



# **Automatic Booklet Maker**

## **Operation Manual**

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# Chapter 1 Product Introduction

## 1.1 Overview

The company is an innovative technology enterprise integrating product development, production, sales and service. The company focuses on the field of digital finishing equipment. The newly built full-automatic booklet maker can reach a speed of 2000 books/hour. The unique side shot and post shot function can help you quickly tidy the paper and save time and effort. The used wire nail head can use ordinary wire loops. Economical and affordable. This machine is suitable for a minimum size of 5.83"×8.27" and a maximum of 13"×19", which can fully satisfy your usual saddle stitching business.

Thank you for choosing our products. If you encounter any problems during the operation, please contact your seller in time.

It is strictly prohibited to operate this machine before reading this operation manual carefully. Please keep this operation manual in a suitable place so that it can be consulted when needed.

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## 1.2 Machine parameters.

<u>Machine packing size</u>	<u>37.4"x27.56"x37.4"</u>
<u>Machine base cabinet packaging size</u>	<u>25.2"x23.62"x8.27"</u>
<u>Paper feeding specification</u>	<u>5.83"x8.27"~13"x19"</u>
<u>Applicable paper weight</u>	<u>60~250gsm</u>
<u>Binding speed (A4)</u>	<u>2000 books/hour</u>
<u>Paper feeding method</u>	<u>Manual feeding</u>
<u>Folding method</u>	<u>knife folding</u>
<u>Paper feed angle</u>	<u>30 degrees</u>
<u>Positioning gauge and operation</u>	<u>Linkage adjustment of nail position, folding position and post-shooting</u>
<u>Binding mode</u>	<u>stitch, flat stitch</u>
<u>Binding method</u>	<u>wire stitch</u>
<u>Binding specification</u>	<u>Saddle stitch 70gsm writing paper, 2~25 sheets or 0.1" /side stitch maximum thickness 0.1"</u>
<u>Wire specification</u>	<u>26#/0.022"</u>
<u>Accuracy</u>	<u>±0.02"</u>
<u>Power</u>	<u>AC110V/60Hz 330W</u>
<u>Gross weight of the machine</u>	<u>320lb</u>
<u>Gross weight of base cabinet</u>	<u>29 lb</u>

Note: This model is being continuously upgraded, and the information and parameters in this manual may be updated at any time without notifying the user.

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# Chapter 2 Security

## 2.1 Environment

Temperature: 50°F to 95°F

Humidity: 30% to 70%

Altitude: Below 3280ft.

There is no flammable, corrosive gas or oil mist around.

## 2.2 Precautions



Be sure to read this manual thoroughly before operation.



Make sure that the power supply voltage and frequency are consistent with the requirements of this manual.



Make sure that all safety covers are closed, otherwise the related switches are disconnected and the machine cannot be operated.



Before moving the machine, be sure to contact your local dealer.



Before cleaning the machine, be sure to disconnect all power sources.



When the machine is not used for a long time, be sure to unplug the power cord.



The machine cannot be installed in an unstable place.



When installing longitudinal knives, pay attention to the sharp blades and cut hands.



Do not operate the machine with wet hands, especially plugging or unplugging the power cord.



Operators should not wear long hair, wear loose clothing, or touch internal parts with their fingers.



Do not place any container with any liquid on the surface of the machine.



Do not place any small items on the machine, especially on the paper feed table.



Do not modify or disassemble the machine without authorization, unless it is done by an engineer certified by the company.



Do not touch any running parts.



Do not power off suddenly while the machine is running.



Do not place any heavy objects on the surface of the machine.



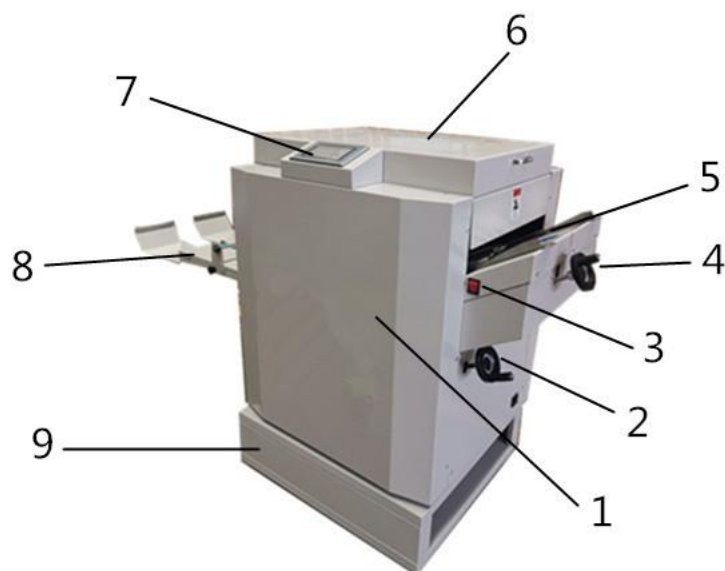
Do not allow any metal or combustible objects to enter the machine, otherwise there is a risk of fire or electric shock. If this happens, please turn off the power first, unplug the power cord, and then contact a technician.

**Note:** If the machine has an unknown abnormality. Please turn off the power immediately, unplug the power cord, and contact a technician.

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# Chapter 3 Main Components

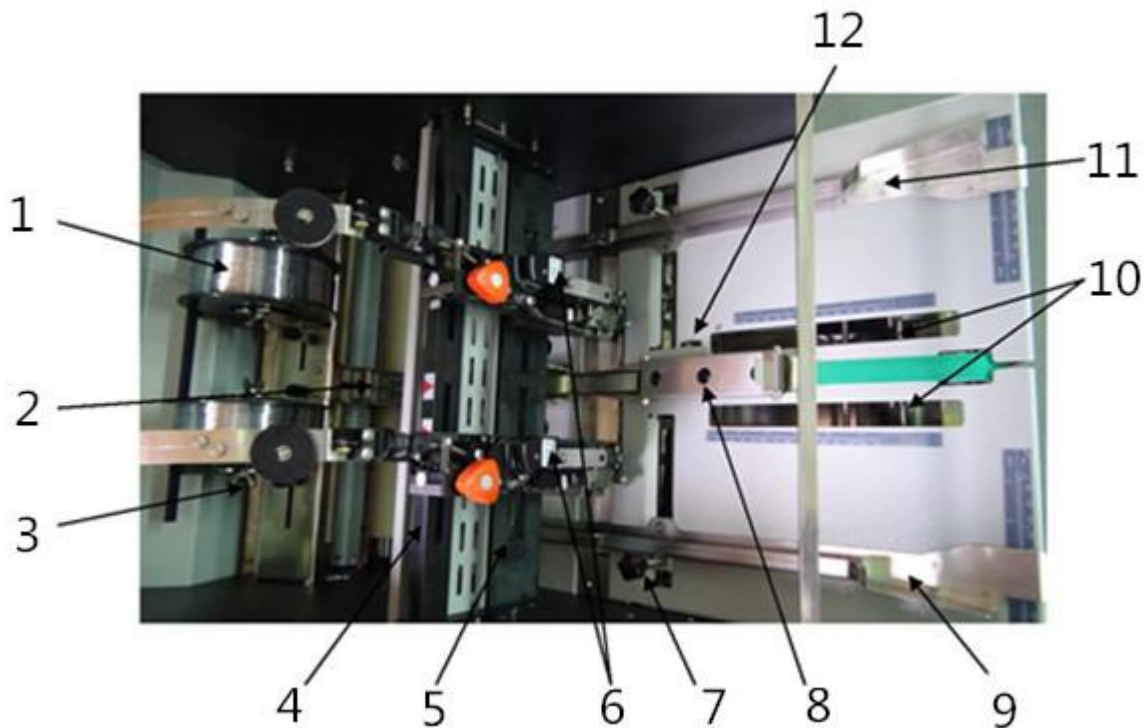
## 3.1 Icon of the whole machine



Number	Name	Description
1	Folding machine head	Main part
2	Adjustment knob A	Used to adjust the position of nails and folding positions
3	Power switch	Machine main power switch
4	Adjustment knob B	Used to adjust the post-push position
5	Paper feed table	Binding paper inlet
6	Upper cover	Protective effect
7	Operation buttons	Main control panel
8	Electric delivery tray	Plate for booklet collect
9	Base cabinet	Move and support the machine body

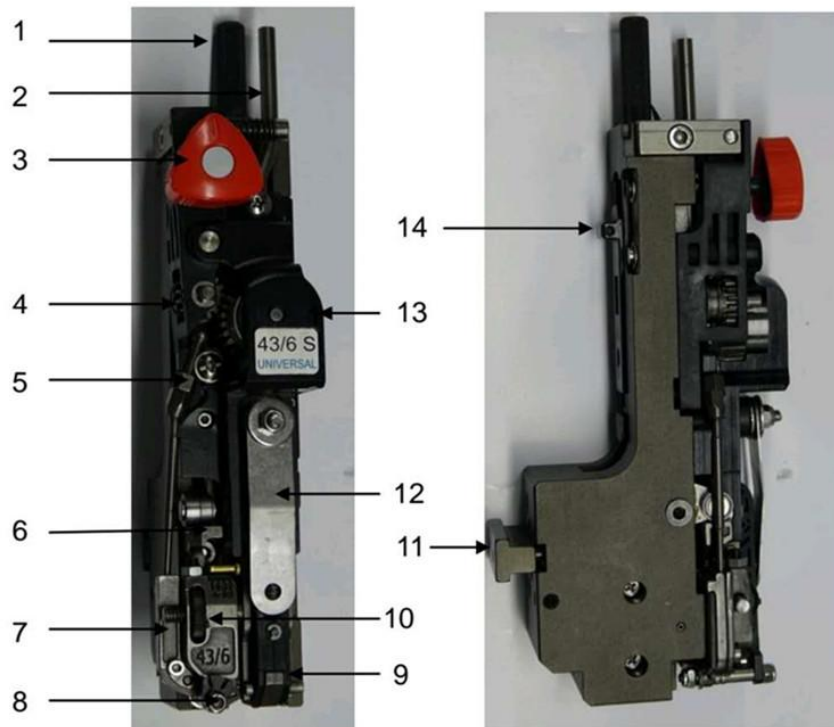


### 3.2 Partial icon



Number	Name	Description
1	Wire loop	Nail material
2	Paper feed pressure spring	Press to adjust the fold line to overlap the nail line
3	Iron core	Place the wire loop
4	Stitch head drive beam	Push the staple head to drive nailing
5	Fixed beam	Used to fix the head
6	Stapler	Nail forming and nailing
7	Side gauge fixing screw	Fixed paper feeding side regulation
8	Paper guide	Used to hold down the feeding paper
9	Left paper side regulation	For paper guide
10	Post shot	Align the paper with the front and back drop
11	Right paper feed side regulation	Align the paper with the left and right drop
12	Paper feed area sensor	Sense the loaded paper

### 3.3 Header icon (43/6)



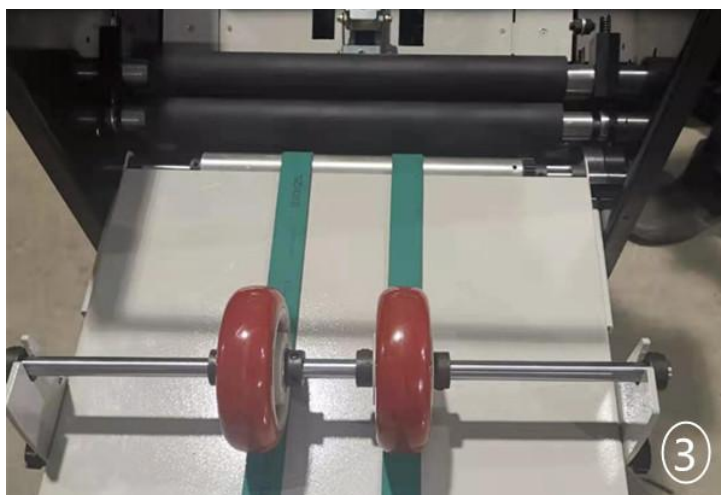
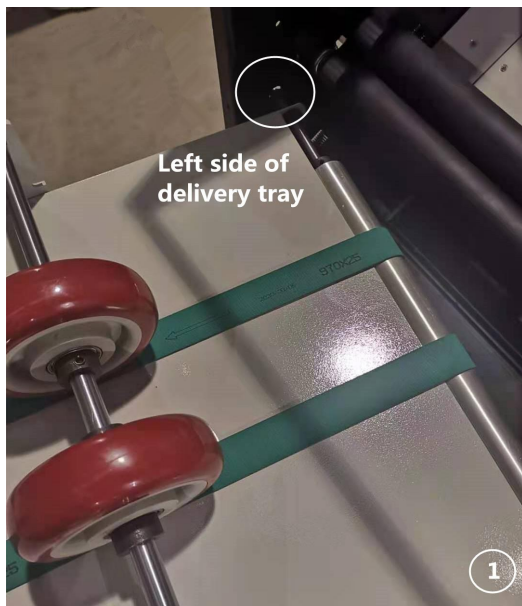
No.	Name	Description
1	Nail cutting adjustment knob	Rotate clockwise, the cut out nails become shorter; otherwise they become longer
2	Upper guide wire tube	For guide wire
3	Wire feed switch	When the logo is facing up, the machine will feed the wire downwards, and when the logo is turned to right side, the wire will not be fed down.
4	Guide wire pinion	Clamp the wire and send it down
5	Lower guide wire tube	For guide wire
6	Upper cutter mounting frame	The small bearing is pressed down, and the cutter frame cuts the delivery wire
7	Guide wire slot cover	Cover the curved guide wire groove
8	Wire adjustment knob	Use a slotted knife to adjust the position of the fan-shaped blade by turning clockwise or counterclockwise to ensure that the delivery wire is straight
9	Tailor beak	Clamp the cut wire to nail the nailer
10	Foot adjustment knob	Cut the iron wire to the same length, turn the knob up, the left leg will become longer, and the right leg will become shorter
11	Stitch head fixed T-slide	For fixed head
12	beak tablet	Press the beak of the stapler to prevent it from jumping out
13	Guide wire gear	Close to the guide wire pinion, clamp the wire for wire feeding
14	Stitch drive block	The force of the stapling head drive is given by the up and down movement of the drive block

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# Chapter 4 Machine Installation

## 4.1 Installation of electric delivery tray

Insert both ends of the shaft of the receiving tray into the round holes of the wall plate (as shown in ①②), and then connect the gear on the right side (as shown in ②) to complete the installation (as shown in ③).



## 4.2 Installation of the Stitch Head

As shown below:

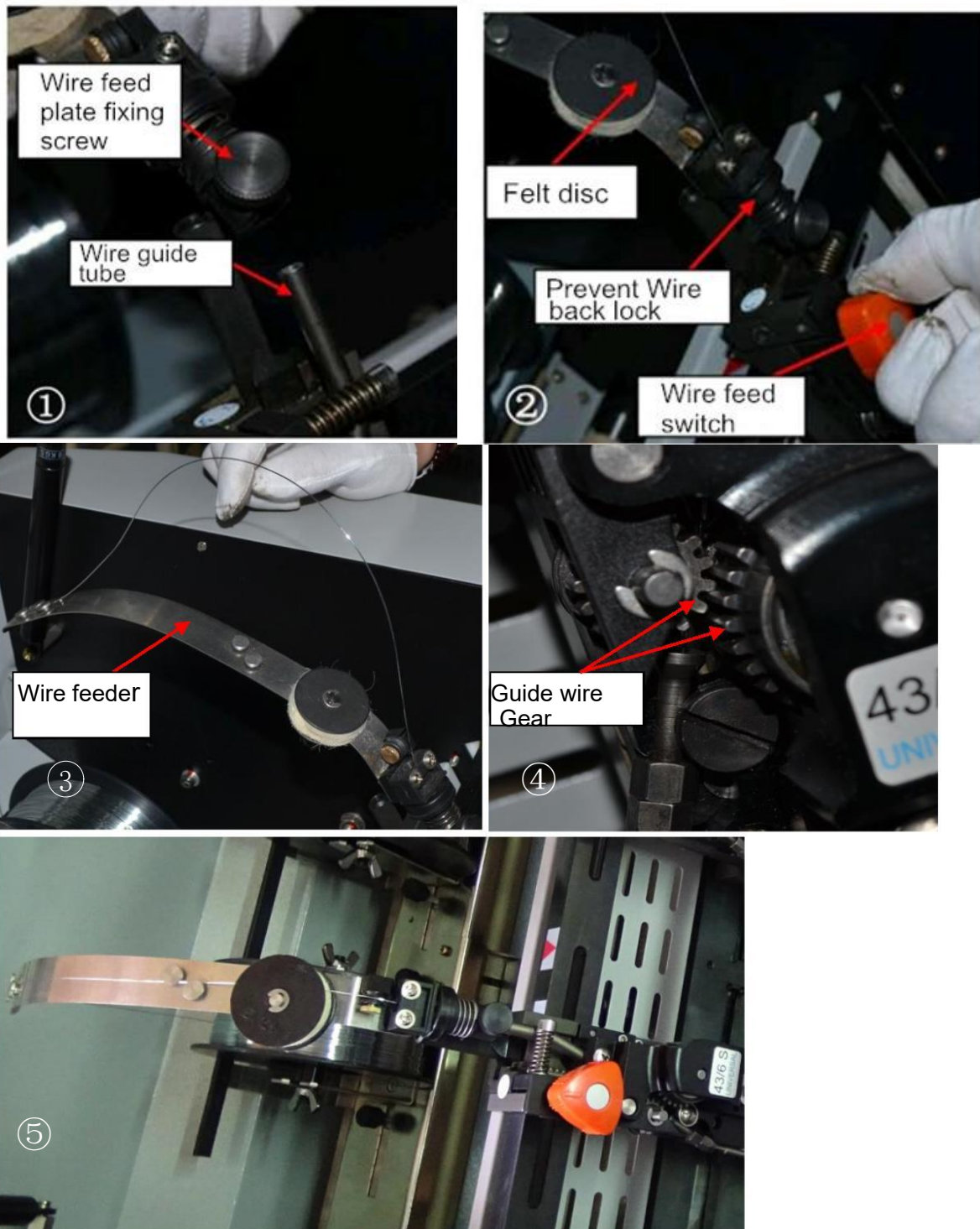
1. Insert the head drive block into the installation slot on the beam.  
2. Insert the staple head fixed T-shaped slider into the installation groove on the staple head.

Fixed head T-slide

3. Align the side of the staple head with the red position installation mark, and then tighten the screws.  
Note: If you want to move the head position, you only need to loosen the fixed hexagonal screw pointed by the arrow, and then move it.

## 4.3 Installation of iron wire

as the picture shows:



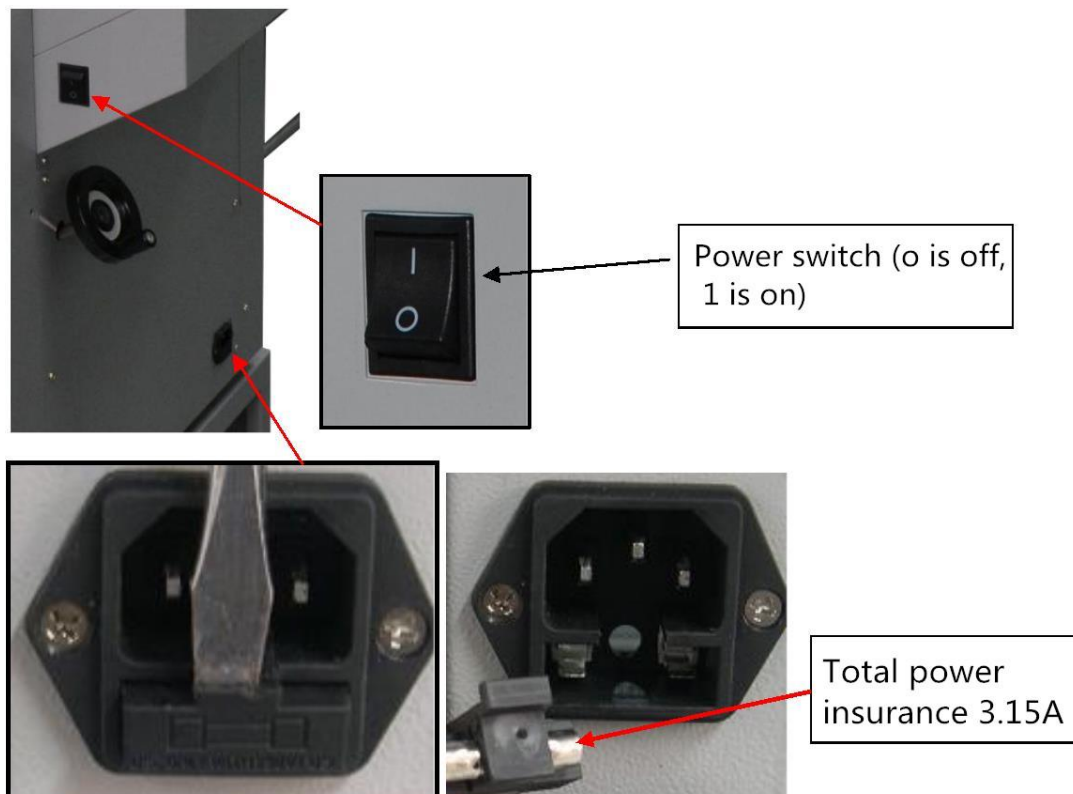
### Step:

1. Insert the wire feed plate into the wire guide tube and fix it (Figure 1)

- 
2. Turn off the wire drive (Figure 2), that is, turn clockwise so that the logo faces right.
  3. Wire threading steps: first pass the iron wire through the three rivets at the front end of the wire feed plate and the lock of prevent wire back way (picture 3), then pass through the two guide wire gears and into the iron wire guide tube 2 (picture 4), Then straighten the wire through the two rivets and two felt discs at the back of the wire feeder plate (Figure 5).
  4. Turn on the wire drive (Figure 5) and turn it counterclockwise so that the logo faces upwards.

Note: After the wire is worn, the nail will not come out after several consecutive hits. Therefore, after passing the wire, you can take a test sample to test until there is a nail in the booklet.

#### 4.4 Power connector and switch

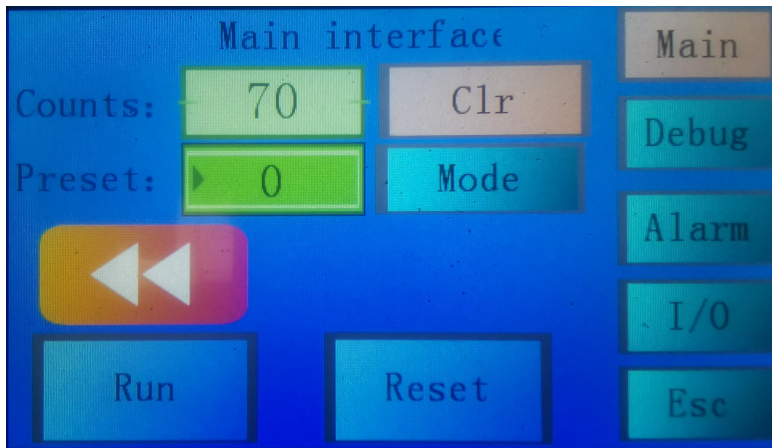


# Chapter 5 Machine Operation

## 5.1 Display screen and buttons

### 5.1.1 Display screen and buttons

The main control panel of this product is as follows:

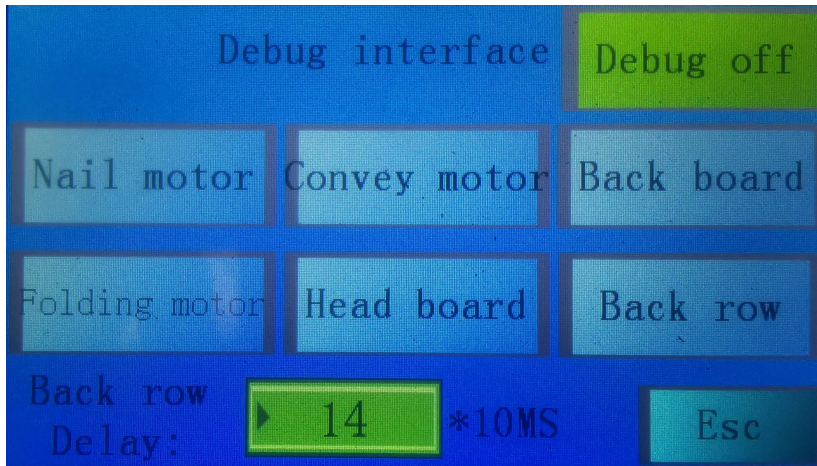


Button	description
Run key	The standby state is changed to the running state, and the machine starts to run.
Reset button	When a failure occurs, press this key after troubleshooting to clear the error message.
Mode selection	Three modes: bind-folding, flat binding, and folding.
Debug key	When debugging the machine, various functions can be tested individually.
Alarm key	When the machine fails, the corresponding indicator will light up.
I/O key	When a problem occurs, you can troubleshoot,
Counts	Record the number of books.
Preset	After reaching the preset number, the machine stops working.
Clear	The count is cleared.
Red arrow button	Jog function, press this key, the machine starts, after releasing it, the machine stops.

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## 5.1.2 Debugging function

Press the "Debug" button to display the debugging interface, as follows:

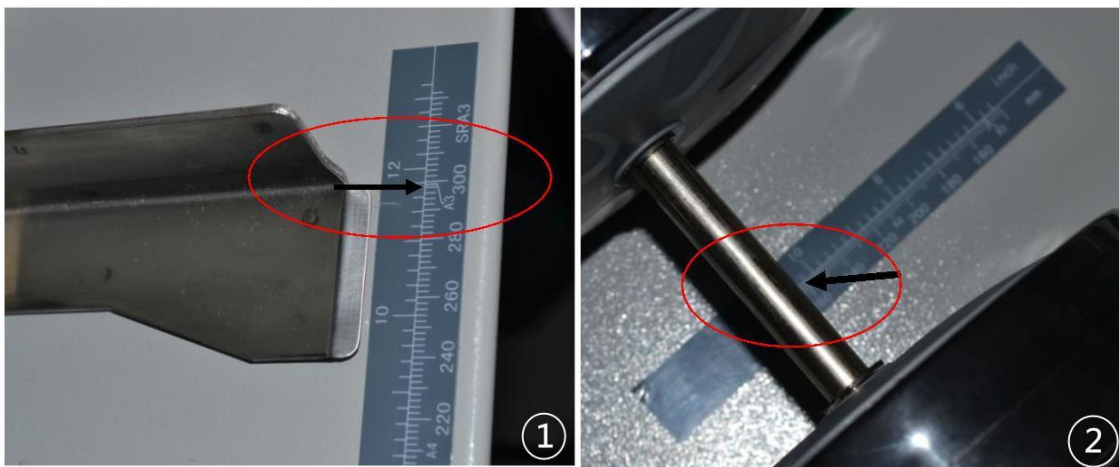


When each function needs to be tested, turn on "Debug On"; when the test is over, turn on "Debug Off".

## 5.2 Operation steps.

### 5.2.1 Operation steps of book folding mode

Step 1: Align the two paper-feeding side stoppers with the scale marks and then fix them, and swing the pinch roller on the electric take-up tray to the scale marks (② in the figure below). Take the A3 format paper as an example, as shown in Figure ① below, align the paper feeding side stopper with the A3 mark.



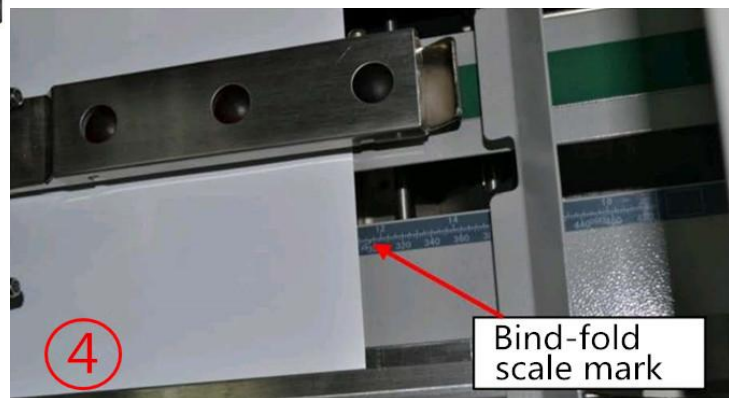
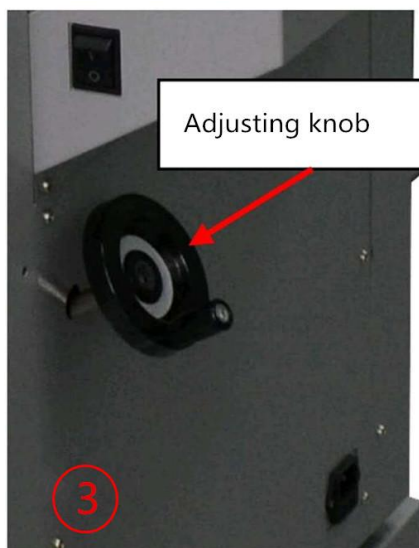


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Note: If the paper width is not a standard specification, you can follow that the distance between the two paper feeding side gauges is about 4-5mm larger than the paper width, to ensure that the paper feeding block does not squeeze the paper in the side shot during operation. Or the paper is not shot.

Step 2: Power on and press the start button.

Step 3: First press the start button, the machine delivery drive starts working, and then put in the paper, turn the adjusting knob (as shown in Figure ③) until the end of the paper is aligned with the fold scale mark (as shown in Figure ④). Press the test button again and the machine will fold once. If the ordered samples have different lengths, please fine-tune the adjustment knob (see Figure ③) and test again until the lengths are the same. At this time, press the start button to work normally.





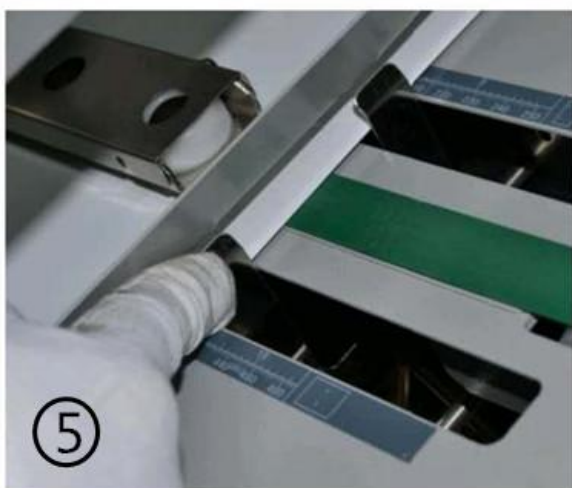
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## 5.2.2 Operation steps of flat binding mode

Step 1: Align the two paper feeding side stop gauges with the scale mark, and then fix it, and then remove the folding press board as shown in Figure ⑥.

Step 2: Turn on the machine and press the mode selection button to select the flat binding mode.

Step 3: Press the start button, the machine delivery drive starts working, and then put in the paper. While holding up the back stop gauge with your hand, turn the adjustment knob (5.2.1 Figure ③) until the back shot touches the edge of the paper (as shown in the figure) Shown in ⑤), after releasing, press the test button again, the machine will work once. If the paper bows during flat binding, please fine-tune the adjustment knob (5.2.1 Figure ③) and test again to make sure that the back-patching gauge can pat the paper without causing the paper to bow. Press the start button again at this time, then machine works normally.



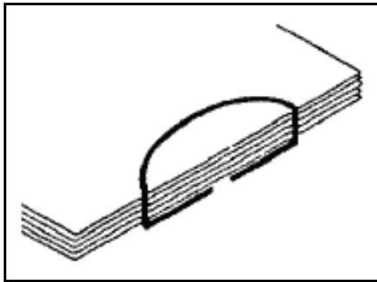


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# Chapter 6 Common Problems and Exclusions

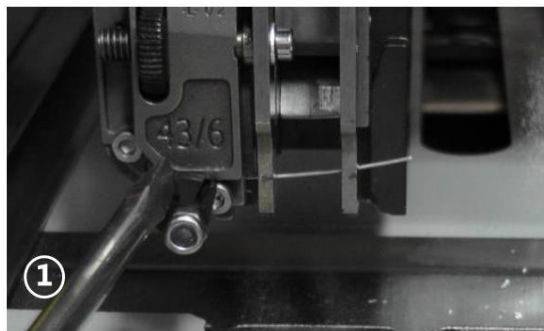
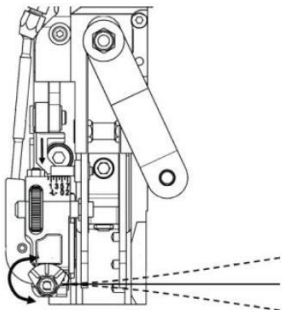
## 6.1 Causes and repairs of the failure of stitch head and staples (43/6)

### 6.1.1 The back of the staple is bent into a banana shape

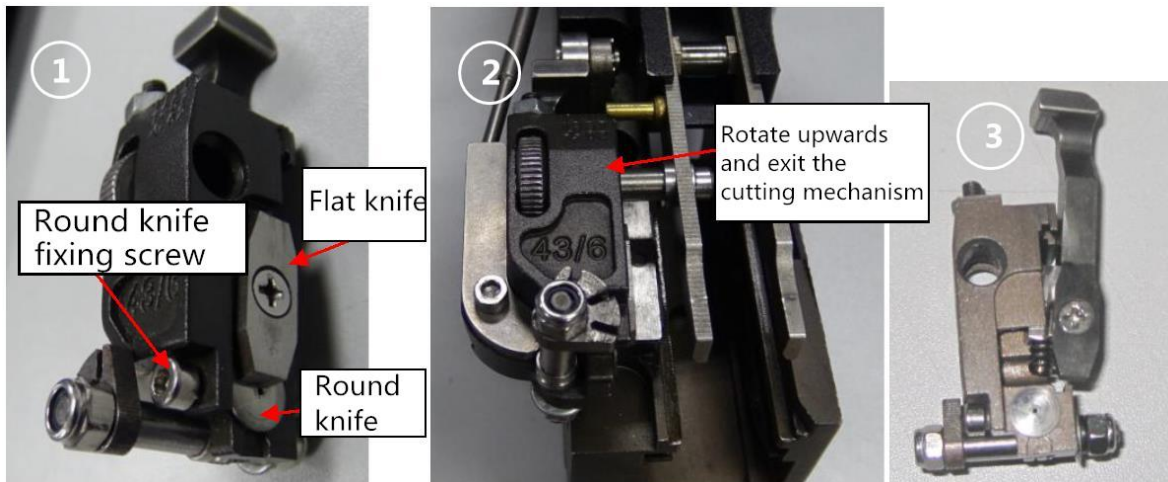


Possible causes and solutions:

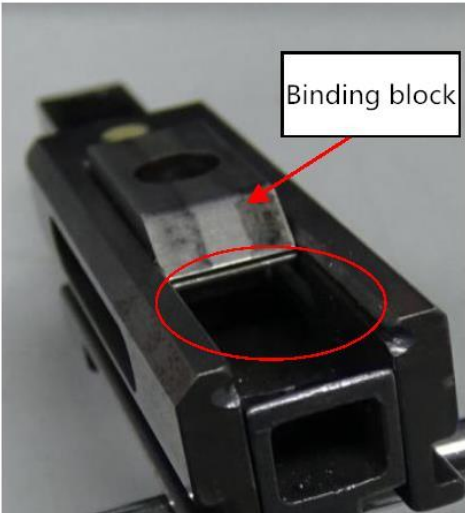
1. The wire is too soft.
2. If the wire is not straight, feed the wire to the dotted line as shown in the figure below, and adjust the wire output adjustment knob in the figure ① below with a flat knife.



3. Round knife or flat knife is damaged. You can loosen the fixed screw of the round knife and turn the round blade to change the cutting position or pull the round blade out of the plane to make the two blades stick tighter (Note: After the round blade is moved out, it is necessary to ensure that the flat knife can automatically rebound after being pressed down. ), in addition, the flat knife can be exchanged for one end.



4. The wire groove of the binding block is dirty, worn or damaged. Clean the groove of the binding block or replace the binding block.



5. The pressure of the nail tool is too low: remove the blocked iron wire.



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### 6.1.2 The back of the staple is not tightly attached



Possible causes and solutions:

The staple has not been fully compressed, adjust the length of the cross beam link to the required thickness or the staple head is not installed in place. See 4.2.

### 6.1.3 The feet of the staples are not sufficiently fastened



Possible causes and solutions:

1. The book binding has not been fully compressed, adjust the length of the binding beam link to the required binding thickness. 2. The butterfly piece has not been lifted to a sufficient position: adjust the lift stroke of the machine. 3. The time from butterfly movement to upward movement is incorrect: the butterfly piece just tops the horizontal position when the calibration binding block drops to the lowest point.

### 6.1.4 The back of the staple is not tightly attached and is in the shape of a saddle



Possible causes and solutions:

1. The book binding has not been fully compressed, adjust the length of the binding beam link to the required binding thickness. 2. The iron wire is too soft. 3. The pressure of the nailer is too low: clean the blocked iron wire, see point 5 in 6.1.1.

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### 6.1.5 Adjust the length of the staple legs.

1. The nail feet are long at one end and short at the other. As shown below:



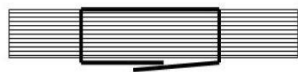
Remedy: Turn the foot adjustment knob downward to make the two nail feet equal, otherwise, turn the roller upward. See item 10 in the 43/6 heading icon.

2. The two nail feet are too short. As shown below:



Remedy: Rotate the nail adjustment knob counterclockwise to make the cut iron nails longer, and then turn the foot adjustment knob upward to make the two nail feet equal. See item 1 and 10 in the 43/6 heading icon.

3. The two nail feet are too long, as shown in the figure below:



Remedy: Turn the nail adjustment knob clockwise to make the cut wire shorter, and then turn the nail adjustment knob down to make the two nail feet equal. See item 1 and 10 in the 43/6 heading icon.

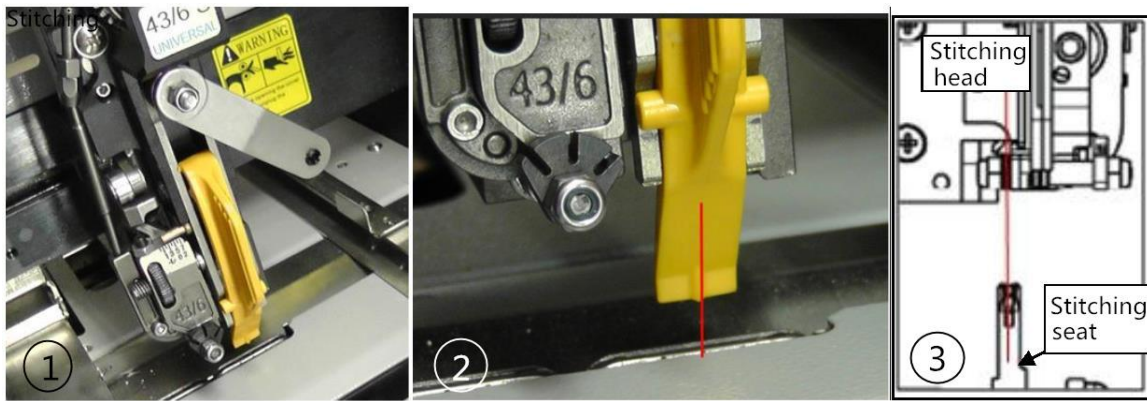
### 6.1.6 The staple leg is wrinkled and not fastened



Possible causes and solutions:

1. The iron wire is too soft.
2. The iron wire is not aligned, see point 2 in 6.1.1.
3. Align the head and seat, see ①② for left and right alignment, and see ③ for the same vertical plane.





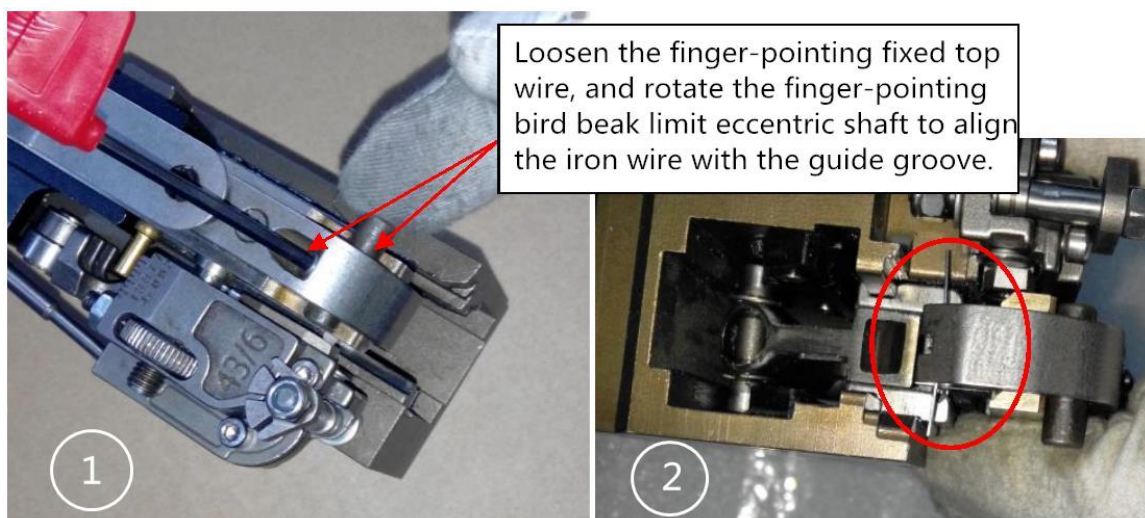
4. For different nail foot lengths, adjust the length of the cut wire to be moderate and the two nail feet are equal, see 6.1.5.
5. The sent iron wire is too short, adjust the length of the cut iron wire, see 6.1.5.
6. Wear of round or flat knife, see item 3 in 6.1.1.

### 6.1.7 Broken staple pin



Possible causes and solutions:

1. The iron wire is too brittle, use iron wires of different quality.
2. The binding block is blocked by wire fragments, remove the wire fragments, and remove the binding block if necessary. See item 4 in 6.1.1.
3. The thickness of the iron wire does not match the iron wire guide parts (bending guide and binding block).
4. Adjust the iron wire clamped by the beak of the stapling head to align with the bending guide groove, as shown in Figure ②.



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### 6.1.8 Stapler angle hump



Possible causes and solutions:

1. The iron wire is too soft.
2. The binding block is damaged, see 6.1.1.
3. Wear of round or flat knife, see 6.1.1.
4. The wire is not straight, see 6.1.1.

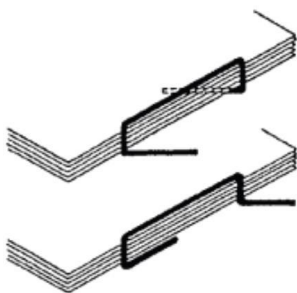
### 6.1.9 The stapling pins are in contact or the gap is too large, and the stapling pins are bent in the wrong direction



Possible causes and solutions:

1. The wire is not straight, see 6.1.1.
2. The head and seat is not aligned, see item 3 in 6.1.6.

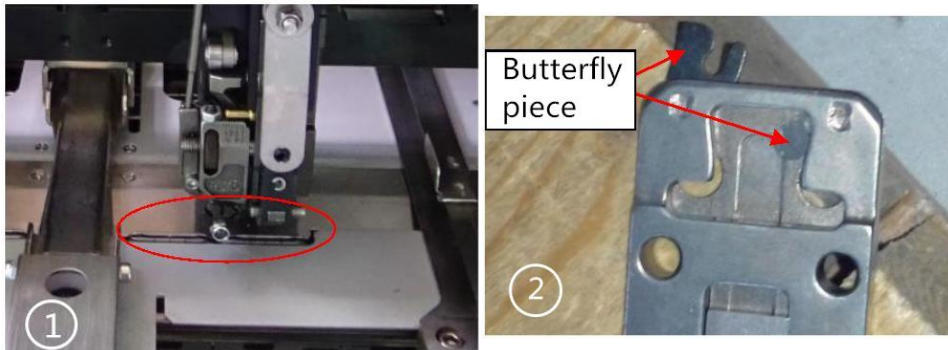
### 6.1.10 One or two legs of the staple are oblique.



Possible causes and solutions:

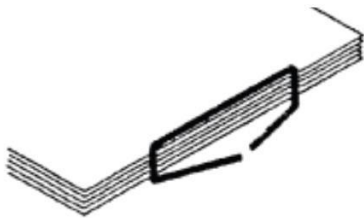
1. The iron wire is too soft.
2. The iron wire is not straight, see 6.1.1.
3. Wear of round or flat knife, see 6.1.1.

4. The butterfly piece is worn, as shown in the figure ①② below.



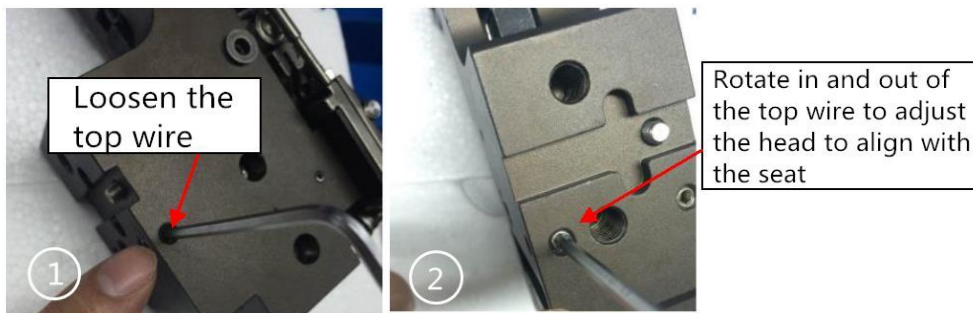
5. The head and seat are not aligned, see item 3 in 6.1.6.

6.1.11 The staple pins are inclined in the same direction.

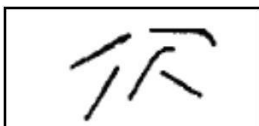


Possible causes and solutions:

1. The wire is not straight, see 6.1.1.
2. The staple head is not aligned, please refer to item 3 in 6.1.6 and the following figure ①② to adjust the staple head to align the seat.



6.1.12 A little bent iron wire fell out.



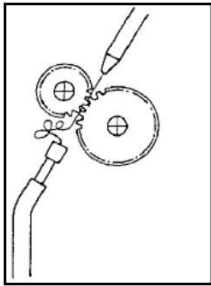
Possible causes and solutions:

1. The wire is not straight, see 6.1.1.
2. The outer groove of the binding block and the groove of the bending guide are

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worn or blocked, see item 4 in 6.1.1.

### 6.1.13 The iron wire loops around the conveying wheel and guide tube

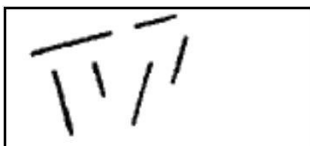


Possible causes and solutions:

1. The wire is not straight, see 6.1.1.
2. The sliding rod of the flat cutter is blocked, and the gap between the round knife and the flat knife is too tight. Refer to item 3 in 6.1.1.
3. The sliding bar of the flat cutter is locked and the compression spring in the sliding bar fails, see item 3 in 6.1.1.
4. The wire guide groove at the cutting site is blocked, as shown in the following figure ①②.



### 6.1.14 The straight cut iron wire falls out



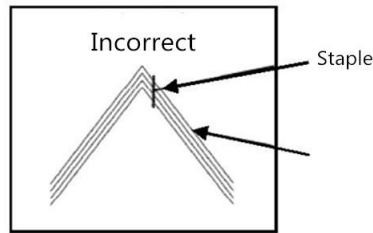
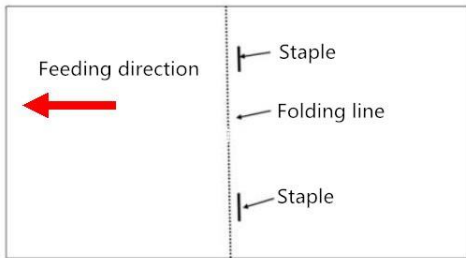
Possible causes and solutions:

1. The beak press on the beak of the stapler is too soft. See item 10 in the 43/6 heading icon.

3. The iron wire clamped by the beak of the stapling head is not aligned with the bending guide groove, see item 4 in 6.1.7.

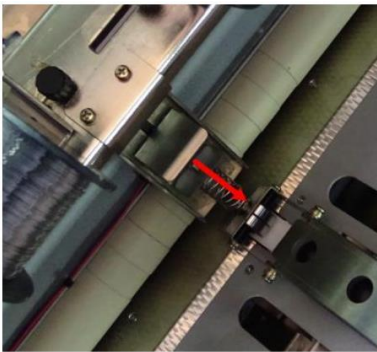
6.2 The folding line of the booklet is not on the same line as the staples.

6.2.1 The folding line is parallel to the first half of the staples.

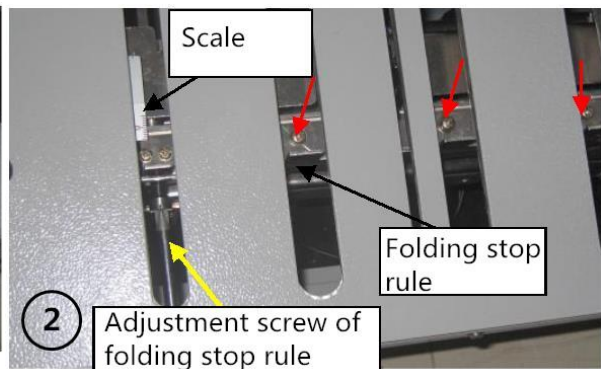
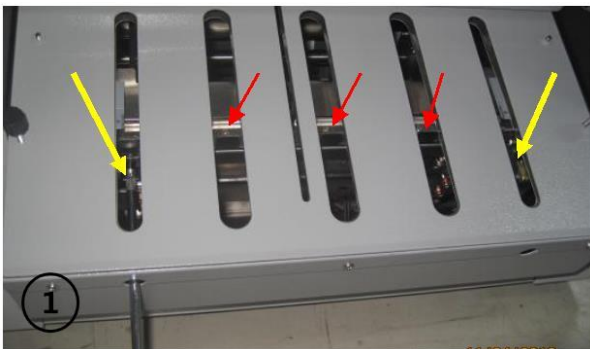


Possible causes and solutions:

1. Press the paper feed spring to increase the pressure, as shown by the arrow in the figure below.

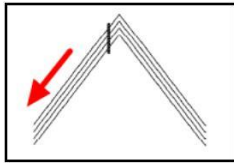


2. Move the folding stop rule downwards, the steps are as follows: First, loosen the 3 fixing screws pointed by the red arrow, and then take a Phillips screwdriver and turn the adjustment screw pointed by the yellow arrow as shown in Figure ①② to push the folding stop rule downwards. After translation, tighten the 3 screws that were just loosened.



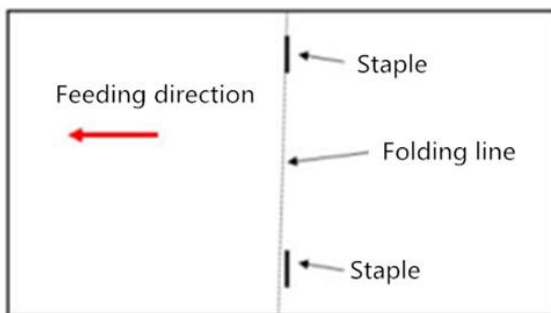
---

6.2.2 The folding line is parallel to the back half of the staples.



The elimination method is the opposite of the steps in 6.2.1.

6.2.3 One nail overlaps the folding line and the other does not overlap.



Refer to item 2 in 6.2.1 for the remedy. Adjust the adjusting screw on the right to move the current gauge down.

6.3 Report C-3 Paper jam in the paper feeding area.

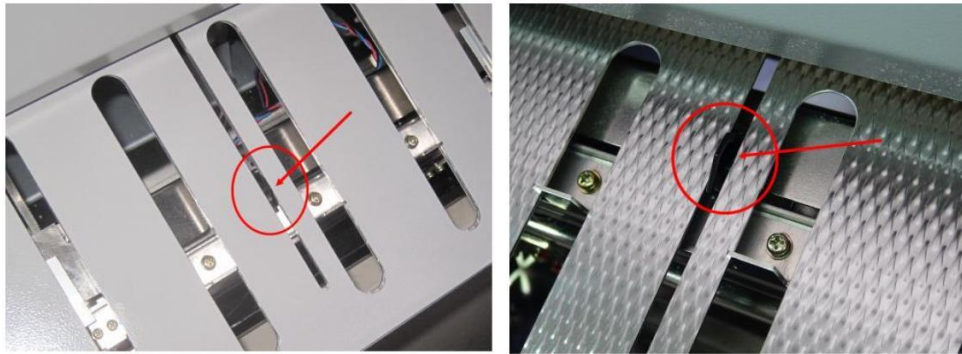
Report C-3 may be caused by the sensor in the paper feed area being irradiated by strong light or accumulated paper dust. Please clean the sensor in the red circle in the figure below.



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## 6.4 Report C-5 Paper Jam in Folding Area

Report C-5. It may be caused by strong light exposure or accumulation of paper dust in the paper feed area. Clean up the sensor pointed in the figure below.



## 6.5 Report C-6 Paper jam in the paper exit area

Report C-6. It may be caused by strong light exposure or accumulation of paper dust in the paper feed area. Clean up the pair of sensors pointed in the figure below.



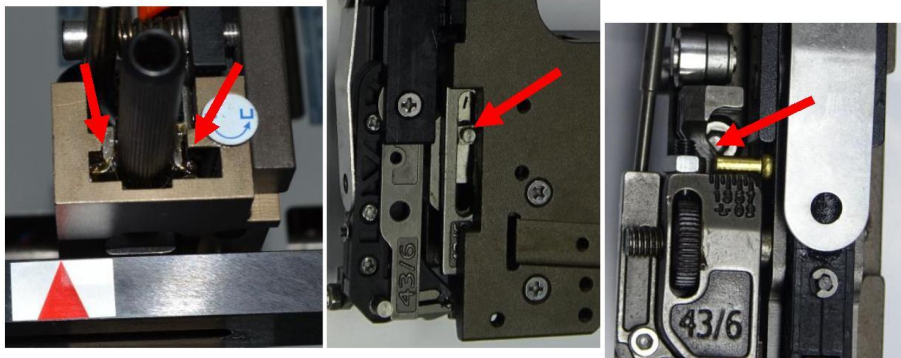
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# Chapter 7 Maintenance

## 7.1 Header Maintenance (43/6)

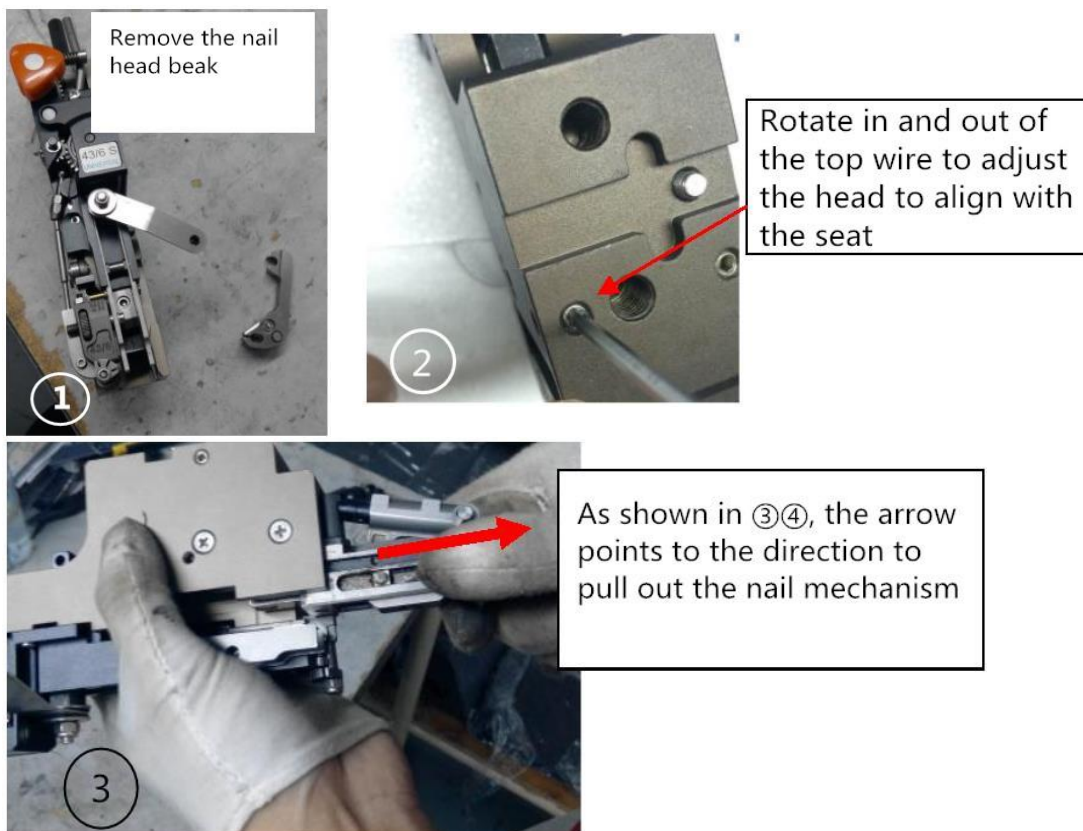
### 7.1.1 Adding grease to the head

Add grease to the position indicated by the arrow as shown in the figure ①②③:

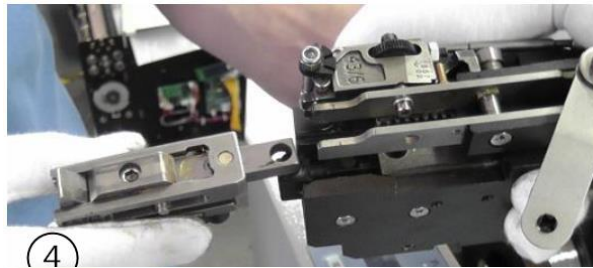


### 7.1.2 Cleaning up the head

The steps are shown in the following figure ①②③④⑤⑥. Remove the head parts and clean them and re-apply grease. The order of parts installation is reversed.

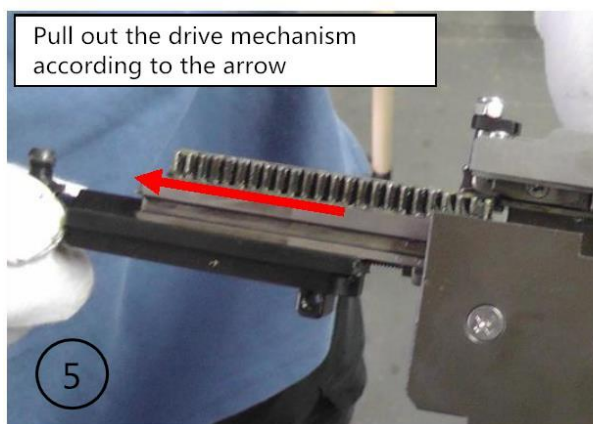




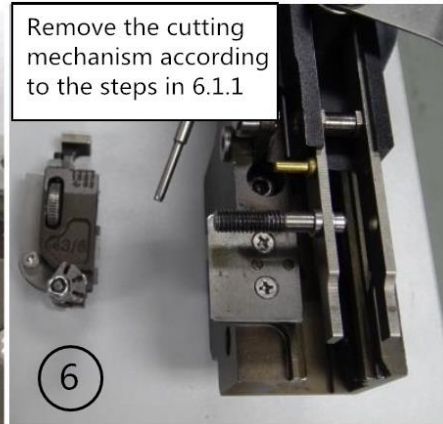


4

Pull out the drive mechanism according to the arrow



5

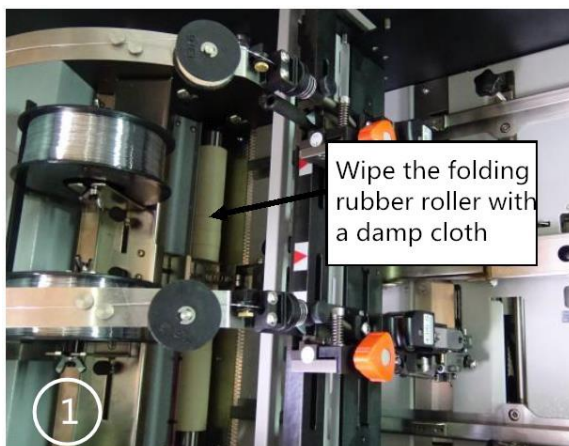


Remove the cutting mechanism according to the steps in 6.1.1

6

## 7.2 Cleaning the folding rubber roller.

As shown below:



1



2

### 7.3 List of commonly used accessories

Number	Name	Quantity
1	Butterfly piece	8
2	Wire loop	2
3	Flat knife	2
4	Round knife	2
5	Beak clip wire	2