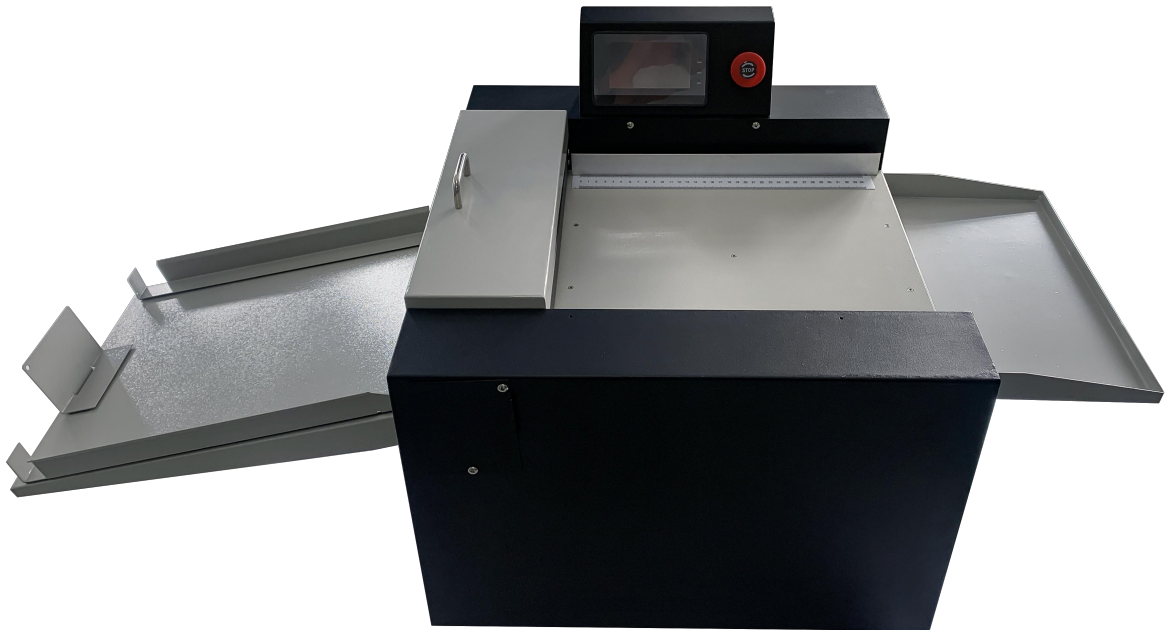


**SCM-330P
AUTO CREASER
OPERATION MANUAL**



INDEX

Introduction	2
Specification	3
Safety	4-5
Main Parts And Assies	6
First Installation	7
Operation	8-16
Hardware Setting	16-18
Trouble Shooting	19-20
Maintenance	21

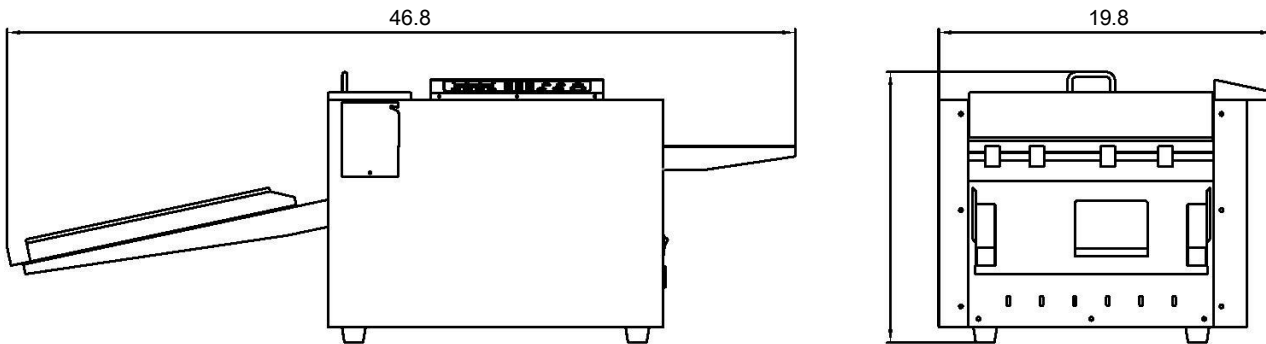
1.Preface

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.

Our company has years of experience R&D team focusing on Precision mechanical design, electrical control, optical design etc. Benefit from advanced processing equipment and unique production process we make the qualified components and machines.

The Auto Creaser SCM-330P is a product developed by us based on our technological superiority and production capacity.The processing position is digital control with creasing and perforating two functions in one. The workding width is 12.99 inch,paper thickness 0.22-0.77 lbs,max. Paper working length 35.4 inch、Max. 48 creasing times on one paper.Hope this machine will makes your work perfect and help you a lot.

2. Machine specifications



2.1 Specifications

Paper size: 1.97*3.54 inch (Min.) , 12.99*35.4 inch (Max.)

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

) Paper type: Coated paper、Laminated paper、Varnish paper etc.

Working precision: ± 0.012 inch

Working speed: 2000 pages/hour (one crease on each A4 paper)

Creasing times in each paper: 0-48 times

Voltage: 110V/60Hz

Power: 150W

Weight: 92.6 lbs (N.W.) , 105.8 lbs (G.W.)

3.Safety

3.1 Environment

Temperature: 50°F to 95°F

Humidity: 30% to 70%

Altitude: below 1000m

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

3.2 Do's and Don'ts



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 While



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

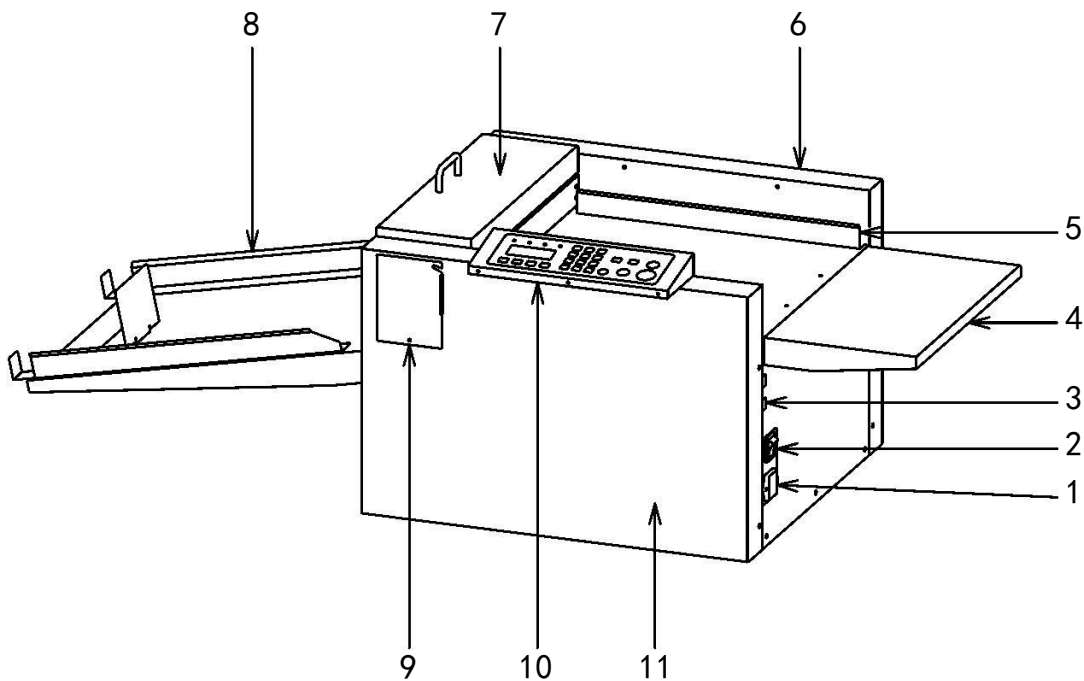


Don't-shut down the machine while running

Be careful of any metal or flammable thing in internal machine,or it may cause fire or electronic shock.if it happens,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.

Main Parts



NO.	Parts	Description
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 internal parts and operators
7	Upper cover	Isolated operating unit (it makes machine disable when it 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

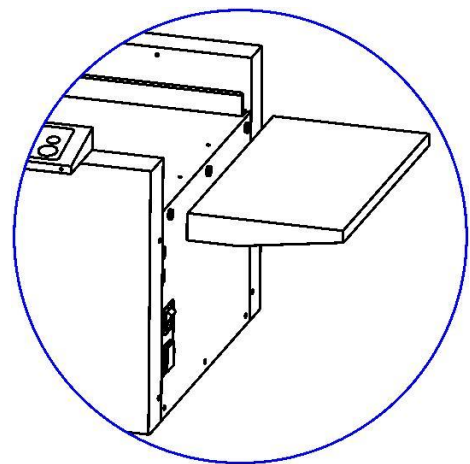
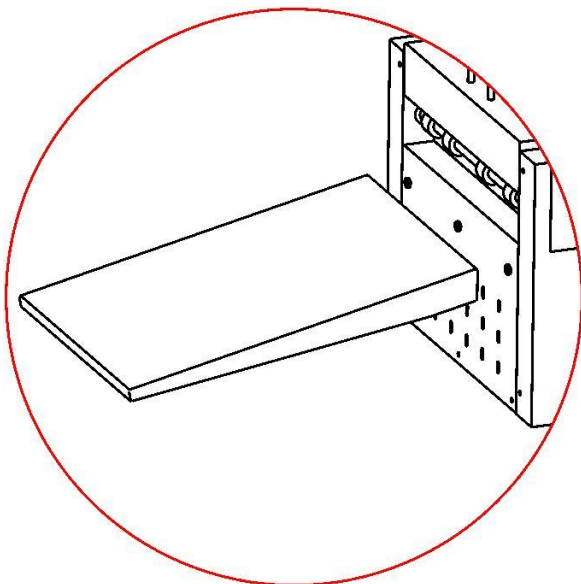
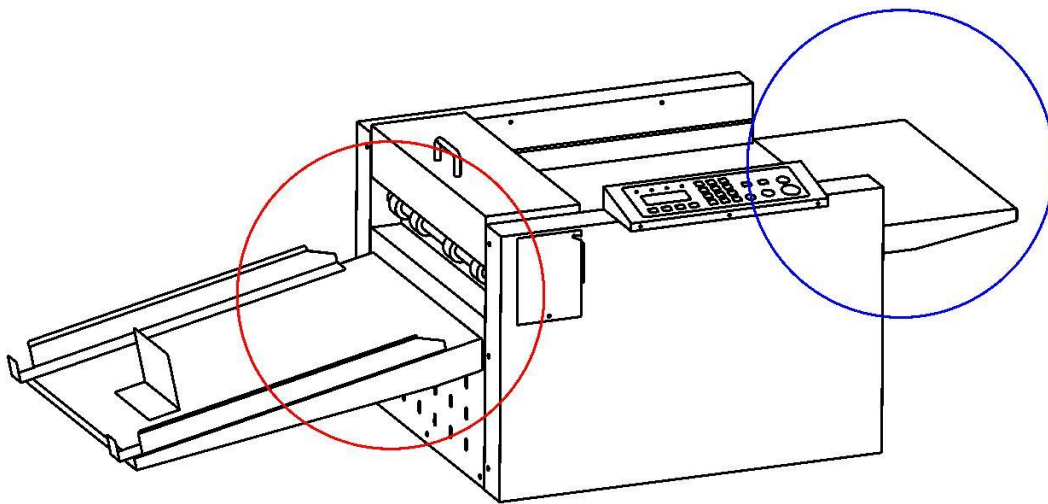
5.First Installation

Un pack it , install the parts as per above illustration.We can see there are 3 screws on trail of feeding table, and there are 3 holes on side of extension table.

1:Loosen 3 screw, but not remove

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

3:Tighten 3 screws.



6 Function and operation

6.1 Main operation:

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

Ready	0/0
[1]0.0	[2]0.0

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.

[3]30.0	[4]40.0
[5]50.0	[6]60.0

"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 haven't setting paper quantity.

Sheet:1
Crease:1

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

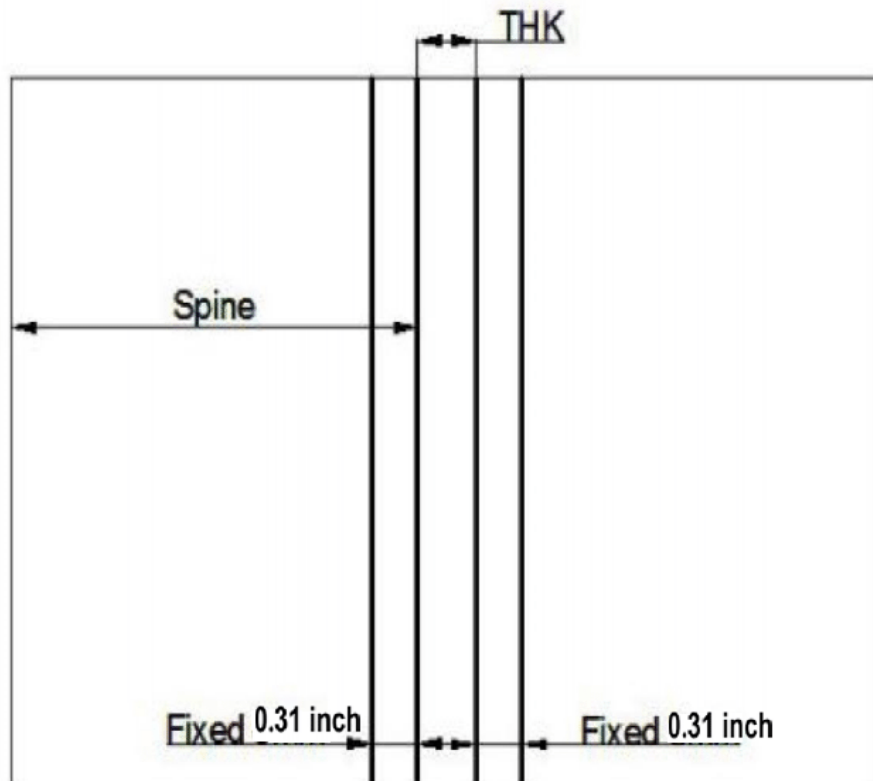
6.2 Cover hinge: This is a mode specially for book cover make

Cover hinge
SPINE:200

Under ready mode double press "mode" button it will jump to Cover hinge, Spine: the first spine line to the leading edge.

THK: the thickness of the book, namely the spine width.

THK: 10

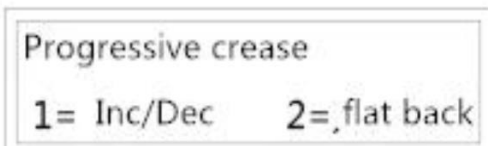


6.3 c crease:

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.



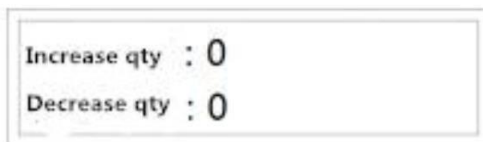
increase/decrease model also has three progress type:

- (Increase&decrease)
- (increase)
- (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

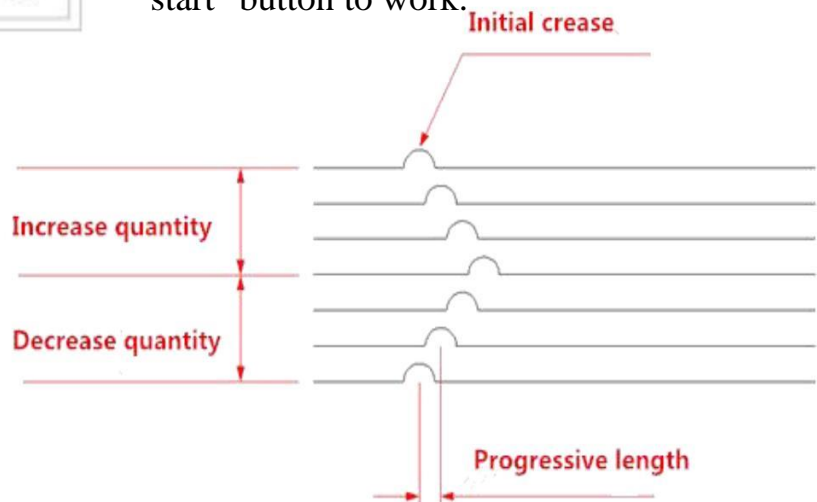


will jump to ready mode.we can use page scroll to check if the data is setin correct or not.after all is ok,we press

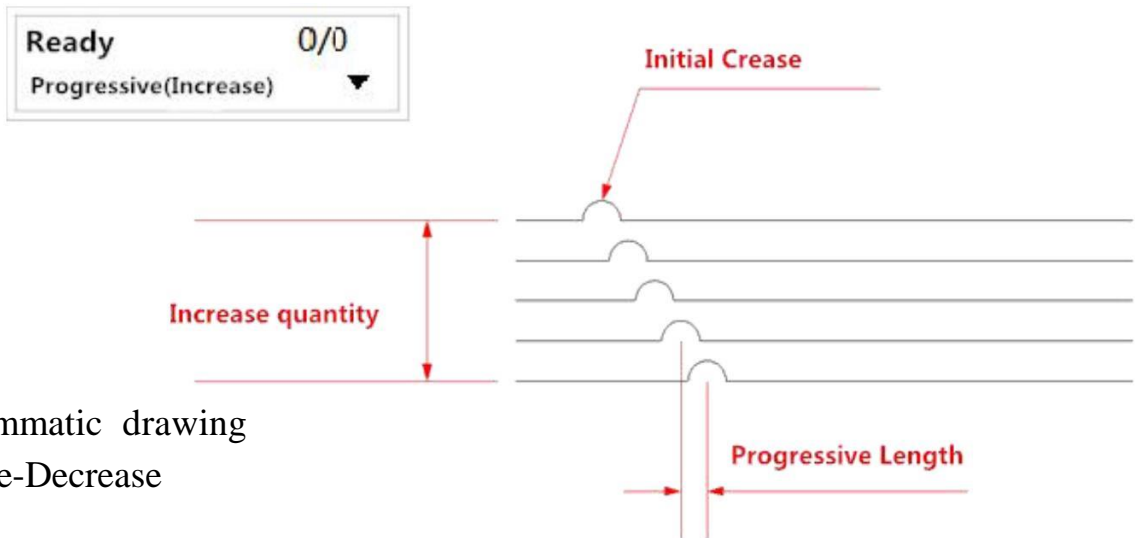
"start" button to work.

Diagrammatic drawing:

Increase-Decrease

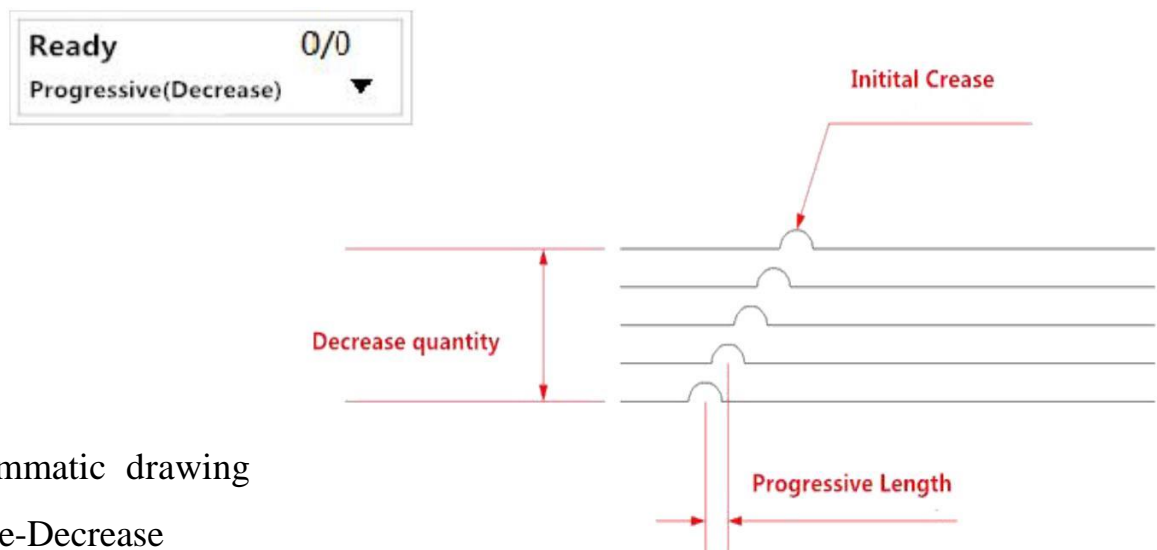


Increase progressive crease: Input the data of increase paper quantity and input "0" on the decrease quantity



Diagrammatic drawing
Increase-Decrease

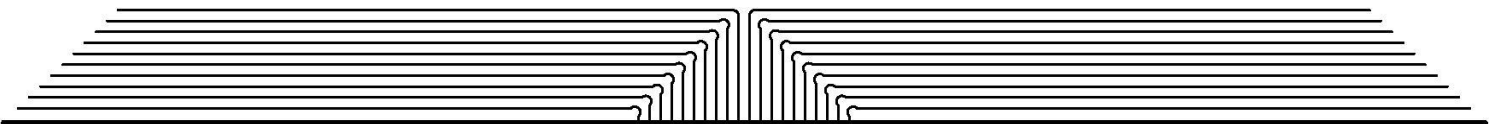
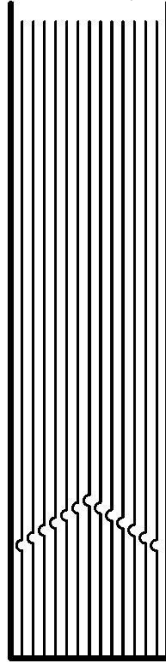
progressive crease: input the data of decrease paper quantity and input "0" on the increase quantity



Diagrammatic drawing
Increase-Decrease

Progressive Increase/Decrease was widely used on perfect binding range.

Even the thick binding book can easily open



flat back mode :

1st Crease : 0
back crease: 0

space length : 0
paper quantity : 0

Ready 0/0
progressive(flat back) ▼

1st Crease: initial crease on the first paper.

back crease: second crease on the first paper.

Press enter button it jump to;

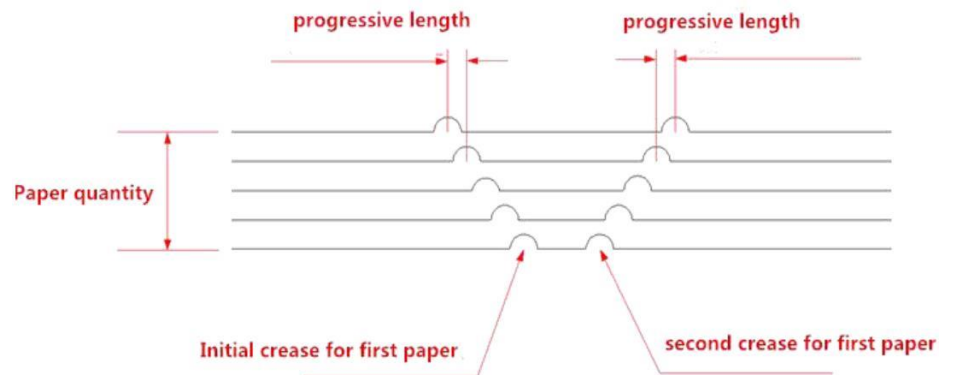
space length: value increase according to the
above crease data automatically

paper quantity:the crease paper quantity.

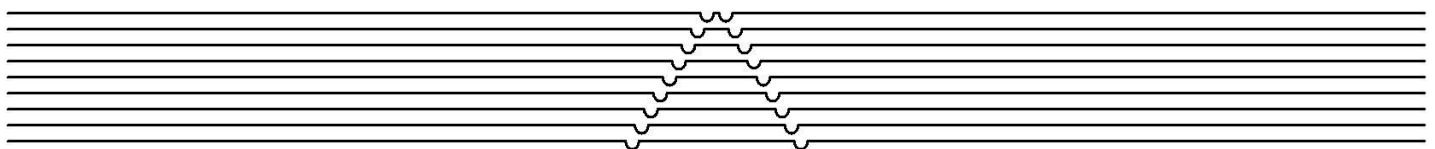
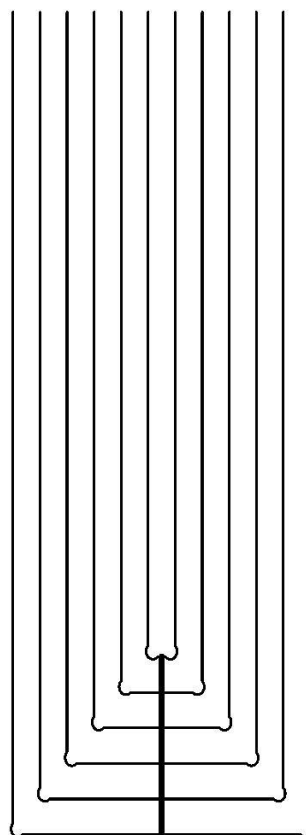
Press enter button; it jump to ready mode
and we see as the left photo shows,

If everything ok,we start work.

progressive(flat back



flat back model crease was widely used on wire stitching binding. it is suitable to flat back perfect binding



6.4 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.



Recall Job
Code:1

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



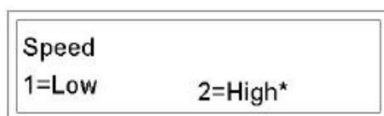
Save Job
Code:1

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 saved. (remark:data will be sweep away if you save another data in same place)



Save Job
Success

6.5 Speed:



Speed
1=Low 2=High*

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

6.6 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.

Recalibrate Length: 420

Insert the Paper...

Input the real distance between two crease 0

(1)

Failure Length:

(2)

Input the real length of the paper as following (say 420mm around 16.53 inch) press "enter", machine runs automatically double times. It will jump to "input the correct crease length"(this is very important, Measure the distance to the nearest decimal point) press enter.

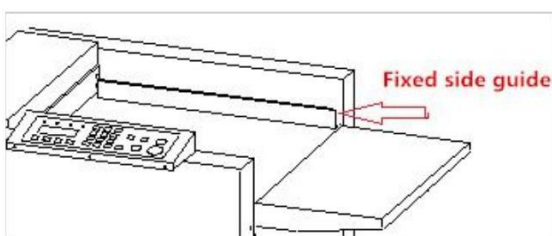
It will shows OK or failure.

If failure the problem maybe the paper length is not suitable or test crease ength and real length too much different.

6.7 hardware setting

6.7.1 skew adjustment

If it is found t he crease is skewed (not vertical to the paper side), you need to adjust the feeding angle to get a satisfied performance .

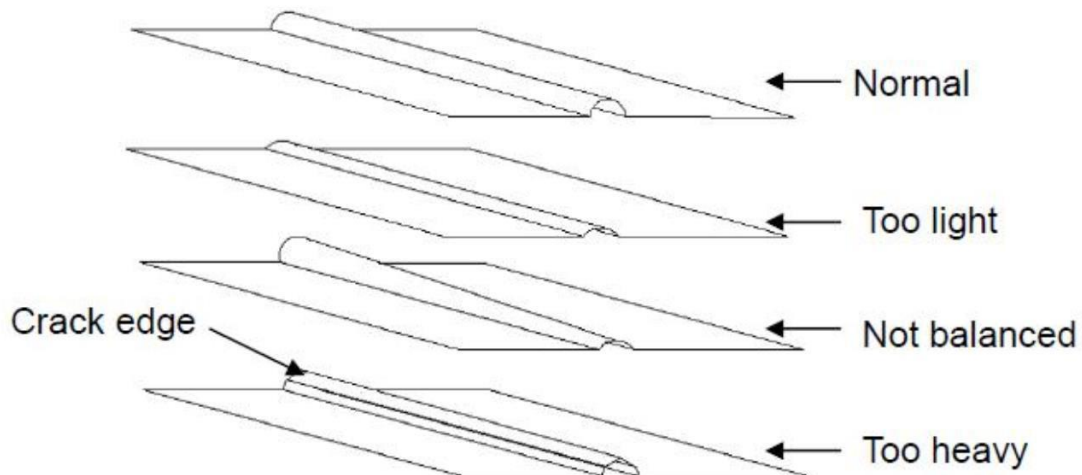


Fixed side guide is the hardware where we adjust the skew. As per above picture, the guide is fixed by 5 screw, rear one is through a slot hole. We can loosen the screw, and move the side guide a bit, so that the feeding direction is micro adjusted to compensate the skew issues.

6.7.2 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.

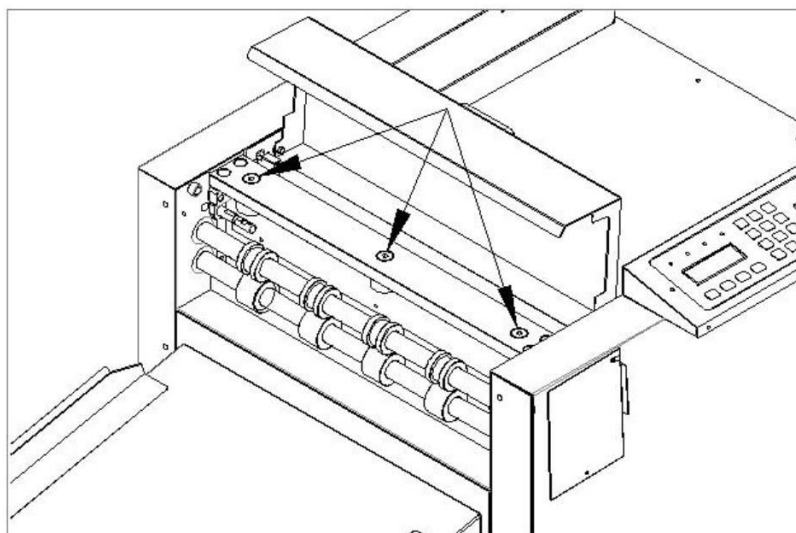
The adjustment is also needed if the crease depth are not balance on both sides.



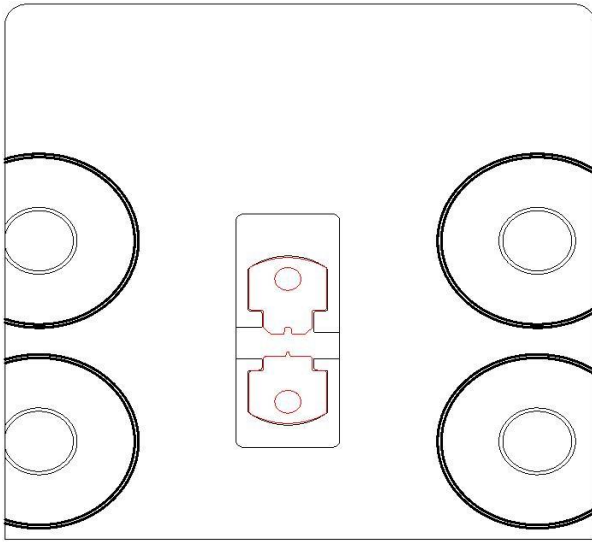
To adjust the Depth:

Open the safety cover and you will see following picture

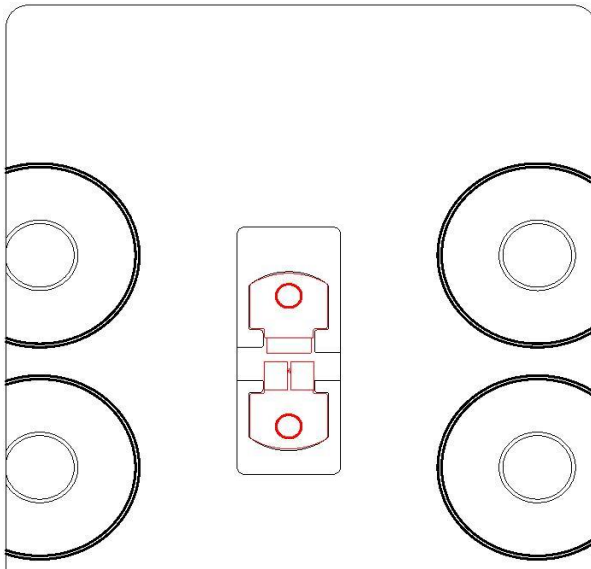
Find 3 screws on both side, turn the Allen screw according to the label beside to make the crease line deeper or light



6.8 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.

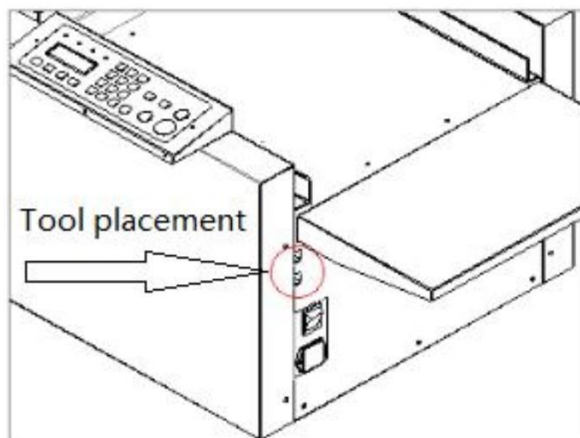


Figure:
place the position
for the idle tool

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.Be careful to use the direction button of the wrong cue interface, 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 display-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 0.02 inch,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 paper to be processed. 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 main tenance. 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.