



CP330B Auto Creaser Operation Manual



Revision : 18/10/21

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1. Safety Rules

The machine has many safety features which make it a safe to operate. Regardless of your experience, safety instructions must be read carefully, completely understood, and applied to your daily work habits. If you do not understand or are confused by certain safety instructions presented in this manual, discuss them with your supervisor. Machine setup, cleanup, and maintenance operation will vary. Therefore, it is essential all employees to practice safe work habits. **SAFE WORK HABITS PREVENT INJURIES.** The main rule to follow is to **ALWAYS** make sure the main drive is **STOPPED** and **LOCKEDOUT** when performing setup, cleanup, adjustment and maintenance operations.

The safety precautions in this manual provide guidelines for the protection and for that of fellow workers.

1.1 Precautions

Before any maintenance is performed on the machine, switch off all sources of electrical; do not operate the equipment when panels and safety covers are not in place. Failure to observe this warning could result in personal injury.

1.2 Avoid Accidents

Most accidents are caused by the failure of some individual to follow simple and fundamental safety rules and precautions. For this reason, most accidents can be prevented by recognizing the real cause and doing something about it before the accident occurs. With any machinery, a careful and trained operator is the best insurance against an accident.

1.3 Safety Issues & General Safety Rules

DO	DO NOT
1. Read and understand this manual before attempting to operate or service the machine.	1. Do not attempt to operate or service the machine without reading and understanding this manual.
2. Be familiar with the machine safety rules and practices.	2. Do not remove the safety devices.
3. Warn others of an intended action that may endanger them.	3. Do not clean or lubricate moving parts of a machine that is running.
4. Perform lubrication and oiling of the machine only when power is off.	4. Do not unauthorized persons to operate the machinery.
5. Verify that all guards are installed before operating the machine.	5. Do not place tools on a machine that is running.
6. When working on electrical	6. Do not reach into the machine to make

<p>equipment, power must be shut off to all circuits before any work is attempted. Individual switches must be opened and the equipment circuits tested to make sure there is no power.</p>	<p>adjustments while it is running.</p>
<p>7. Be sure all operators are aware of all areas and operations that require extra safety measures.</p>	<p>7. Do not allow horseplay in the work area</p>

1.4 AC Supply

1.4.1 Voltage steady state voltage: 0.9 to 1.1 of nominal voltage.

1.4.2 Frequency 0.99 to 1.01 of nominal frequency continuously; 0.98 to 1.02 for short time.

1.4.3 Harmonics distortion not exceeding 10% of the total r.m.s. voltage between live conductors for the sum of the 2nd through to the 5th harmonic.

1.4.4 Voltage Interruption Supply interrupted or at zero voltage for not more than 3ms at any random time in the supply cycle with more than 1 s between successive interruptions.

1.4.5 Voltage dips not exceeding 20% of the peak voltage of the supply for more than one cycle with more than 1 s between successive dips.

1.5 General Physical Environments

1.5.1 The minimum requirement for all electrical equipment is correct operation between air temperature of +5° C and +35° C.

1.5.2 Electrical equipment is capable of operating correctly when the relative humidity does not exceeding 50% at a maximum temperature of +45° C.

1.5.3 Electrical equipment is capable of operating correctly at altitude up to 1000m.

1.5.4 Electrical equipment is designed to withstand to protect against the effects of transportation, and storage temperature within a range of -25° C to +55° C and for short periods not exceeding 24 hours at up to +70° C.

1.5.5 Avoid exposing to vibration environment.



1.5.6 Avoid exposing to direct sunlight or heat rays.

1.5.7 Have to connect to the factory grounding system correctly.

1.5.8 Away from electric magnetic interference source sites, such welding, discharge machine.

2. Specifications

Specification	Description
Feeder system	Roller
Feeder capacity	2.36"
Minimum size	2.76"X3.94"
Maximum size	13"X39.37"
Paper stocks	70-350gsm
Minimum crease distance	1mm
Minimum crease from lead margin	1mm
Speed (one crease on Letter size)	2400sheets
Accuracy	±0.2mm
Quantity of crease in one pass	32
Counter	Yes
Skew adjustment	±0.2mm
Crease depth adjustment	Stepless Regulation
Feeding tray	20.47"
Eject stacker	18.50"
Power	115/230VAC 50/60Hz
Consumption	160W
Dimensions (H x W x D)	12.68" x 46.1"x 20.07"
Weight	108lbs

***sysform* CP330B**
 Paper Creasing Machine
 230V 50/60Hz 160W
 S/N:330B.000.160



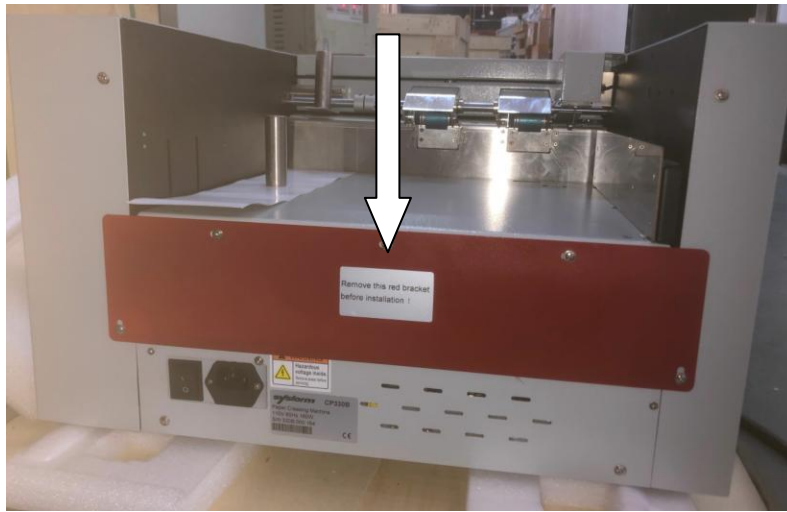
***sysform* CP330B**
 Paper Creasing Machine
 110V 50/60Hz 160W
 S/N:330B.000.160



Note: A dedicated AC power line is required.

3. Installation

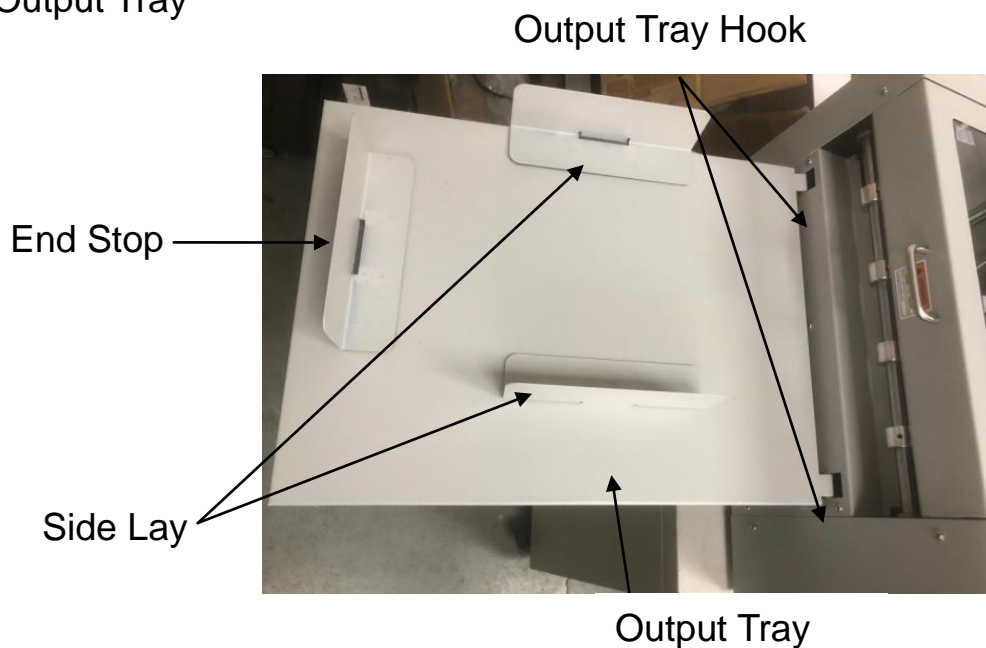
3.1 Remove this red bracket before installation.



3.2 Use 3 screws to fix the extension table to the table.



3.3 Output Tray



The side lays and the end stop should be adjusted according to the ejecting situation.

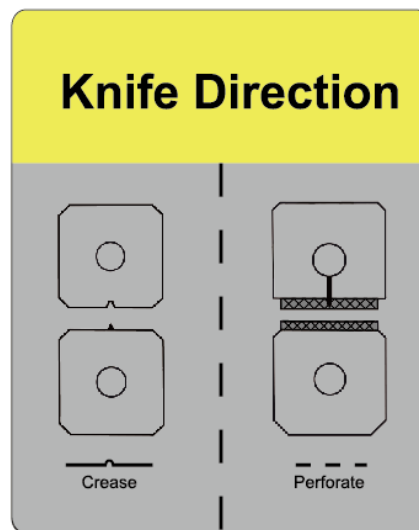
3.4 Guides & weight



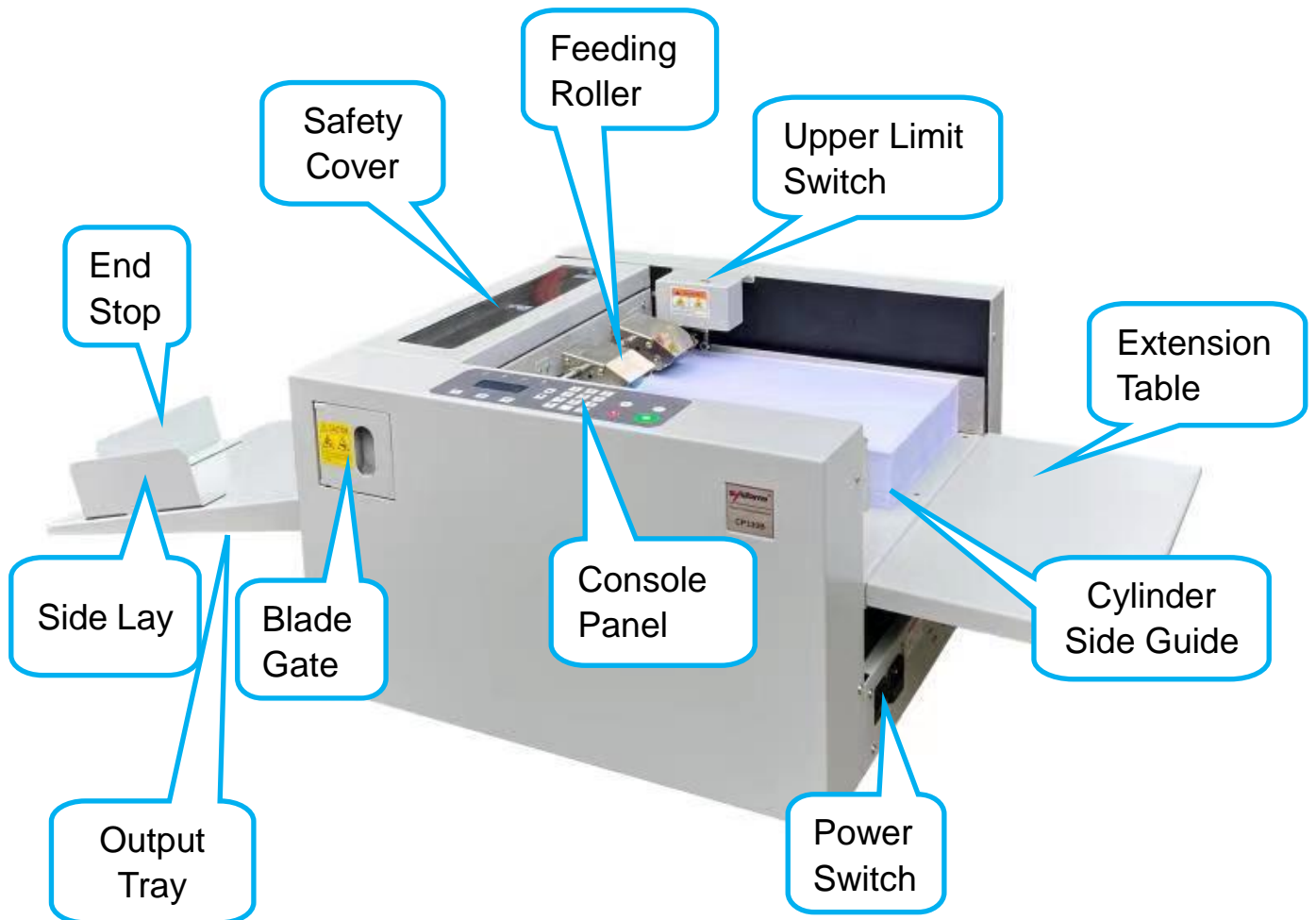
The side guides should be on proper position to hold the paper stack. The weights are used to add the gravity force of the feeding rollers on the top to get a smooth feeding.

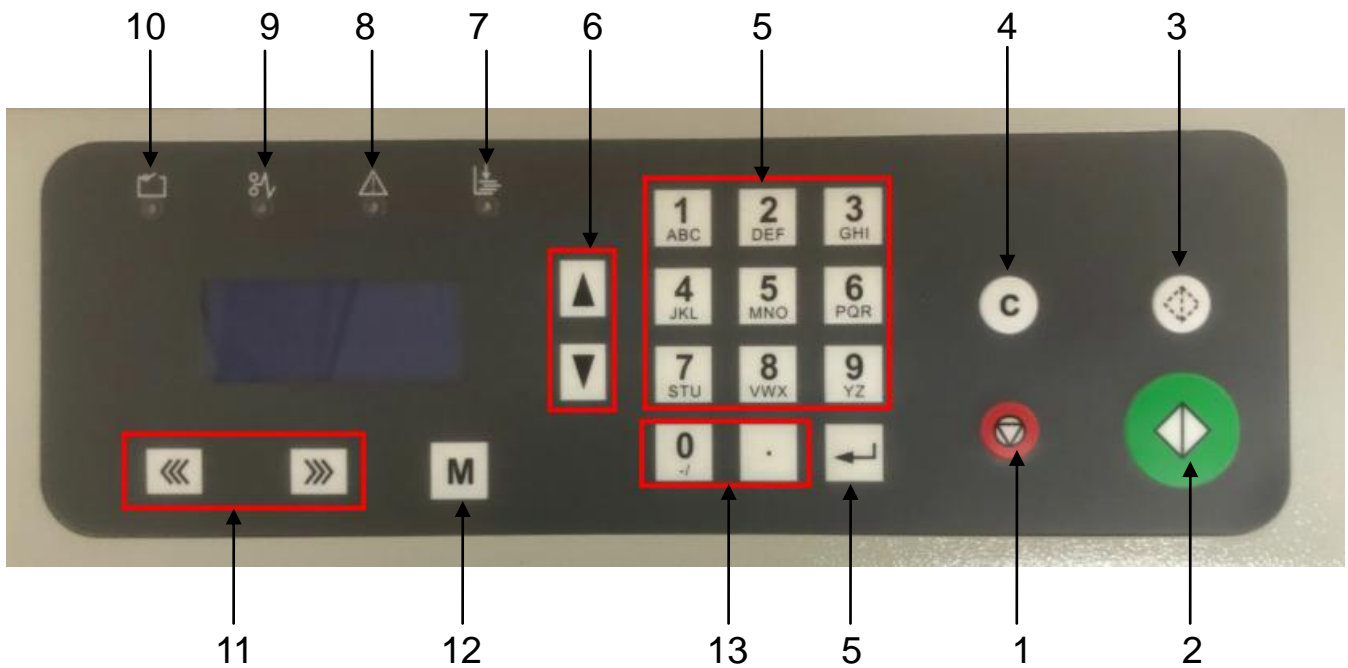
3.4 Installation of Blade

Open the blade gate. Push the blade all the way into the machine. The installation direction refers to the label on the blade gate.



5. Key Components





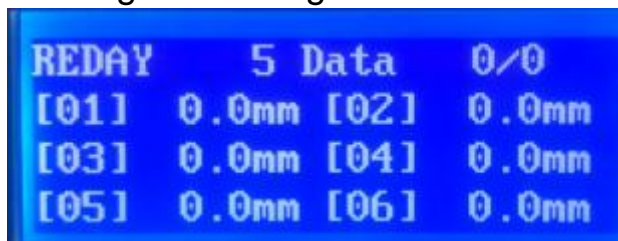
No.	Name	Description
1	Stop	Stop running or change to standby
2	Start	Start processing or change standby to running
3	Test	Feeding one pass to check the machine settings
4	Clear	Delete input or reset errors
5	Numeric Key	Input 0-9 numbers
6	Scroll Key	Scroll pages on the screen
7	No Paper	This LED will be on when no paper is loading
8	Crease Error	This LED will be on when crease motor is stall
9	Paper Jam	This LED will be on when paper jam occurs
10	Cover open	This LED will be on when the safety cover is open
11	Forward/Backward	Run the roller forward or backward to eject the jammed paper out when paper jam occurs
12	Menu	Access the settings interface
13	LCD screen	Displays information
14	Enter	Acknowledge input

5. Start-up

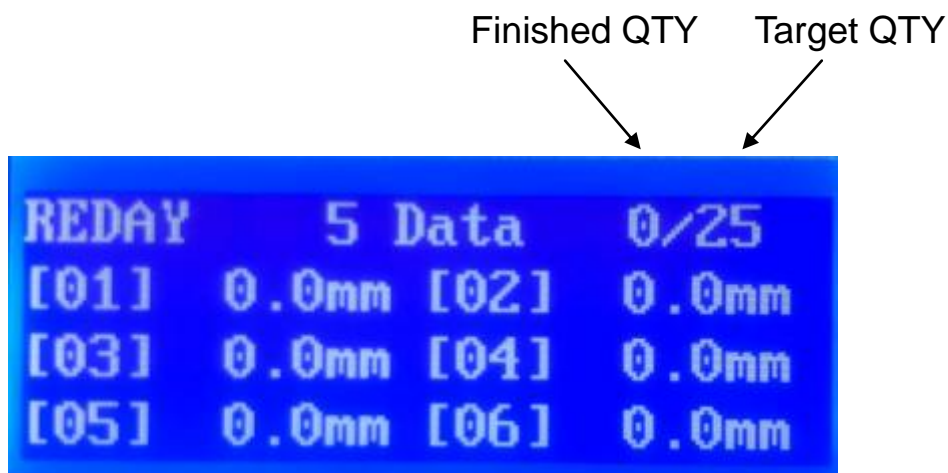
5.1 While Machine is Off

5.1.1 Press the main power to on "I".

5.1.2 Main screen is showing last settings.







5.1.3 When the machine is standby, enter the quantity of the desired processing sheets from the keypad. Press the "Enter" key to acknowledge the input. Press the "C" key to modify the input. If target QTY is set 0, the machine will feed sheets continuously.









6. Settings


6.1. Size Input




In the standby status, press  to access the setting menu. Press  or  to choose "size input" then press .

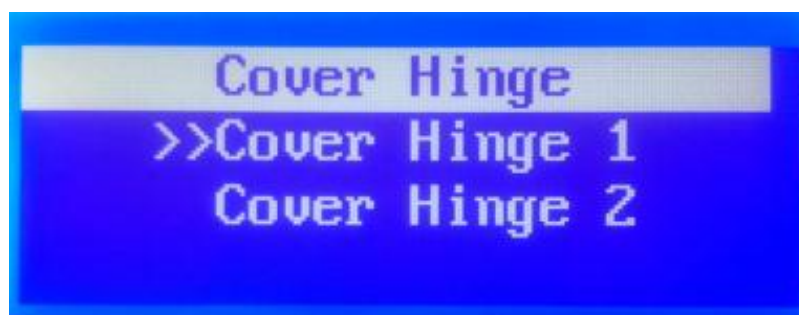
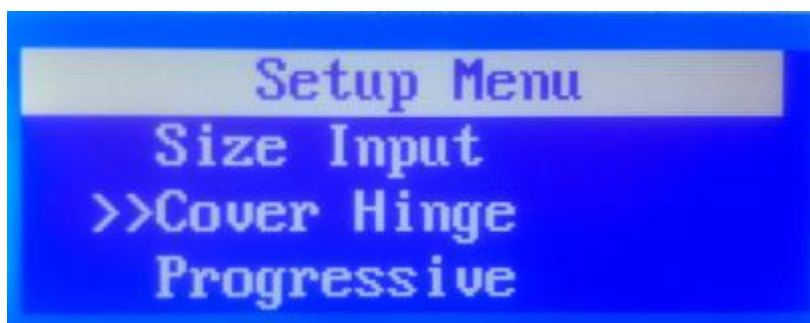


6.1.1 Enter the crease position from the keypad then press  to acknowledge the input. The measurement is from the feeding edge to the creasing position. 32 position data can be processed in one pass once. Press  to delete input.

Press  and hold it for 3 seconds to clear all data in this group. After finishing all settings, press  twice to get into standby mode then press  or  to start processing sheets.

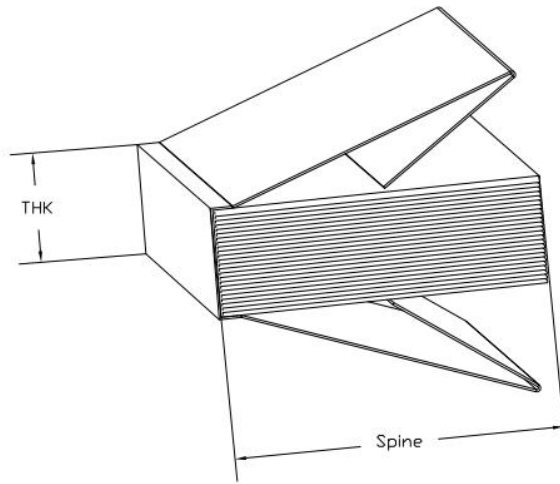
6.2. Cover Hinge: In the standby status, press  to access the setting menu.




Press  or  to choose "cover hinge" then press .



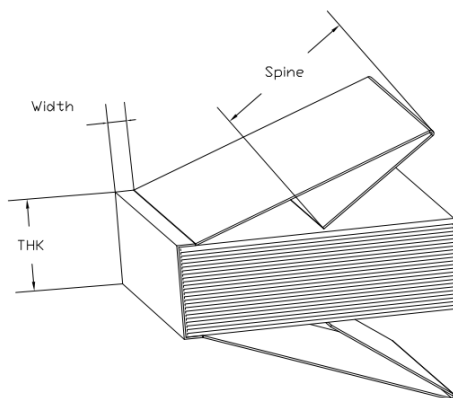
6.2.1 Cover Hinge 1:







Enter the settings referring to the above illustration and enter the quantity desired processing sheets. After finishing all settings, press  twice to get into standby mode then press  or  to start processing sheets.




6.2.1 Cover Hinge 2:






Enter the settings referring to the above illustration. Press  twice to get into standby mode then

press  or  to start processing sheets.

6.3. Progressive: In the standby status, press  to access the setting menu.



Press  or  to choose "progressive" then press .



Press  or  to choose "ON" then press .

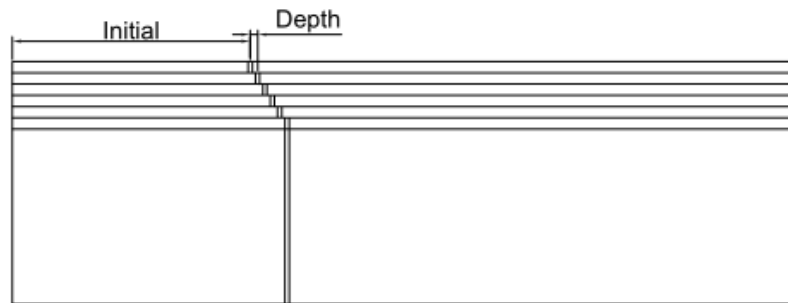
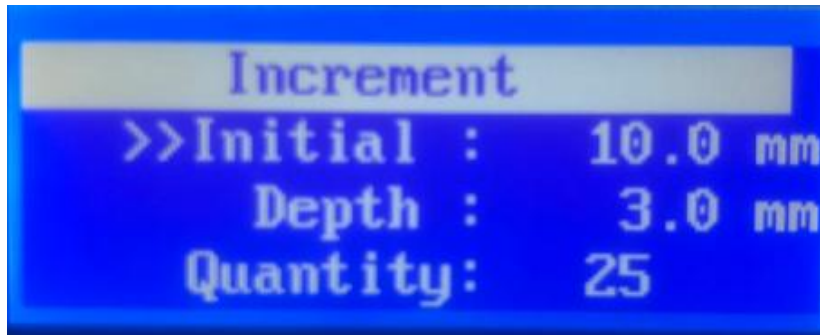
✧ **Notice: To turn off the "Progressive" function, must set it off.**




Press  or  to choose one progressive mode then press .





6.3.1 Increment:

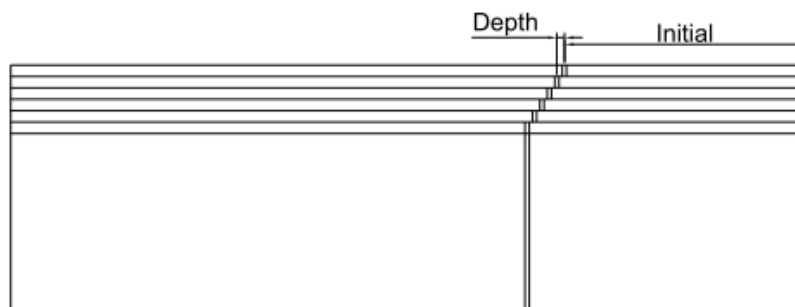
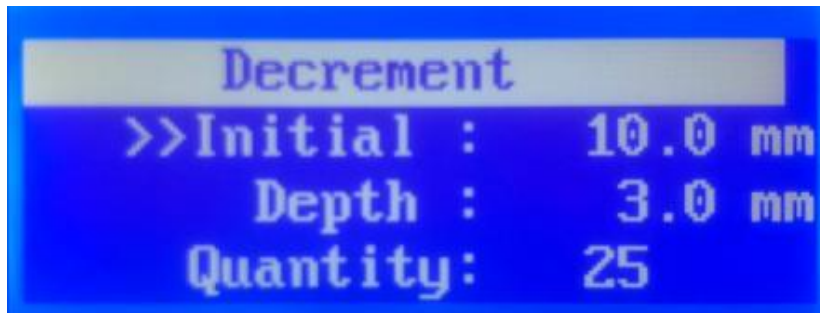


Enter the settings referring to the above illustration and enter the quantity desired




processing sheets. After finishing all settings, press  to get into standby

mode then press  or  to start processing sheets.

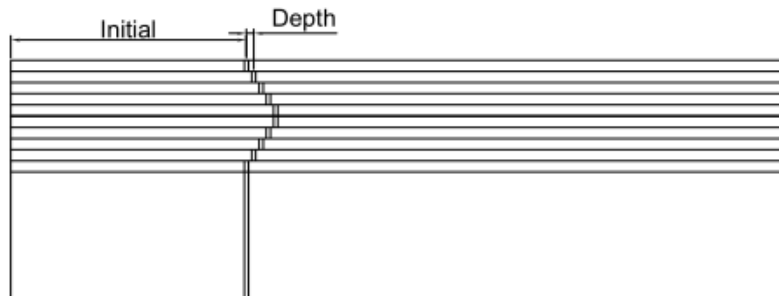
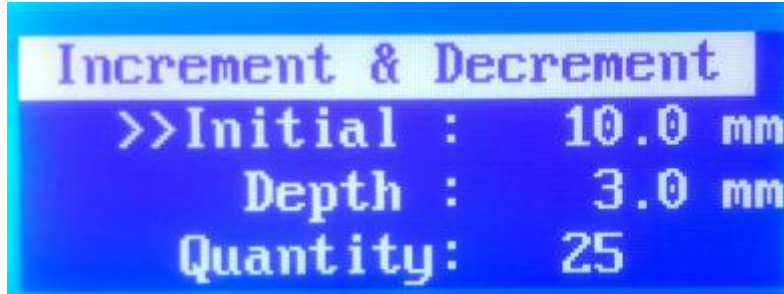
6.3.2 Decrement:






Enter the settings referring to the above illustration and enter the quantity desired

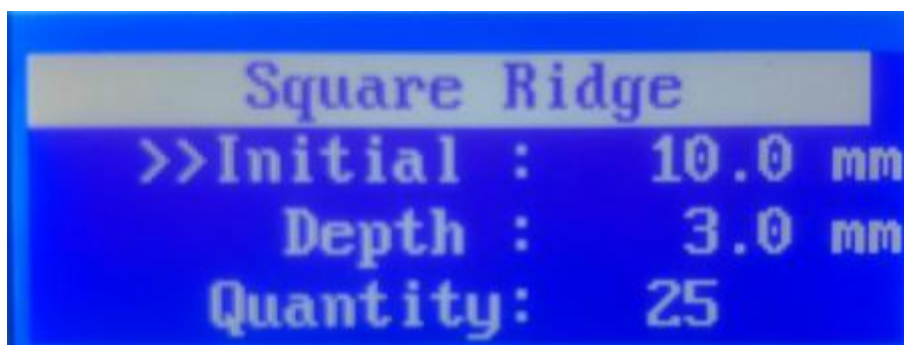
processing sheets. After finishing all settings, press  to get into standby mode then press  or  to start processing sheets.

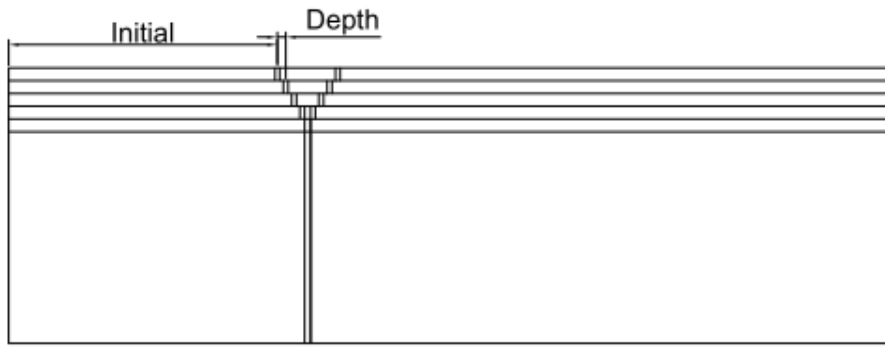
6.3.3 Increment & Decrement:






Enter the settings referring to the above illustration and enter the quantity desired processing sheets. After finishing all settings, press  to get into standby mode then press  or  to start processing sheets.

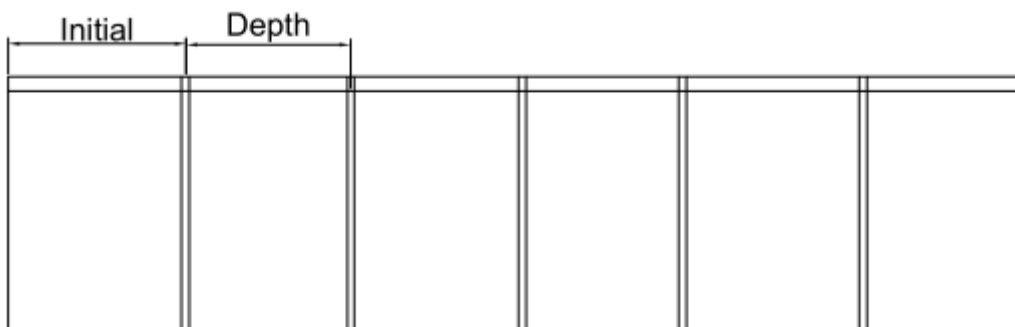
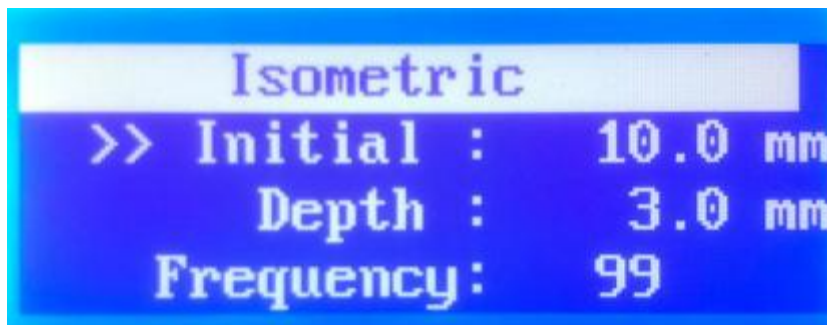
6.3.4 Square Ridge:












Enter the settings referring to the above illustration and enter the quantity desired processing sheets. After finishing all settings, press  to get into standby mode then press  or  to start processing sheets.

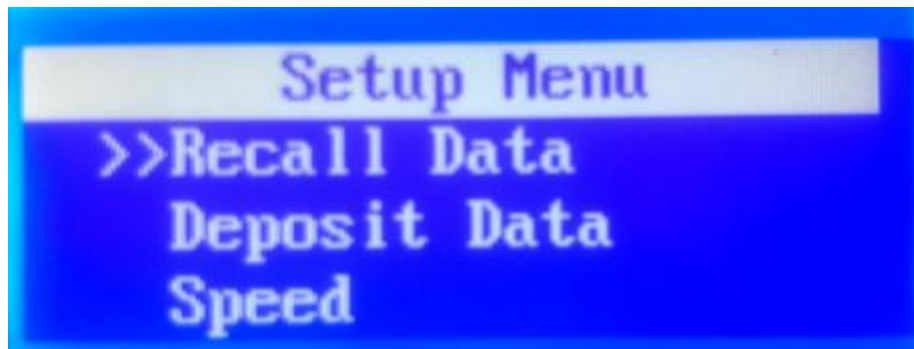
6.3.5 Isometric:




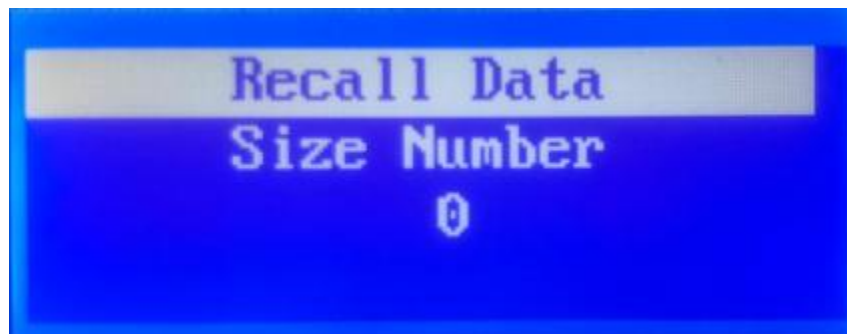
Enter the settings referring to the above illustration and enter the quantity desired processing sheets. After finishing all settings, press  to get into standby mode then press  or  to start processing sheets.


6.4. Recall Data: In the standby status, press  to access the setting menu.

Press  or  to choose "Recall Data" then press .

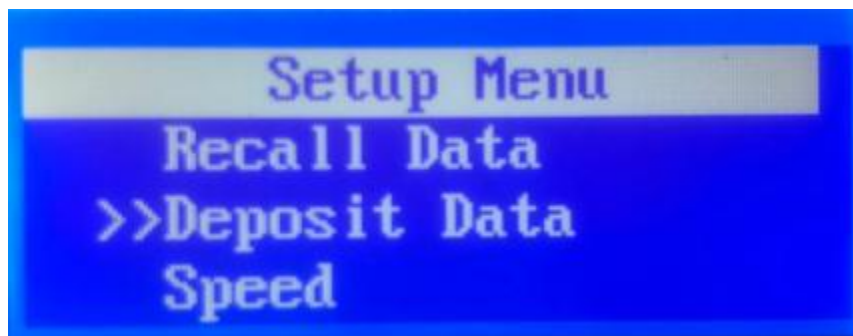




Enter the memory No. from the keypad then press .



6.5. Deposit Data: In the standby status, press  to access the setting menu.

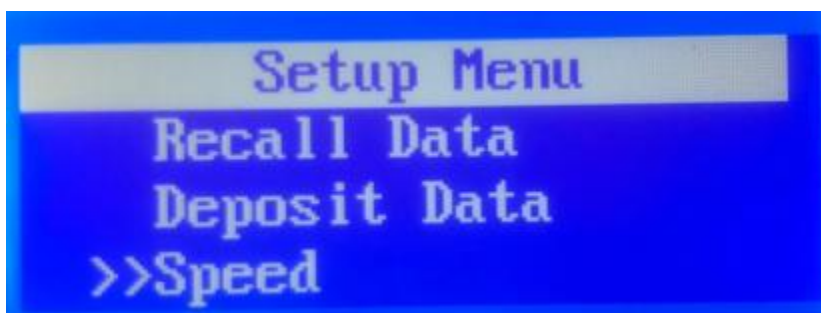
Press  or  to choose "Deposit Data" then press .



Enter the memory No. from the keypad then press . Press  to go back to up page.


6.6. Speed: In the standby status, press  to access the setting menu.




Press  or  to choose "Speed" then press .





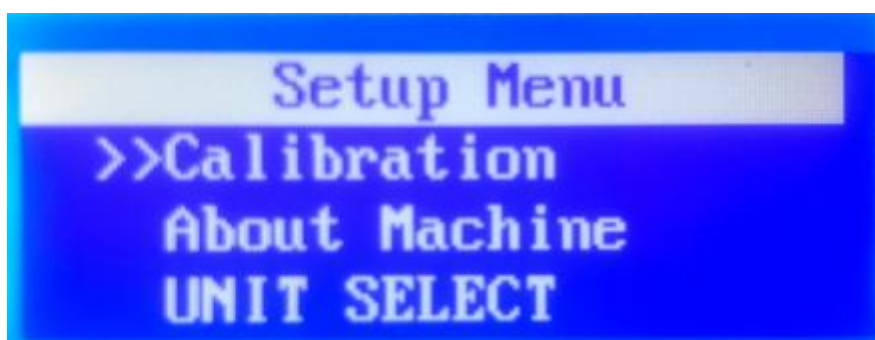
Press  or  to choose "LOW" or "HIGH" then press .

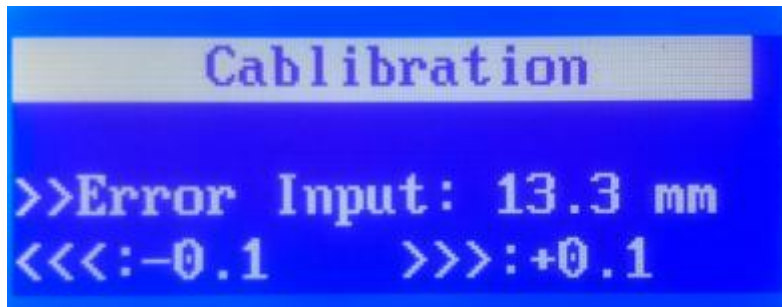






6.7. Calibration: In the standby status, press  to access the setting menu.

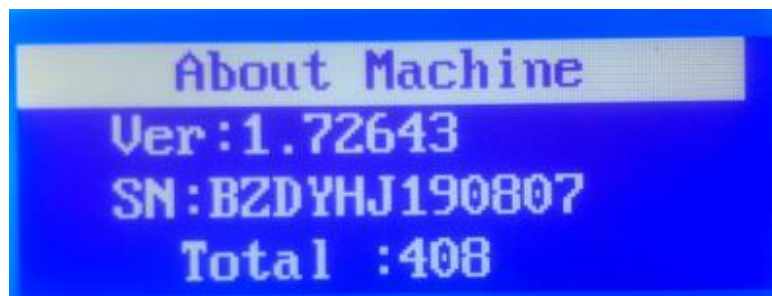
Press  or  to choose "Calibration" then press .





Press   to adjust the measurement of the first creasing position.








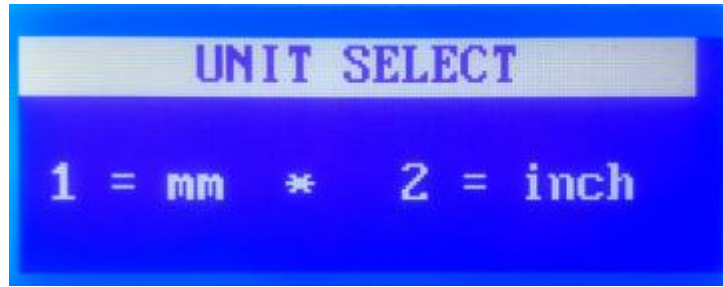
6.8. About Machine: In the standby status, press  to access the setting menu. Press  or  to choose "About machine" then press  to show the information of this machine.



6.9. : Unit Select: In the standby status, press  to access the setting menu. Press  or  to choose "Unit Select" then press .



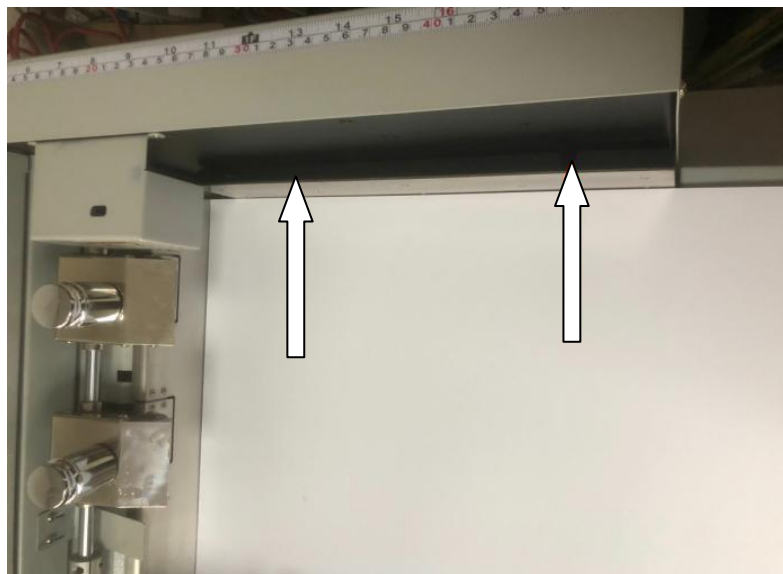
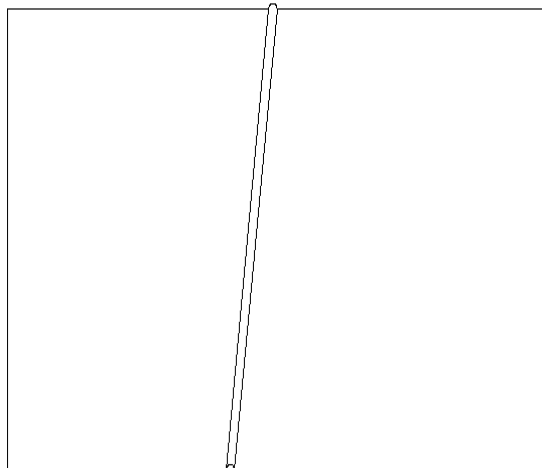
Press  or  to choose "mm" or "inch" then press .



7. Adjustment

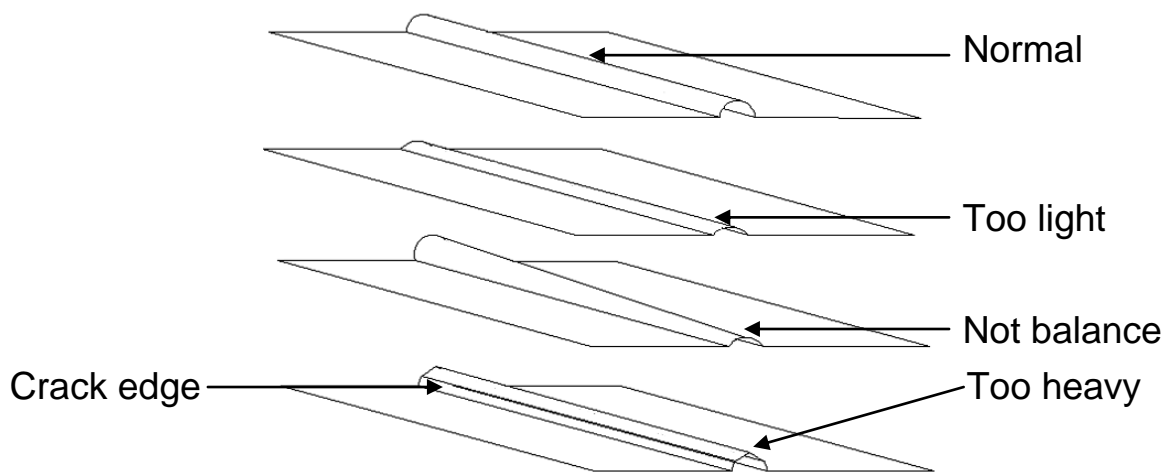
7.1 Creasing skew

7.1.1 Adjust the side lay on the table to get a proper feeding angle. Loosen the two screws then adjust the angle of the side lay then tighten the two screws as shown in the illustration.



7.2 Creasing Depth

7.2.1 Creasing depth is important to crease quality. It depends on the gap between upper die and lower die. Creasing depth should be adjusted according to paper thickness.



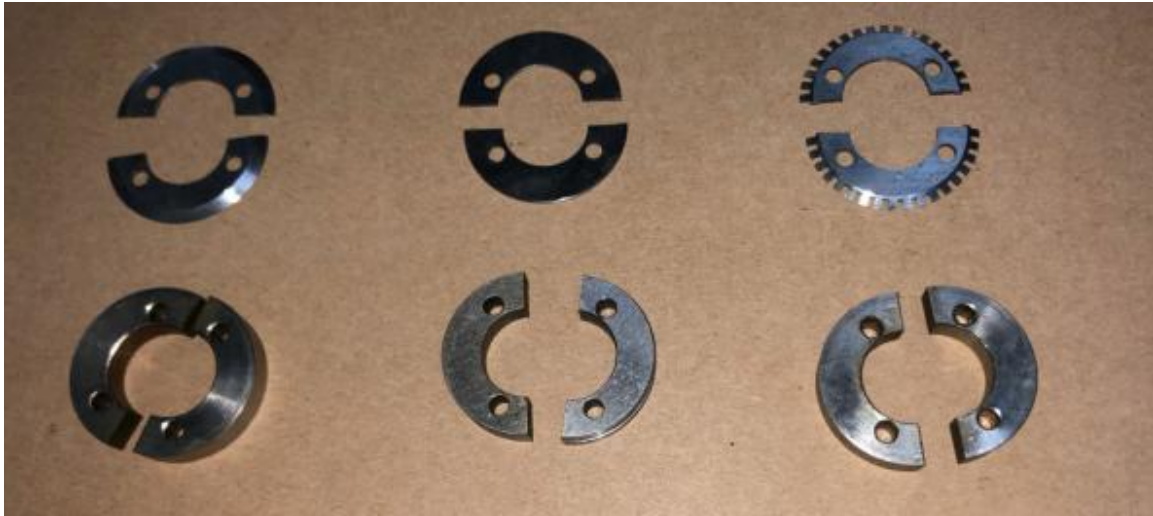
11.5.2 To adjust the creasing depth, open the top cover and adjust 3 allen screws on the bar. Depend on paper type and feeding situation to adjust it. Turn clockwise to get a deeper crease and turn counter-clockwise to get a shallower crease.



3 Creasing depth adjusting screws

8. Rotary Knives(Optional)

There are 3 types of rotary knife.



Slitter

Scorer

Perforator

8.1 Loosen the grub screws in the lower roller using Allen key 2.0, stagger it away from the upper rubber roller.

8.2 Install one of the lower die to the lower roller with 2 M3*10 screws using Allen key 2.5, mind the 4 threaded holes position. Do not set it too tightly.



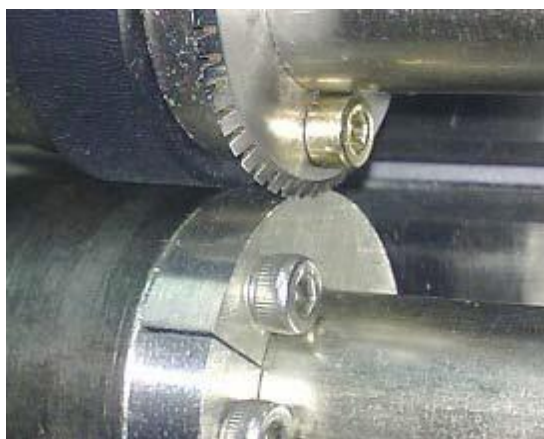
8.3 Install the both lower dies then tighten them.



8.4 Install the upper knives to the upper roller one by one like the lower dies with M3*6 screws.

8.5 Move the upper and lower rollers to make the upper knife and the lower die

touch each other.



- **Warning! Be careful when opening the safety cover.**

9. TROUBLE SHOOTING


9.1 Crease motor error/Jamming the blade

9.1.1 Feed too many papers in one pass.

9.1.2 Set the blade too low.

9.1.3 Run the thicker paper than the blade are set for

Solution:

1. Carefully use the scroll buttons  to move the rollers and pull the paper out, find the every reason and solve it accordingly.

2. If above doesn't work, please uninstall the unit, and test the machine from the beginning.

9.2 Paper jam

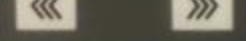
9.2.1 The paper is too thin (under spec, the paper will crumple).

9.2.2 There is some waste present in the pass path of the machine.

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

9.2.5 The lead edge of the paper is being damaged by the paper separator.

Solution:

Use the scroll buttons  to control the roller manually to drive the jammed paper out of mechanical system . do not pull hard on the paper, or you may damage the in-feed rollers !

9.3 Feed failure

9.3.1 The feeding roller can not scratch the paper.

Solution: Put a weight on the feeding roller.

9.4 Bubbling in laminated stock

9.4.1 This occurs if you try to crease laminated paper. The curve of the crease will not adhere to the film

solution: Make a shallower crease or use a better film.

9.5 Paper wrapped around the perforating wheels

9.5.1 This occurs if the card is too thin/ has no body and will get hooked on the perforating teeth and wrap around the disc.

solution: keep the paper within the spec..

9.6.Wear on the rollers

Solution:

- 1.Replacement.

9.7 Feed skew

Solution:

- 1.Check if the paper is out of specification or not guided properly. Set the side guides and paper press properly.
- 2.Adjust the feed angle referring to the item 7.1.

9.8 Coating on the rollers

9.8.1 The rollers will accumulate the coat from the passing paper and this will reduce the friction significantly and cause sliding.

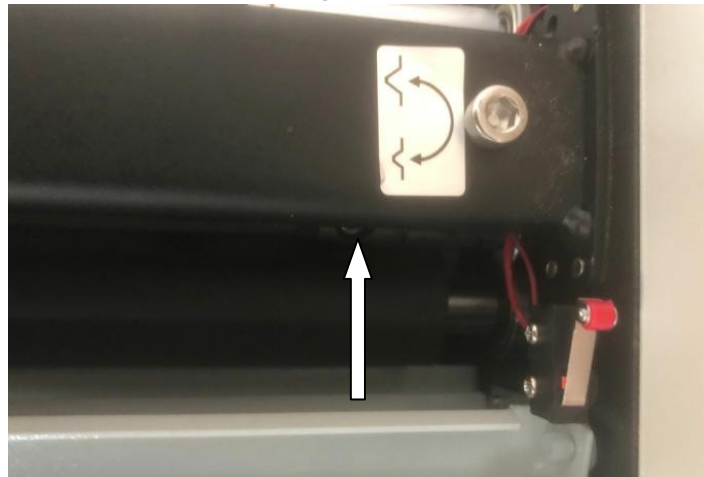
Solution:

1. Clean out with water or alcohol.

9.9 Measurement is not accurate

Solution:

1. Clean out the upper & lower feeding sensors.



2. Calibrate the measurement in the system according the above item 6.7.

