

# Operation Manual for Perfect Binder

**SPB-55HA4**

*Details determine success or failure*



For reference only, information is subject to change without notice.

---

# CONTENTS

Foreword.....	1
1.Safety Precautions.....	2
2.Machine Description.....	3
3.Parts Descriptions.....	4
4.Machine Parameters.....	5-6
5.Operation Instruction.....	7-12
6.Binding Skills.....	13
7.Troubleshooting.....	14
8.Error Codes.....	14
9 .Electric Circuit.....	15
10.Warranty.....	16
11.Certification.....	16
12.Users Opinions.....	17

# FOREWORD

Thank you for your selection for the intelligent wireless perfect binder. This manual is designed to help you to install, operate and maintain the perfect binder. Please read and understand this manual, and keep it in a safe and convenient place.

With market as guide and technical force as backup, the series of perfect binder is an intelligent, practical and gas-electric integrated new product developed by the company with its abundant experience accumulated in many years. Each perfect binder was carried out strict quality management from design, development to purchase of materials, fully reflecting the company's aim of “Constantly Striving for Perfection and Making Customers Satisfactory”. The perfect binder possesses the characteristics of attractive appearance, simple operation, high efficiency etc., and is the optimal selection for binding books for graphic design and printing center, digital printing company, printing and packaging factory etc.

Mapping out a strategy, gaining a decisive victory a thousand miles away---this product will help you set foot on the road to success!!!

## 1、 Safety Precautions

When using the product, do not touch the glue tank which is hot; not place other articles on the operating rail of the machine to avoid accident happening. When you use and carry out maintenance for it, the following safety items should be noticed.

**Placing:** The machine should be placed dry, clean, smooth and solid ground; before and after the machine, should have enough space to be convenient for operation (never place articles on the machine);

**Power supply:** Please refer to correct connecting method shown on the name plate on the side of the machine (if voltage was over-low or over-loading, it will lead to the machine operating abnormally);

**Earthing:** In order to ensure your safety, please use power supply socket with earthing;

**Disassembly forbidden:** Forbid disassemble and modify machine without permission (if trouble happened, please switch off power supply, and make contact with local supplier so as to solve it properly).

**Before installing and debugging,** must carefully read the instruction, familiarize yourself with the requirements of operating the machine;

**Clean and maintenance:** Before clean or maintenance, you must switch off power supply.

## 2、 Machine Description



Open package for check  
Open external package, first check accessories attached with the equipment, if having damage or being incomplete, please make contact with supplier or our factory.

- |                         |           |
|-------------------------|-----------|
| 1. Main machine         | one unit  |
| 2. Operation manual     | one piece |
| 3. Brush                | one piece |
| 4. Small milling cutter | one piece |
| 5. Power supply wire    | one piece |
| 6. Toolkit              | some      |
| 7. Spine glue           | one bag   |
| 8. Warranty card        | one piece |



### Kindly prompt

1. Before using the perfect binder, please carefully read the instruction, this will help you to improve the binding skills and to bind exquisite books.
2. Please keep the wooden box so as to use it if secondary transportation.

### 3.Parts Descriptions



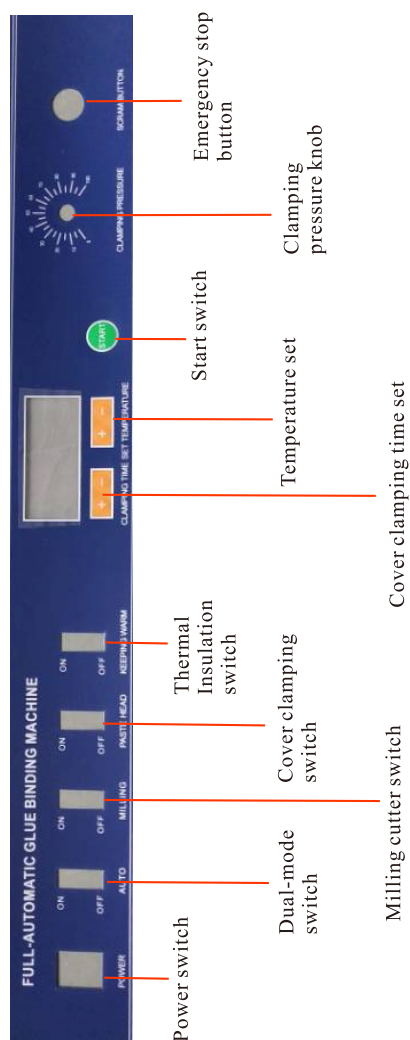
1. Carriage clamp;
2. Carriage clamp switch;
3. Power supply socket;
4. Fuse;
5. Hole for lifting machine;
6. Air switch;
7. Lock block for cover supporting plate;
8. Cover supporting plate;
9. Cover clamping platform;
10. Milling cutter catch wheel;
11. Sun milling cutter + Small milling cutter;
12. Brush;
13. Glue roller;
14. Star handle screw for adjusting glue layer;
15. Squeegee baffle;
16. Cover lock block;
17. Power switch;
18. Dual-mode switch;
19. Milling cutter switch;
20. Cover clamping switch;
21. Thermal Insulation switch;
22. Display screen;
23. Stepless transmission;
24. Emergency stop button;
25. Cover rest plate;
26. Dust collection bag;
27. Start switch;
28. Fine adjustment wheel;
29. Book rest plate

### 4、 Machine Parameters

Model	SPB-55HA4
Binding length	12.6 inch
Binding thickness	2.2 inch
Binding speed	280 books/hr
Glue melt time	≤ 25 min
Milling mode	Sun milling cutter + Small milling cutter
Book clamping mode	Electric
Cover clamping motor	Single motor
Gluing mode	Single glue roller
Milling fold	Bi-fold
Cover platform	uncovered
Carriage clamp	Linear guide
Cover clamping mode	Vertical
Power Supply	110V / 60Hz / 1000w
Machine weight	353 lbs
Machine dimension	43.3*18.1*38.2 inch

As a result of technical improvement, some parameters may be slightly different from the ones above, which does not affect your normal use.

## 4.2 Operation panel



6

## 5. Operation Instruction

### 5.1 Manual Operation Mode

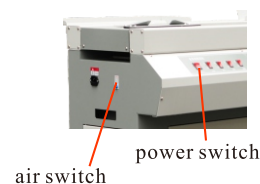


figure 1



figure 2

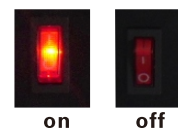


figure 3

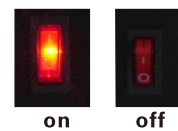


figure 4

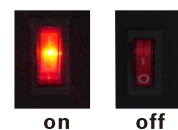


figure 5

1. Install cover supporting plate.
2. Check power supply connecting wire, after confirmation was no error can air switch, power switch and emergency stop switch be turned on, let the machine to be heated (pre-heating time: about 25 min.), as shown in figure 1.
3. Dual-mode switch: Press “O” end, stands for manual mode; Press “I” end, stands for automatic mode, as shown in figure 2.
4. Milling cutter switch: Press “I” end, stands for turn on, milling cutter is working, as shown in figure 3.
5. Cover clamping switch: Press “I” end, stands for turn on, clamp is working; Press “O” end, stands for turn off, clamp isn't working (generally used for binding without cover only), as shown in figure 4.
6. Thermal insulation switch: Press “O” end, stands for turn off, thermal insulation function isn't working, glue roller works to get gluing; Press “I” end, stands for turn on, thermal insulation function is working, and display shows “KEEP” (generally used for thermal insulation for the glue tank, if leaving machine for over two hours, suggest to turn off the machine), as shown in figure 5.
7. Set cover clamping time through “+” and “-” key (unit: s; scope: 1-9s; for the same weight cover, the clamping time of thinner book pages is slightly longer; and that of thicker book pages is slightly shorter), as shown in figure 6.

7



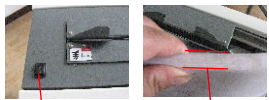
figure 6



figure 7

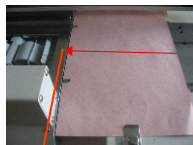


figure 8



carriage clamp switch book thickness

figure 9



the center position on cover clamping platform

figure 10

cover sensor hole

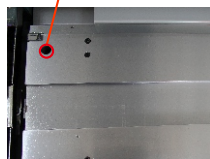


figure 11

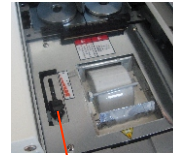
8. Set pre-heating temperature through “+” and “-” key (the optimal temperature has been set up before delivery), as shown in figure 7.

9. Adjusting knob of cover clamping pressure: adjust cover clamping pressure by clockwise or anticlockwise rotating the knob (cover clamping pressure was set up as 70 before delivery, the clockwise rotate is to increase cover clamping pressure), as shown in Figure 8.

10. After reaching pre-heating temperature, press the carriage clamp switch, according to the thickness of book block, adjust the proper width for the carriage clamp (if the range of carriage clamp is smaller than the thickness of book block, book pages failed to be placed in; if the range of carriage clamp is bigger than the thickness of book block, book pages are not easy to align tidy); Note: Press “-” end, stands for clamp, Press “=” end, stands for loosen; when book sensor detected book block, glue roller operates automatically, as shown in figure 9.

11. Place cover: place the cover according to the mark of the center position on cover clamping platform, adjust cover position, move it leftward close to both lock blocks of the cover clamping platform, make cover center align with the center of cover clamping platform; move the lock block on the cover supporting plate, make it close to the right end of the cover (next binding does not need aligning the center position again, locating can be done directly by lock block on cover supporting plate).as shown in figure 10.

Note: The cover must cover the sensor on the cover clamping platform, otherwise, when press “Start” button, buzzing sound, meanwhile “COVER” flashing on the display screen, showing no cover is detected, as shown in figure 11.



screw for adjusting glue layer

figure 12



adjust the book angle

figure 13

12. Loosen star handle screw for adjusting glue layer, adjust the glue layer according to the thickness of book block; for thinner glue layer, move leftward; for thicker glue layer, move rightward, as shown in 12

13. Press “Start” key, carriage clamp moves from the left to the right; through cover spine milling and slotting by milling cutter, then gluing, when the carriage clamp reached the right end and meet the sensor of the right limited position, cover clamping platform rise and clamp up; pressure maintained according to pre-set cover clamping time; when the cover clamping time attain and buzzing sound, front and back platforms loosen automatically, cover clamping platform goes down to the lower limit position; carriage clamp opens automatically, move the book rightward; only when carriage clamp moved automatically leftward, attain the left end, meet the sensor of left limited position, next binding can be done.

Note: If binding effect is not good, customer can adjust the machine's external functions, refer to figure 13.

Note: If cover clamping platform switch is off and cover clamping platform doesn't work, according to pre-set cover clamping time, wait for the glue on book spine to be cooling down, then carriage clamp automatically loosen and return to the left end (Generally used for binding without cover).

### KINDLY PROMPT

**In the course of using the perfect binder, you will accumulate many practical experiences, welcome to communicate with our company so as to let more users to be beneficial.**

## 5.2 Automatic Operation Mode

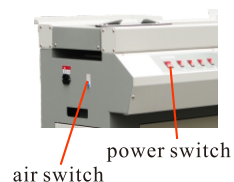


figure 1b



figure 2b

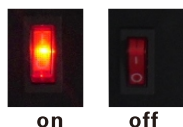


figure 3b

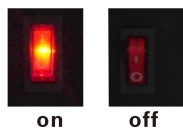


figure 4b

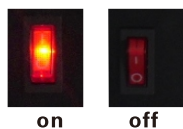


figure 5b

1. Install cover supporting plate.
2. Check power supply connecting wire, after confirmation was no error can air switch, power switch and emergency stop switch be turned on, let the machine to be heated (pre-heating time: about 25 min.), as shown in figure 1b.
3. Dual-mode switch: Press “O” end, stands for manual mode; Press “I” end, stands for automatic mode, as shown in figure 2b.
4. Milling cutter switch: Press “I” end, stands for turn on, milling cutter is working, as shown in figure 3b.
5. Cover clamping switch: Press “I” end, stands for turn on, clamp is working; Press “O” end, stands for turn off, clamp isn't working (generally used for binding without cover only), as shown in figure 4b.
6. Thermal insulation switch: Press “O” end, stands for turn off, thermal insulation function isn't working, glue roller works to get gluing; Press “I” end, stands for turn on, thermal insulation function is working, and display shows “KEEP” (generally used for thermal insulation for the glue tank, if leaving machine for over two hours, suggest to turn off the machine), as shown in figure 5b.
7. Set cover clamping time through “+” and “-” key (unit: s; scope: 1-9s; for the same weight cover, the clamping time of thinner book pages is slightly longer; and that of thicker book pages is slightly shorter), as shown in figure 6b.



figure 6b



figure 7b

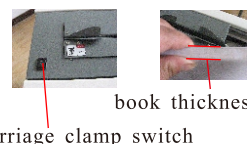


figure 8b



screw for adjusting glue layer

figure 9b



carriage clamp switch

figure 10b

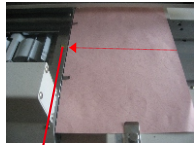
8. Set pre-heating temperature through “+” and “-” key (the optimal temperature has been set up before delivery), as shown in figure 7b.

9. Adjusting knob of cover clamping pressure: adjust cover clamping pressure by clockwise or anticlockwise rotating the knob (cover clamping pressure was set up as 70 before delivery, the clockwise rotate is to increase cover clamping pressure), as shown in Figure 8b.

10. Place cover: place the cover according to the mark of the center position on cover clamping platform, adjust cover position, move it leftward close to both lock blocks of the cover clamping platform, make cover center align with the center of cover clamping platform; move the lock block on the cover supporting plate, make it close to the right end of the cover (next binding does not need aligning the center position again, locating can be done directly by lock block on cover supporting plate).

11. Loosen star handle screw for adjusting glue layer, adjust the glue layer according to the thickness of book block; for thinner glue layer, move leftward; for thicker glue layer, move rightward, as shown in 9b (In 55HC-A4, there are 7 levels for adjusting the glue layer, bigger number, thicker glue layer)

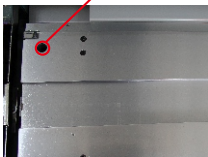
12. Press the carriage clamp switch, according to the thickness of book block, adjust the proper width for the carriage clamp (if the range of carriage clamp is smaller than the thickness of book block, book pages failed to be placed in; if the range of carriage clamp is bigger than the thickness of book block, book pages are not easy to align tidy); when book sensor detected book block, glue roller operates automatically, carriage clamp clamps automatically. Note: Press “-” end, stands for clamp, Press “=” end, stands for loosen; as shown in figure 10b.



the center position on cover clamping platform

**figure 11b**

cover sensor hole



**figure 12b**



adjust the book angle

**figure 13b**

### Kindly prompt

**In the course of using the perfect binder, you will accumulate many practical experiences, welcome to communicate with our company so as to let more users to be beneficial.**

## 6.Binding Skills

If you are not familiar with the performance of the perfect binder, you may meet many problems in the course of binding books, such as spine wrinkling, gluing not enough, spine's both ends with square head at one end and round head at another end etc., hereby hope that you can communicate with us more to richen your binding book experiences and improve binding quality and binding speed.

1. After book being binded and cooled down, book pages are easy separated and scatter, cover glue being not firm, or glue thickness being not uniform, etc. Method: check if the whole part of the glue tank is over-high, causing the gap between spine and roller wheel to be smaller, thus affecting gluing quality; aiming at this condition, adjust glue tank height; generally the gap between roller wheel and spine is about 2.5 mm.

2. Spine wrinkling or too much glue at edges, book spine with square head at one end and round head at another end.

Method: the above phenomenon can be adjusted through adjusting height of cover clamping platform.

3. If inner fold face of binding book failed to be milled.

Method: the requirement of milling depth can be reached through adjusting the height of milling cutter; adjusting scope of milling cutter: 0-1.5 mm.

4. How to bind hardcover.

Method: as hardcover is a special thick cover, it needs secondary gluing. When first gluing, do not place cover on cover clamping platform, but cover clamping platform and both clampers need to be coated with proper white oil (sewing machine oil), book block are clamped, milling the book spine and gluing, then to be clamped (without cover). When second gluing, place glued book block on carriage clamp and place thick cover on cover clamping platform; adjust clamping pressure to position 50, second gluing, lifting cover clamping platform and keep such state for a certain time, then open carriage clamp and take out book.

5. How to bind financial instruments.

Method: as financial paper bills are very thin, pages are difficult to be processed tidy. Thus first cut the end which needed to be binded, then carry out for binding.



## 7.Troubleshooting

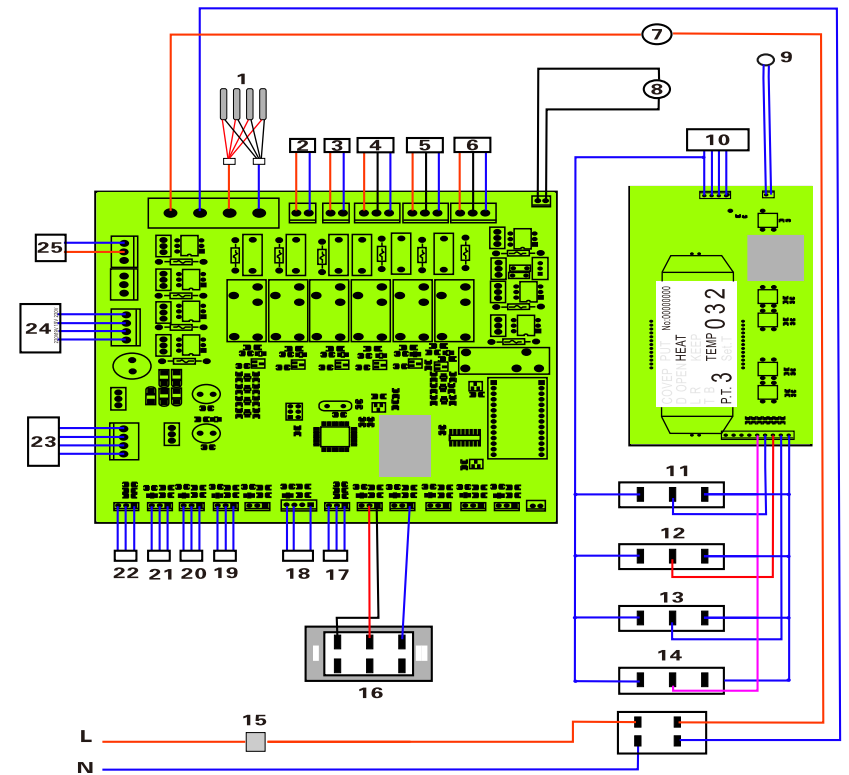
when turn on the machine within 5 seconds, holds both “start” and temperature set key “-” about 2 seconds, machine can be into monitoring mode.

1. Milling cutter switch monitors if milling cutter motor has trouble;
2. Gluing switch monitors if glue tank motor has trouble (only when glue is fully melted can monitor be carried out);
3. Thermal insulation switch monitors if heater has trouble;
4. “+” and “-” keys of cover clamping time monitors the trouble of cover clamping motor;
5. “+” and “-” keys of setting temperature monitors the trouble of carriage clamp motor.

## 8. Error Codes

Code	Fault	Solution
L	Trouble of left limit sensor	Magnetic steel slice dropping off or shifting; Left limit sensor dropping off or shifting; Connection short circuit or damage of left limit sensor; Trouble of main board's related components.
R	Trouble of right limit sensor	Magnetic steel slice dropping off or shifting; Right limit sensor dropping off or shifting; Connection short circuit or damage of right limit sensor; Trouble of main board's related components.
D	Trouble of sensor under cover clamping platform	Magnetic steel slice under cover clamping platform dropping off or shifting; Sensor under cover clamping platform dropping off or shifting; Sensor connection under cover clamping platform short circuit or damage; Trouble of main board's related components.
C	Trouble of cover sensor	Cover has not been placed in proper position or there is dust on sensor surface; Short circuit or damage of cover connection; Trouble of main board's related components.
T	Trouble of temperature sensor	Short circuit or damage of temperature sensor; Trouble of main board's related components.
B	Trouble of main board	No showing of temperature and “T”, trouble of main board's related components; Showing temperature or “T”, trouble of display board's related components.
P	Trouble of book block sensor	Book block has not been placed or there is dust on sensor surface; Short circuit or damage of book block connection; Trouble of main board's related components.
<b>KEEP</b>	<b>Thermal insulation</b>	<b>HEAT(blinking)</b>
		<b>Heating</b>

## 9.Electric Circuit



- |                              |  |
|------------------------------|--|
| 1.heat tube                  | 16. book clamp switch                      |
| 2.milling motor              | 17. book block sensor                      |
| 3.glue tank motor            | 18.cover sensor                            |
| 4.carriage clamp drive motor | 19.cover clamp platform sensor             |
| 5.cover clamp motor          | 20.left limit sensor                       |
| 6.book block motor           | 21.right limit sensor                      |
| 7.emergency stop switch      | 22.temperature sensor                      |
| 8.stepless transmission      | 23.display board connection                |
| 9.start button               | 24.transformer                             |
| 10.main board connection     | 25. carriage clamp drive motor signal wire |
| 11.thermal insulation switch | L.fire line                                |
| 12.gluing switch             | N.zero line                                |
| 13.milling switch            |  |
| 14.dual mode switch          |  |
| 15.Air switch                |  |

## 10. Warranty

From machine purchasing date, the following regulations belong to the scope of guarantee:

1. Mechanical part: one year guarantee;
2. Electric circuit and parts: free repair within a year;
3. Motor: free repair within six months;
4. Sensor: free repair within 3 months;

**Note: During guarantee term, traveling expenses are not included.**

The following conditions do not belong to guarantee scope; users must pay for maintenance and parts fees:

1. No company's maintenance mark;
2. Trouble was caused from irregular operation or malicious damage;
3. Trouble of electronic components caused from oil or water entering into the machine;
4. Trouble of electric part caused from voltage instability;
5. The machine was damaged due to other impurities entering into the machine;
6. The machine was repaired by maintenance station unauthorized by the company or using the materials and parts not stipulated by the company;
7. Consumables: operation panel, brush, sun milling cutter, small milling cutter, switch, heater.

## 11. Machine Inspection Conformity Certificate

<b>Machine Description</b>	<b>Wireless Glue Binding Machine</b>
<b>Model</b>	
<b>Class</b>	
<b>Inspector</b>	
<b>Inspection date</b>	

## 12. Users Opinions

<b>Manufacturer</b>	
<b>Model</b>	
<b>Production Date</b>	
<b>Machine S/N.</b>	
<b>User</b>	
<b>Address</b>	
<b>Tel.</b>	
<b>Phenomena appeared:</b>	
<b>Opinion and suggest:</b>	