



# 50A/50B PERFECT BINDER



# OPERATING MANUAL

VER. 2022/07/28 US



# Safety

**Please use this machine carefully, do not touch the heated glue box to avoid hurt, do not put your hand or any other things to the binding track of this machine, to avoid hurt and contingency. Please note the followings when you use this machine:**

**Place:** The machine is approximate 180kg, please fix the machine in a flat and sturdy and well-ventilated place.

**Electric supply:** Please connect the electric supply correctly as per the instruction on the back of the machine. The electric supply should be stable AC110/220V, 50/60Hz, and 1100W. No matter the voltage is too low or high, both will make the machine work incorrectly.

**Grounding:** For safety concern, please use the socket with earth wire.

**Overload:** Please do not connect too many electric appliances in a same socket because overload may cause fire.

**Clean:** Before you clean this machine, please switch-off the power and pull the plug out of the socket.

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## **1. Technical Specification**

- 1) Model : 50A/50B
- 2) Maximum length of book: 320mm (12.6")
- 3) Maximum thickness of book: 60mm (2.36")
- 4) Cycle Speed(per hour): 400 books
- 5) Cover thickness: 70gsm-300gsm
- 6) Heat-up time: about 30 minutes
- 7) Power input: 110V/60Hz
- 8) Rate Watt: 1.1Kw
- 9) Dimension: 1180mm×520mm×950mm  
(46.46" x 20.47" x 37.4" H)
- 10) Weight: 337.3 lbs (153KG) / 343.3 lbs (156KG)

## 2. Unpack and check

**After you open the box, please check the machine and attached parts, if you find any damage or something lost, please contact us immediately.**

a. Binding machine	1 set	g. Central Line Indicator	1 pc
b. Manual	1 pc	h. Exhaust Fan & Safety Guard	1 set
c. Hexagon wrench	1 set	i. Paper Table	1 pc
d. Philips screwdriver	1 pc	j. Jogger Table	1 pc
e. Glue	1 Kg	k. Fuse 15A *1 pc, 10A *1 pc, 5A *5 pc	
f. Cover Plate	1 pc		

### ✧ **Note**

- **It is suggested to read this manual carefully before you use this binding machine, which will improve your skill to use it to get an excellent result.**
- **Remove the plastic foam from book binding unit.**
- **Please save the packing carton and the plastic bag for transferring next time.**

### 3. Names and Functions



A. Control Panel

F. Waste Collecting Unit

B. Book Binding Car

G. Control System

C. Cover Clamping Unit

H. Exhaust Fan & Safety Guard

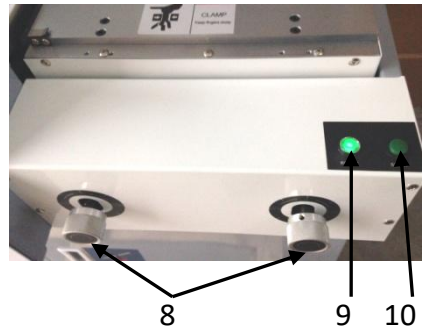
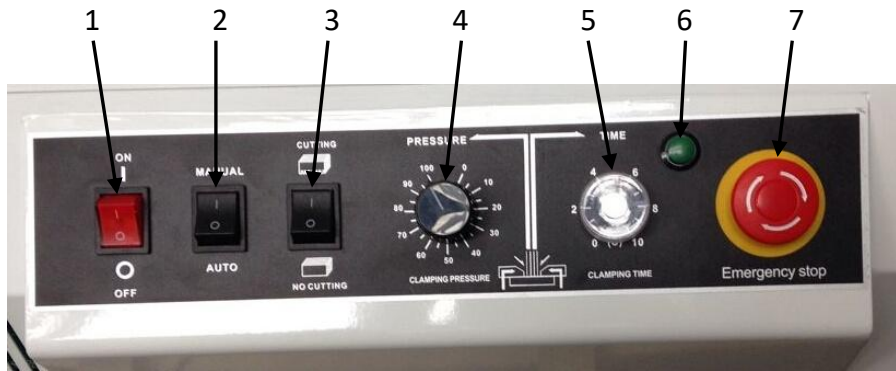
D. Cutting Unit

I. Paper Table

E. Gluing Unit

J. Jogger Table

#### 4. Instruction On Control Panel

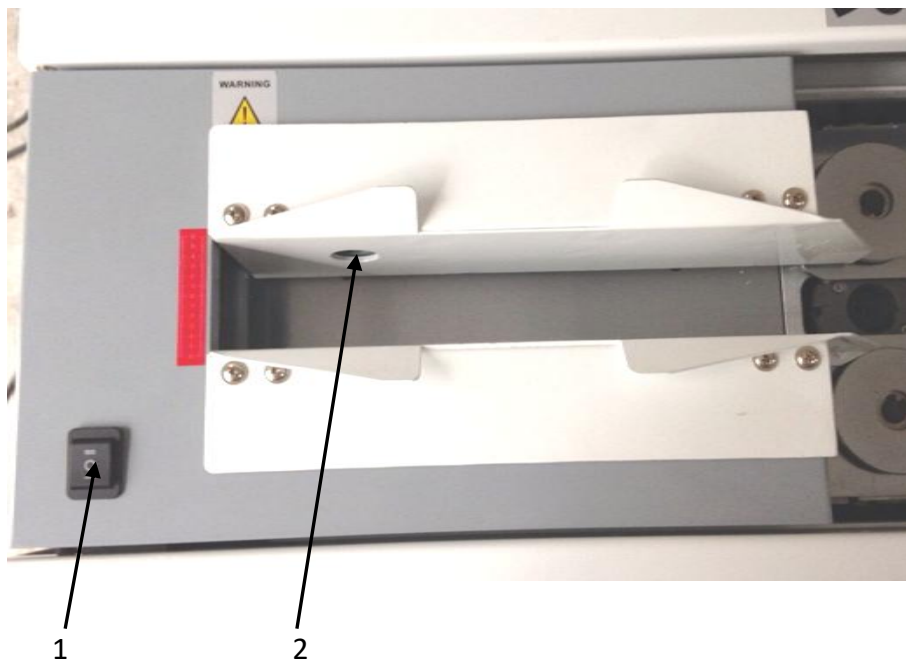


1. Power Switch: red light shows power on
2. Manual/Auto Switch
3. Cutter on/off Switch
4. Cover Clamp Pressure Adjuster: range from 40 – 100Kg
5. Cover Clamp Time Adjusting Knob: range from 2 – 10 seconds (not less than 2 seconds)



6. Start Button: start binding job in manual operation mode.
7. Emergency Stop Switch
8. Round/Square Adjustor
9. Ready Indicator: show the glue has been dissolved completely and the machine is ready to work.
10. Start Button: start binding job in manual operation mode.

## 5. Book Binding Car

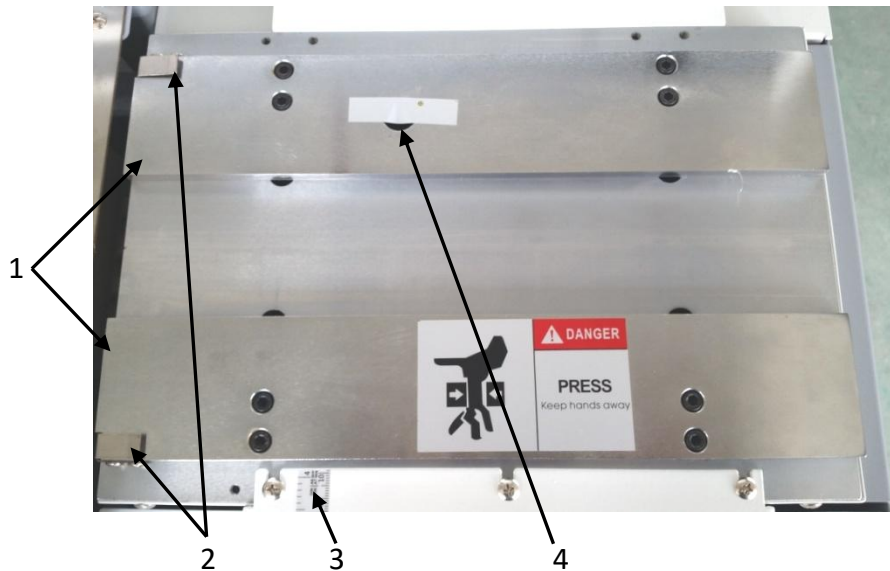


1. Button: in manual operation mode, clamp or loosen the book.

↑ Clamp ↓ Loosen

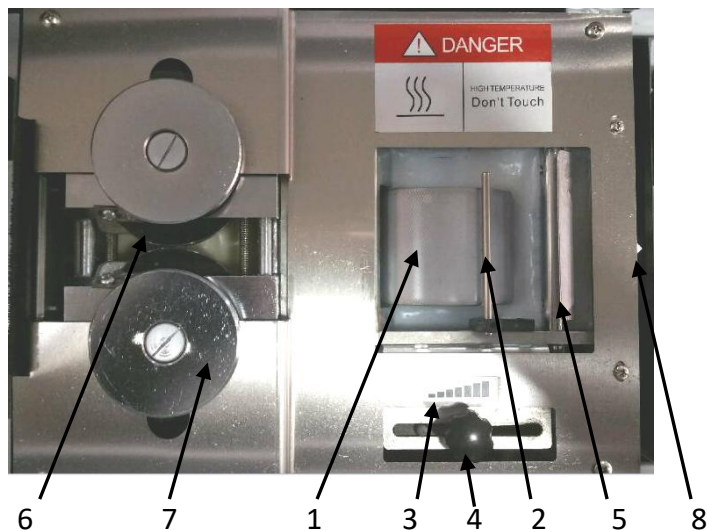
2. Sensor: it is a photoelectric switch which detects whether the paper is placed into the binding car.

## 6. Cover Clamping Unit



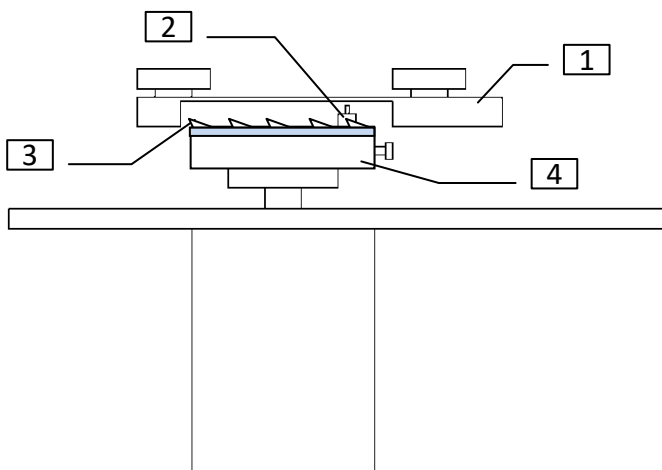
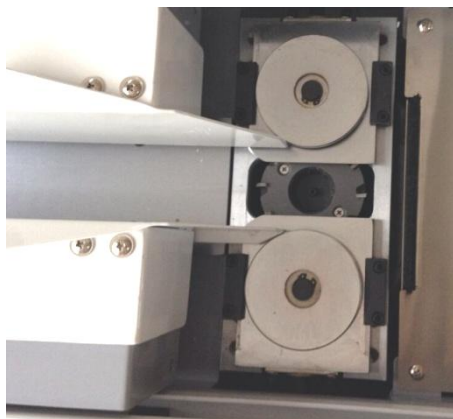
1. Cover Clamp: clamp the book spine
2. Cover Gauge: can be adjusted the cover position and tilting of cover
3. Cover Central Position Adjustment Gauge: mm scale on the gauge
4. Sensor: It is a photoelectric switch which detects whether the paper is placed in the binding car. The machine will stop when there is no cover on it.

## 7. Gluing Unit



1. Gluing Roller: gluing
2. Gluing Lever: squeezing glue
3. Glue level Indicator: indicate the maximum level limit of glue
4. Glue Thickness Knob: Adjust height of adjusting lever to adjust the thickness of glue on the book spine
5. Glue Adjusting Lever: make the glue on the book spine level
6. Side Gluing Roller (50B): glue the two side of book
7. Open Wheel for Side Gluing (50B): open the two side gluing roller
8. Cover Central Indicator: Indicate the central of the cover

## 8. Cutting Unit



- 1 Cutter Cover: fix the book spine
- 2 Small Miller: roughen or mill the book spine
- 3 Solar Miller: roughen or mill the book spine
- 4 Cutter Base: fix the cutters

## 9. Waste Collecting Unit

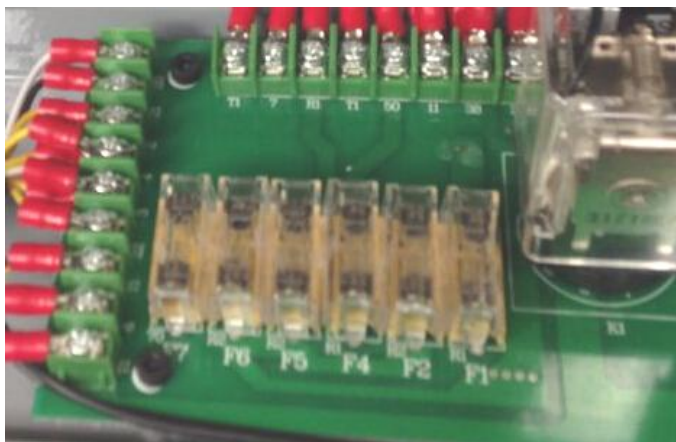


Inside the door, there is a pump that is used to suck paper dust into collecting bag after book is milled. Please clean the collecting bag regularly.

## 10. Electric System

### a) Fuse

- Switch the power off before replacing fuse.
- The fuse is located inside the control panel.



F1. Glue Heat-Up Unit 10A

F2. Cover Platform 5A

F4. Clamping Book Motor 5A

F5. Binding Car Motor 5A

F6. Cutter Motor and Waste Collecting Pump 15A

F7. Gluing Motor 5A



b) Timing Adjustment	Ex-work setting
TR. Timing for clamping book spine	4 S
TR1. Timing for loosening the book clamp	0.7S
TR2. Timing for clamping book	1.2S
TR3. Timing for placing book	1S

Timing is adjusted according to operators' operating speed.



## **11. Operation Instruction**

### **a) Manual Operation Mode**

1) Switch the power on, heat-up time is about 15-30 minutes. The ready light will be bright when glue is dissolved.

2) Set the machine according to binding thickness and cover thickness.


① Glue thickness: when the binding thickness is less than 2 cm, adjust the glue thickness knob to central position. When the binding thickness is over 2cm, adjust the glue thickness knob to maximum limit position.

② Cover Clamping time:

● Binding thickness under 1cm	4 seconds
● Binding thickness approx. 2cm	6 seconds
● Binding thickness under 3cm	8 seconds
● Binding thickness over 3cm	10 seconds

③ Pressure of the Cover Clamp: adjust clamping pressure: according to book cover thickness. The pressure range is 60-100 Kg, adjust the pressure according to the requirement but the book spine shall not be ruffled.

3) Press “MANUAL” of MANUAL/AUTO operation switch.

4) Place the paper in book binding car. The paper shall put in the left side, and then press the button  to clamp the paper. Place the cover on the cover clamping unit.

5) Press the start button, the binding car moves to the right side. After the book binding is finished, the book clamping unit will loosen automatically. Take out the book from the right side. The book binding car returns to the left side.

#### **b) Auto Operation Mode**

**In the auto operation mode, the first book shall be processed in the manual operation mode when you want the machine to work in automatic operation mode.**

1) Same as manual operation 1).

2) Same as manual operation 2).

3) Press “AUTO” of MANUAL/AUTO operation switch.

4) Place the paper in book binding car, then the paper will be clamped automatically.

5) Place the book cover on the cover clamping unit (there is only 1 second for operator to adjust the book cover’s position), then the book binding unit automatically moves to the right side of the machine. After the book binding is finished, the book clamping

unit will loosen automatically. Take out the book from the right side. The book binding car returns to the left side.

## **12. Warning**

- The machine shall not be operated by two operators at the same time.
- Cutter: the cutter only works when the binding job starts, if you want to check the cutter, please switch the power off.
- Gluing Unit: The temperature ranges from 170-190°C. Please don't touch the glue container. When the glue is below the mark line, please add new glue into the glue container.
- The machine shall be well-connected and well maintained. If you want to maintain machine, please disconnect the machine from power.