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# PART 1

## Special Cautions

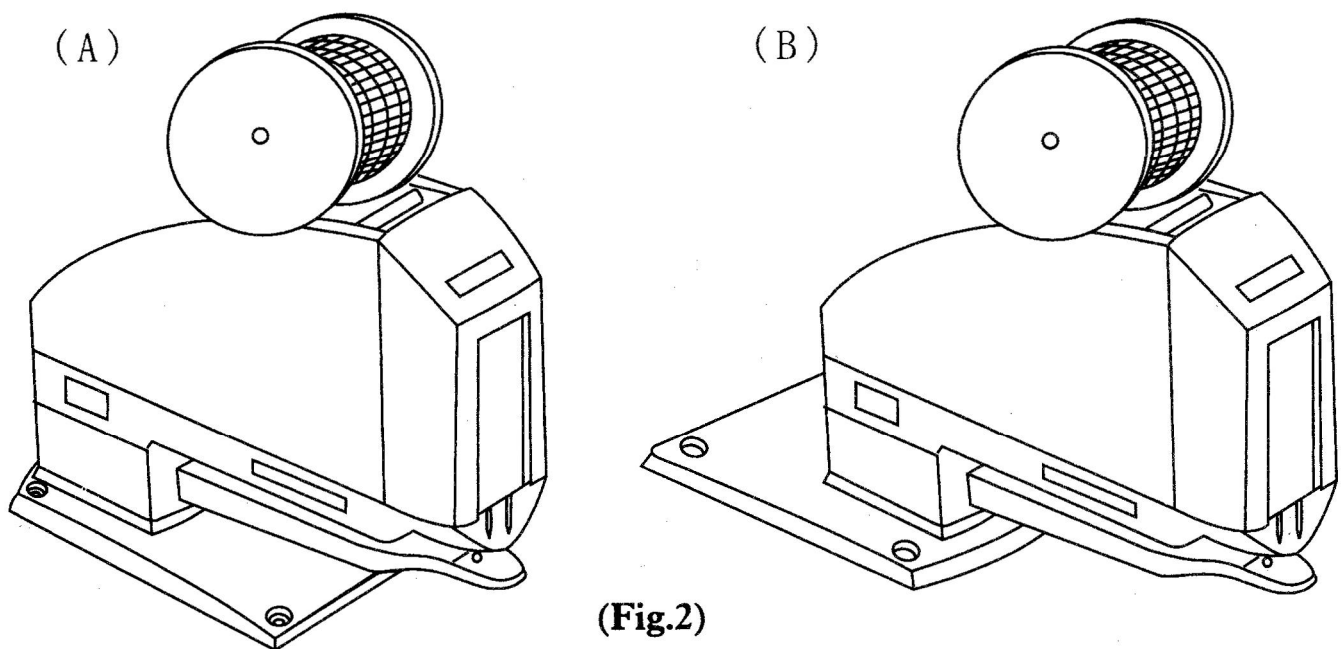
1. After binder has been shipped to your place, first check the outer packing state and the sealing. Then tear off the packing and check the packing list with the contents. Please contact your sales agent if any unconformity exists.
2. Please read this operation manual before actual start the installation.
  - a) Please take reference of Part 6 Trouble Shooting if any problem occurs and operate according to the correct instructions. Don't try disassembling any parts. If you need any help, please contact the sales agent.
  - b) If you want to change any parts, please first find out the parts number for the parts you want to change, then tell this number to your sales agent. You may get satisfied services from them.
  - c) The rated voltage is 220V~240V. Before actual using of this machine, please make sure the local power supply is in conformance with the rated voltage.
  - d) Before connecting the power supply, open the front cover and take off the transportation fixing screw that has a warning mark on it.
  - e) During operation, the front cover must not left opened and don't put your hands too close to the running needles.
  - f) Shut the power off before performing maintenance works or changing needles.
  - g) Keep clean of the binder's body and the sliding part. Don't put any kind of solvent on the binder.
  - h) Don't use any kind of lubricant on plastic locker and at its track.  
You can only use compressed air for the cleaning of it.

## PART 2

### Installation & Test Run

#### Installation

1. There are two kinds of installation styles showing in Fig.2. The default style when shipping is type A. For changing to type B, take out the 4 screws on the bottom board, then turn the bottom board for 180° and put on the 4 screws. When doing this, take care not turning the machine upside down.
2. Use 4 M8×60 screws to fix the binder's bottom board on specified table. The table should be steady.



(Fig.2)

- 1) Open the front cover and take off the transportation fixing screw that have a warning mark on it.

#### Warning:

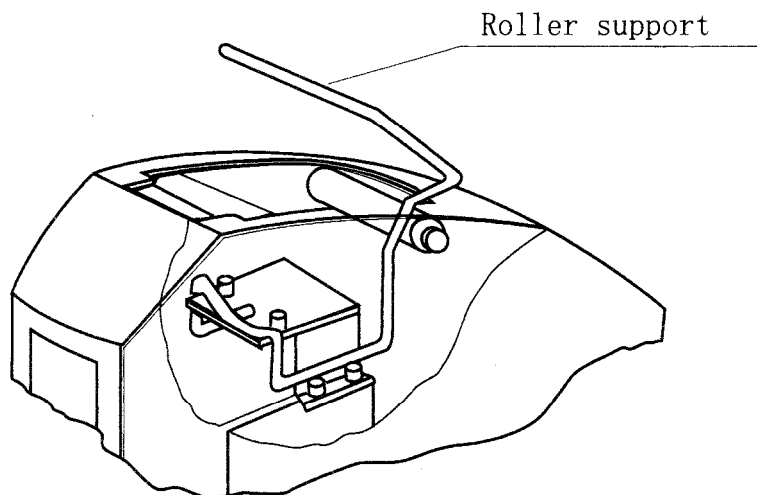
- \* Don't connect power in before this screw has been taken off.
  - \* Keep good care of this screw. You will need it to fix the machine for future transportation purpose.
- 2) Make sure the power button is at the OFF (0) position.
  - 3) Insert the plug of foot-operation switch into the foot-operation socket.
  - 4) Connect power. Switch the button to CONNECTION (-) position and the machine will start running.
  - 5) Inch operating the foot-operation switch and make the binder perform one binding action.

## PART 3

### Operation Guidance

1. Take following steps to install and adjust the plastic locker:

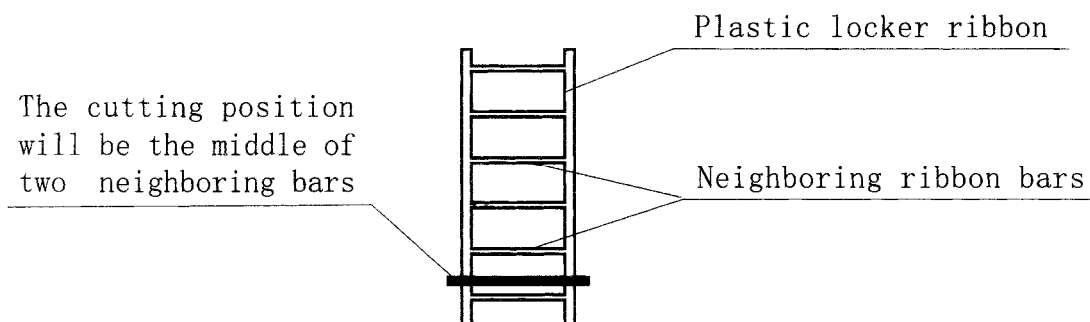
a. Install and adjust the roller according to Fig.3



(Fig.3)

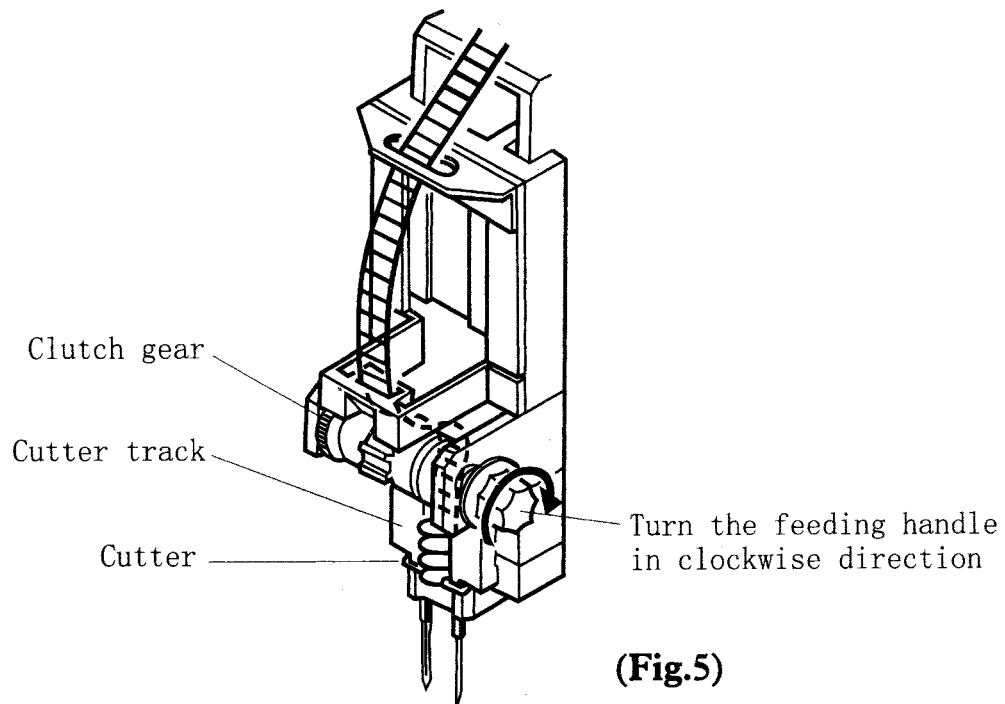
b. Put the roller of plastic locker on the roller support.

c. Cut the plastic locker ribbon at the middle position between two neighboring bars. When doing this, keep the cutting edge even and smooth. See Fig.4



(Fig.4)

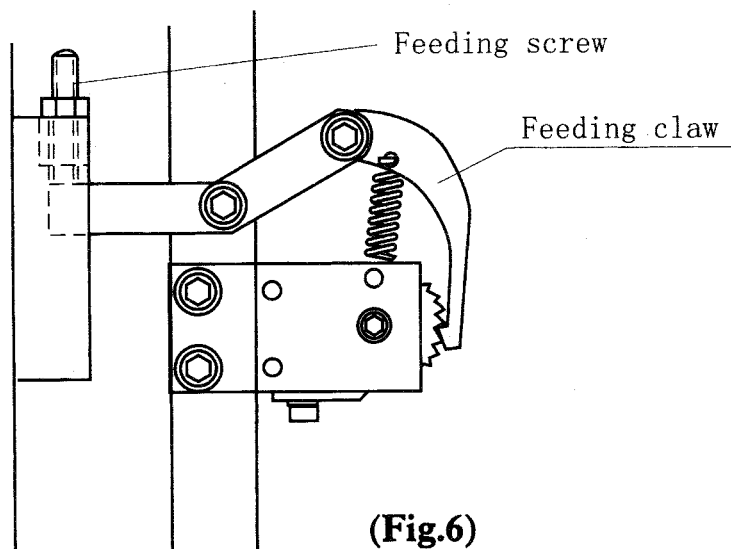
d. Pass the plastic locker ribbon through feeding support and the groove of feeding guiding bear, and pull it out from the back end of the feeding wheel. (See Fig.5) Turn the feeding handle in clockwise direction and make the plastic locker ribbon pass through the localization block of the separation bar and cutter, and finally into the needles.



**(Fig.5)**

- e. Turn the feeding handle and make the middle of two neighboring bars of plastic locker ribbon locate at the cutter's outlet.
  - f. Adjust the feeding screw and make only section of the plastic locker ribbon be fed in for one binding action.
2. How to adjust the feeding screw

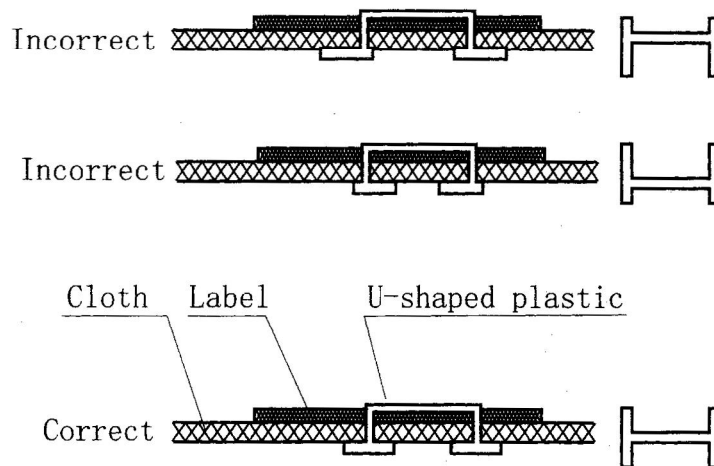
Usually it is not necessary to adjust the feeding screw since it has been adjusted before it is shipped to you. You can take the following steps to adjust the feeding screw if you need to do this during inspection. (See Fig.6)



**(Fig.6)**

- a. Test running for 25 times (binding for 25 times). If the first and last cut plastic lockers are both in correct shapes, then we can say the fixing screw is in the correct position.

- b. After test running according to above-mentioned method, if the last cut plastic locker is not at the middle of two neighboring bars of the locker ribbon, you should adjust the screw and make it finally meet the requirements in a.
3. Adjusting the cutting position of plastic locker:



**(Fig.7)**

As shown in Fig.7, observe the plastic locker bond on cloth. If it is in the incorrect position, then you will need to adjust the cutting position according to following steps:

- a. Taking reference of Fig.5, push the feeding handle to separate the clutch wheel, then rotate the feeding handle clockwise for a certain degrees.
- b. After the clutch wheel been adjusted to the right position, turn the handle clockwise and make the middle of plastic locker's two neighboring bars facing cutter's edge.
- c. Put the front cover on and start the machine. Check whether the plastic locker bond is in conformance with the correct shapes shown in Fig.7. If not, repeat the above steps until correct shape can be made.
4. Open display before start  
Open the front cover and turn the switch under the display box to ON position.

# **PART 4**

## **Maintenance**

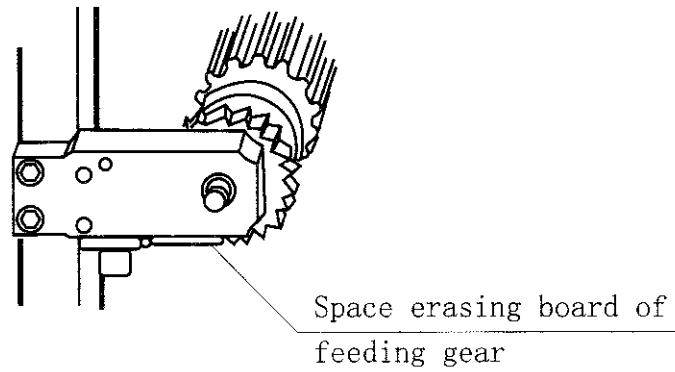
### **1. Daily Care**

- 1) Keep the locker track clean and with no garbage.
- 2) Keep the cleanness and brightness of the needle front cover, digital displayer and machine cover's surface.
- 3) Take care of any exceptions found during operation.
- 4) How to fix the fixing screws when transportation:

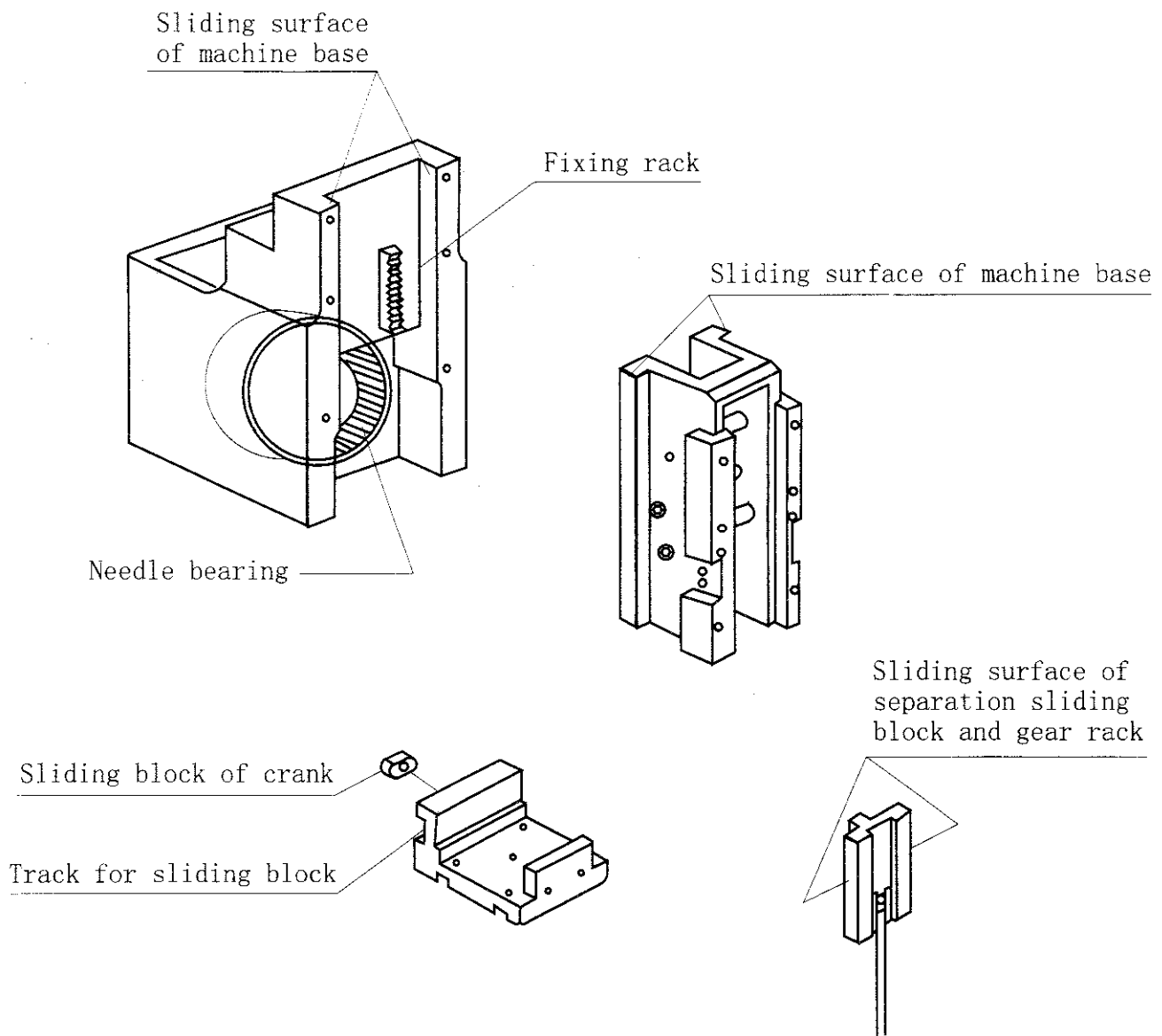
Start the binder and lower the binder head. Before one working cycle has been finished, open the front cover quickly and shut the power off. Raise the binder head manually until fixing screw can be put into the fixing hole. Screw tightly.

### **2. Lubrication**

- 1) After 6 months' use or digital displayer has taken 1 million times of record, check every parts shown from Fig.8 to Fig.15 and put in proper amount of lubricant.
- 2) Take care when assembling parts. (See page 8 and page 9):

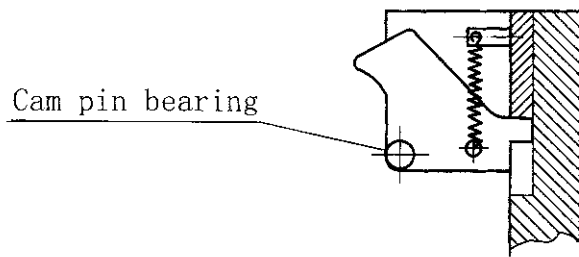


(Fig.8)

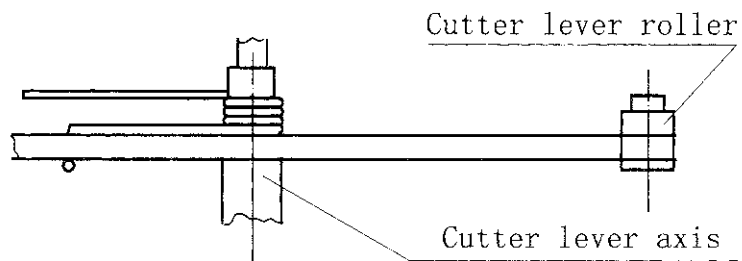


(Fig.9)

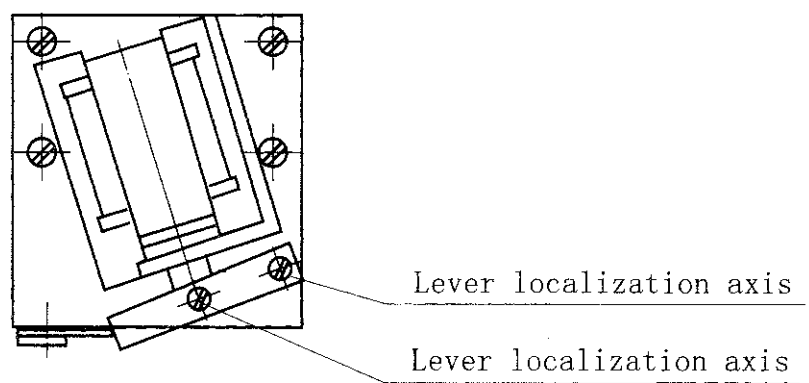




**(Fig.10)**



**(Fig.11)**

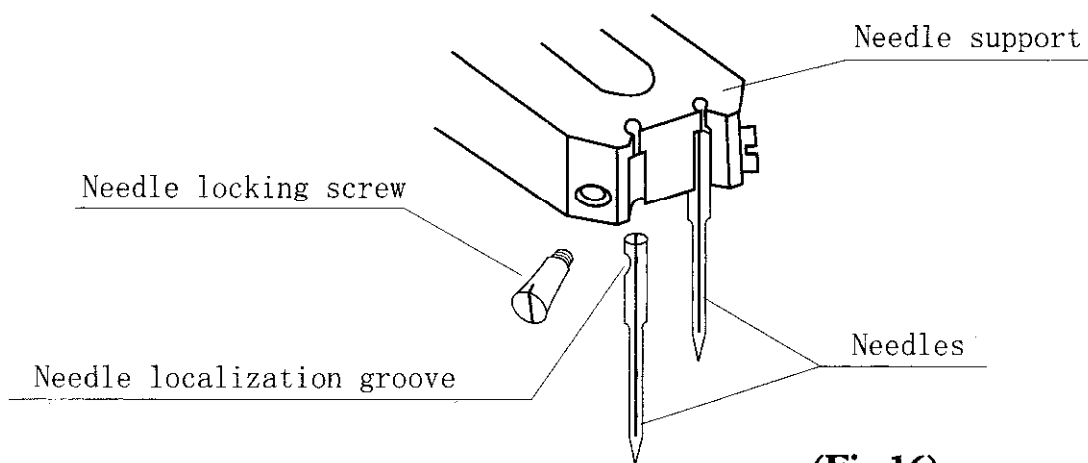


**(Fig.12)**

### 3. Changing of Parts

#### 1) Changing of Needle: See Fig.16

1. Switch off the power and open the front cover. Screw off the needle locking screw and pull off the needle you want to change.

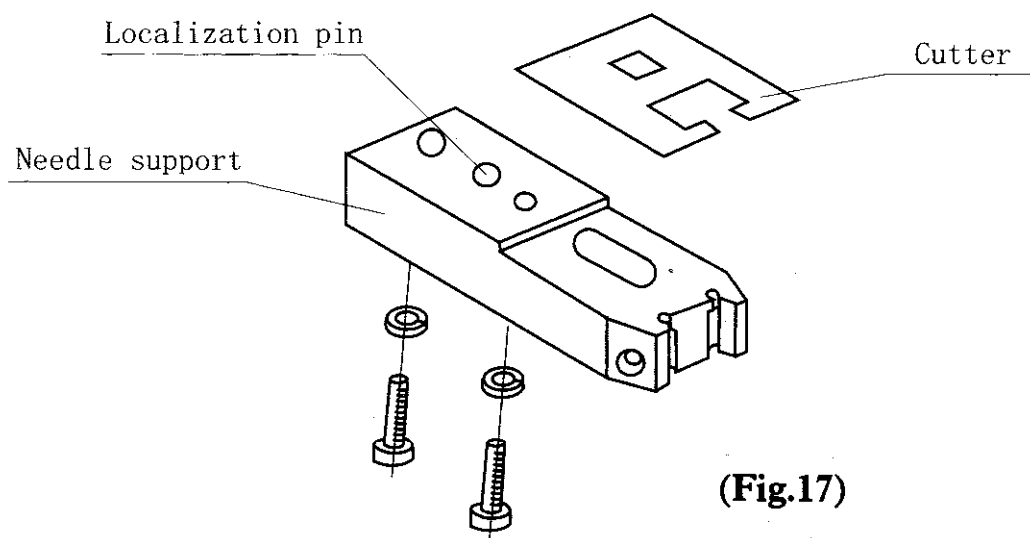


(Fig.16)

2. Make new needle's localization groove facing the needle locking screw and insert it into the needle support's hole. Screw on the locking screw tightly.

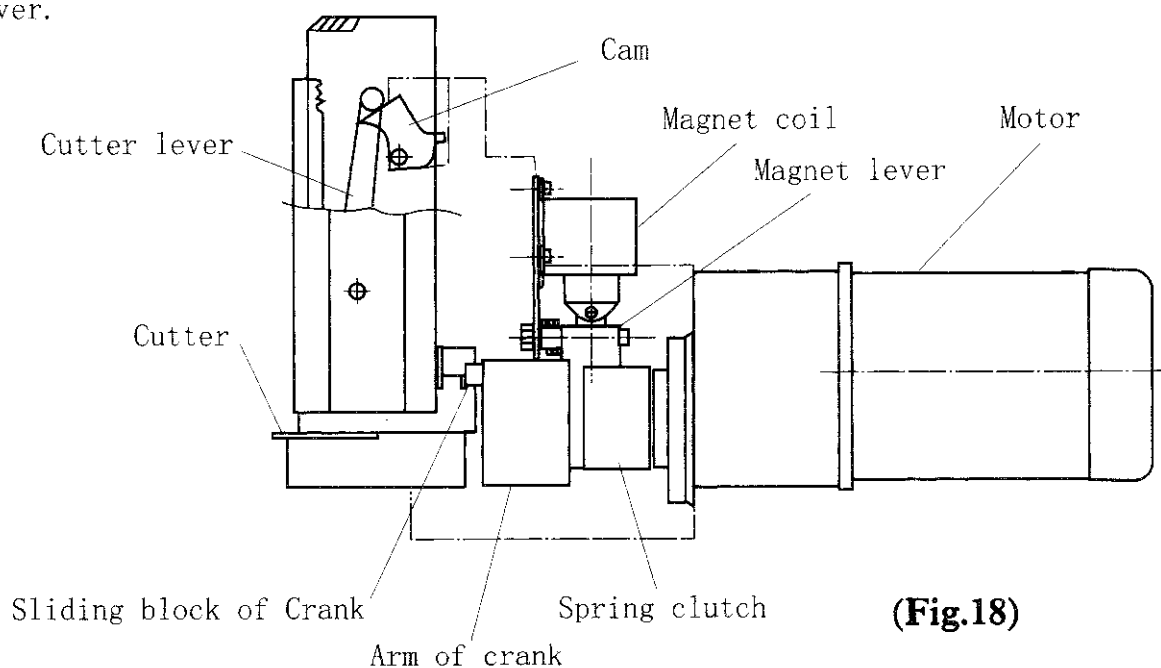
#### 2) Changing of cutter

1. Pull off binder's power plug and open the front cover. Take off bottom cover and needle. Screw off the 2 screws under needle support and take off the needle support then the needle you want to change. See Fig.17.



(Fig.17)

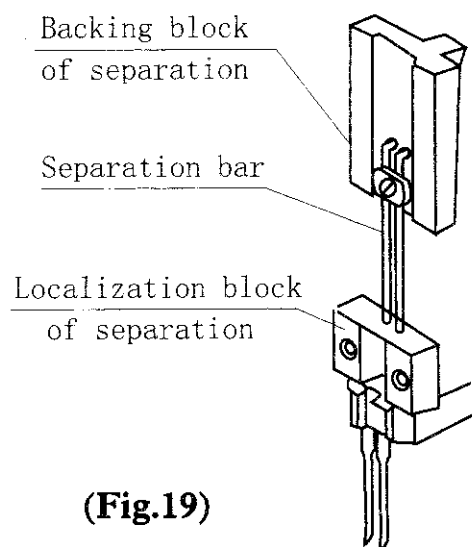
ake the cutter's blade face upwardly (i.e. the side with reverse corner downwardly). The square hole should fit to the lower edge part of the cutter lever and the localization pin on needle support fit to the pin hole under the cutter track. (See Fig.18) Screw on the 2 locking screws to fix the needle support. Pull the cutter lever from above the sliding base and check whether the cutter can move forward and backward freely by the cutter lever.



**(Fig.18)**

### 3) Changing the separation bar

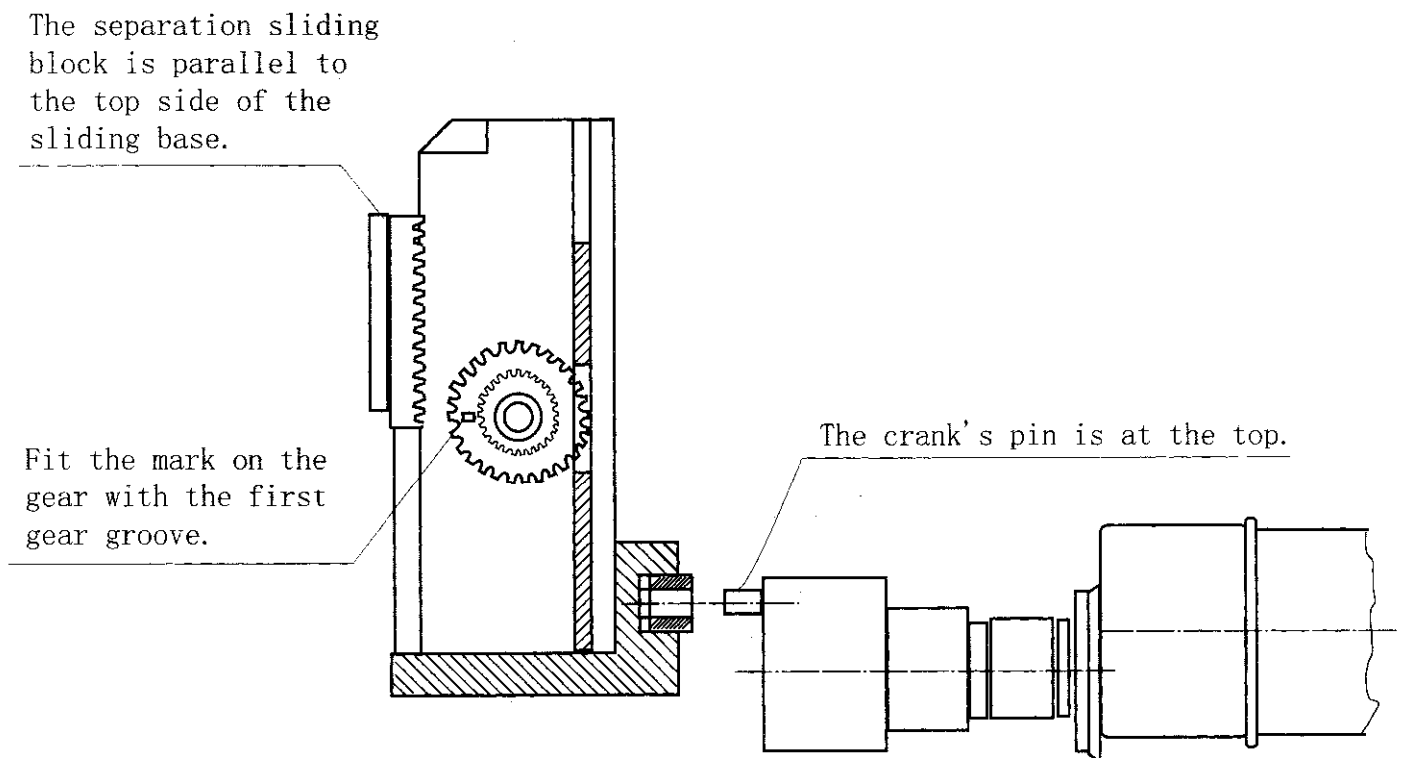
Release the backing block and rotate in for 90°. Take off the broken separation bar and insert the new one into the hole in the separation bar localization block. Then insert the other side into the separation sliding block and press it tightly using the backing block. (See Fig.19)



**(Fig.19)**

Take reference of Fig.20 for re-assembly the separation sliding block and sliding base.

- i. Face the mark on the separation gear to right front side and make it fit to the first gear groove under the separation sliding block.
- ii. Make the top of separation sliding block parallel with the upper side of the track of sliding base and the crank pin be at the highest position. Install right into the hole of the crank's sliding block. Fix it tightly by using the left and right press plate.



**(Fig.20)**

## PART 5

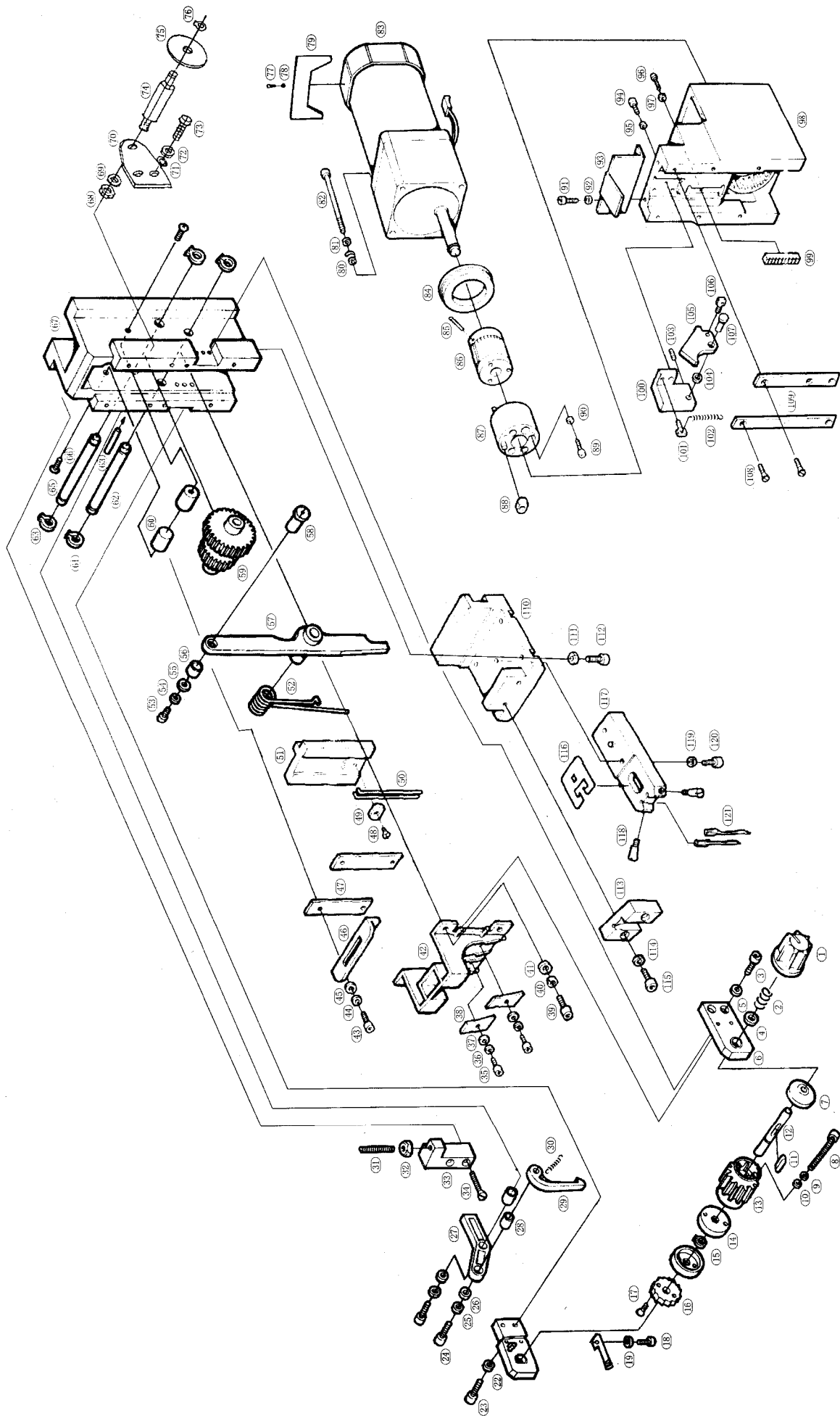
### Trouble-shooting

Trouble	Cause	Trouble-shooting
Motor runs normally, but the head hangs at the top and cannot move downwards.	Relay is broken.	Change relay.
	Magnet coil is broken.	Change magnet coil.
	Foot operation switch is broken.	Check or change the foot operation switch.
	Power connection trouble.	Check connections are properly made.
Binder head hangs at the top and motor does not run.	No power.	Check whether power is properly connected.
	Front cover is not properly shut.	Shut front cover properly.
	Power connection problem.	Check connections are properly made.
Binder head runs continuously and would not stop.	Relay or magnet coil is broken.	Check relay and magnet coil respectively. If there is any damage, replace with a new one.
Binder head hangs at lower part.	Clutch is broken.	Replace with a new clutch.
Binder head is stopped by on-making materials.	Clutch is broken.	Replace the clutch.
	Bent or broken needle.	Replace needle.
Bent separation bar.	Cutter being fixed too tightly.	Check the cutter and make it movable.
	The torsional spring of cutter lever is broken.	Change the torsional spring.

### Possible troubles with feeding plastic locker

Trouble	Cause	Trouble-shooting
Plastic locker stopped when feeding.	Bad cutting of plastic locker.	Release plastic locker and cut again.
	Plastic locker track is blocked.	Clean obstructions off the track.
Fail to cut plastic locker	Wrong installation of cutter.	Make sure the blade is facing upwards.
	Cutter blade is not sharp enough.	Change cutter.
	Cam spring of the cutter is broken.	Change spring.
Plastic locker is not cut right at the middle of neighboring bars.	Problems with feeding handle.	Adjust the feeding clutch wheel.
The plastic loker fed is more or less than normal size.	Maladjusted feeding screw	Adjust the feeding screw.

Breakdown drawings of transmission system.(1-121) Fig.21



Breakdown drawings of motor.(122-200) Fig.22

