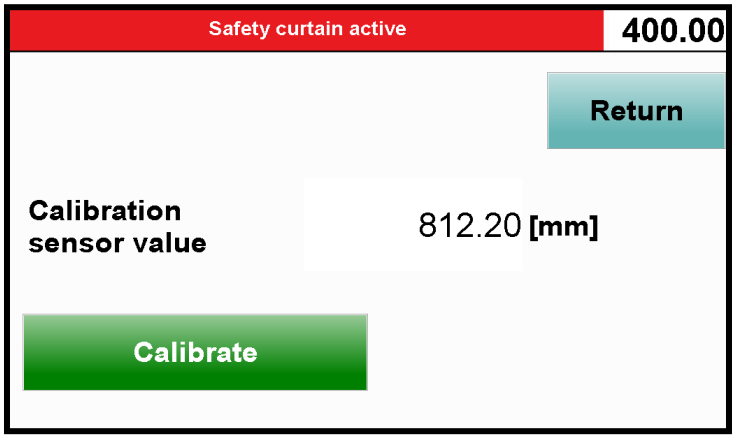
5.8.3 Service – Factory Settings

All parameters in the Dimensions and Encoder windows are restored using the Factory Settings function, but some may require adjustment depending on the equipment installed in the machine.



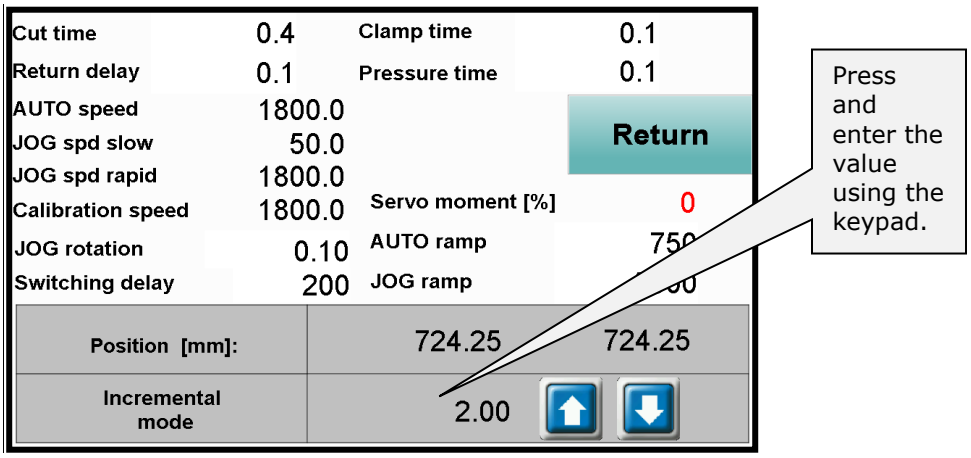
To restore factory settings, press and hold the **Yes** button.

5.8.4 Service – Calibration



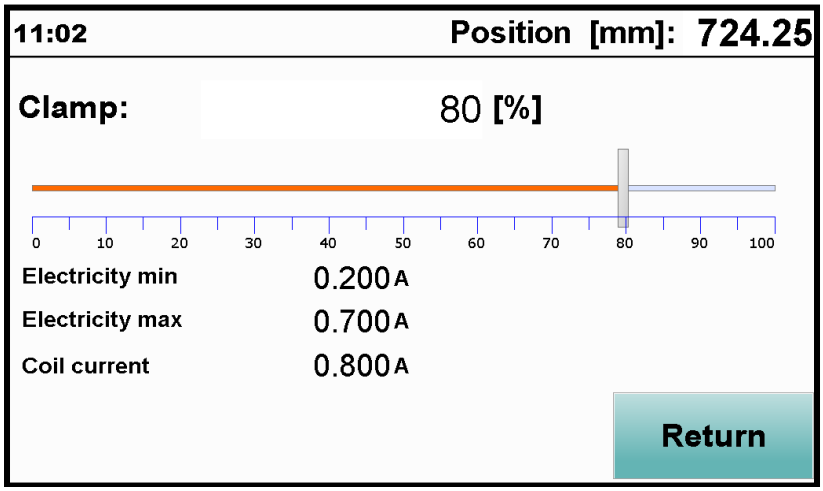
Calibration – allows re-calibration without turning off the machine and making adjustments if the dimension displayed differs from the actual dimension.
(See 5.3 Base Correction)

5.8.5 Service – Test



In the **Position** table, the first dimension represents the actual dimension, and the second dimension is the value close to the actual dimension.

5.8.6 Clamping Force



5.8.7 Counters

