

# Staple Folding Machine

## Operation Manual



# Introduction

Dear customer :

Thank you for choosing products from our company.

Our company is a professional office equipment manufacturer. We have a team for design, manufacturing, installation, commissioning, maintenance.

In order to make our equipment more convenient and efficient for your work, please read the operation instructions carefully before using this machine.

When the machine breaks down, please do not allow the machine to work with disease. Please refer to the instructions in the appendix for trouble shooting. During maintenance, please make sure power is off.

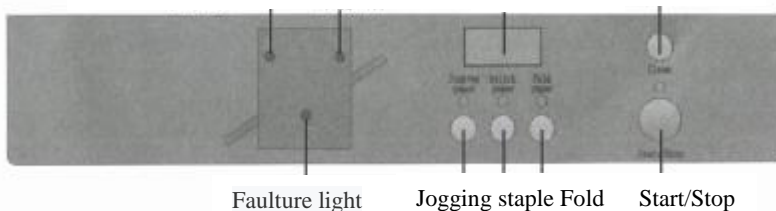
In this process, if you can't solve the problem by yourself, please contact our after-sales engineer in time, we will provide you with fast and high quality service!.

# Content

I. Control Pannel.....	P3
II. Function.....	P4
III.Parts, principle, parameters.....	P4
IV.Installation and debugging.....	P6
V. Maintenance.....	P9
VI.Failure phenomenon, cause and solution.....	P10
VII.Instructions for use and maintenance of riding staple head.....	P11

# I.Control Pannel

The front cover is not install well.    The behind cover is not install well.    Cumulative quantity    Clear key



NO.	NAME	DESCRIPTION
1	Left error light	The left cover is not covered properly.
2	Right error light	The right cover is not covered properly.
3	Paper jam light	Paper jam inside.
4	Function key 1	In waiting for cutting time fine tuning function, as a fine tuning key.In the paper - out electromagnet suction time fine - tuning function, as a fine tuning key.In the test paper code as a fine tuning key.
	Function key 2	Press and hold this button when starting up to enter the function of fine tuning waiting for paper cutting time.
	Function key 3	In the paper - out electromagnet time fine - tuning function, as a fine - tuning key.In the paper - out electromagnet absorption time fine - tuning function, as a fine - tuning key.In the test paper code,as a fine-tuning key.
5	Start/Stop	Press this key,start or stop the machine.
6	Clear	Clear the current cut text number.Displays the total number of cut text.Press and hold this key to enter the function of fine tuning the paper - out electromagnet's closing time.
7	Window	When the light shows green, it is standby, orange is working, and red is paper jam or debugging.

## II.Function

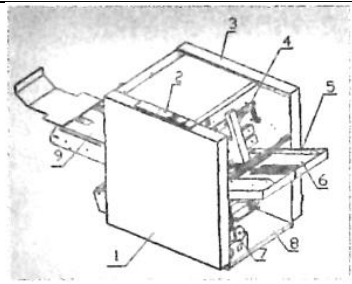
This machine is not only can be independently set and fold two processes of the machine, and press cutting machine for online operations, with the press cutting machine online, can achieve online set, fold, press, cut a dragon continuous operation, greatly facilitate the printing of enterprise customers, greatly improve the work efficiency.

This machine USES the digital display, with the key operation, the user can be very convenient to set and fold a whole, only or only set the mode of switching.

## III.Parts, principle, parameters

SBM-460

NO.	NAME
1	LEFT COVER
2	SCREEN
3	RIGHT COVER
4	STAPLE
5	PAPER BLOCK BOARD
6	FEEDING BOARD
7	STAPLE ADJUSTMENT KNOB



# 1、 PRINCIPLE

Use the flat belt to send paper to the bottom of the staple, the machine automatically identify the paper in place and on the riding staple;Then continue forward to the folding roller, when the paper in place, the machine will automatically fold the text in half compactness, and then automatically code in turn, stacked on the receiving table.

## NOTICE: TEST CODE

- a.Press “start/stop”, screen display“HO”。
- b.Press “Jogging”and“Stitch”to adjust from“H0”to“H7”。
- c.Press “start/stop”,test the machine。
- d.Press “clear”to exit test.

CODE	DESCRIPTION
H0	Test digital tube and indicator light
H1	Test disposal paper blocking (origami) electromagnet: press "start/stop" button once to close, and press "start/stop" button again to disconnect.
H2	Test the paper feeding electromagnet: press the "start/stop" button once to close, and press the "start/stop" button again to disconnect.
H3	Test the paper tapping electromagnet: press the "start/stop" button once to close, and press the "start/stop" button again to disconnect.
H4	Test the staple electromagnet: press the "start/stop" button once to close, and press the "start/stop" button again to disconnect.
H5	Test origami electromagnet: press the "start/stop" button once to close, and press the "start/stop" button again to disconnect.
H6	Test main motor: press the "start/stop" button once to close, and press the "start/stop" button again to disconnect.
H7	Feed sensor: 0 pass light, 1 block light. Fold sensor: 0 pass light, 1 block light.

## 2、Parameters

NO.	PROJECT	Parameters	Notice
1	WORK MODE	STAPLE/FOLD/STAPLE AND FOLD	
2	PAPER SIZE	A5~A3	
3	VOLUME OF 70g PAPER	20 PCS	
4	SPEED OF 70g PAPER	1500pc/h	
5	NOMINAL VOLTAGE V	110	
6	Hz	60	
7	RATED POWER W	300	
8	TEMPERATURE°F	59-95	
9	HUMIDITY RH	20%-80%	
10	NET WEIGHT lbs	249	
11	ROUGH WEIGHT kg		
12	MACHINE SIZE LXBXH inch	55x21x25	



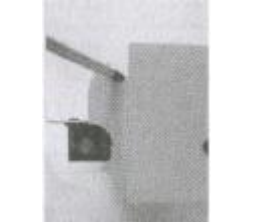
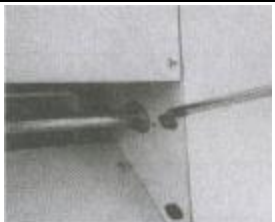
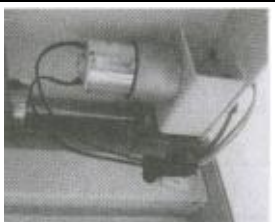
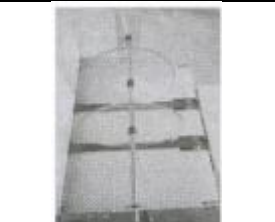
## 二、INSTALLATION AND DEBUGGING

Use scissors to cut the plastic binding tape, remove the paper outer box, slowly move the machine from the wooden base to the workplace, and lock the casters when it is properly placed.

Check the random list of accessories and start installation and debugging after it is complete:

NO.	NAME	QUANTITY	NOTICE
1	MAIN MACHINE	1	
2	COLLECTING UNIT	1	
3	POWER LINE	1	
4	PRESS PAPER WHEEL UNIT	1	
5	CROSS SCREWDRIVER	1	
6	STRAIGHT SCREWDRIVER	1	
7	WRENCH	1	
8	OPERATION MANUAL	1	

**a.**Install the receiving table. See the following picture for details :

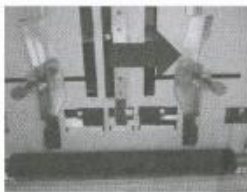
Loosen screw	Reverse and lock the receiving table	Hang the gap on the wallboard post
		
paper table notch buckle	Moter Plug	Fix the pressure wheel and bracket well
		

**b.**According to the text specifications (such as A3, A4, etc.), adjust the position of paper folding board and folding board (the paper folding board is slightly wider than the paper folding board);Then fold in half with a piece of paper that needs to be stapled and insert it under the stapler head. Adjust the handwheel to make the stapler head flat with the paper crease.At this time, the position of folding is basically synchronized with that of binding. If there are still differences, further fine-tuning is required.

Adjust side beat position

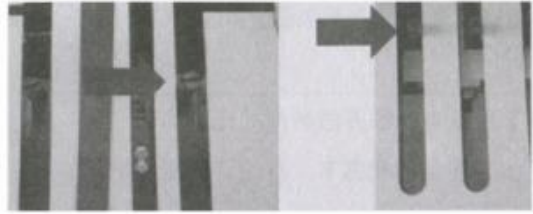
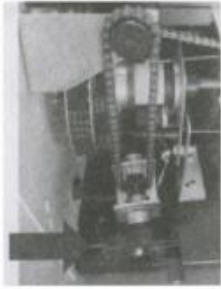
Adjust folding flap

Fold the paper in half and tuck it under the staple head

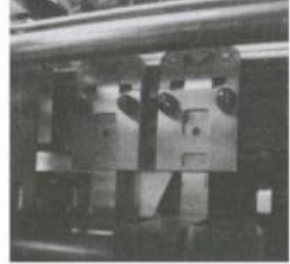


Adjust the pin head position limit by adjusting the hand wheel to be flush with the pin head position.

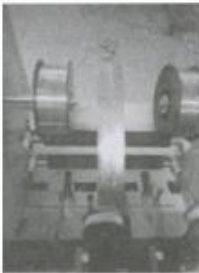




Adjust A3, A4 set head die position and set head, or the foot will be uneven or skew.



Wire go through 1



Wire go through 2



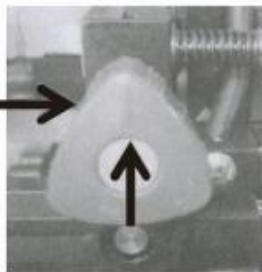
Wire go through 3



Wire go through 4



Wire go through 5



Wire go through 6



**C.** Plug in the power cord, turn on the power switch and press the start button to start working normally.

**【NOTICE】** Nonpolar adjustment for opening time of paper feed electromagnet

1. In the shutdown state, press and hold the stitch paper button (middle key) start, digital tube display Numbers.

2. Press the fold paper button (right button) to add, and the jogging paper button (left button) to subtract. The higher the value, the longer the time. General A4 paper adjust to 500 to 700, A3 paper adjust to 1400 to 1900.

3. Press the start button to confirm, and you will hear two beeps, indicating that the Settings have been saved.

4. Power off after you can set the appropriate length of the paper.

5. Press and hold the clear button to start the machine according to step 1, and adjust the speed of saving origami according to the above steps (generally 500-600, the longer the time, the better the stability of origami).

## V.MAINTENANCE

- 1 Clean the machine with compressed air (prevent blocking sensor);
- 2 Check the moving parts of the machine and tighten the loose parts in time;
- 3 Put a little white oil on the guide rail, gear, etc. (no oil drilling on the synchronous belt).

## VI .Failure phenomenon, cause and solution

Fault Phenomenon	SOLUTION
1.Stop working	1.Check the power. 2.Check all the cover be closed 3.Check for poor socket contact
2.The machine is running normally, no paper is fed	1.Check the belt for peeling 2.Whether the right and left sides of the patting board clip is too tight 3.Whether the origami knife is too high to block the paper
3.Staple without wire	Check the fixed state of the wire in the staple head
4.The thread is not at right angles to the book	1Make sure the paper clip is at right angles to the post 2Make sure the board is at right angles to the booking
5.Books are not stapled or folded	1Check whether the sensor is in good condition 2Test whether the electromagnet performs well 3Check that the Settings on the actions panel are correct 4Check if the clutch is in good working condition
6.Paper folding has an inclination or position deviation	1. Check whether there is any loosening of the paper retaining column 2. Adjust origami adjusting screw

# VII. Instructions for use and maintenance of riding staple head




## 2.3 Type of sign

This model plate is fixed on the front of the staple.

## 2.4 Technical data

Staple net weight	3.31 lbs
Staple weight with wire	Only use high quality, normal or strength wire, pay attention to the friction resistance, too much resistance will block the wire guide parts.

### 2.4.1 Staple

Wire installation size	
Maximum staple thickness:	
The wire diameter: 24#-26# φ0.60-0.50mm (φ0.024-0.020in)	

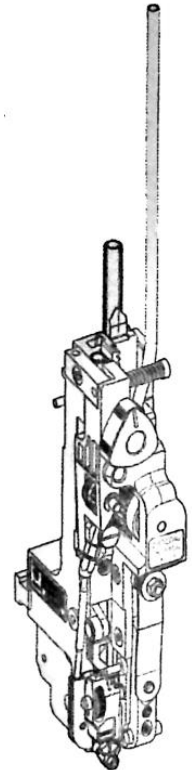
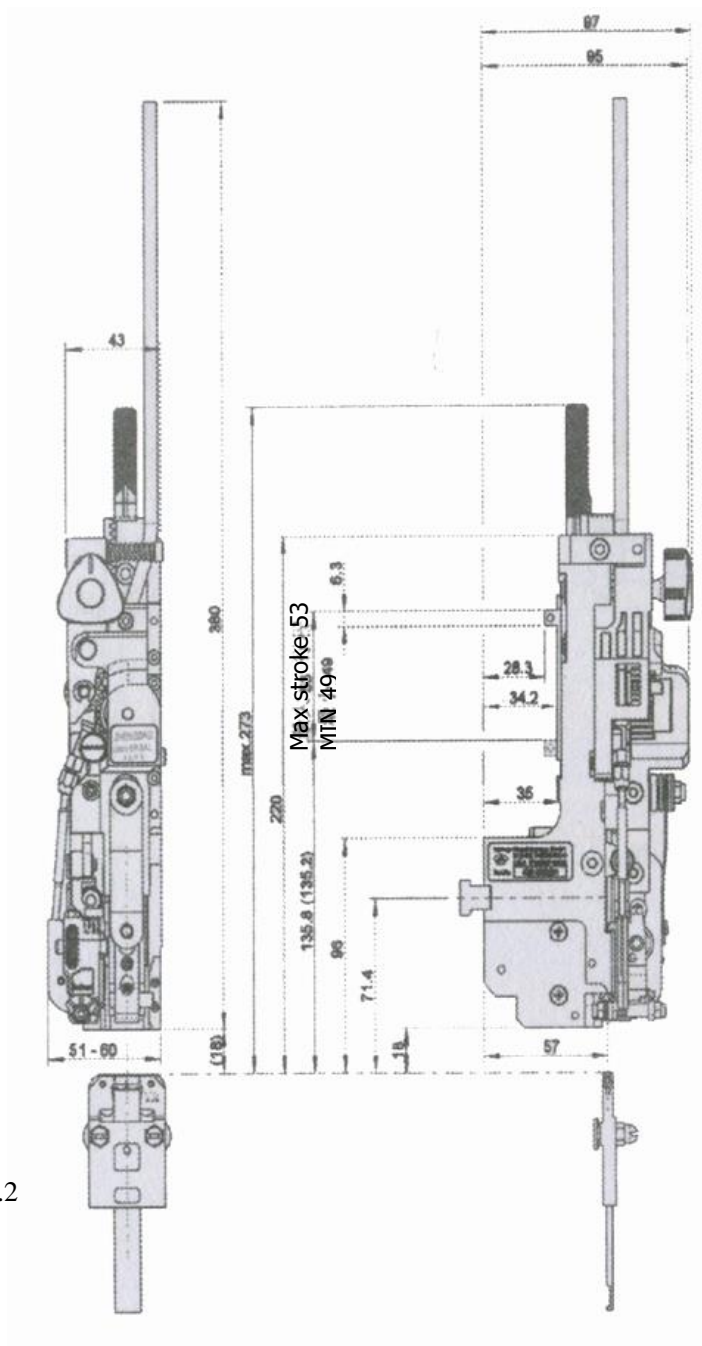


FIG.2



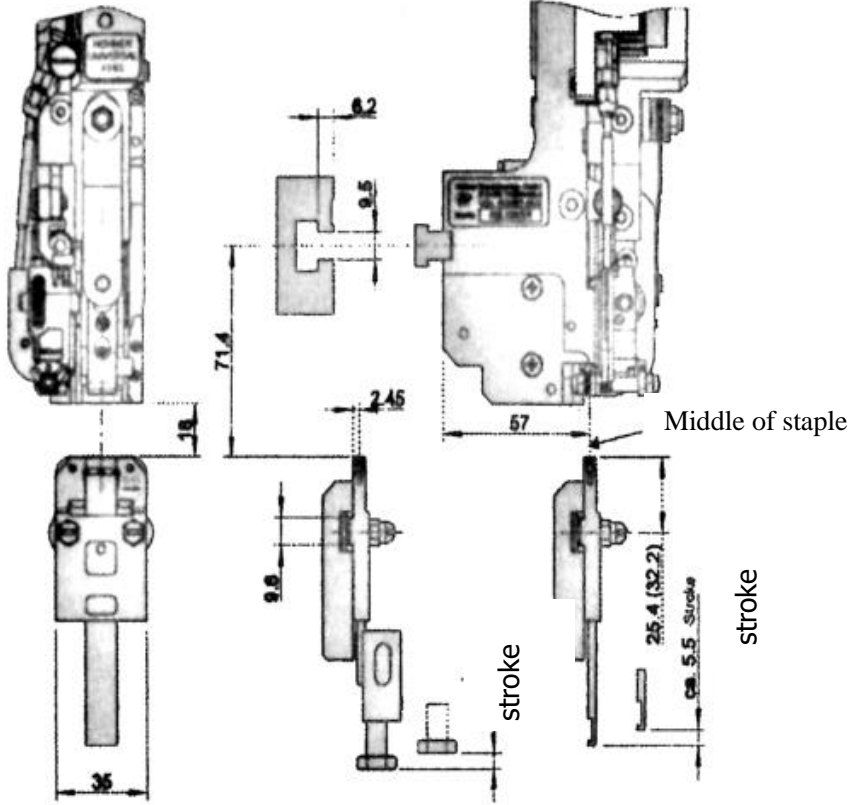


FIG.3

## 2.5.STAPLE SIZE

FIG.2, FIG.3

## 2.6.Tools for staple

### 3.Operation

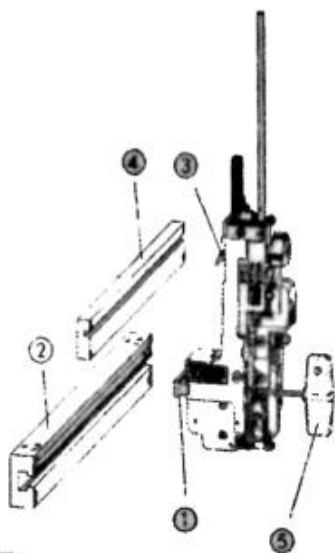


FIG.4

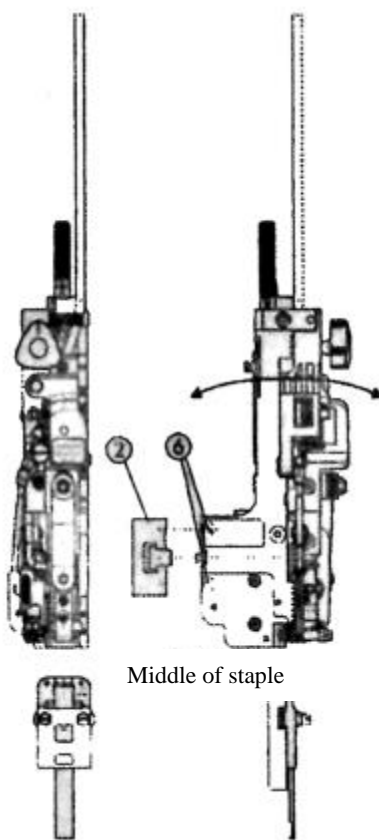


FIG.5

## 3.1 STAPLE INSTALLATION

### 3.1.1. Install the staple on the machine

-FIG.4-

- the staple head is installed on the machine through the t-block mounted on the staple head.
- use an SW4 wrench to loosen the t-block from the stitching head.
- mount the T block from the side into the mounting beam on the staple head of the machine.
- insert the staple head into the mounting block so that the drive block (3) is also inserted into the drive beam (4) and the t-block is just in the slot of the staple head.
- use a t-wrench to tighten the t-block mounted in the stitching head mounting slot to hold the stitching head.

#### 3.1.1.1. Side adjustment of staple

-FIG.4, FIG.5-



- the center of the wire forming block inside the staple head must be set to the ideal position for wire binding by adjusting back and forth.- loosen the t-type mounting block ① with the t-wrench ⑤.- move the staple head horizontally until it reaches its desired position.- use a t-wrench to fasten the t-block to the staple head and install the beam ②.

#### 3.1.1.2. Adjustment for front of staple

-FIG.5-



- Wire hook rod upward movement must be accurate to set the book set into a tight hook claw molding groove
- If the center of the wire set is too tight hook forward or backward, this can be corrected by the set head adjustment screw ⑥.
- remove the staples.
  - adjust screw ⑥.
  - tighten the staple.



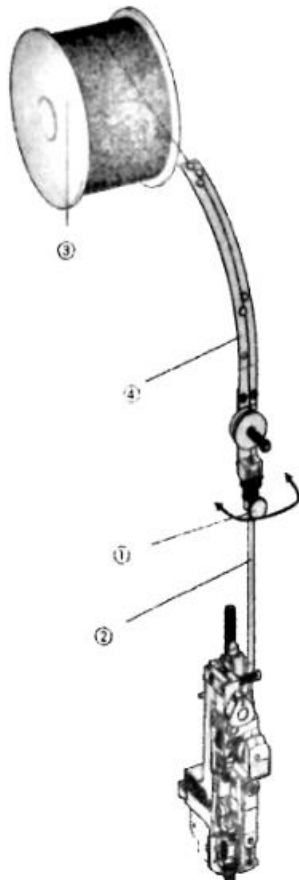


FIG.6

### 3.1.2.Fixed wire guide

-FIG.6-

- loosen the screw with flange ①, put the wire feed plate ④ in the wire guide pipe ②.
- align the wire feed plate with the wire roller to ensure accurate wire guidance.
- tighten the screw with the flange to secure the wire feed plate ④.

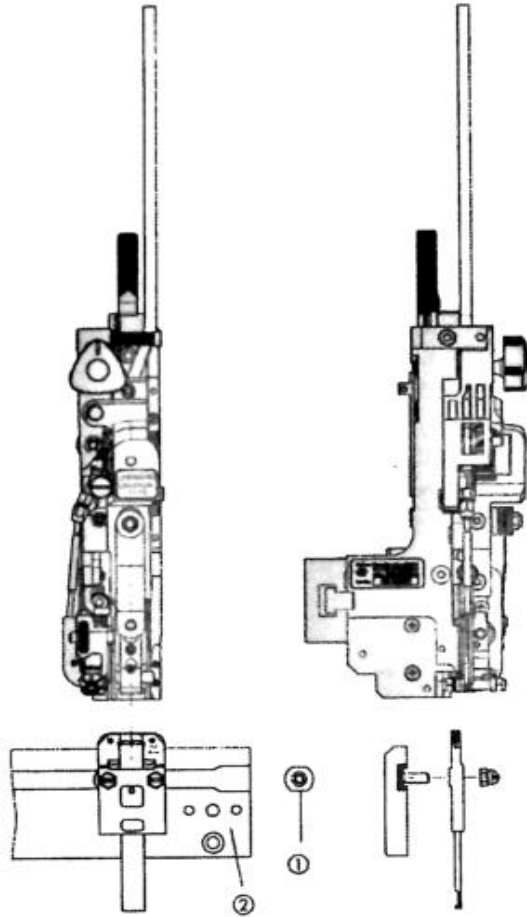


FIG.7

### 3.1.3. Fix the grip

- FIG.7-
- mount the opening screw (and t-block) from the side into the mounting beam of the clamping hook.
  - slide the grip to the center position below the staple head.
  - tighten the nut and tighten the grip.

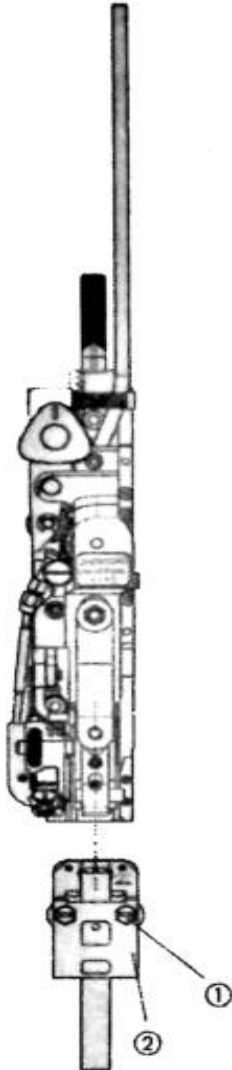


FIG.8

### 3.1.4 ADJUST THE GRIP

-FIG.8

The center of the molding machine inside the staple head must be precisely aligned with the center of the hook claw.

- loosen the locking nut (and the locking screw).

- move the gripper (2) to precisely align it with the center of the shaper.

- screw locking nuts (and locking screws).

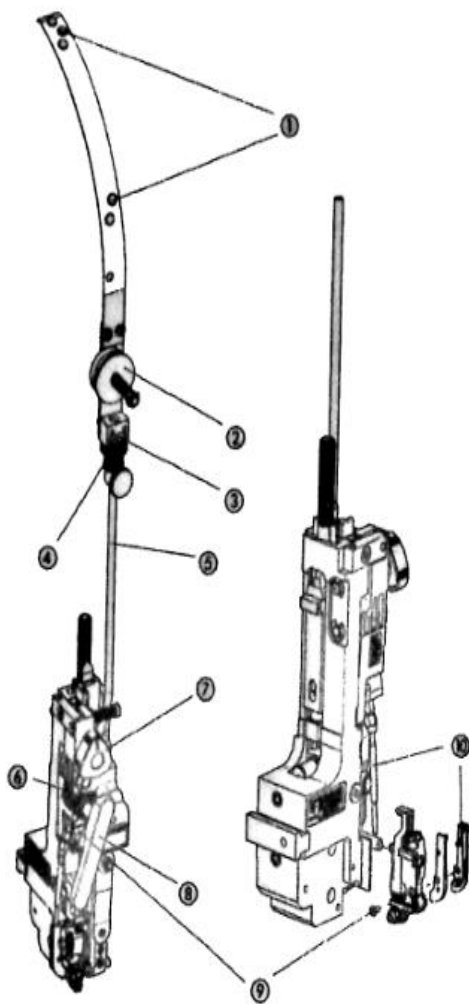


FIG.9

FIG.10

## 3.2 WIRE FEED

-FIG.9, FIG.10-

- Turn off wire drive (rotary triangle handle⑦) to separate feed wheel.
- Through the top into the binding wire, in the following order: through the wire feed plate rivet 1- through two felt discs 2- through the wire check lock ③ - through the wire guide pipe ⑤ and the two feed rollers⑥.
- Start wire transfer (turn triangle handle⑦ to left).
- Install the handle⑧.
- Transfer the wire to the cutting knife by rotating adjustment handle 8 to the right.

## 3.3 Uninstall wire

- Turn off wire drive (rotary triangle handle⑦) to separate feed wheel.
- Hold down the wire check ring④ to disable the check function and pull out the wire.

## 3.4 Remove the guide pipe when the wire is blocked

When the wire is blocked at the guide pipe, removing the guide pipe can easily eliminate the secondary fault.

- Turn off the wire (turn the triangle handle⑦) until you see the feed wheel come apart.
- Loosen screw ⑨ and remove the guide tube⑩.
- Loosen the wire and remove it from the wire guide pipe.
- Hold down the wire check ring④ to disable the check function and pull out the wire.

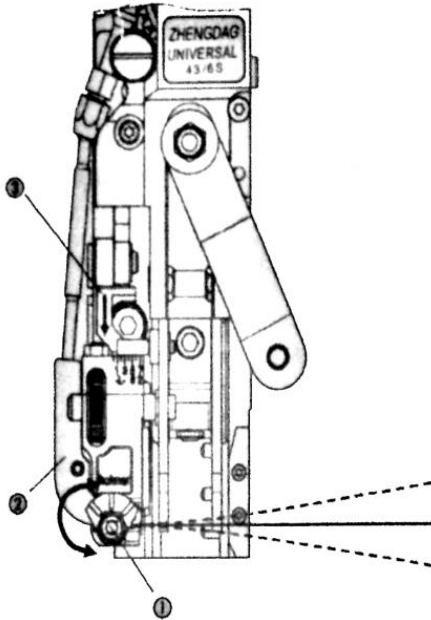


FIG.11

### 3.5 WIRE STRAIGHTENING

-FIG.11

- The wire must be absolutely straight when it comes out of the circular blade. The feeding of the wire can be carried in the absolutely straight direction by adjusting the eccentric roller 1.

Steps for horizontal adjustment of iron wire:

- First remove the shaper.

a) If you can turn the machine on to slow gear.

b) Manual wire feeding (see 3.2 wire feeding), which can be realized by turning the motor clockwise through the adjustment handle provided in the attachment of the machine. A better way is to press the cutting knife push rod ③ and cut off the wire head.

- Use a screwdriver to rotate the eccentric wheel① on the wire roller until the binding wire is straight out of the circular blade mouth.

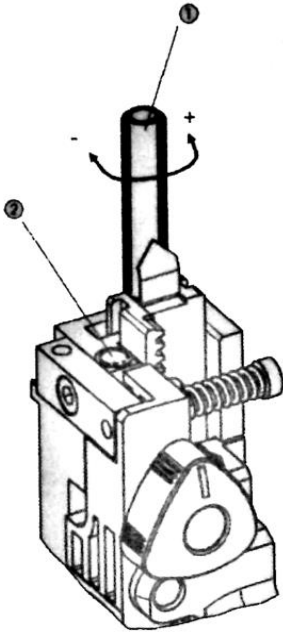


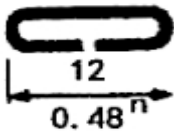
FIG.12

## 3.6 Set staple length

### 3.6.1. Basic setting for staple length

This setting is based on machine travel

The basic setting does not include other work (the set stroke is 50mm).



It is recommended to bind 2 pages of paper with a wire length of about 23mm. The machine must be set up to bind 2 pages of paper.

-Set the machine to the minimum binding thickness.

-Rotate adjustment knob 1 to align the scale line to the middle of "N" before starting adjustment.

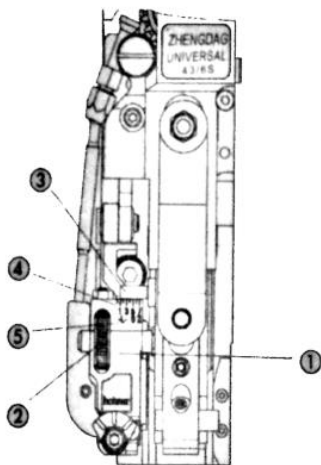


FIG.13

### 3.6.3.Adjust the length of the stitching leg

-FIG.13-

Stitching needle leg length depends on the thickness of the binding products, cutting knife box ① can be adjusted to adapt to the thickness of the product, and bookbinding calibration pin ③ the indicated at the top of the scale of the value of binding thickness, the unit is mm, the scale line ④ the value of the above (1-7) expressed as: flat binding thickness, its scale line ⑤the value of the (- L - 0-2), expressed as a binding thickness of ring.

- by rotating the patterned roller ② to adjust the cutting knife box ①, so that the top of the pin ③ indicated by the scale to the corresponding binding thickness (in mm).

- test leg length by trial-binding.

- rotate the pattern roller ②to make the length of both legs of the staples exactly the same.



Turning the roller up is clearance pair



Turn the roller down to center the gap



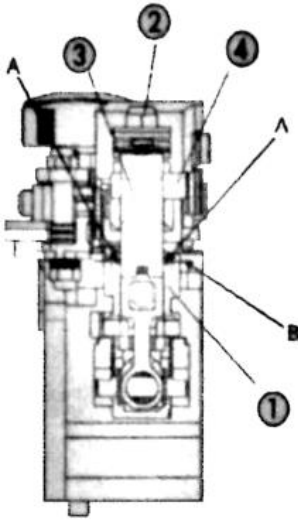


FIG.14

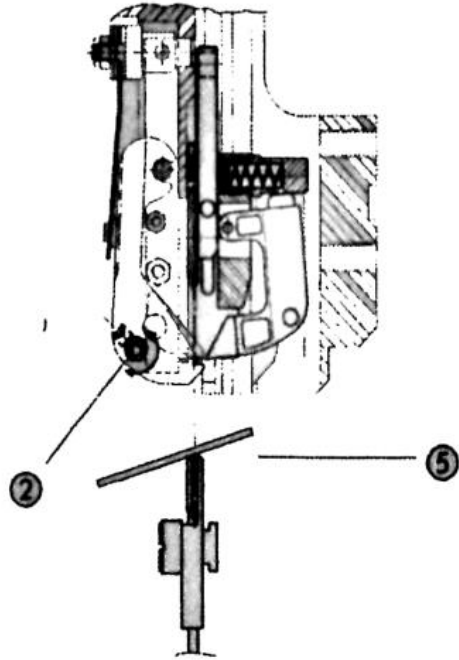


FIG.16

### 3.7 Adjusting shaper

-FIG.14, FIG.15, FIG.16-

In order to ensure the perfect binding effect, shaper<sup>③</sup> contains enough binding wire (arrow B) to accurately set the guide<sup>①</sup> to the groove (arrow A) center.

Put a small mirror<sup>⑤</sup> on the hook to check whether the setting of the binding head is appropriate, the travel gear 3 must accurately align the wire (arrow B) to the groove (arrow A) of the guide 1.

- loosen the compression screw <sup>②</sup>.
- eccentric pins on rotary shaper<sup>④</sup> to ensure accurate alignment.
- tighten the fixing screw<sup>②</sup>.

When binding thickness changes, it is necessary to check the molding Settings, if necessary to modify.



FIG.17

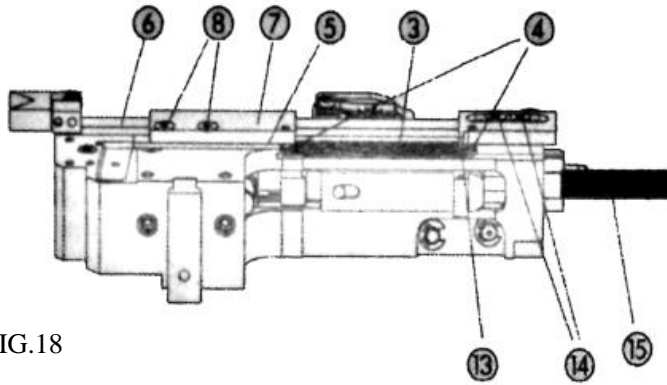


FIG.18

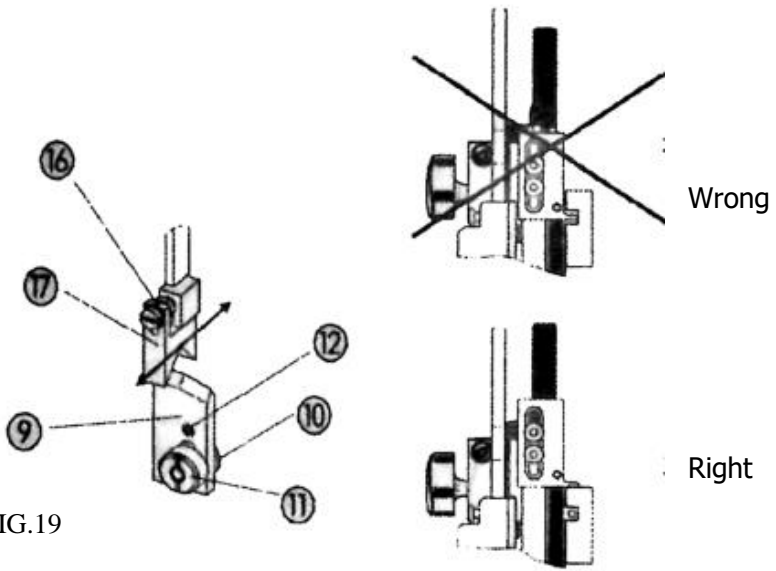


FIG.19

FIG.18a

## 3.8 book dorsal alignment device FIG. 17

Book back to the device only used in riding, it makes the binding position can accurately make the needle① in the book back to the center.

### 3.8.1. Medium pressure block device FIG 18

- Put spring③ on two fixing screws④.

- Install pad⑤ on the top of the staple.

In the case of ring - shaped set need another pad⑤ , or too long wire will touch the center of the V - shaped block ( 17 ) .

- The press assembly ⑥ with a guide board⑦ is installed on the pads, and the countersunk head screws⑧ are applied to the binding head.

- Ensure that the assembly of the slide rod enables the slide rod to move freely.

### 3.8.2. Install slide bar FIG. 19

- Install the opening screw⑩ into the clamping jaw mounting beam from the side.

- Tighten slider ⑨by opening screw and tighten gently with locking nut.

- Push the whole slider⑨ to align the hook claw.

-Align the center of the v-shaped block of the slide rod with the center of the locking claw through the fixing screw ( 12 ) of M5.

- Set the height of the v-shaped block about 0.5mm higher than the clamping jaw.

- Screw the locking nut ( 11 )

### 3.8.3. Set pressure device FIG. 18, ,FIG. 19

The bottom part connecting the slide bar (17) must be positioned approximately 3-5mm below the bottom edge of the bent guide. This can be done by moving the connection block(15).

- To install the binding head into the stapler (see 3.1), make sure that the clip(13) of the upper drive block is placed above the drive beam of the machine, and that the driving block of the binding head is inserted into the slot of the drive beam. See figure 18a.

- Loosen 2 countersunk head screws(14).

- Adjust the position of the slide bar in the connecting block(15) so that the bottom part of the slide block is about 3-5mm lower than the bottom edge of the bent pin guide.

- Tighten two countersunk head screws(14).

The middle pressure block(17) can be moved forward and backward by adjusting the screw(16).

- moving the presser(17) forward and backward allows it to be accurately v-shaped slider ⑨.

Replace ring binding parts  
 Replace the flat staple parts

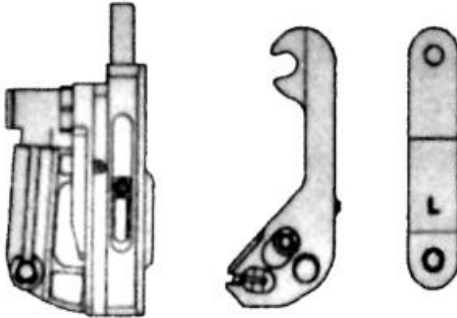


FIG.21

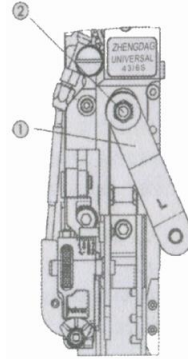


FIG.21a

### 3.10 Step

The center of the - turn off wire drive (rotary triangle handle) to separate feed wheel.

- hold down the wire check ring to disable the check function and pull out the wire.

molding machine inside the staple head must be precisely aligned with the center of the hook claw

-remove the staples

- install the additional clamp L-1. When installing the clamp L-1, tighten the hexagon self-locking nut ②. It doesn't matter if you tighten it a little, you can still turn the blade spring.

- remove the shaper (see 4.2.1 replace the shaper).

- remove the bent guide (see 4.2.3 replace the bent guide).

- reinstall the loop binding shaper and bending guide in reverse order.

- install and adjust staples.

### 3.11 Adjust the leg length of binding and stitching needle

Because the loop binding needs a long wire, the length of the wire and the length of the stitching leg need to be reset (see 3.6).

## 4、 Maintenance

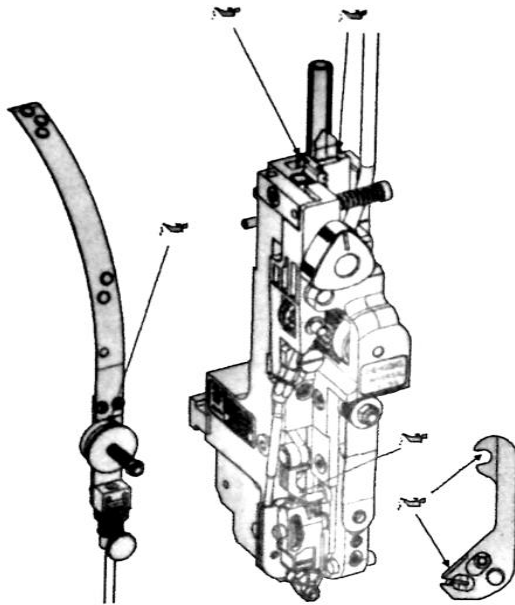


FIG.22

### 4.1 Lubrication

-FIG.22-

After approximately 16 hours of operation, the staples must be lubricated as described below.

The picture of wool felt at the wire feed spring must be slightly lubricated every day.

If the stapler head does not carry on the regular lubrication, will increase the wear, the service life of the stapler head will be greatly shortened and premature failure.

#### 4.1.1.Lubricant

Guide rails and contact points with grease:

High performance high temperature resistant grease

## 4.2 Install and replace parts

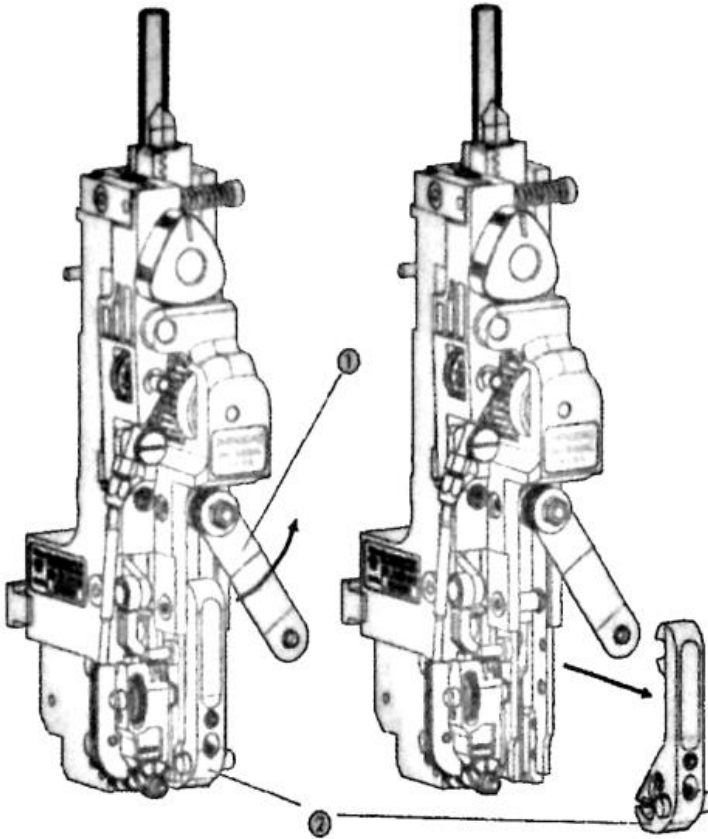


FIG.23

### 4.2.1. Replace shaper

-FIG.23, FIG.24-

- Turn the compression sheet 1 to the side and remove the molding from the front.

The installation order is the opposite.

- Adjust the shaper according to section 3.7.

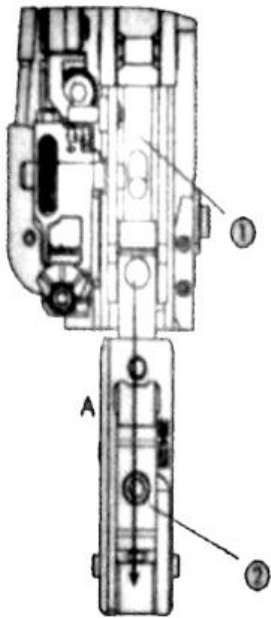


FIG. 26

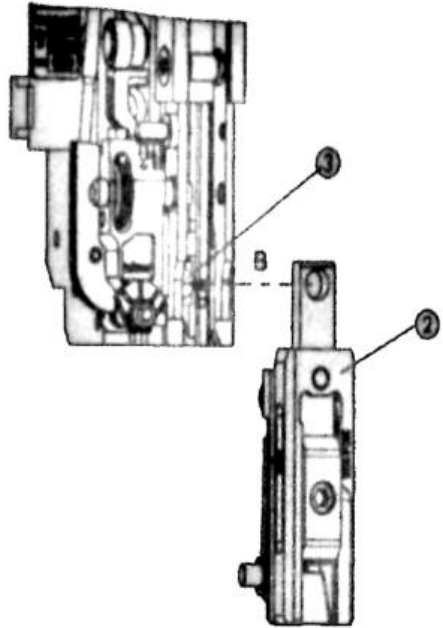


FIG. 27

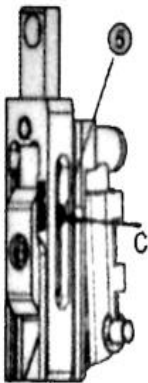


FIG. 28

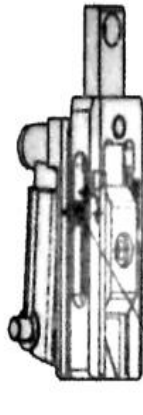


FIG. 29

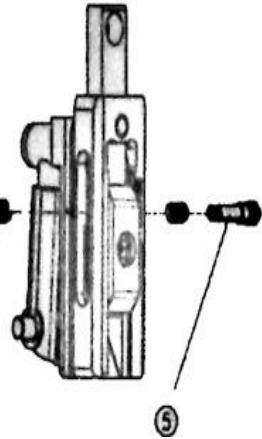


FIG. 30



## 4.2.2. Replace the bender steering gear

-FIG.26, FIG.27-

Replace the bending guide, set the book head center slider (1) and the bending guide 2 must drag down the book head enough distance to allow the bending guide to lift out of the center slider pin 3.

- remove bent guide limit (see 4.2.2).
- remove the shaper (see replacing the shaper).
- remove the bent guide from traction pin 3.

The order is reversed.

### 4.2.3.1. Bent guide lock

The reliable wire forming is realized by fixing the lock on the bent guide.

### 4.2.3.2. Remove the bent guide lock

-FIG.28, FIG.29, FIG.30-

- press drive pin 5 into the bending guide (arrow C) until pin sleeve 4 is far enough from the bending guide to allow the sleeve to rotate.
- rotary drive pin sleeve 90 °(arrow D) and remove.

It's in the opposite order.



- check the smooth movement of pin sleeve and limit pin every time after assembly.

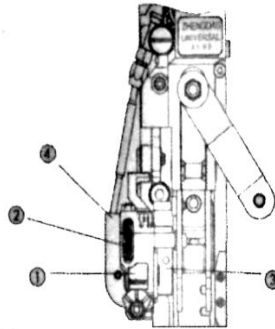


FIG.31

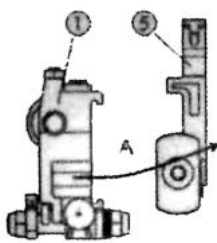


FIG.32

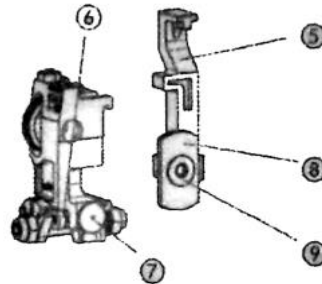


FIG.33

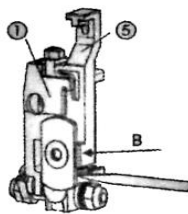


FIG.34

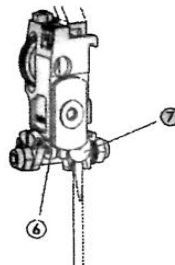


FIG.35

### 4.2.3. Replace blades

FIG.31 - -

- change the blade, rotate the handwheel② to make the knife box ① turn outward along the guide③ track and remove the knife box from the staple head.

Figure 32 - -

- push the cutter push bar<sup>⑤</sup> to remove the box (arrow A) and be careful not to pop the spring.
- replace the cutter (see section below).

Figure 34 -

- replace the cutting knife push rod<sup>⑤</sup> into the knife box (arrow B), and use a screwdriver to press the knife slide pressure spring into the knife box to ensure that the pressure spring is not bent.

Figure 31 - -

- place the knife box on the guide track.
- plug the wire catheter into the hole of the knife box.
- return the knife box to its original position by rotating and adjusting the handwheel.

#### **4.2.4.1. Rotate and replace flat blades**

Figure 33 - -

A flat blade has two edges. If the first edge is worn, rotate to use the other side.

- loosen fixing screw (9).
- rotate or replace smooth blades (8) and tighten fixing screws (9).

#### **4.2.4.2. Replace round blade**

Figure 33 - -

- loosen the tightening screw (6), remove the round blade (7)
- press the new round blade into the corresponding position of the knife box.
- adjust the round blade (see adjusting the round blade).

#### **4.2.4.3. Adjust the round blade**

Figure 35 - -

The round blade is adjusted to cut the wire neatly.

When installing the blade, use a screwdriver to pry carefully to leave a small gap between the flat blade and the round blade.

- loosen the pressing screw 6 and leverage it with a screwdriver so that the round blade 7 touches the flat blade accurately.
- tighten the screw.
- if the ground distance between the blades is set too tight, the slide rod 5 of the blade will be crushed and cause the wire to block.

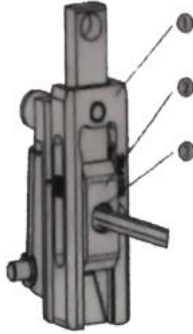


FIG.36

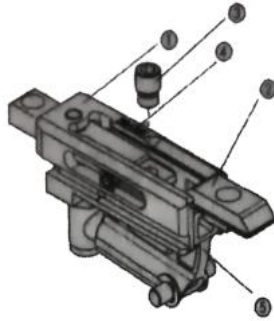


FIG.37

#### 4.2.4. Replace binding block

-FIG.36, FIG.37-

Binding block (2) can be used 2 times (only on the flat), if the edge damage or wear, binding block can be used

The binding block and the bending guide are equipped with a piece number. Be careful that the binding block and the bending guide are matched (see the table below). Their wire guide slots are different.

- loosen the fixing screw (3) downward push binding block (2) to slide out of the bending guide.

-binding block falls off.

or

- replace the binding block.

- press the nailing device downward and load the binding block into the bending guide from below.

- tighten the fixing screw to tighten the binding block.

Round wire 24-26#	
Binding block: 31 64 335	Bent guide: 31 64 325
Round wire 26-28#	
Binding block: 31 64 337	Bent guide: 31 64 327

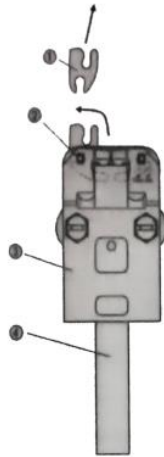


FIG.39

#### 4.2.6. Replace butterfly plate

-FIG.39-

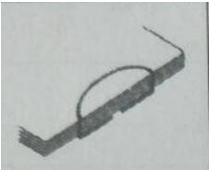
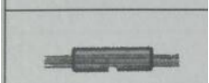
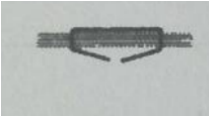
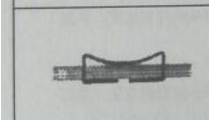
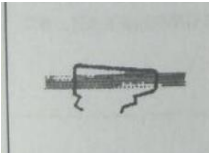
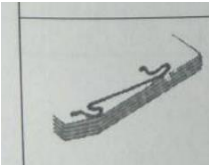
Remove the push lever④ of the hook claw downward, and rotate the butterfly piece① upward in the hook claw③ and turn the butterfly piece① from the support pin②.

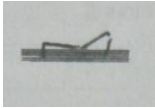
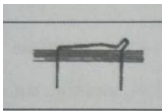
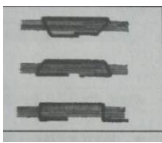
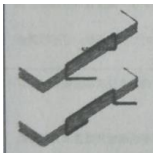
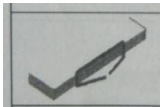
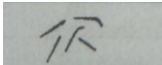
Take the new butterfly piece and turn to the middle position of the hook claw, and reinstall the push rod of the hook claw.

## **5.Failure**



### **5.1.Failure cause and repair**

Here are some examples of failures and what might have caused them. When a fault is caused by different causes, there may be several Suggestions for troubleshooting. At this time, it is not enough to test whether the fault can be eliminated after improvement according to these Suggestions. Instead, it should be tested one step at a time. If the fault is not eliminated, the next step of adjustment will be carried out. Of course, you should first replace the worn parts.

stitching needle	fault phenomenon	Possible causes and ways to eliminate them
	<p>The staples are bent on the back</p>	<ul style="list-style-type: none"> <li>- the wire is too soft</li> <li>- wire not aligned, see 3.5</li> <li>- round or flat knives worn.</li> <li>- if the nailer pressure is too low: remove the blocked wire sheet or replace the pressure spring of the nailer.</li> <li>- remove the binding block if the wire groove of the binding block is dirty, worn or damaged. See 4.2.5. Clean the binding block groove or replace the binding block.</li> </ul>
	<p>The staples are not fastened on the back</p>	<ul style="list-style-type: none"> <li>- book binding has not been fully pressed, adjust the binding machine to the required binding thickness.</li> </ul>
	<p>The leg of the staples was not adequately fastened</p>	<ul style="list-style-type: none"> <li>-book binding hasn't been fully pressed, adjust the binding machine to the required binding thickness.</li> <li>- the butterfly is not jacked sufficiently: adjust the jacking pressure of the stapler.</li> <li>Incorrect timing from butterfly motion to upward motion: stapler must be reset by manufacturer.</li> </ul>
	<p>The back of the staples is loose and saddle-shaped</p>	<ul style="list-style-type: none"> <li>-adjust the binding machine to the required binding thickness if the book isn't tightly pressed.</li> <li>- the wire is too soft.</li> <li>- if the nailer pressure is too low: remove the blocked wire sheet or replace the pressure spring of the nailer.</li> </ul>
	<p>Stitch leg crease Wrinkled and not firm</p>	<ul style="list-style-type: none"> <li>- the wire is too soft</li> <li>- the wire is not straight, see 3.5.</li> <li>- align claws, see 3.1.4.</li> <li>- different leg lengths, see 3.6.3.</li> <li>- feed wire too short, see 3.6.2.</li> <li>- round or flat knives worn, see: 4.2.4.</li> </ul>
	<p>Wire not passed through (occurs in ring stitching)</p>	<ul style="list-style-type: none"> <li>- the wire is too soft</li> <li>- the groove of the bent guide is blocked by a piece of wire.</li> <li>- knife or flat knife wear, see 4.2.4.</li> <li>- remove the binding block if the wire groove of the binding block is dirty, worn or damaged. See 4.2.5. Clean the binding block groove or replace the binding block.</li> <li>- if the nailer pressure is too low: remove the blocked wire sheet or replace the pressure spring of the nailer.</li> </ul>

stitching needle	fault phenomenon	Possible causes and ways to eliminate them
	<p>A staple needle has a broken leg</p>	<p>Possible causes and ways to eliminate them</p> <p>Broken needle leg - bent guide lock defective, see 4.2.3.1.</p> <ul style="list-style-type: none"> <li>- the wire is too brittle, use different quality of wire.</li> <li>- the binding block is blocked by wire fragments: clear the wire fragments and remove the binding block if necessary.</li> <li>- defective claw spring or claw in binding block.</li> <li>- wire thickness does not match wire guide parts (bent guide and binding block).</li> <li>- adjust the molding block to be consistent with the bent guide groove.</li> </ul>
	<p>In stitching needle horn hump</p>	<ul style="list-style-type: none"> <li>- the wire is too soft.</li> <li>- damage to binding block, see 4.2.5.</li> <li>- round or flat knives worn, see 4.2.4.</li> <li>- if the wires are not aligned, see 3.5.</li> </ul>
	<p>Too much contact or clearance: the leg of the binding needle bends in the wrong direction</p>	<ul style="list-style-type: none"> <li>- wire not aligned, see 3.5.</li> <li>- aim the grip, see 3.1.4.</li> </ul>
	<p>One or both legs of a staples are slanted</p>	<p>One or both legs of the staples are slanted - the wire is too soft.</p> <ul style="list-style-type: none"> <li>- wire not aligned, see 3.5.</li> <li>- round or flat knives worn, see 4.2.4.</li> <li>- butterfly wear, see 3.1.3.</li> <li>- adjust the installation position of the binding head corresponding to the installation of the clamping claw, see 3.1.4.</li> <li>- wire not aligned, see 3.5.</li> <li>- adjust the installation position of the binding head corresponding to the installation of the clamping claw, see 3.1.4.</li> </ul>
	<p>The stitch legs lean in the same direction</p>	<ul style="list-style-type: none"> <li>- wire not aligned, see 3.5.</li> <li>- adjust the installation position of gripping claw corresponding to the installation position of staple head, see 3.1.4.</li> </ul>
	<p>A few bent wires fell out</p>	<ul style="list-style-type: none"> <li>- wire not aligned, see 3.5.</li> <li>- bending lock failure, see 4.2.3.1.</li> <li>- bent guide worn, see 4.2.3</li> </ul>



stitching needle	fault phenomenon	Possible causes and ways to eliminate them
	<p>The wire is rounded at the conveyor wheel and the guide pipe</p>	<ul style="list-style-type: none"> <li>- wire not aligned, see 3.5.</li> <li>- blocking cutter slide bar, too tight between garden and peace knives, see 4.2.4.3.</li> <li>- the slide bar of the cutter is locked and the compression spring inside the slide bar of the cutter fails.</li> <li>- next, the wire tube on the knife box has been shifted: adjust it up and down slightly.</li> <li>- improper installation of forming blocks, see 4.2.1.</li> </ul>
	<p>Straight pieces of wire fell out</p>	<ul style="list-style-type: none"> <li>- the blade spring at the top of the reforming block is too soft.</li> <li>- wire not aligned, see 3.5.</li> <li>- improper installation of forming blocks, see 4.2.1.</li> </ul>
	<p>Fault repair (annular binding)</p>	<ul style="list-style-type: none"> <li>- you will find most of the faults and their causes in the previous segment.</li> </ul>