

GLUE BINDING MACHINE

OPERATION MANUAL



Notice



1.Control section

1).This section consist of control panel , digital screen, key of “confirm”, “+”“-” ,etc .

2)”Txx” on digital screen indicate the environmental temperature before heating .

2.Setting of temperature controller

1).Press the key of “ok”, video indicate setting temperature ,then adjust the temperature to around 170° by pressing “+”, “-”.

2).seconds after finish setting ,the showing temperature

will back to current temperature and show “HXX”. In the meantime ,relay pick-up and glue box start heating ,the showing temperature rise gradually and up to the setting 170°during 15-20 minutes. The relay close at this moment .Showing temperature continue to rise then go down gradually till 1-3°under the setting , the relay pick-up and heating again. Time after time ,the temperature of melting glue can be maintained .The key “ok ” should be pressed if temperature need remain the

3.Turn on the machine after setting.same .

	Phenomena	Reason	Solution
1	Indicate:ER-01	Thermal Tube Malfunction	Replace thermal tube
2	Indicate:er-02	Thermal couple malfunction	Replace thermal couple

HONEST AND BOON

Thanks for choosing binding machine. For operation easily and better binding result, now promote new model of 4 machine, it is binding, creasing, cutting perfect all in one. Please read operation manual carefully before operate. If any problem else, please contact supplier.

Model	Milling cutter	Temperature controller	Hardback setting	Creasing setting
2	✓	✓		
3	✓	✓	✓	
4	✓	✓		✓
5	✓	✓	✓	✓

List

- List 1
- Packing list and installation 2
- Precautions 2
- Operate parts 3
- Operation manual(soft cover) 4
- Operation manual(hard cover) 8
- Adjustment of gluing roller 11
- Adjustment of milling blade 12
- Using of creasing setting 13
- Using of hard back setting 14
- Malfunctions, causations and solution 16

Binding Machine Packing list Installation and Precautions

Packing list

1. 1 unit of machine
2. 1 set of soft cover template
3. 1 pcs of cable
4. 1 pcs of cross screw-driver
5. 1 pcs of M5 hexagonal socket spanner
6. 1 operate manual
7. 1 bag of glue

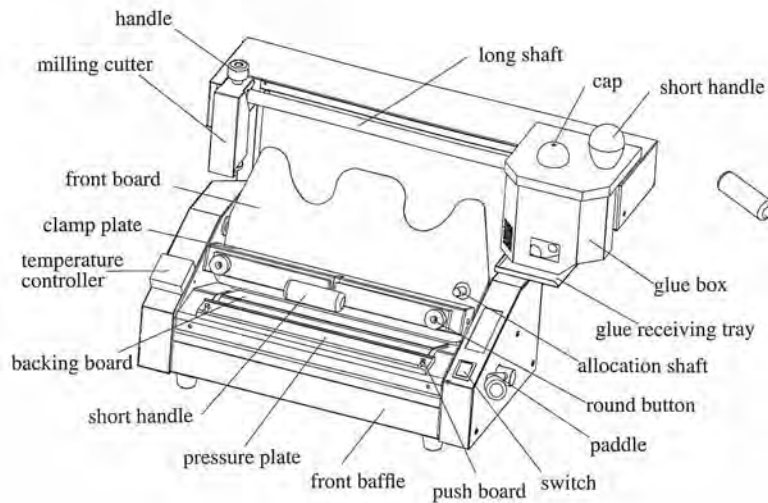
Installation

Please put this machine onto a stable worktop, avoid approaching any humidity. Certain space should be kept to operate the machine

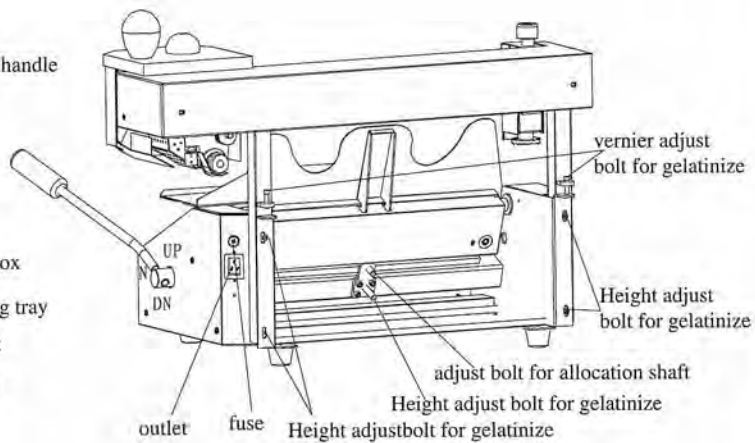
Precaution

1. Connect to the specified power supply(220V/50Hz or 110V/60Hz).Open glue box cover, put in the solid glue. Note:
A.The glue should be clean and without any sundries.B Regularly add the glue particles into the glue box according to glue slurry consumption. Thus a proper amount of glue slurry can be continuously supplied.
2. Turn on the switch, the glue to be heated under 170 degree about 15-20 minutes. During heating, don't move the glue box to avoid damage. Pay special attention to avoid the glue box touching hard thing during operating.
3. Make sure the template on the machine is accordant to the cover of binding file.(e.g. soft cover matches soft cover template and hard cover file matches hard cover template)
4. Put the paddle on "N" position.
5. During the installation, if the gluing roller on the glue box is not parallel to the spine of the binding book, please adjust it according to "Adjustment of the gluing roller" section in this manual. (page 11)
6. Milling cutter's position can be adjusted by adjusting four screws. (page12)

OPERATION PARTS

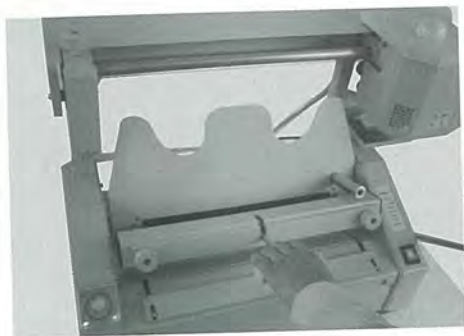


图A

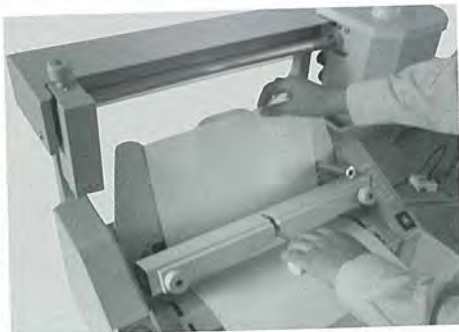


图B

Operation manual(soft cover)



1. Press the handle and draw out the paper Pressurer



2 .Put the cover in-between the paper pressurer and platform, and keep it close to the localizer.The platform could be raised so that the cover could be easily placed.



3. Put the paper in-between the cover and paper pressurer, piling it up neatly.

Operation manual(soft cover)



4. Push the paper pressurer down against the paper and rotate the handle up, locking the paper in as the picture shows.



5. Press paddle down to “DN” position, so that a crease can be made on the bottom cover. And then push paddle back to “N” position.



6. Push paddle to “UP” position, rotate the platform upwards and make sure the bottom side of files is flat.

Operation manual(soft cover)



7. Push the milling cutter back and forth on the bottom side of files



8. Gelatinize by moving glue box



9. After gelatinizing, Immediately draught the back cover slightly by left hand, press the paddledown to "N" position by right hand, and then to "DN" position, sustaining for around 6---8 seconds.

Operation manual(soft cover)



10. Push the paper presser down against the paper and rotate the handle up, turn the book to back face and put in again, sustain about 3seconds

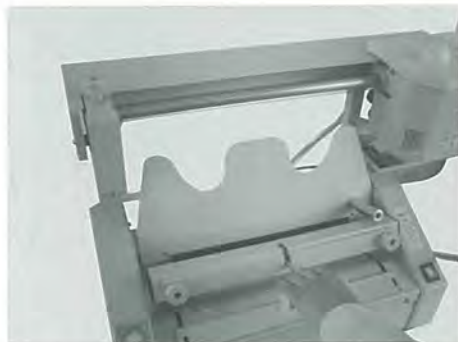


11. Press the handle down, draw the paper presser open, and take out the made-book. Cut the untidy edges of the book to neatly by the paper cutter

Operation manual (hard cover)

Before operation:

- ① Prepare the hard cover
- ② Replace the paper pressurer complied for hard cover and allocation shaft.
- ③ Allocate the operation handle to "N" position



1. Press the handle and draw out the paper pressurer.

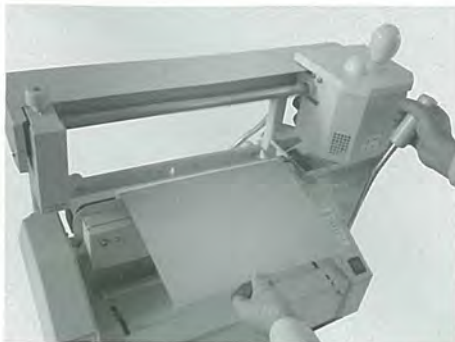


2. Put the hard cover in-between the platform and paper pressurer. Adjust allocation shaft to press the hard cover against the front baffle tightly

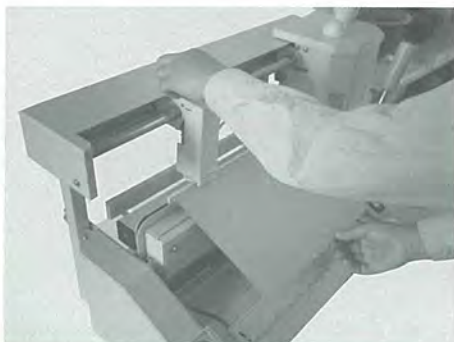


3. Put two pieces of self-adhesive mount separately on two sides of the files, tidy them neatly, and then put them inside the hard cover. Keep them close to the allocation shaft, then push the handle

Operation manual (hard cover)



4 . Push the paddle to “UP” position, rotate the platform upwards.

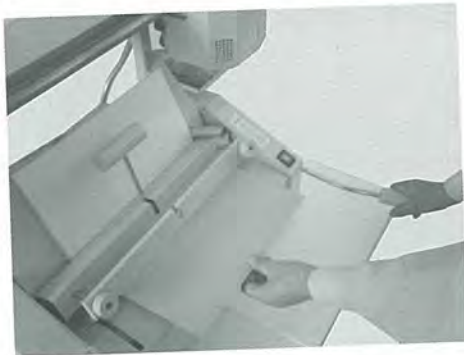


5. Push the milling cutter back and forth movement on the bottom side of files.

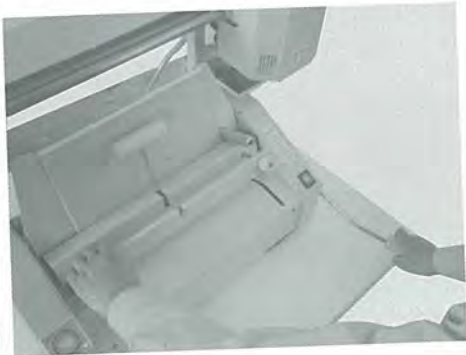


6. Press the back cover of hard cover close to platform document, gelatinize by moving glue box

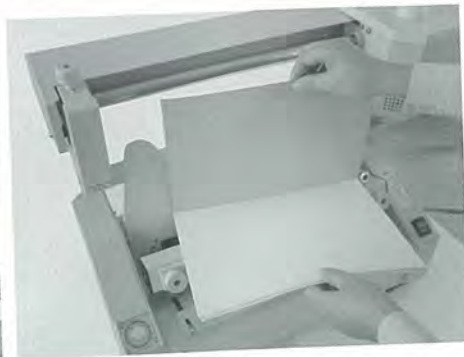
Operation manual (hard cover)



7. Draw the paddle back to “N” position and then press it to “DN” position for 2 seconds



8. Draw out the paper pressurer, turn the book to back face and put in again, press the paddle down again to “DN” position for about 3 seconds.



9. Take out the made-files and tear the seal paper, back up the mount of the inside cover, and then make it smooth.

Adjustment of the gluing roller

Step 1

1. Place a piece of sheet(thickness:0.8mm,320mm*60mm)on to the platform
2. Place pile of 25mm—thickness paper on the right position of the binder.
3. Push clamp plate and lock it.
4. Upturn the rotating unit(Platform),until spine of book is upward.
5. Move the glue box after the glue is heated
6. Watch whether the glue roller is parallel to the spine of book
7. If not parallel, please adjust bolt(4) until they are parallel.

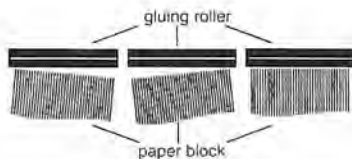


图 1

Step 2

8. Loosen the bolt(1)in picture B
9. Adjust bolt(3),until the roller touches the back surface of paper
10. Tighten the bolt(1)
11. Push the glue box to the other side
12. Loosen the bolt(2)in picture B
13. Adjust bolt(5),until the roller touches the back surface of paper
14. Tighten the bolt(2) in the picture B
15. Complete the steps as showed in picture 2(as Showed in the attached picture)
16. After finishing the adjustment, tack back the sheet, and place another pile of paper, glue it ,and watch whether the glue is evened,otherwise more adjustment will be needed, following the same steps as above

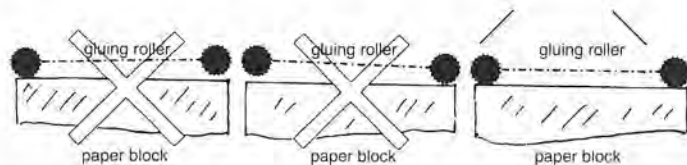
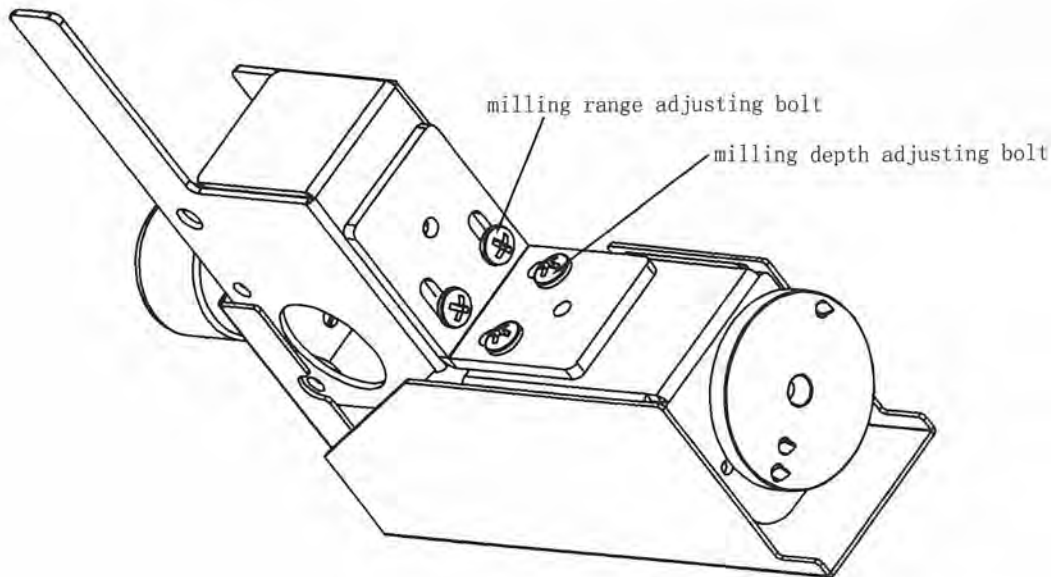


图 2

Adjustment of milling blade

1. The milling depth can be adjusted by adjusting the depth adjusting bolt. Loose the adjusting bolts on milling blade, move the blade to suitable place, then tighten the bolt.

2. The milling range can be adjusted by adjusting the range adjusting bolt. Loose the adjusting bolt on blade, move the blade to suitable place, then tighten the bolt.



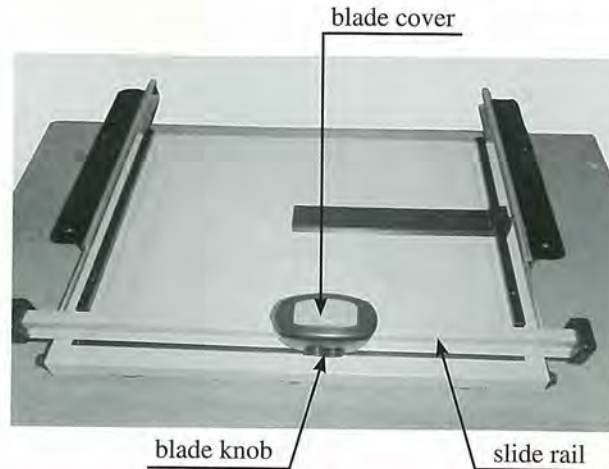
Using of marking setting

1. Creasing setting is one accessory of 4 there are four kinds of different blades, creasing blade, undee blade, beeline blade and breakpoint blade.

2. As user demand,choosing blade for different paper binging effect.

3. Blade replacing, twist the blade knob, install right blade, then twist the blade knob back.

4. Adjusting paper position, press forcibly the blade cover and slip along the slide rail.



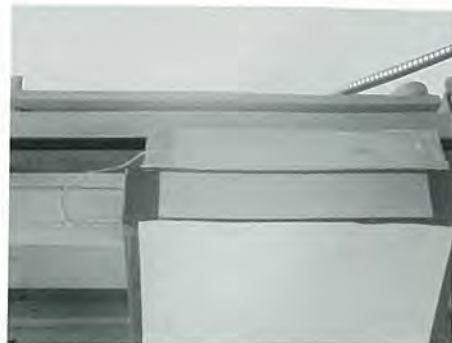
Using of hardback setting



(Image one)



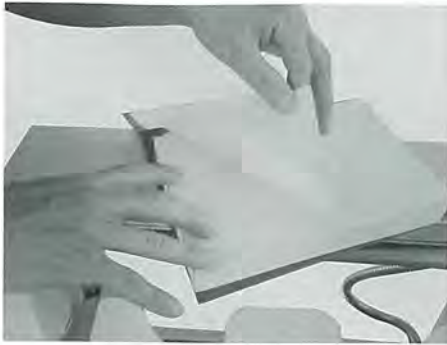
(Image two)



(Image three)

1. Ready for hardback operation, take down the pressure plate A. (Image one)
2. Put the cover in between the pressure plate and platform, fixup it by the localizer. (Image two)
3. Put two sheets self adhesive head page as the first page and end page. (Image two)
4. Put the paper in between the cover and the plate against teh localizer .(Image two)
5. Piling the paper up neatly and overturn the platform, gelatinize two or three times by moving glue box, and the timen is not more than six second. (Image three)
6. Put the fibrillar webbing on the gelatinized spine of a book, and put the cloth on the both book ends. (Image three)

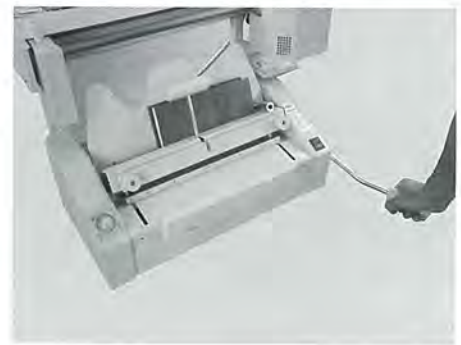
Using of hardback setting



(Image four)



(Image five)



(Image six)

7. Overturn the platform, press out the cover and the paper by the pressure plate, take out the book and press out the inverse side.
8. Take out the gelatinized book, rip off the release paper and put the self adhesive head page on the hardback cover smoothly. (Image four)
9. If there is tectorial cover, heating pressure for tighten binding, the operation as below:
 - ① Install the heating pressure plate and switch on power
 - ② Waiting for the red light on the plate is ok (Image five)
 - ③ Press the gelatinized book 4 second by the heating plate.
 - ④ Release the plate, take out the book and press out the inverse side. (Image six)
10. After heating pressure, the hardback book is OK.

1. Malfunctions, causations and solution

	Malfunctions	Possible causations	Solutions
I	The glue box can't be heated	1.the fuse of power source is burned	Replace a new fuse
		2.The melting fuse tube is burnt	Replace a new tubes
		3.the thermostat doesn't work	Replace a new electro heat tube
		4.the electro heat tube is broken	Replace a new electro heat tube
II	The glue is not layed on evenly or insufficient	1.the glue in the box is insufficient	Add glue
		2.The gluing roller doesn't rotate	Fit the roller and tighten the bolt, don't move the glue box until the temperature reaches to the point
		3.the gluing roller doesn't average distance to the spine of book	Adjustable the gluing roller
		4.the pressure of gluing roller is insufficient	Adjust the gluing roller
III	It's hard to move the glue box	1.the glue isn't heated well	Run the glue box when it is heated
		2.some sundries is in the box	Be aware of cleaning the glue particulate
		3.the glue slurry goes bad due to long idleness	Heat and clear the remain glue slurry in the box, then add new glue.
IV	The spine of book is not well formed	1.The paper not neatly placed	Make the paper sheet tidy and flat
		2.Too short time to push and press the cover template	Adjust the time of pushing and press the cover template
		3.Misuse the cover template	Check whether the binding document matches the cover template
		4.The pressure of two ends of the cover template isn't balanced	Adjust and correct the pressure on two end
V	Poor fastness of binding	1.too slow gluing	Speed up gluing
		2.too slow or too short of pushing and pressing the cover template	Rapid pushing and pressing, and master the proper time
		3.poor quality of the glue	Use the recommended glue
		4.wrong grain direction of paper	Bind in the same grain direction of paper

GLUE BINDING MACHINE

OPERATION MANUAL



Notice



1.Control section

- 1).This section consist of control panel , digital screen, key of “confirm”, “+”“-” ,etc .
- 2)”Txx” on digital screen indicate the environmental temperature before heating .

2.Setting of temperature controller

- 1).Press the key of “ok”, video indicate setting temperature ,then adjust the temperature to around 170° by pressing “+”, “-”.
- 2).seconds after finish setting ,the showing temperature

will back to current temperature and show “HXX”. In the meantime ,relay pick-up and glue box start heating ,the showing temperature rise gradually and up to the setting 170°during 15-20 minutes. The relay close at this moment .Showing temperature continue to rise then go down gradually till 1-3°under the setting , the relay pick-up and heating again. Time after time ,the temperature of melting glue can be maintained .The key “ok ” should be pressed if temperature need remain the

3.Turn on the machine after setting.same .

	Phenomena	Reason	Solution
1	Indicate:ER-01	Thermal Tube Malfunction	Replace thermal tube
2	Indicate:er-02	Thermal couple malfunction	Replace thermal couple

HONEST AND BOON

Thanks for choosing binding machine. For operation easily and better binding result, now promote new model of 4 machine, it is binding, creasing, cutting perfect all in one. Please read operation manual carefully before operate. If any problem else, please contact supplier.

Model	Milling cutter	Temperature controller	Hardback setting	Creasing setting
2	✓	✓		
3	✓	✓	✓	
4	✓	✓		✓
5	✓	✓	✓	✓

List

- List 1
- Packing list and installation 2
- Precautions 2
- Operate parts 3
- Operation manual(soft cover) 4
- Operation manual(hard cover) 8
- Adjustment of gluing roller 11
- Adjustment of milling blade 12
- Using of creasing setting 13
- Using of hard back setting 14
- Malfunctions, causations and solution 16

Binding Machine Packing list Installation and Precautions

Packing list

1. 1 unit of machine
2. 1 set of soft cover template
3. 1 pcs of cable
4. 1 pcs of cross screw-driver
5. 1 pcs of M5 hexagonal socket spanner
6. 1 operate manual
7. 1 bag of glue

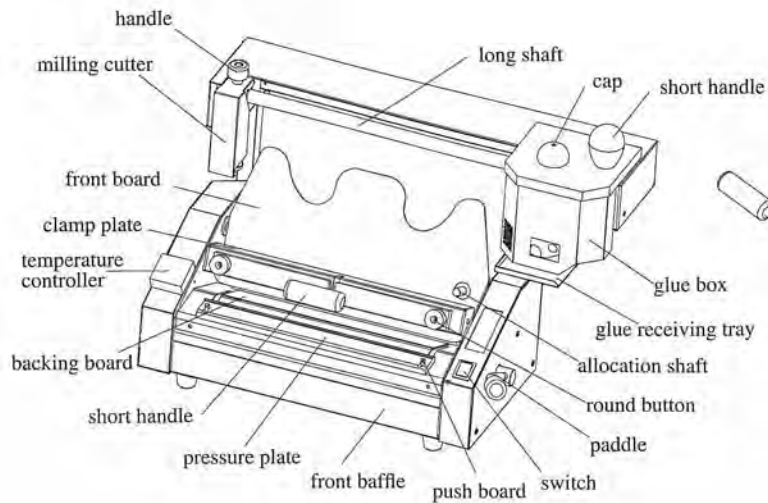
Installation

Please put this machine onto a stable worktop, avoid approaching any humidity. Certain space should be kept to operate the machine

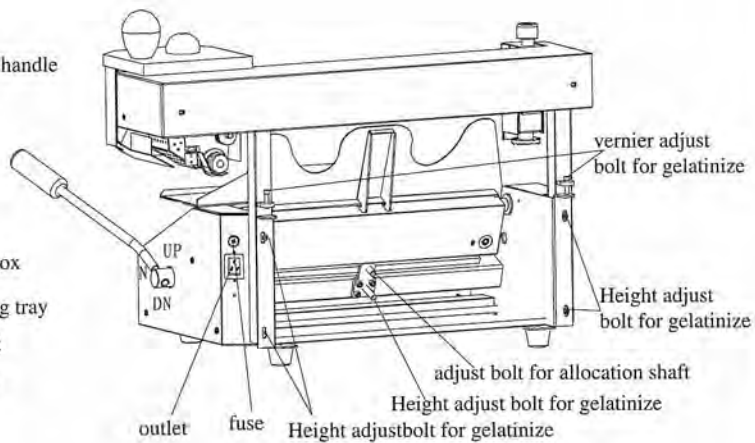
Precaution

1. Connect to the specified power supply(220V/50Hz or 110V/60Hz).Open glue box cover, put in the solid glue. Note:
A.The glue should be clean and without any sundries.B Regularly add the glue particles into the glue box according to glue slurry consumption. Thus a proper amount of glue slurry can be continuously supplied.
2. Turn on the switch, the glue to be heated under 170 degree about 15-20 minutes. During heating, don't move the glue box to avoid damage. Pay special attention to avoid the glue box touching hard thing during operating.
3. Make sure the template on the machine is accordant to the cover of binding file.(e.g. soft cover matches soft cover template and hard cover file matches hard cover template)
4. Put the paddle on "N" position.
5. During the installation, if the gluing roller on the glue box is not parallel to the spine of the binding book, please adjust it according to "Adjustment of the gluing roller" section in this manual. (page 11)
6. Milling cutter's position can be adjusted by adjusting four screws. (page12)

OPERATION PARTS



图A

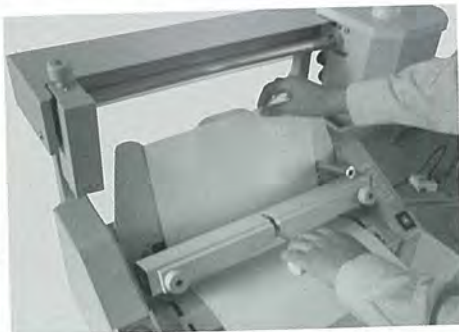


图B

Operation manual(soft cover)



1. Press the handle and draw out the paper Pressurer



2 .Put the cover in-between the paper pressurer and platform, and keep it close to the localizer.The platform could be raised so that the cover could be easily placed.



3. Put the paper in-between the cover and paper pressurer, piling it up neatly.

Operation manual(soft cover)



4. Push the paper pressurer down against the paper and rotate the handle up, locking the paper in as the picture shows.



5. Press paddle down to “DN” position, so that a crease can be made on the bottom cover. And then push paddle back to “N” position.



6. Push paddle to “UP” position, rotate the platform upwards and make sure the bottom side of files is flat.

Operation manual(soft cover)



7. Push the milling cutter back and forth on the bottom side of files



8. Gelatinize by moving glue box



9. After gelatinizing, Immediately draught the back cover slightly by left hand, press the paddledown to "N" position by right hand, and then to "DN" position, sustaining for around 6---8 seconds.

Operation manual(soft cover)



10. Push the paper pressurer down against the paper and rotate the handle up, turn the book to back face and put in again, sustain about 3seconds

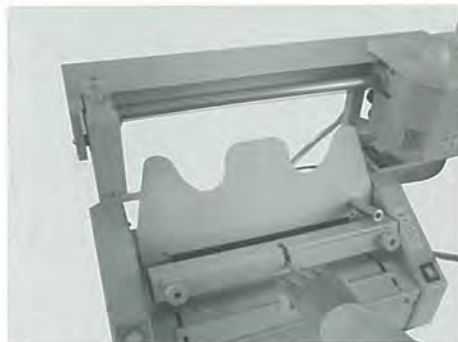


11. Press the handle down, draw the paper pressurer open, and take out the made-book. Cut the untidy edges of the book to neatly by the paper cutter

Operation manual (hard cover)

Before operation:

- ① Prepare the hard cover
- ② Replace the paper pressurer complied for hard cover and allocation shaft.
- ③ Allocate the operation handle to “N” position



1. Press the handle and draw out the paper pressurer.

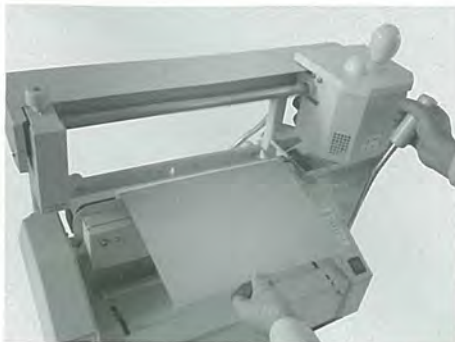


2. Put the hard cover in-between the platform and paper pressurer. Adjust allocation shaft to press the hard cover against the front baffle tightly

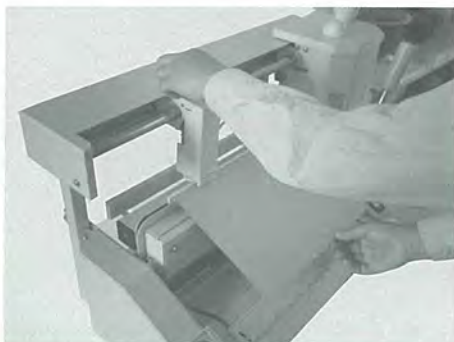


3. Put two pieces of self-adhesive mount separately on two sides of the files, tidy them neatly, and then put them inside the hard cover. Keep them close to the allocation shaft, then push the handle

Operation manual (hard cover)



4 . Push the paddle to “UP” position, rotate the platform upwards.

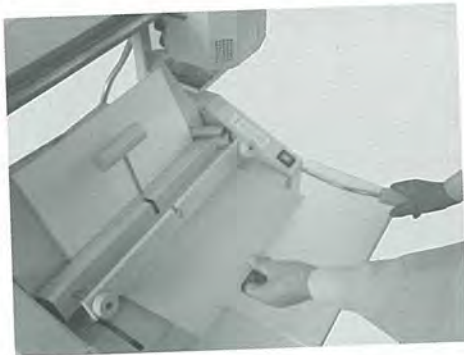


5. Push the milling cutter back and forth movement on the bottom side of files.



6. Press the back cover of hard cover close to platform document, gelatinize by moving glue box

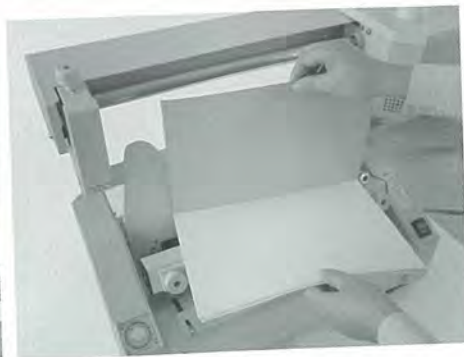
Operation manual (hard cover)



7. Draw the paddle back to “N” position and then press it to “DN” position for 2 seconds



8. Draw out the paper pressurer, turn the book to back face and put in again, press the paddle down again to “DN” position for about 3 seconds.



9. Take out the made-files and tear the seal paper, back up the mount of the inside cover, and then make it smooth.

Adjustment of the gluing roller

Step 1

1. Place a piece of sheet(thickness:0.8mm,320mm*60mm)on to the platform
2. Place pile of 25mm—thickness paper on the right position of the binder.
3. Push clamp plate and lock it.
4. Upturn the rotating unit(Platform),until spine of book is upward.
5. Move the glue box after the glue is heated
6. Watch whether the glue roller is parallel to the spine of book
7. If not parallel, please adjust bolt(4) until they are parallel.

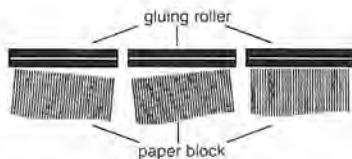


图 1

Step 2

8. Loosen the bolt(1)in picture B
9. Adjust bolt(3),until the roller touches the back surface of paper
10. Tighten the bolt(1)
11. Push the glue box to the other side
12. Loosen the bolt(2)in picture B
13. Adjust bolt(5),until the roller touches the back surface of paper
14. Tighten the bolt(2) in the picture B
15. Complete the steps as showed in picture 2(as Showed in the attached picture)
16. After finishing the adjustment, tack back the sheet, and place another pile of paper, glue it ,and watch whether the glue is evened,otherwise more adjustment will be needed, following the same steps as above

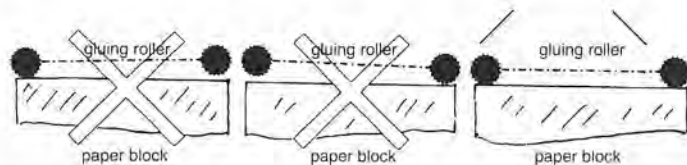
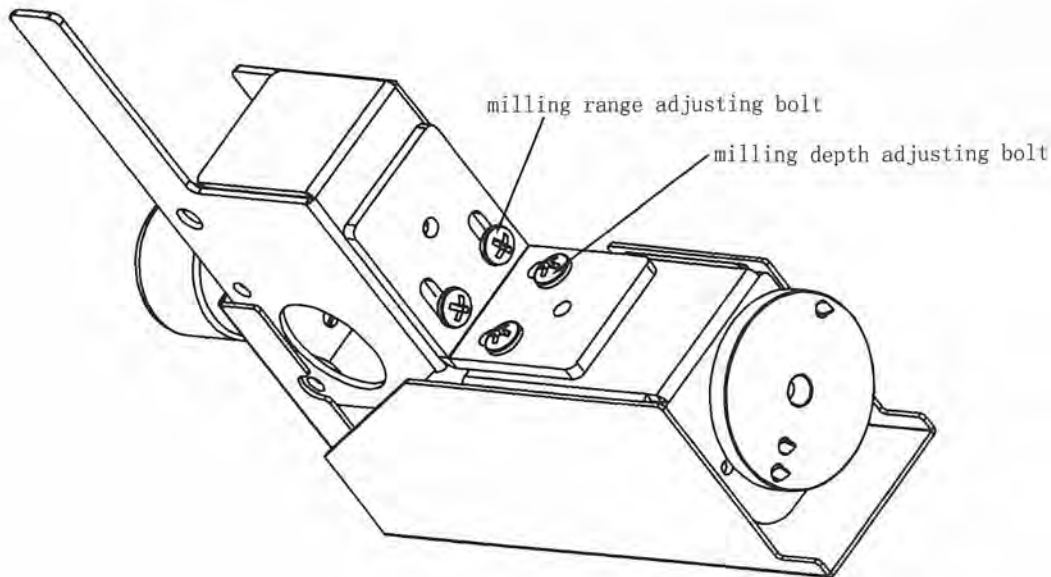


图 2

Adjustment of milling blade

1. The milling depth can be adjusted by adjusting the depth adjusting bolt. Loose the adjusting bolts on milling blade, move the blade to suitable place, then tighten the bolt.

2. The milling range can be adjusted by adjusting the range adjusting bolt. Loose the adjusting bolt on blade, move the blade to suitable place, then tighten the bolt.



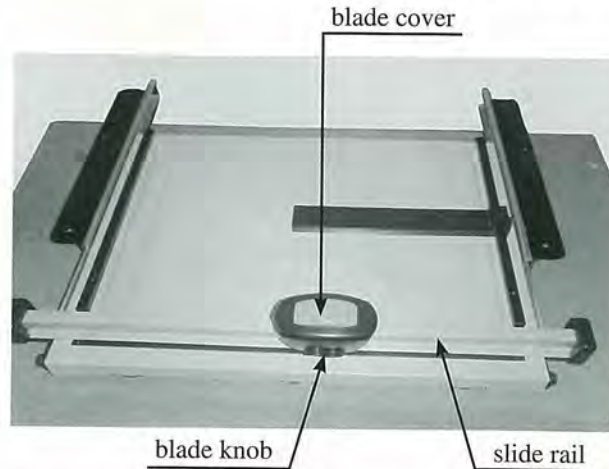
Using of marking setting

1. Creasing setting is one accessory of 4 there are four kinds of different blades, creasing blade, undee blade, beeline blade and breakpoint blade.

2. As user demand,choosing blade for different paper binging effect.

3. Blade replacing, twist the blade knob, install right blade, then twist the blade knob back.

4. Adjusting paper position, press forcibly the blade cover and slip along the slide rail.



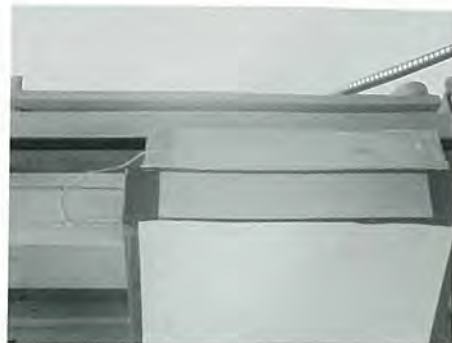
Using of hardback setting



(Image one)



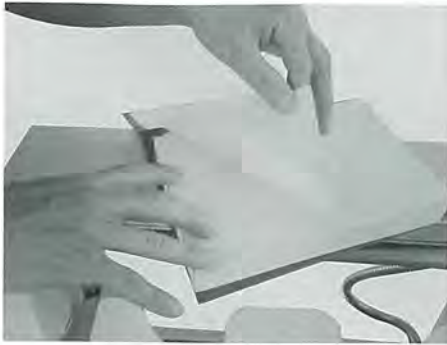
(Image two)



(Image three)

1. Ready for hardback operation, take down the pressure plate A. (Image one)
2. Put the cover in between the pressure plate and platform, fixup it by the localizer. (Image two)
3. Put two sheets self adhesive head page as the first page and end page. (Image two)
4. Put the paper in between the cover and the plate against teh localizer .(Image two)
5. Piling the paper up neatly and overturn the platform, gelatinize two or three times by moving glue box, and the timen is not more than six second. (Image three)
6. Put the fibrillar webbing on the gelatinized spine of a book, and put the cloth on the both book ends. (Image three)

Using of hardback setting



(Image four)



(Image five)



(Image six)

7. Overturn the platform, press out the cover and the paper by the pressure plate, take out the book and press out the inverse side.
8. Take out the gelatinized book, rip off the release paper and put the self adhesive head page on the hardback cover smoothly. (Image four)
9. If there is tectorial cover, heating pressure for tighten binding, the operation as below:
 - ① Install the heating pressure plate and switch on power
 - ② Waiting for the red light on the plate is ok (Image five)
 - ③ Press the gelatinized book 4 second by the heating plate.
 - ④ Release the plate, take out the book and press out the inverse side. (Image six)
10. After heating pressure, the hardback book is OK.

1. Malfunctions, causations and solution

	Malfunctions	Possible causations	Solutions
I	The glue box can't be heated	1.the fuse of power source is burned	Replace a new fuse
		2.The melting fuse tube is burnt	Replace a new tubes
		3.the thermostat doesn't work	Replace a new electro heat tube
		4.the electro heat tube is broken	Replace a new electro heat tube
II	The glue is not layed on evenly or insufficient	1.the glue in the box is insufficient	Add glue
		2.The gluing roller doesn't rotate	Fit the roller and tighten the bolt, don't move the glue box until the temperature reaches to the point
		3.the gluing roller doesn't average distance to the spine of book	Adjustable the gluing roller
		4.the pressure of gluing roller is insufficient	Adjust the gluing roller
III	It's hard to move the glue box	1.the glue isn't heated well	Run the glue box when it is heated
		2.some sundries is in the box	Be aware of cleaning the glue particulate
		3.the glue slurry goes bad due to long idleness	Heat and clear the remain glue slurry in the box, then add new glue.
IV	The spine of book is not well formed	1.The paper not neatly placed	Make the paper sheet tidy and flat
		2.Too short time to push and press the cover template	Adjust the time of pushing and press the cover template
		3.Misuse the cover template	Check whether the binding document matches the cover template
		4.The pressure of two ends of the cover template isn't balanced	Adjust and correct the pressure on two end
V	Poor fastness of binding	1.too slow gluing	Speed up gluing
		2.too slow or too short of pushing and pressing the cover template	Rapid pushing and pressing, and master the proper time
		3.poor quality of the glue	Use the recommended glue
		4.wrong grain direction of paper	Bind in the same grain direction of paper