8603 Digital Creasing Machine

Operation Manual

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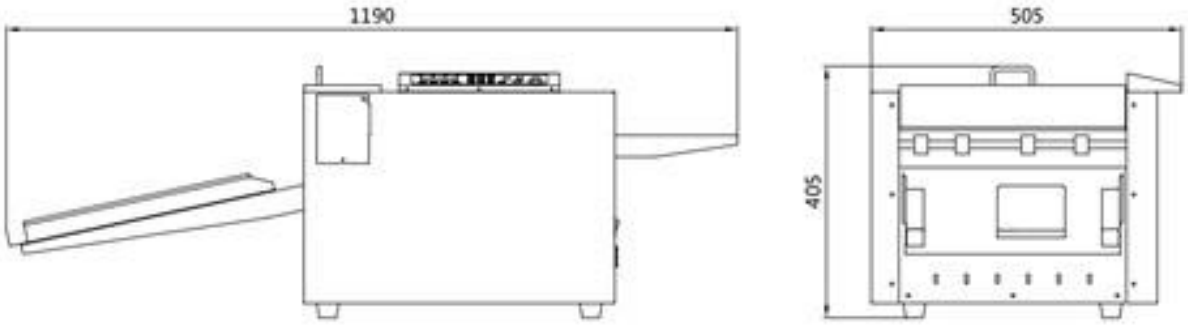
1. Introduction

Thank you for choosing our products. In order to ensure you can use this product in correct way, please read the manual carefully, pay attention to every details of the operation. It will help you on production and improve your skills.

8603 Digital Creasing Machine is a product developed by us based on our technological superiority and production capacity. The processing position is digital control with creasing and perforting two functions in one. The workding width is 340mm, paper thickness 100-350g, Max. paper working length 900mm, Max.32 creasing times on one paper. Hope this machine will make your work perfect and help you a lot.

2. Machine Specifications



2.1 Specifications

Paper Size: 50*90mm (Min.) , 340*900mm (Max.)

Paper Thickness : 100-350 g/㎡ (creasing) , 100-200 g/㎡ (perforating)

Paper Type : Coated paper、Laminated paper、Varnish paper etc.

Working Precision : ±0.3mm

Working Speed : 2400 pages/hour (one crease on each A4 paper)

Creasing Times in Each Paper : 0-32 times

Voltage : 220V/50Hz OR 110V/60Hz

Power : 150W

Weight : 42KGS (N.W.) , 48KGS (G.W.)

3. Safety

3.1 Environment

Temperature：10˚C to 35˚C

Humidity： 30% to 70%

Altitude：below 1000m

There is no corrosiveness gas, flammable gas, oil mist and so on in room.

3.2 Notice

Do-Read this manual and fully understand before the operation.

Do-Check the plug and machine voltage and frequency to your main supply,and that the socket has a correct working earth lead for this single insulated machine.

Do-make sure all safety covers are in place.The top covers have an interlock switch which will disable the unit if removed.

Do-disconnect the power before clean the inner side.

Do-unplug the cord if you won't use the machine for a long time.


Don't-install the machine on an unstable ground.


Don't-operating with wet hand,especially plug or unplug the cord.


Don't-wear long hair,loose fitting clothes or put your fingers into the creasing unit nip,while the operation.


Don't-place any receptacles with any liquid on any surface of machine.


Don't-put other pieces,especially tiny pieces on loading table.


Don't-alter or uninstall the machine,unless by authorized engineer.

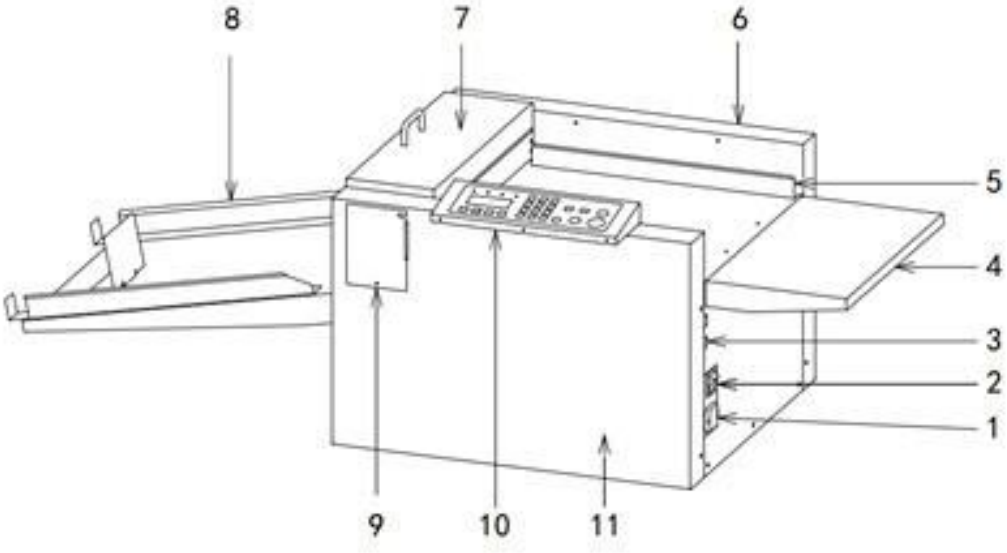

Don't-touch any running parts while running.


Don't-shut down the machine while running.

Be careful of any metal or flammable thing in internal machine, or it may cause fire or electronic shock. If it happends, first shut down the power, disconnect the cord, then contact the technician.

If the machine become heat, smoke,or smelly, shutdown at once, disconnect the core, and contact the maintenacnce staff.

4. Main Parts



1. Power Socket	for system power
2. Power Switch	on/off
3. Tools Mounter	store tools/knives
4. For Longer Sheet	for longer sheet
5. Side Guide	flexible guide for the paper infeeding
6. Right Cover	protect the safety of intermal parts and operators.
7. Upper Cover	isolated operating unit (it makes machine disable when it is not set well)
8. Output Tray	to stack the finished products
9. Slid-in Tool	crease tool, easy to exchange
10. Control Panel	input the data
11. Left Cover	protect the safety of internal parts and operators

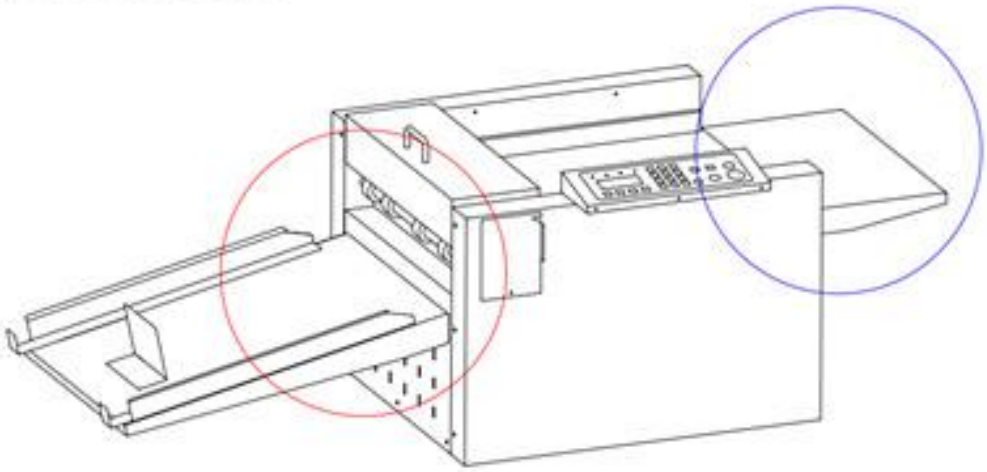
5.First Installation

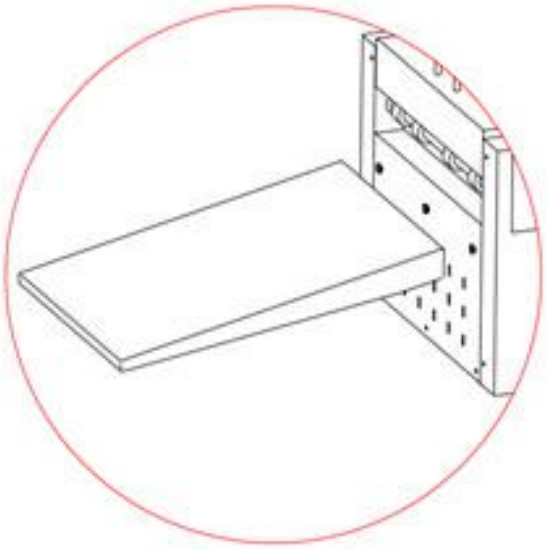
Un pack it , install the parts as per above illustration. We can see there are three screws on trail of feeding table, and there are three holes on side of extension table.

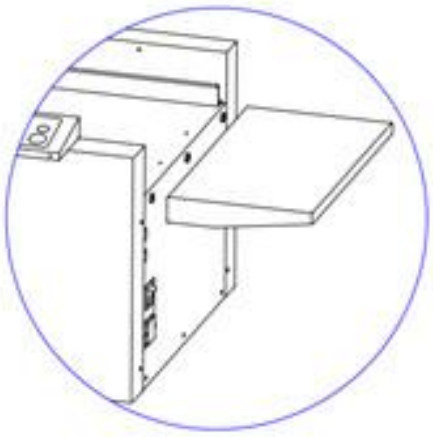
1: Loosen three screws, but not remove.

2: Connect extension table, with each screw head through a hole, clip the extension table on.

3: Tighten three screws.

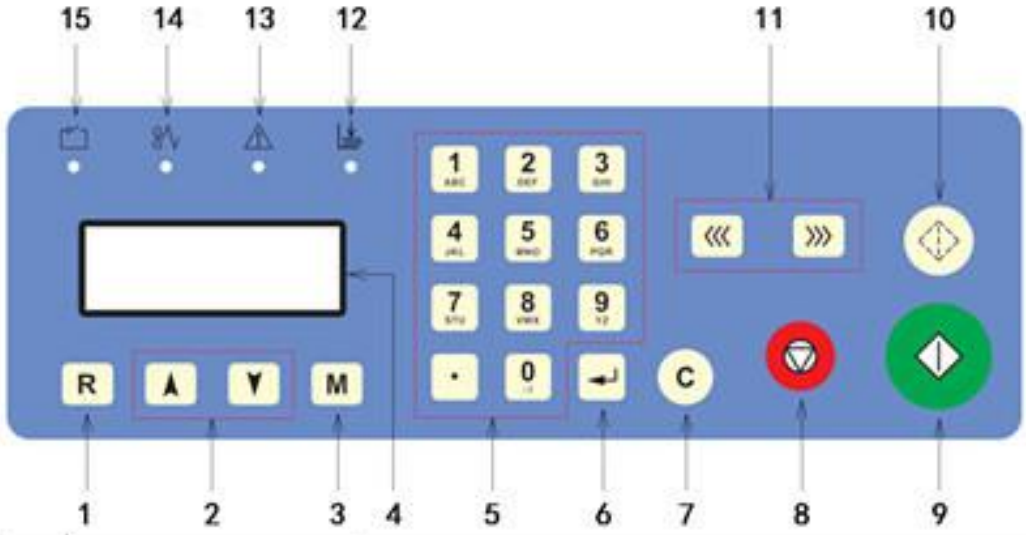






6. Operation

6.1 Control Panel

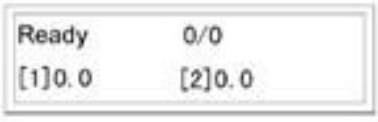


1	Reset	Counter reset
2	Scroll	Turn the page
3	Mode	Change the modes
4	Screen	Display information
5	Numbers	Input data
6	Enter	After the data input, press it to confirm
7	Clear Lear	Clear the data or clear the error display
8	Stop	Stop the machine
9	Start	Run the machine
10	Test	Machine will stop after one sheet
11	Unjam Forward /Reverse Button	When paper jams, press them to move rollers, so that the paper can be easily cleared.
12	Indicator -No Paper	If the machine didn't find a paper in long time,it lit and return a error report 1(no paper or paper entrance jam)
13	Indicator-Blade Jam	If the crease motor locks, it lighten and return a error report 4 " CR Motor Error"
14	Indicator-Paper Jammed	If the paper is jammed inside the machine, it lighten and return a error report 2 (Jam at infeed) or 3 (Jam at outfeed)
15	Indicator-Safety Cover	If the safety cover is not well setting, it lighten and returned a error report 1 (cover open)

6.2 Function and operation

6.2.1 Main operation：

Plug the machine，turn on the power，machine will do self-test，then jump to operation mode automatically.



Now the machine will remember the last setting data,in this condition,if press "start button" or "test button" it copy the last command..

When press the "Mode" button,it will jump to Crease data input,[1] will flash automatically,you can input data from 0-900,it accurate to one decimal place.
After it finished,press "enter" button.[1] stop flash and [2] start flash,and you do the same operating until finished total 32 data input or you press "enter" button when the data is "0" so it will jump to Home Screen. Press "start" or "test" button,machine will work automatically.

"0/0" indicate "pass paper quantity/setting paper quantity,when pass paper quantity reach to setting paper quantity,the machine stop.Under ready mode,press "reset"button can input setting paper quantity,then press "enter" button.double press "reset"button,it clear all data.
The Max.data is 900,when digit is 0 means havn't setting paper quantity.

Under ready mode,press "SCROLL- up" button,it will jump to quantity count.
Total working times: total counter of sheets
Total creasing times: total counter of crease

Ver:1.2.4
S/N:123456789

In count view,press "SCROLL-down" button

Ver: Software version

S/N: Serial Nr, factory setting, it can not be overwritten unless main board is changed.

6.2.2 Cover hinge： This is a mode specially for book cover make

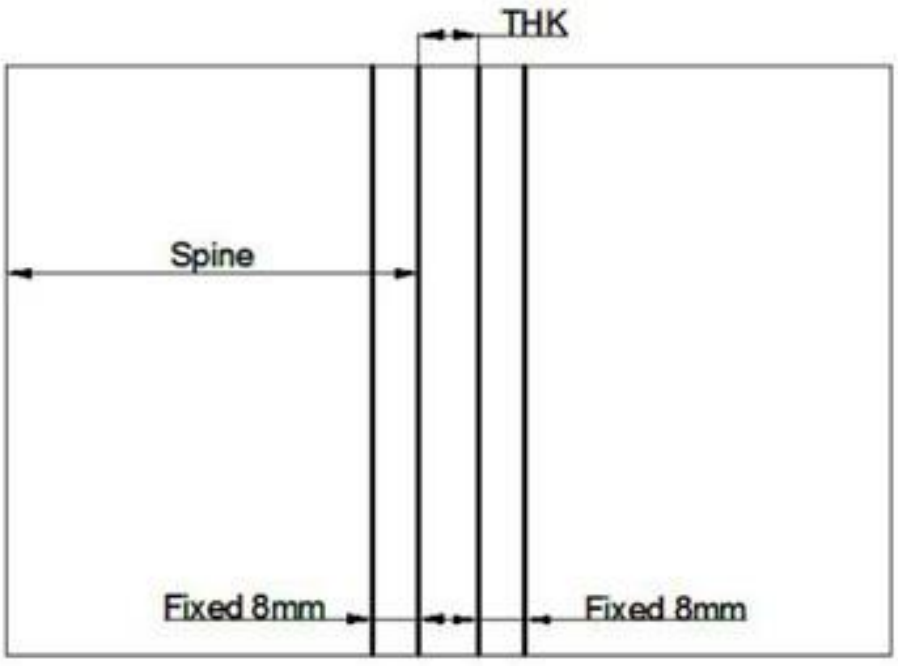
Cover hinge
SPINE:200

Under ready mode double press"mode" button, itwill jump to Cover hinge,

Spine： the first spine line to the leading edge.

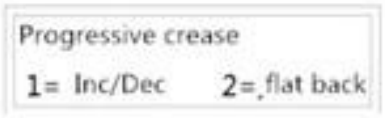
THK： the thicknessofthebook,namely the spine width.

THK: 10



6. 2. 3 crease

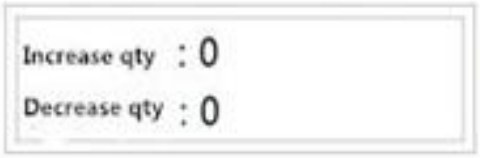
User do not need edit different crease data or adjust the position on manual creasing machine.



On ready mode press three times "mode" button, it will jump to progressive crease. it has two style: increase/decrease mode & flat back mode. users can press 1 or 2 to choose.

Increase/decrease model also has three progress types: increase&decrease, increase, and decrease.

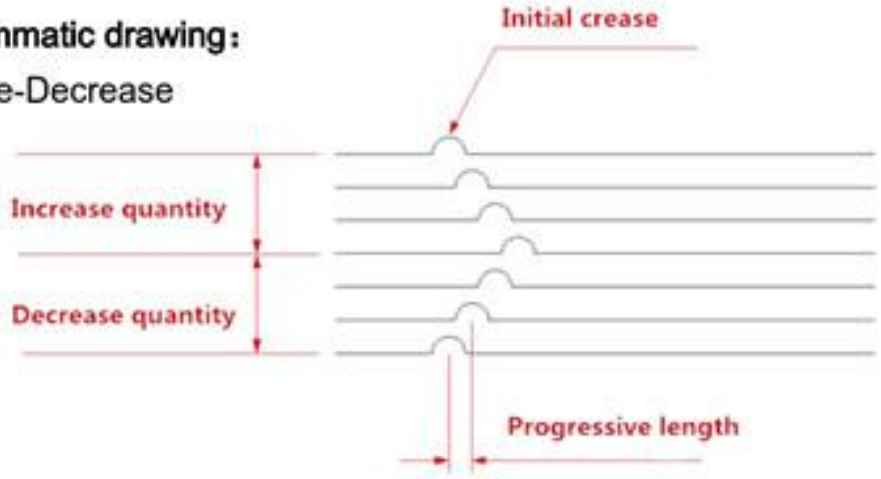
Initial position: the distance from the paper edge to the first crease position, press"enter".
Progressive length: increase or decrease based on the Last data. Press "enter" button.



Increase qty: the increase of paper quantity.
Decrease qty: the decrease of paper quantity. press "enter" button then it will jump to ready mode.we can use page scroll to check if the data is setin correct or not.after all is ok,we press "start" button to work.

Diagrammatic drawing:

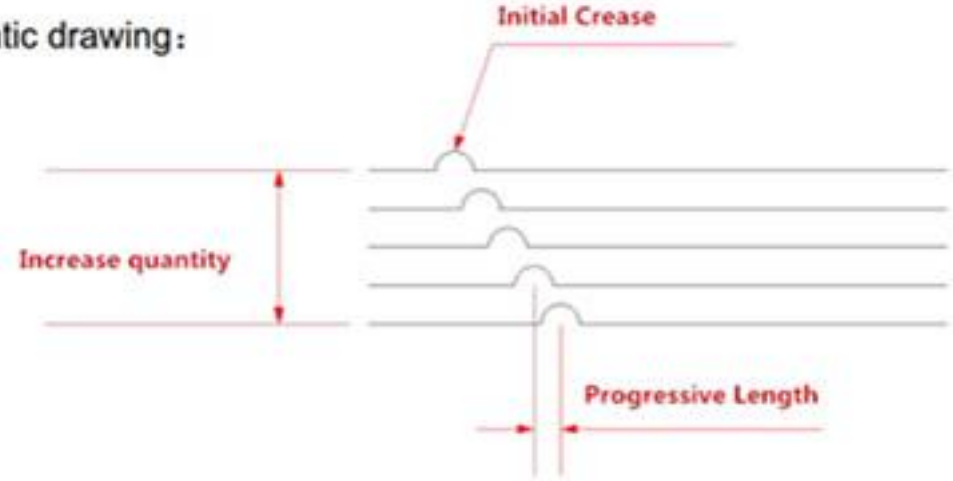
Increase-Decrease



Increase progressive crease：

Input the data of increase paper quantity and input "0" on the decrease quantity.

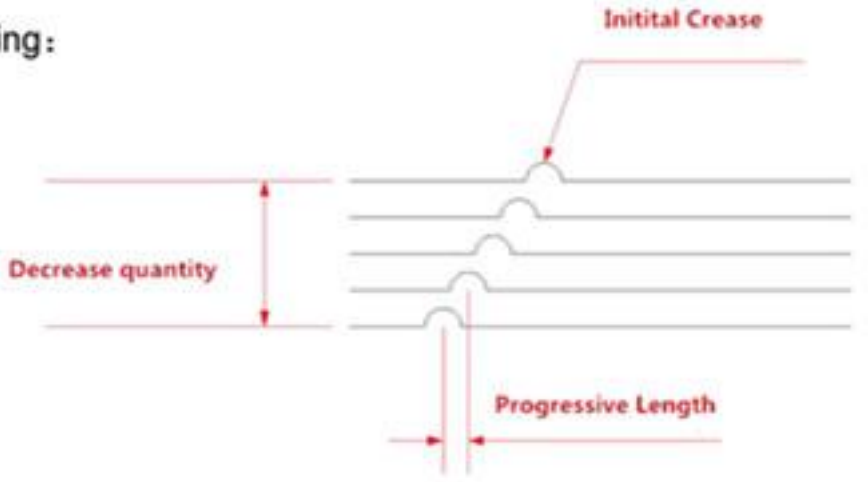
Diagrammatic drawing：
Increase



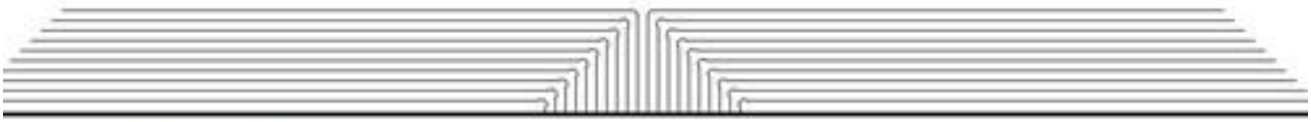
Decrease progressive crease：

input the data of decrease paper quantity and input "0" on the increase quantity.

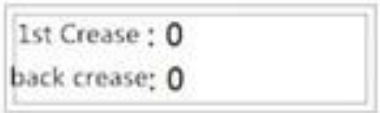
Diagrammatic drawing：
decrease



Progressive Increase/Decrease was widely used on perfect binding range. Even the thick binding book can easily open.



Flat Back Mode ：

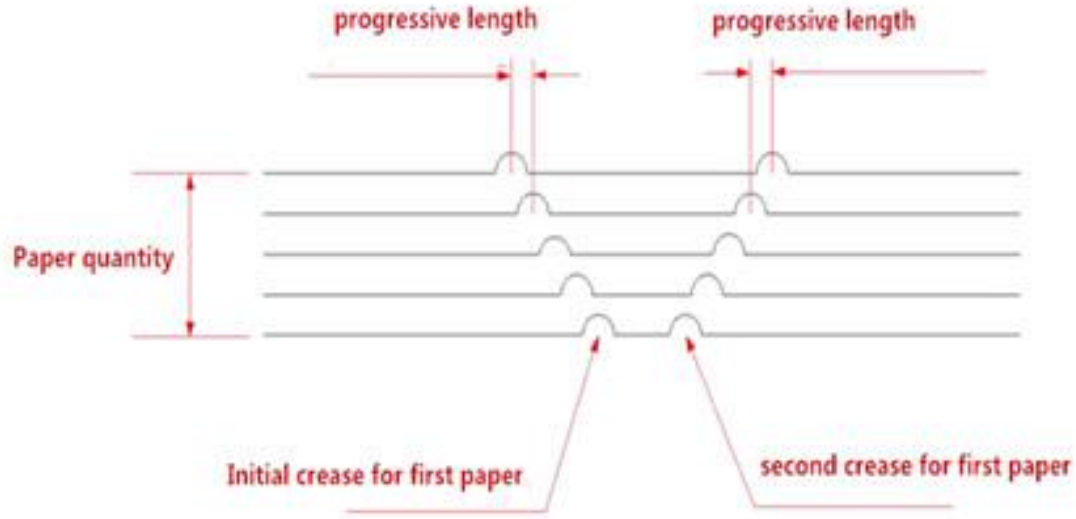


1st Crease : initial crease on the first paper.
back crease : second crease on the first paper.

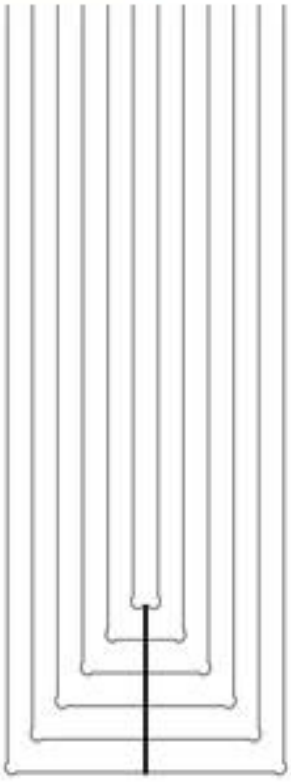
Press enter button it jump to；
space length : value increase according to the above crease data automatically.
paper quantity: the crease paper quantity.

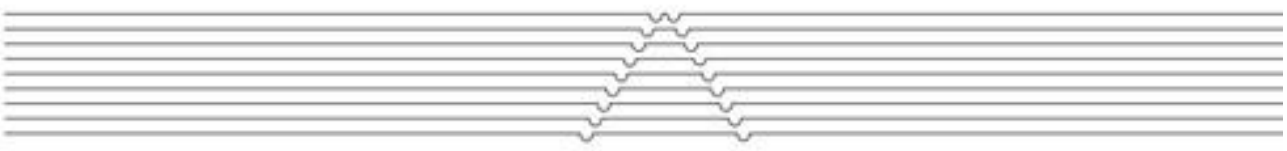
Press enter button, it jump to ready mode and we see as the left photo shows,
If everything ok, we start work.

Progressive (flat back) Drawing：



Flat back model crease was widely used on wire stiching binding. It is suitable to flat back perfect binding.





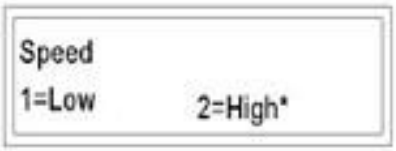
6.2.4 Recall job and save job:

Frequently used crease data can be saved and recalled, so that user don't have to input data each time. The system at most saves 30 jobs.

On the ready mode, press four times"M" button,you can input 1-30 digit to recall the job.

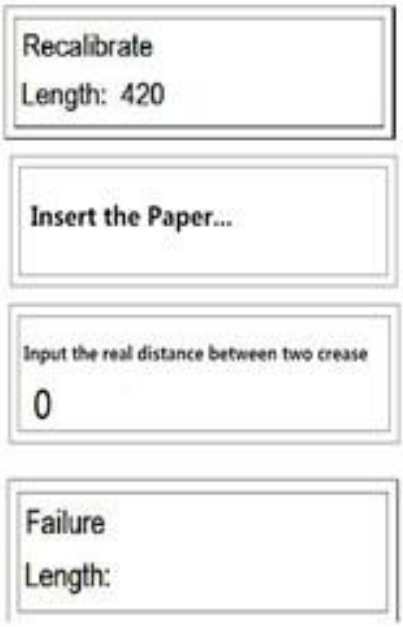
On the ready mode, press five times "M" button, you can input 1-30 digits to save job. It will return a success after it is saved.
Remark: data will be sweeped away if you save another data in same place.

6.2.5 Speed:



On the ready mode,press six times "M" button to choose the speed 1 or 2 press "enter"to confirmed.

6.2.6 Recalibrate：If the Crease line gap is stretched or shirinked, the crease tolerance will be accumulated as crease line increased. For a quick calibrate, we operate on Recalibrate mode.

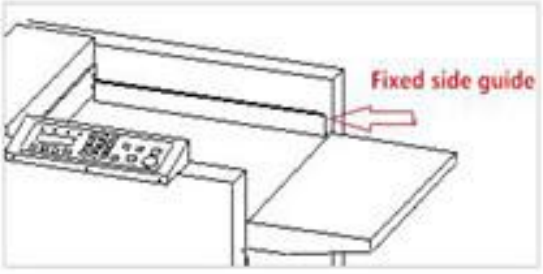


Input the real length of the paper as following (say 420mm) press "enter",machine runs automatically double times. It will jump to "input thecorrect crease length"(this is veryimportant, Measure the distance to the nearest decimal point) press enter.

It will shows OK or failure.
If failure,the problem maybe the paper length is not suitable or test crease length and real length too much.

6.3 hardware setting

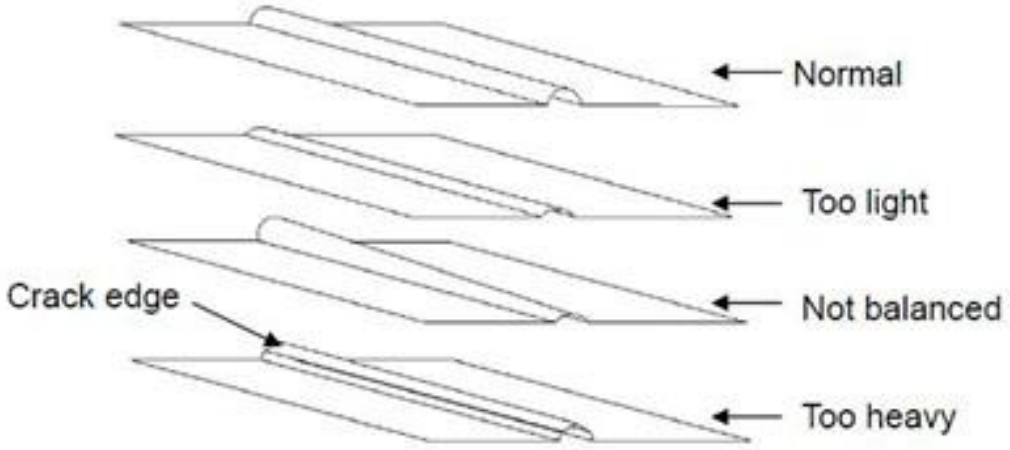
6.3.1 skew adjustment



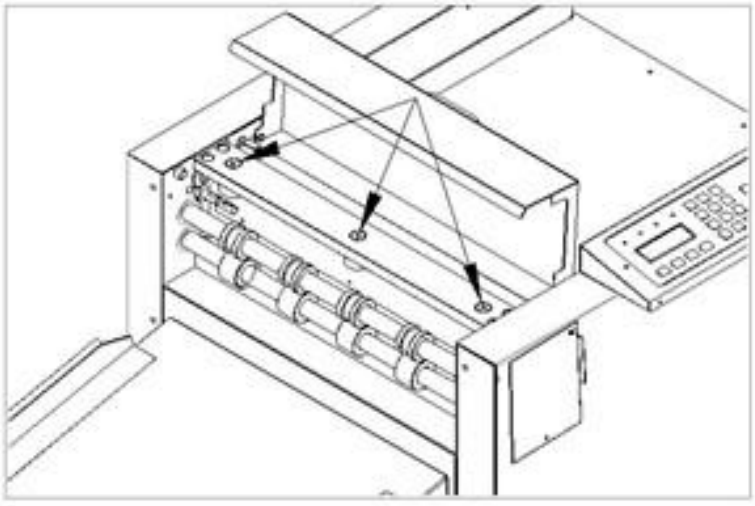
If it is found t he crease is skewed (not vertical to the paper side), you need to adj ust the feeding angle to get a satisfied performance .
Fixed side guide is the hardware where we adjust the skew.
As per， above picture, the guide is fixedby 5 screw, rear one is through a slot hole.
We can loosen the screw ,and move the side guide a bit, so that the feeding direction is micro adjusted to compensate the skew issues.

6.3.2 Crease depth

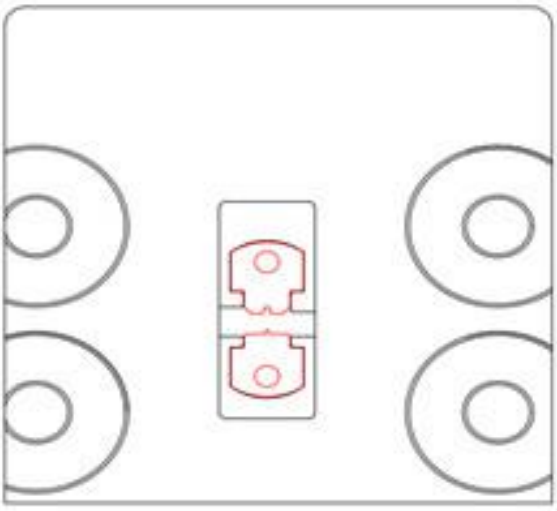
Crease depth is important to crease quality. It just depends on the gap between male die and female die. Depth should be adjusted according to the paper thickness. Low Depth will perform a not clear crease. but a high Depth may cause cracking, cause system take it as a double feed.
The adjustment is also needed if the crease depth are not balance on both sides.



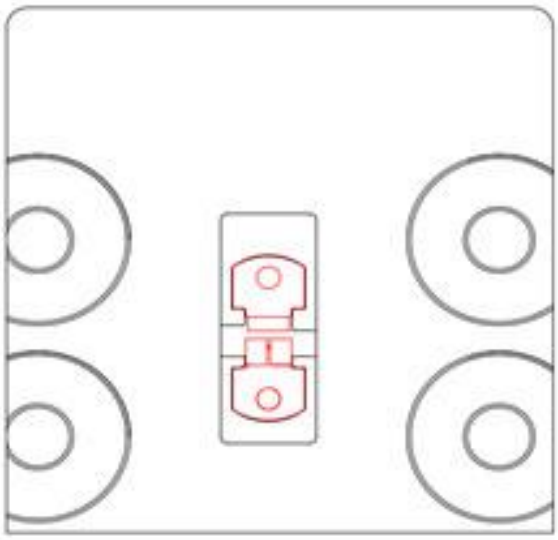
To adjust the Depth:
Open the safety cover and you will see following picture.
Find 3 screws on both side, turn the Allen screw according to the label beside to make the crease line deeper or light.



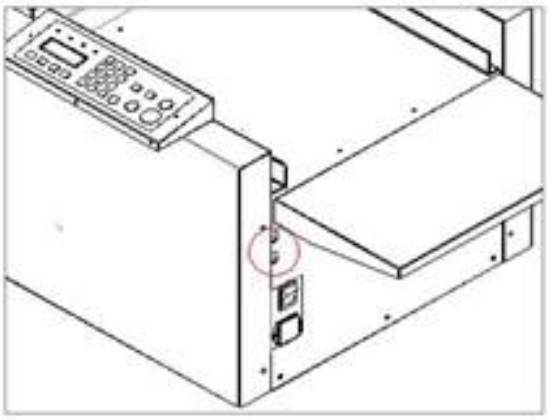
6.4 OPTIONAL PARTS



Crease tool install:open the safety cover,put the two crease blade same as the photo shows.



Perforating tool install: open the safety cover,put the two crease blade same as the photo shows.



In the photo which marked red is the tool box.

7. TROUBLE SHOOTING

1. Crease cracking or Motor error (error code on display-4)

This occurs:

- 1)feeding too much paper one time
- 2)the upper blade is set too low
- 3)If the card is too thick (over 400gsm)

Solutions:

1.Becarefultousethe directionbuttonofthewrongcueinterface, and use hand assist to remove the paper

2.Choose right paper, set Adjust the depth, according to 6.3.2

3.contact with engineer

2.Paper jam（error code on dispaly-2 -3）

This occurs：

A. paper too thin (the paper will crumple)

B. if there is some waste present in the paper path.

C. if there is too much ambient light shining on the IR sensor (especially direct sunlight or neon light which will send fake paper jam signal)

D. the papers are curled or the blade is set too low

Solution:Press the button as below photo and take away the paper from the machine

3. Bubbling in laminated stock

This occurs if you try to crease laminated stock ,the curve of the crease will not adhere to the film.

Solution: make a less deep crease or use a better film.

4. Not a deep crease

This occurs :

1) If the card is too thick

Solution: The paper is out of standard spec, then you have to customize crease dies, with deeper female die.

2) the upper blade is set too high

Solution: Adjust the depth, according to 6.3.2

5. Need more wider crease

Solutions:crease two times and the distance between two crease line less than 0.5mm,so two crease superposition into one,it become wider

6. Infeed skew

Check if the paper is square,

No-Solution: Use standard paper or adjust the side guide to get a satisfied performance.

Yes- Solution: Adjust the fix side guide according to 6.3.1

7.there is paper coating on the roller

The roller will accumulate the layers of the paperto beprocessed.

These residues may cause friction to decrease, resulting in skidding.

Solutions:Wash the roller with alcohol

8. Maintenance

Maintenance is essential to the machine, and necessary maintenance can extend the life of the machine and improve mechanical efficiency.
Maintenance work mainly includes two aspects: user maintenance and technical maintenance.

User maintenance

When the machine is used for a long time, dust or scraps of paper will accumulate between the mechanical parts and adversely affect the use of the machine. So operators should regularly clean the paper scraps and dust inside the machine.For example, each production of 4000-5000 pieces of maintenance.
The rubber roller and the screen are regularly cleaned with alcohol, and we should pay attention to the working environment of the machine, ensuring the environment is dry and clean, and there is no direct light.

Technical maintenance

It is also important to carry out technical maintenance on a regular basis. It is mainly carried out by technical personnel, including regular inspection of the loss of parts, replacement of damaged parts and lubricant.