

Morgana DigiBook 450 PUR Automatic Perfect Binding Machine

Instruction Manual



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DigiBook 450r2

Operators Manual (inch)



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rel. 02.00-B

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1 INTRODUCTION



THE READING OF THIS OPERATOR AND MAINTENANCE MANUAL IS FUNDAMENTAL FOR THE SAFETY OF THE USER AND FOR THE PROPER USE OF THE EQUIPMENT.

We thank you to have bought our product. This machine has been designed specifically for your job and your applications, and provides a high quality production and a wide range of functions.

This manual describes how to use the machine, starting from the configuration phase to the most important operations. This manual has been written in order to be easily understood also by user not trained about the use of this kind of machine. For the best use of the equipment, please read carefully this manual before to use the machine. After reading, we suggest saving the manual in a safety place and don't hesitate to read him when necessary.

1.1 CE CONFORMITY

DICHIARAZIONE DI CONFORMITÀ CE
CE CONFORMITY DECLARATION
DIRETTIVA CE PER MACCHINE 2006/42/CE,
DIRECTIVE FOR MACHINES 2006/42/CE,
E SEGUENTI DIRETTIVE EUROPEE (ALLEGATO IIA)
AND FOLLOWING EUROPEAN DIRECTIVES (ANNEX IIA)

- **COSTRUTTORE, MANUFACTURER: K.G.S.SRL** Via Donizetti 5 – 20090 Assago (Mi) Italy
- RESPONSABILE DELLA COSTRUZIONE DEL FASCICOLO TECNICO / **RESPONSIBLE FOR PREPARING THE TECHNICAL DOSSIER: RACCANELLO ROBERTO**

CON LA PRESENTE DICHIARIAMO CHE LA FABBRICAZIONE DEL / **WE HEREWITH DECLARE THAT THE MANUFACTURE OF:**

- MODELLO TIPO / **MODEL TYPE : PERFECTBINDER MASTERBOOK 450**
- MATRICOLA / **SERIAL : MB450-XXXX**
- ANNO DI COSTRUZIONE / **MANUFACTURED IN 2013**

CORRISPONDE ALLE SEGUENTI DISPOSIZIONI NELLA VERSIONE ATTUALMENTE VALIDA / **IS IN ACCORDANCE WITH THE FOLLOWING DIRECTIVES AS IT IS :**

- Direttiva CE per Macchine 2006/42/CE / **Directive 2006/42/CE**
- Direttiva EMC 2004/108/CE / **EMC Directive 2004/108/CE**
- Direttiva sulla Bassa tensione 2006/95/CE / **Low Voltage Directive 2006/95/CE**

NORME ARMONIZZATE APPLICATE , IN PARTICOLARE
HARMONIZED STARDARDS, IN DETAIL :

- EN 1010
- EN 60 204-1
- EN 61 000-6-2, EN 61 000-6-3, EN 61 000-6-4

Assago , (MI) Italy
___/___/2013

Dott. Marco Alfredo Tumaini
Amministratore unico

K.G.S. s.r.l. con socio unico
Via Donizetti 5 – 20090 Assago (Mi)
C.F. / P. IVA n. 07011970964 – R.E.A MI - 1929278 – Capitale Sociale € 10.000,00 i.v.


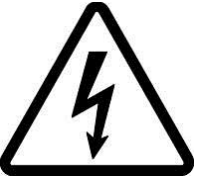





SAFETY


1.2 SAFETY SYMBOLS

In the manual some symbols are used to inform about dangerous situations for people and/or things

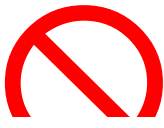


The following symbols mean dangerous situations for people and/or things

If you don't follow carefully the appropriate procedures, damages can occur to people and/or things, and in extreme situations also fatal accidents. Together with the symbols it is written also what to do.

| | |
|---|---|
|  | Attention – General danger! |
|  | Attention – Electrical voltage! Risk of electric shock. |
|  | Attention – Sharp blades! Risk of cut. |
|  | Attention – Hot surfaces! Risk of burn. |
|  | Attention – Risk of rolling parts! Risk of crushing. |
|  | Attention – Risk of chain on the go! Risk of crushing. |
|  | Attention – Risk of parts on the go. Risk of crushing and cutting |

| | |
|---|--|
|  | In case of not warning of the symbols damages, also great, can happen to the machine and to the accessories. |
|---|--|

1.3 SYMBOLS OF PROHIBITION AND OBLIGATORINESS

| | |
|---|---|
|  | This symbol means a prohibition. |
|  | This symbol means an imperative. |
|  | This symbol means that it is mandatory to read in this manual information regarding specific topics (for ex. related to the specifications of the electric and pneumatic connection). |

1.4 THE SAFETY DURING THE USE OF THE MACHINE



1.4.1 GENERAL

The manufacturer guarantees that the contents of this manual are in specification with the procedures required by the machine. The manufacturer therefore will be not responsible if the machine will be used in a different way from what indicated in this manual.

1.4.2 SAFETY WARNINGS


Before the use of the machine, please read carefully the manual.
Save the manual for further needs.

By apply different procedures, and not the specific procedures described in the manual, can produce operational problems.
Please, read carefully the following safety rules.

| | |
|---|---|
|  | <p>It is forbidden to use the machine when occurs one of the following situations:</p> <ul style="list-style-type: none">• in explosive environment;• in flammable atmosphere;• in excessive dust environments. |
|  | <p>Danger! Failure to comply with some or all the instructions listed in this manual could cause damage to the machine and / or personal injury. The manufacturer is not responsible for an arbitrary and improper use of the machine such as:</p> <p>Using the machine by untrained personnel; Use contrary to law; Incorrect installation; Defects in electrical power and / or pneumatic; Partial or total failure to comply with the instructions; Lack of maintenance and / or use of aftermarket parts; Changes or other actions not authorized by the Manufacturer;</p> |


1.5 SAFETY CLOTHING

Clothing to use during the cleaning and /or maintenance operations

| | |
|---|--|
|  | <p>Eye protection against any spray of PUR glue or high temperature cleaner</p> <p>Respiratory mask suitable for the glue you are using</p> <p>Protective gloves</p> |
|---|--|

Tight clothing, to avoid that they remain engaged with protruding parts.
Long hair must be covered or otherwise collected by using e. g. a protective screen.
Do not wear watches or jewels.


Safety clothing

| | |
|--|---|
|  | <p>The safety clothing IS NOT INCLUDED in the machine and must be procured by the machine user.</p> <p>The operator should wear clothing appropriate to the situation and specially during the following operations:</p> <ul style="list-style-type: none">-Maintenance-Replacing of the PUR glue-Cleaning of the PUR system <p>a) Eye protection against any spray of PUR glue or high temperature cleaner</p> <p>b) Respiratory mask suitable for the glue you are using</p> <p>c) Protective gloves for high temperature</p> |
|--|---|

1.6 INSTALLATION OF ELECTRICAL CABLES AND HOSES



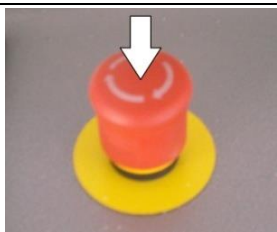
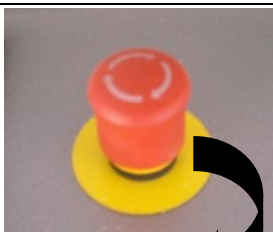
Cables and hoses must be put inside of special cable channels to avoid the people to stumble and get hurt.

1.7 SAFETY EQUIPMENTS IN THE PERFECT BINDER

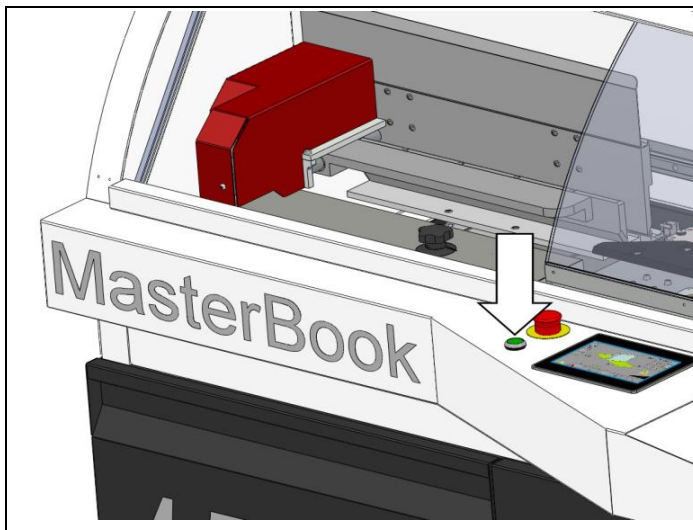
| | |
|---|---|
|  | <p>DANGER! It is forbidden to remove or disable the safety guards for the safety of persons, and to tamper and / or modify, even partially, safety devices installed on the machine. In case of alarm signals due to the intervention of the safety, the operator must request the immediate intervention of technical people trained on the maintenance. The manufacturer is not responsible of any damage to persons or animals caused by tampering with the guards.</p> |
|---|---|

1.7.1 EMERGENCY BUTTON

It is located on the front, easily accessible from the operator's position.

| | |
|---|---|
|  | <p>In the diagrams the emergency button is identified SB20.01</p>  |
| <p>Activation state of emergency: the push-button must be pressed</p> | <p>OFF state emergency stop: the button must be turned clockwise"</p> |
|  |  |

1.7.2 GREEN BUTTON FOR START CYCLE



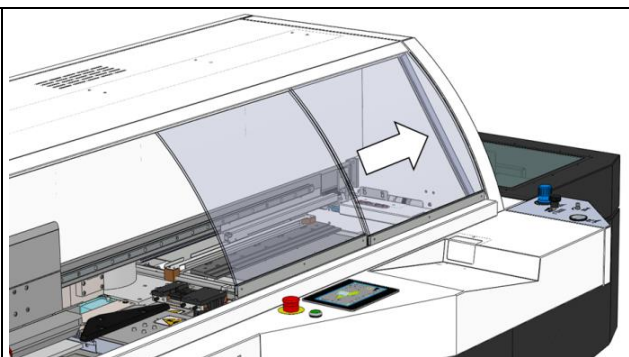
The green button accomplishes the command to start the cycle; that means that the cover feeder (if enabled) draws the cover and lay it down on the nipping station, the clamp closes and moves rightwards. The milling station (if enabled) will make the cut, the glue will be applied and the nipping station (if enabled) will apply the cover on the book. The release will automatically lay down the book on the exit belt. All this if I have put the book in the clamp.

1.7.3 OPTICAL BARRIERS AND SAFETY PROTECTIONS

There are two safety optical barriers at the end of the binder.

In case of occupation of the work place during the production cycle, the machine stops instantly in a state of emergency, preventing and avoiding of shocking or crushing objects or hands or arms of the operator

Detail: safety barrier

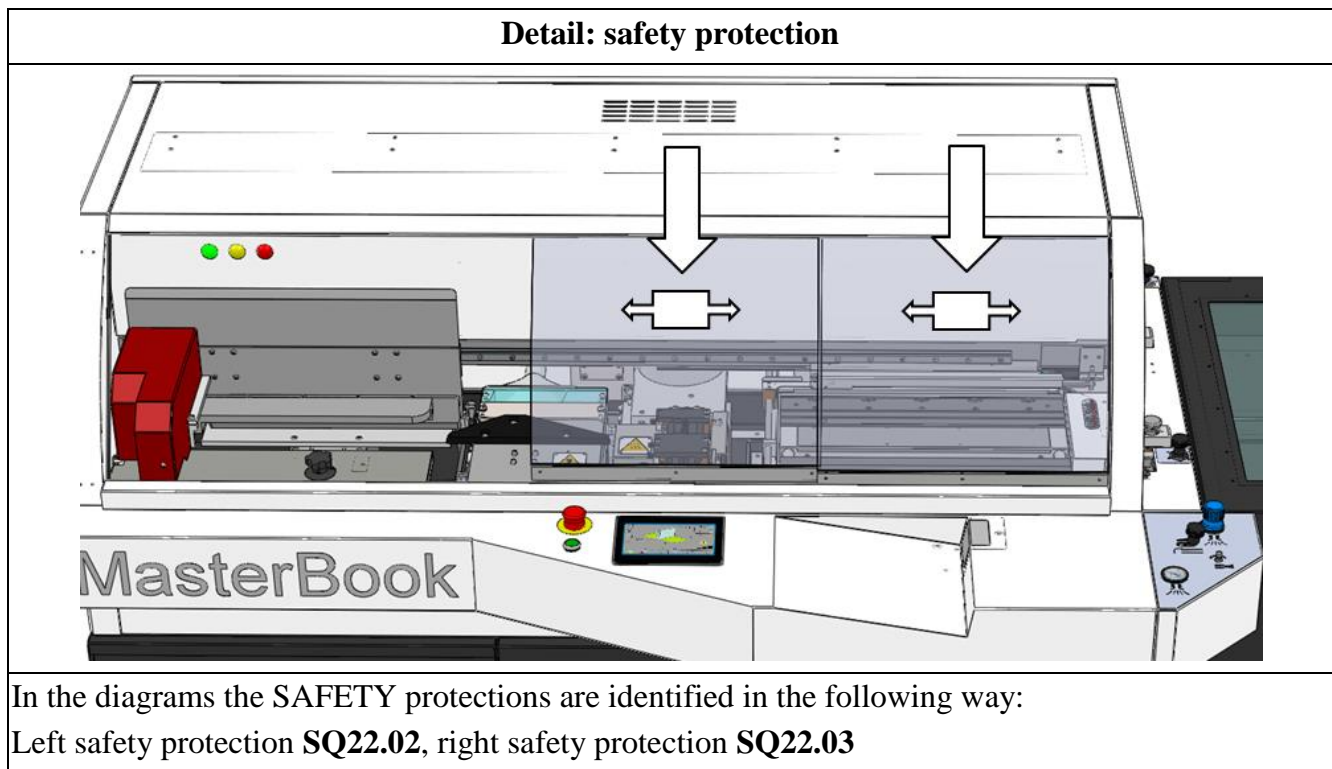


In the diagrams the SAFETY curtains are identified in the following way:

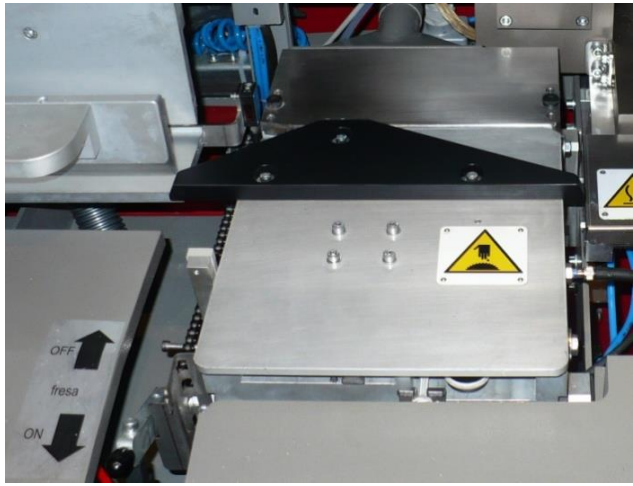
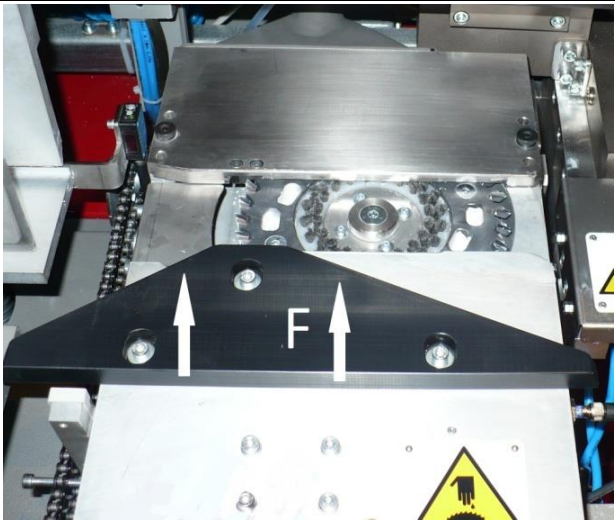
Left safety barrier **E21.03**, right safety barrier **E21.02**

There are two sliding barriers on the right end of the binder.

In case of opening, they block the nipping station operation avoiding and preventing shocks and crushing for hands and arms of the operator.

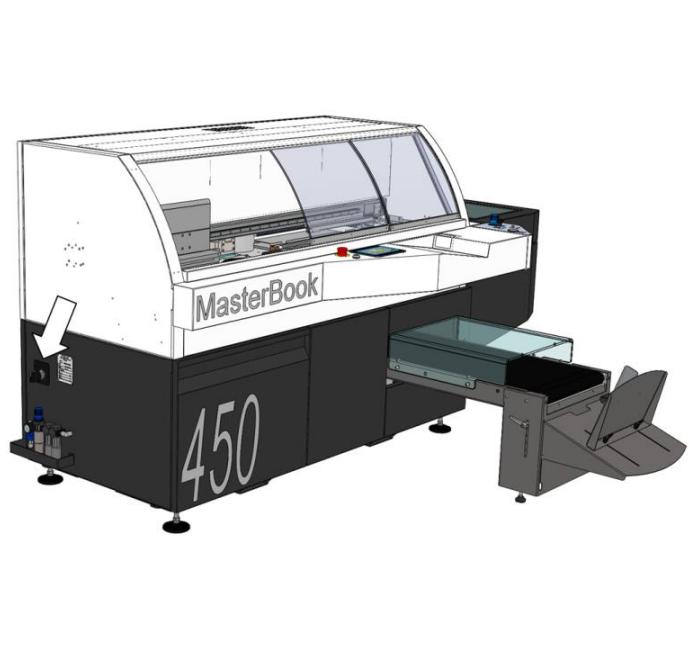




1.7.4 PROTECTIVE PLATE FOR MILLING STATION

| | |
|--|---|
| <p>The plate consists of a mobile plate that, except when the book block is moving, covers the mill in all operating conditions, even at a standstill.</p> | <p>An elastic cord with a long excursion exerts constantly on the plate (F) a force (see arrows) that covers the mill disc. A sensor monitors and stops the cutter if the guard is closed, the motor of the cutter is also equipped with a brake.</p> |
|  |  |

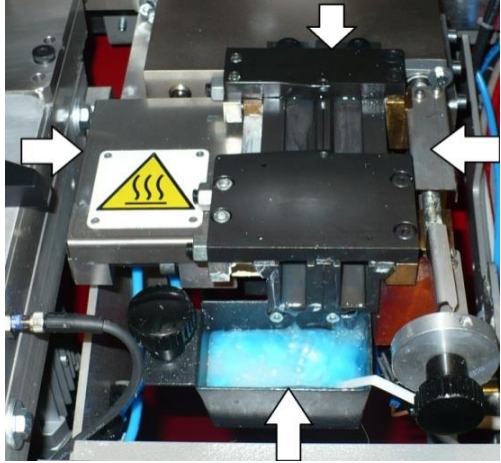



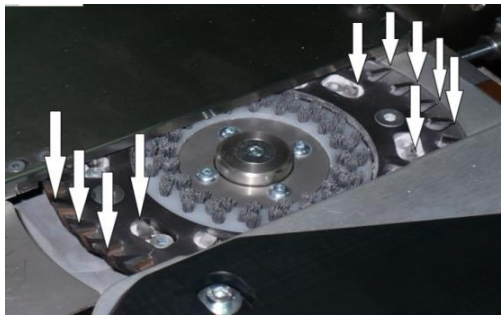

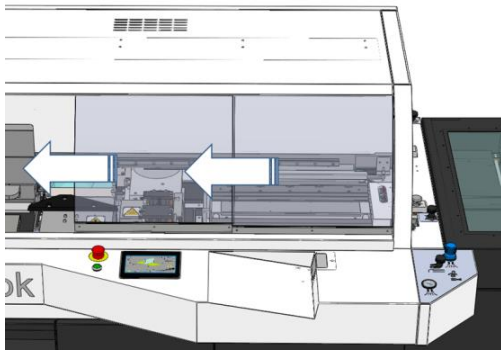

1.7.5 MAIN SWITCH

It is located on the left side of the machine

| | | |
|---|--|---|
|  | <p>Position OFF</p> <p>The switch is open. The machine is off.</p> |  |
| | <p>Position ON</p> <p>The switch is closed. The machine is on.</p> |  |

1.8 RESIDUAL RISKS

These are risks that cannot be completely eliminated by either protective devices or by the machine design.

| | | |
|---|--|--|
|  |  | <p>Area of the glue head.</p> <p>Attention – Hot surfaces! Risk of burn. Use protective gloves.</p> |
|  |  | <p>Area of glue loading.</p> <p>Attention – Hot surfaces! Risk of burn. Use protective gloves</p> |
|  |  | <p>Area of the mill.</p> <p>The disc contains several types of milling cutters. Use protective gloves, in case of removing the Notching Roughening or the brush.</p> |
|  |  | <p>Never put your hands in the machine inside the nipping station without opening the front protections of the machine.</p> |



1.9 PURPOSE

The machine is used to bind books using the following materials:

- a) Signatures, or sheet of paper (printed or not) for the block book
- b) Cardboard as cover of the book

within the limits specified in the data sheet, included in this manual.

1.9.1 USES NOT PROVIDED, USES PROHIBITED

| | | |
|--|---|--|
|  | <p>Any other use such as,</p> <ul style="list-style-type: none">- Milling / Roughening of book spines already binder (adhesive binder, stitching book, sewing book, etc.)- Use of materials other than those specified in a) and b)- Operations beyond the technical specifications are not to be regarded as intended use. |  |
|--|---|--|

The user has the total responsibility of the damages to people or things due to an improper use outside of their intended use.

2 TECHNICAL SHEET DigiBook 450

2.1 MECHANICAL SPECIFICATIONS

Machine features:

| | |
|---|---|
| Cycle/Hour | 450 mechanical cycles |
| Spine length | 39.370 – 177.17in |
| Workable height of the book | 47.244 – 125.98in |
| Max. Cover size | 275.59 x 177.17in/94.488 x 43.307in |
| Workable thickness of the book | from 0.78740 to 19.685in |
| Max. Cover Weight min./Max. | from 0.017lb to 0.057lb |
| Control Screen | |
| Touch - Screen | Yes |
| Copy Counter | Yes |
| Memory of the jobs | Yes |
| Diagnostic and Check | Yes |
| Setting size, temperature control | Yes |
| Speed | Yes |
| Book Loading | |
| Adjustment of the clamp | Automatic, according to parameters introduced by the user |
| Clamp opening | Automatic, electrically driven |
| Clamp closing | Adjustable air |
| Spine preparation | |
| Milling disks | Ø 62.992in |
| Notching | (4 optional) |
| Roughening for spine processing | 8 |
| Brush for spine processing and cleaning | 1 |
| Excludable mill | Mechanical (with position control) |
| Milling thickness | Variable from 0 to 0.090551in |
| Chips aspirator | Enclosed in the machine |
| Glue application system | |
| Tank PUR/Hot-Melt glue | 6.6lb sealed |
| Extrusion system of PUR/Hot-melt | Integrated and sealed |
| Extrusion head adjustment | Automatic |
| Side adjustment (used for signatures or stitching book) | Mechanical |
| Glue Stop | Adjustable by Touch-Screen |
| Cleaning / sealing | Yes |

Nipping station

| | |
|---------------------------|---|
| Nipping station | Pneumatic |
| Adjustment | Force / pressure, nipping time |
| Mechanical Adjustment | Automatic/mechanical height adjustment |
| Mechanical Adjustment | automatic front and rear guide for the cover on the nipping station according to the parameters set on Touch-Screen |
| Positioning for the cover | automatic |

Cover Feeder

| | |
|-------------------------------------|-----------------------|
| Positioning for the plane for cover | automatic |
| Adjustment for cover positioning | automatic/manual |
| Cover draw | automatic |
| Scoring system | (optional with rolls) |
| Check for presence of cover | yes |
| Check for cover misfire | yes |
| Cover perforation system | (optional with rolls) |

Dimensions, weight

| | |
|--------|----------|
| Length | 101.77in |
| Width | 82.283in |
| Height | 53.937in |
| Weight | 1874lb |

Electrical absorption

| | |
|----------------------------|--------------------------------------|
| Installed Power | 8,5 Kw |
| Absorbed Power | 6 Kw |
| Power distribution network | 400 V \pm 5%, 50 Hz, 3 ph + N + PE |

2.1.1 ELECTRICAL SPECIFICATION

Electrical power 400 V ±5%, 50 Hz, 3 ph + N + PE

| | |
|-------------------------------------|--|
| Power of the machine | Protection fuses on the power network are duties of the customer |
| Distribution cabinet, customer side | 16 A Differential protection class A 300mA |

2.1.2 PNEUMATICS SPECIFICATION

Supply pressure

The pneumatic system of the user must ensure, in the inlet connection of the compressed air in the perfect binder, the following values:

Min.: 101.5psi (7 bar)

Must guarantee an air consumption of 12.3 ft³/min (350 l/min)

air quality: **Class 3**

Pneumatic Characteristics of the machine

Compressed air consumption

7.06 ft/min (220 l/min)

Calibration of input gauge

87 psi (6 bar)

Min. working pressure

79.7 psi. (5.5 bar) If the pressure value falls below this value the machine enter in an “alarm” condition

Diameter of air inlet

0.39in (10mm)

The 0.39in diameter hose for the connection to the compressor is not provided together with the machine.

It is suggested the use of a compressor equipped with the automatic condensate drain, to avoid verify weekly if there is some water inside the compressor.

It is suggested to use a silenced compressor, if the compressor is located inside the working plant.




Air quality provided to the Perfect Binder
CLASS 3, DIN ISO 8573-1

Durst: 5 micron - 5 mg/m3

Water: -20°C (-4F) - 0,88 g/m3

Oil: 1 mg/m3

| | |
|---|---|
|  | The compressed air system upstream of the machine must be equipped with a dryer. |
| | Periodically check the quality of the compressed air supplied to the machine and the operating values . |

AIR QUALITY PROVIDED TO THE PERFECT BINDER

To make work the pneumatic devices in an affordable, efficient and safe way, the compressed air supplied to the pneumatic device must have the following quality features:

Pressure, Quantity, Water content, Solids content, Oil content.

DIN ISO 8573-1 – AIR QUALITY CLASS

The manufacturers of pneumatic components refer to the quality of compressed air to use on their products, referring to the table below.

| Classe | Corpi solidi | | Contenuto d'acqua | Contenuto d'olio |
|--------|--|---|-------------------------------|--|
| | Max. dimensioni delle particelle [µm] | Max. densità delle particelle [mg/m ³] | Max. punto di rugiada [°C] | Max. concentrazione olio [mg/m ³] |
| 1 | 0,1 | 0,1 | -70 | 0,01 |
| 2 | 1 | 1 | -40 | 0,1 |
| 3 | 5 | 5 | -20 | 1 |
| 4 | 15 | 8 | 3 | 5 |
| 5 | 40 | 10 | 7 | 25 |
| 6 | - | - | 10 | - |
| 7 | - | - | non specificato | - |

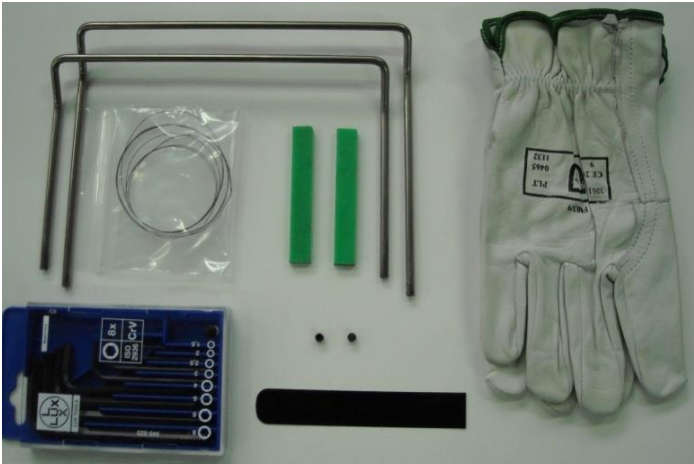
The compressed air used in the industry contains water, oil, dust and other impurities. The interaction of these elements produces an aggressive mixture that can damage the compressed air devices and also the PUR glue contained in the PUR tank, the results will be a low quality production and increased maintenance costs.

3 STANDARD ACCESSORIES

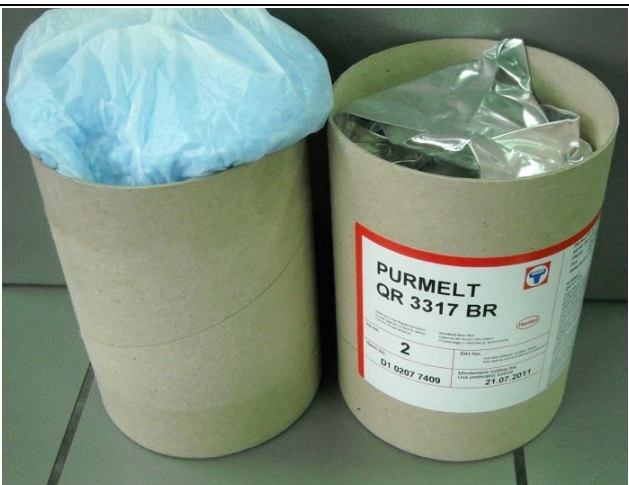
The standard composition includes:

- **Cleaning Kit**
- **Start- up Kit**



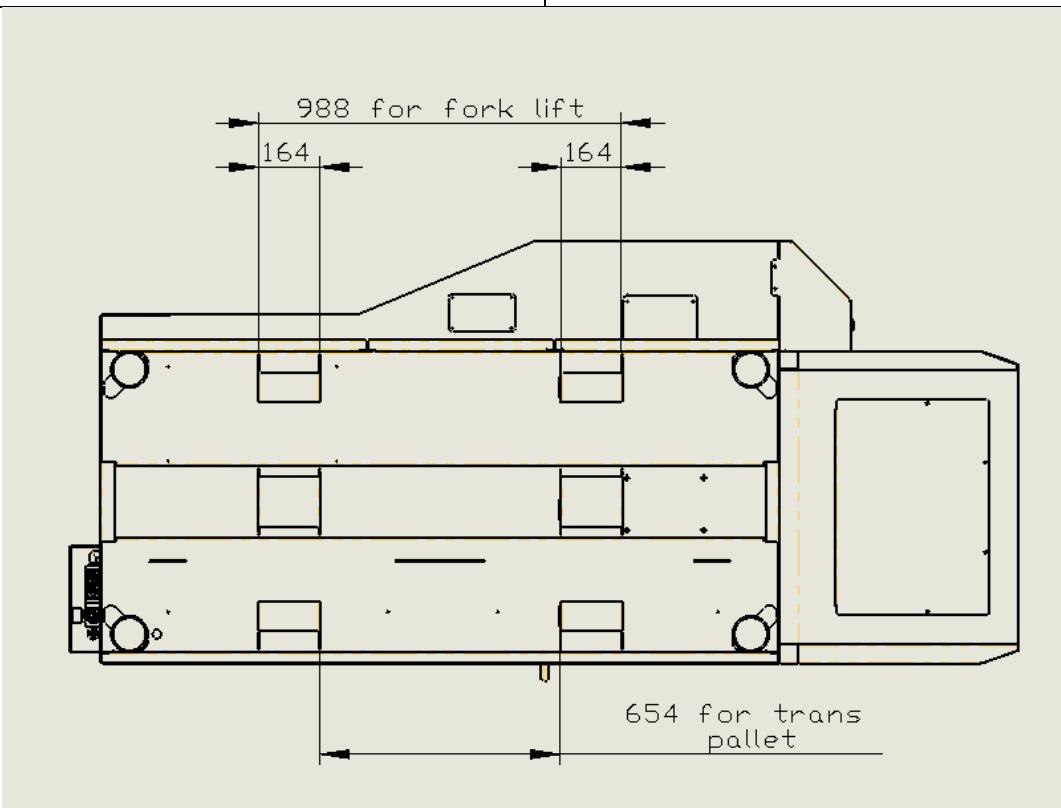
CLEANING KIT



| | |
|---|--|
| <p>Polizene green spatula (to remove excess glue or cleaner)</p> <p>Steel Wire Ø0.015748in (for cleaning the channels of leakage of the lateral glue)</p> <p>Lamella thickness of .015748in (for cleaning the slit of leakage of the spine glue)</p> <p>Spare Headless screws for the closure of the ducts</p> <p>Protective gloves</p> <p>Set of allen keys</p> <p>Small arches for supporting the book block in the clamp</p> |  |
|---|--|

START-UP KIT

| | |
|--|---|
| <p>One pack of 6.6lbs (2 kg) of PUR Glue Henkel</p> <p>One pack of 3.3lbs (2kg) of beans Cleaner-Blue Henkel</p> |  |
|--|---|

4 TRANSPORTATION

| | |
|--|---|
|  | <p>The binder must be moved with a forklift. It can be forked frontally or from the back. On the bottom of the frame, the binder is provided with channels for insertion of the forks. The machine can be moved only after removal of the exit belt.</p> |
|  | <p>For final positioning or small transfers you can use a trans pallet. The machine can be moved only after removal of the exit belt.</p> |
|  | |
| <p>The image shows the location and size of the channels for the brackets for the trans-pallet and the forklift.</p> | |

| | |
|---|---|
|  | <p>DANGER! For no reason the staff is authorized to pass under a suspended load during transport or in the proximity of. The producer is not responsible for what happens during this operation, this operation must be carried out by qualified and authorized personnel, with the necessary individual safety protections (clothes, shoes, gloves, helmet, and glasses).</p> |
|  | <p>Attention! <i>The machine is balanced.</i> In any case keep the forks low. In case of unbalance use weights. It is forbidden to hold by the hands the projecting parts. The machine and its parts must be protected from the weather outside. In particular, water, dust and moisture can oxidize certain elements of the machine, damaging them irreversibly. Follow the usual precautions to avoid falls and bumps.</p> |

IMPORTANT

- a) We do not provide tools for docking and lifting.
- b) The disposal of packaging materials will be provided by the recipient and must be conducted in accordance with the local regulations.
- c) Remove dust and dirt accumulated during the transportation.

5 STORAGE

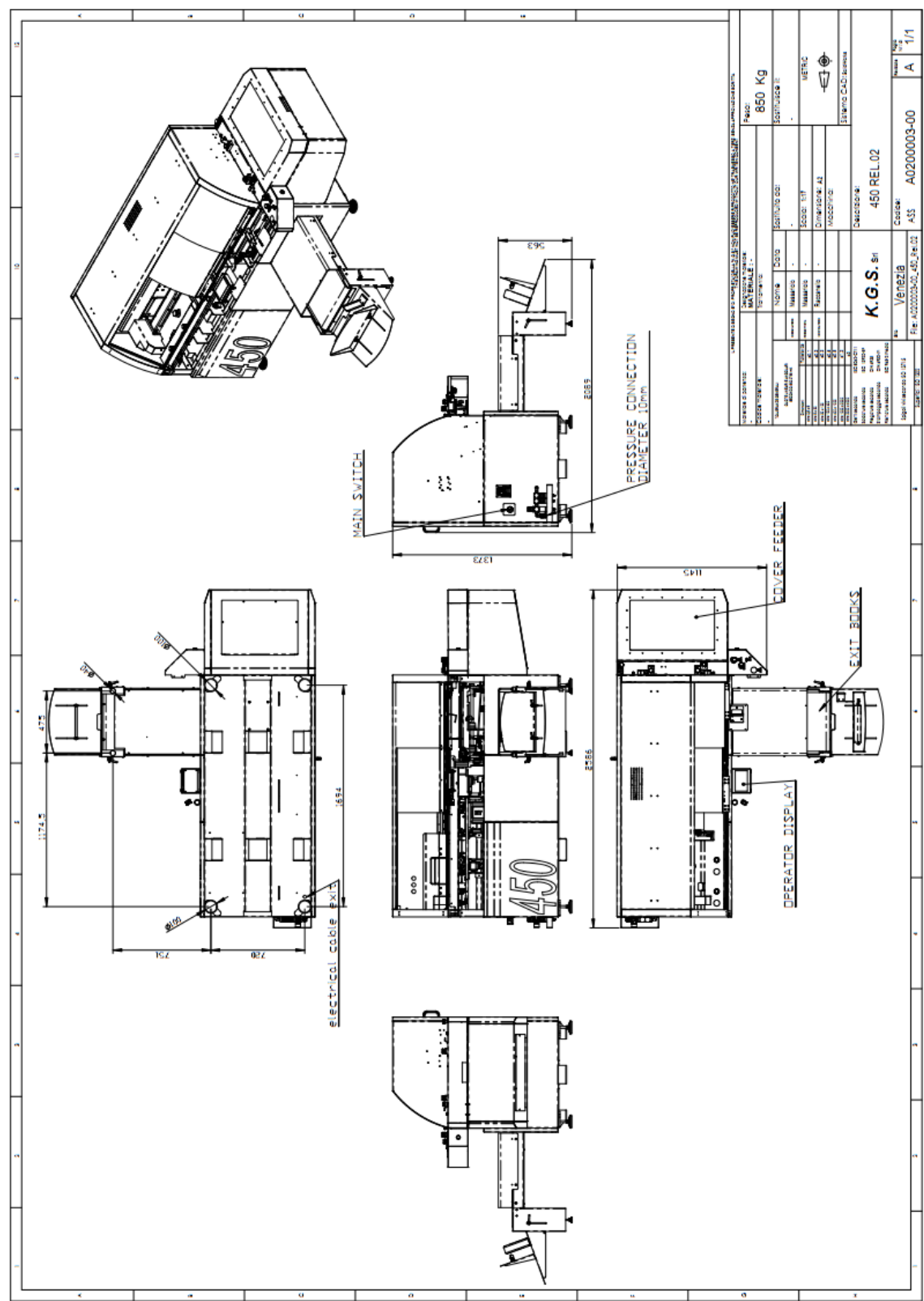
The information contained in this section must be observed in case of temporary storage of the machine that may occur in the following situations:

- Installation of the machine not immediately after its delivery.
- Uninstalling the machine.
- Storage awaiting a new location.

The machine must be stored and transported under conditions of SAFETY as shown in the table below.

| <i>Conditions of transportation and storage</i> | |
|--|---|
| Temperature average | 23/+131°F |
| Humidity average | 30/90% |
| Lighting | Adequate natural and / or artificial |
| Weather | Adequate weather protection |
| Space required | Adequate to allow the operations of lifting and carrying in SAFETY. |
| Horizontal bolster | Horizontal bolster must have a capacity in excess of the total mass of the machine. |
| In the case of removal or unused for long periods (over 30 days), it is necessary to drain the glue system and to put inside the protection cleaner. | The damage caused by this failure will void the warranty of the glue device. |
| During periods of downtime you should not open the tank containing the glue; otherwise it accelerates the deterioration creating serious permanent damage to the glue device. | The damage caused by this failure will void the warranty of the glue device. |
| Protect with anti-corrosive products the parts subject to wear and work plans. Ref. to the section “maintenance”. | |
| Do not climb or place any objects on top of the machine | |

6 LAY-OUT

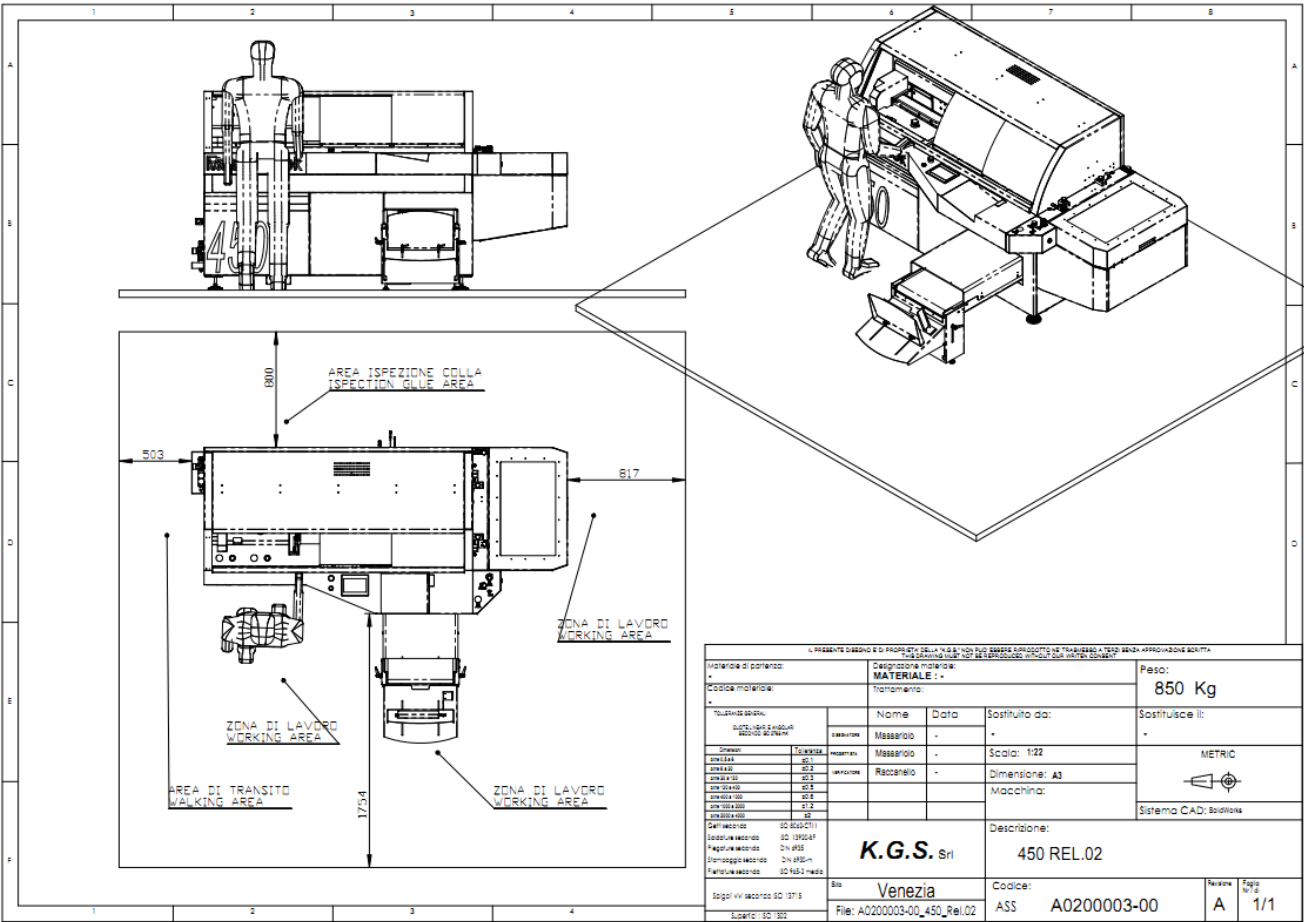


7 POSITIONING AND WORKSPACES

Positioning:

The Perfect Binder must be positioned so as to have a clear space around of at least 31in, and around the work area at least 59.055in.

The room where the machine is installed must be properly ventilated with air change as required by law.



Aree di lavoro

| | |
|----------------------------|---|
| Glue Inspection Area | Glue loading area. The operator accesses to this area to load the glue on the machine. Access area for service, to reach the electrical and pneumatic panel. |
| Transit Area | Transit area from workplace to glue loading area. |
| Work Area for the Operator | Working area for the operator for normal use of the machine. |

8 INSTALLATION

8.1 TECHNICAL STAFF FOR THE INSTALLATION

The machine must be installed by people specifically trained and authorized by K.G.S. .

8.2 PHYSICAL CHARACTERISTICS OF THE AREA OF PLACEMENT

In addition to the overall dimensions of the machine given in the previous chapter, you must also meet the following conditions:

Near the area of placement of the machine should be arranged the sources of electric power and pneumatic following what is written in this manual.

Provide sufficient space for normal use, maintenance of machinery, for any command and for additional equipments to connect. Refer to the draft in the chapter of the positioning.

The chosen site should not be close to deposits of flammable materials, or to operational sites that may create flammable or explosive atmospheres.

For the installation you must choose an operational area depending on the size of the machine parts and lifting equipment selected, pay attention to the presence of any obstacles on the road (equipment's, walls, etc.).

8.3 BOLSTER

The machine requires no special foundations. It must be ensured the availability of an industrial floor.

The producer has no responsibility about construction of foundations (resistance calculation, thick reinforced concrete, etc.), which are under responsibility of the customer or company performing the design and construction of the foundations themselves.

The Perfect Binder lays on 4 feet (2 with 3.9in diameter and 2 with 1.6in diameter).

8.4 WEATHER PROTECTION

The machine must be placed indoor, protected from direct contact with atmospheric agents.

8.5 LIGHT

To use and maintain in a safety way the machine a good light is needed. The room lighting should have a value that should allow normal operations without causing risks due to the shadows.

8.6 ENVIRONMENTAL CONDITIONS

The values of temperature and humidity should be within the values in the table below.



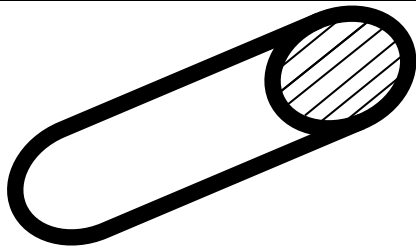
In case of use of the system in corrosive environments it is important to intervene in the maintenance of the machine with adequate time to avoid excessive wear of components.

| | MIN | MAX |
|-------------------|------|-------|
| Room temperature | 41°F | 104°F |
| Relative humidity | 20% | 80% |

8.7 ELECTRICAL CONNECTION


Electrical cable

The end of the cable is prepared according to the destination of the binder.

| | | |
|--|---|---|
|  |  | a) With the European standard plug with protective earth (PE) mounted on a 3 meters length cable |
|  | | b) Cable length of 3 meters with sectioned end, with the earth conductor (PE) It is the responsibility of the user to adjust the connection cable in accordance with the applicable legislation. |

8.7.1 GROUND CONNECTION

The Perfect Binder is equipped with an earth conductor (PE).

| | |
|---|--|
|  | During the installation the customer must realize the ground connection in accordance with the applicable legislation. |
|---|--|

9 QUALIFICATION OF THE OPERATOR



DANGER! The operator must be trained about the operations to perform during the occurrence of possible faults, malfunctions or conditions of danger to themselves or others, and anyway he must perform the following procedures:

Stop the machine quickly by pressing the emergency button (red button installed aboard of the machine itself);

Do not carry out operations that go beyond the specific knowledge and techniques;

Immediately inform their superior head, avoiding taking personal initiatives.

It is assumed that the operating and maintenance personnel possess the following minimum requirements:

- Culture in general and specific enough, each to his ability, to read and understand the contents of the manual including the correct interpretation of drawings and diagrams, pneumatic and hydraulic;
- Ability to understand correctly the symbols and video messages;
- Overall knowledge of the machine and the plant in which it is installed;
- Specific experience in the applied technology;
- Knowledge on what to do in an emergency, the availability of personal protection equipment and how to use them.

10 POWER ON

- 1) Be sure that the machine is correctly fed by air and electrically..
- 2) Turn on the machine turning the general switch.
- 3) Open the valve on the premelter
- 4) Close the rear inspection panel.

On display you will see:

- machine in emergency
- machine with cleaner
- machine not in temperature

The red light is on

- 5) Press once the green key,

green is blinking

orange is on

red is blinking






on display :









machine with cleaner

low temperature

- 6) Exit from the alarms page using the arrow, in case the machine is equipped with the table to measure thickness, you must press “OK” to set to zero the table.
- 7) When the temperature icon becomes green, press the green key. The machine sets to zero the axes.
- 8) Press the key “glue cleaner” to load the glue.
- 9) Set the values for the book and the cover you want to realize and press the green button.
The orange light is on, the green one is blinking, the machine will position the axes.
- 10) Put the cover in the cover feeder, fix the lateral and the rear positioning devices. Close the safety cover.
- 11) Put the book in the clamp and press the green button. The machine will produce the book and it will release it on the plane for collection at the end of the release belt.



10.1 FUNDAMENTALS

| | | |
|---|--|--|
|  | Pay Attention during the glue loading because of the high temperature, as indicated by the label, and use protective systems such as gloves. | |
|  | When you operate with PUR glue or with glue that is harmful to health, you have to adopt all the safety systems to handle these kind of substances, especially when you open the glue tank or when you replace the glue or you do the cleaning procedure for the nozzle and the premelter. | |
|  | The tank has to be added with the same type and model of glue. You can use a different kind of glue only when the system is completely empty and cleaned by using the Blue-Cleaner. | Drain as much as possible the glue that you want to replace. Enter in the tank a quantity of about 500g of Blue-Cleaner and make it protrude from the main slot and the channel of the glue; if at the end of this cleaning cycle you are not sure that from the valve 100% Blue-Cleaner exits, repeat the operation. |
|  | Never open the tanks when they are cold. | Possibility to break the seal gasket. In addition to that the air humidity will enter into the tank and will be trapped causing premature ageing of the glue (curing) with likely obstructions and need of maintenance. |
|  | The machine can't stay with the glue tank opened more than 10 minutes if there is PUR glue inside. | The glue in contact with moist air modifies her composition, <u>damaging the machine.</u> |

| | | |
|---|--|---|
|  | The machine can't stay with the glue system empty for more than 10 minutes | The PUR glue dries permanently; in this case you risk permanent damage to the glue system. If you don't have a glue cartridge available, put in the tank at least 500 grams of Blue and wait to be melted before to switch off the machine. |
|  | The machine cannot be without air compressed when the glue station is still hot. | Without air compressed inside the machine, the valve that handles the glue spilling in the head could open damaging itself. |
|  | Clean the nozzle of the glue station and of the tank as described in the following chapters. | <u>Any failure to comply with these procedures will make void the guarantee of the machine.</u> |
|  | On premelter and on glue nozzle use the temperatures suggested by glue producer. | |
|  | Avoid opening the lid frequently, the moisture in the air damages the features and durability of the glue. | |
|  | The depletion of the glue is found in two ways: the lack of glue on the book; ejection at the glue extrusion zone of air and glue bubbles. | |
|  | When you finish the glue and insert a new cartridge you have to wait about 20 min before the new glue melts. | |
|  | The machine does not operate until the set temperature is not reached. | |
| Red light on | | Machine in emergency with auxiliary turned off |
| Red light blinking | | Machine on cycle with warnings |
| Red light off | | Machine in emergency and without alarms on |
| Orange light on | | Machine with fed auxiliary |

| | |
|-----------------------|---------------------------------|
| Orange light blinking | Auxiliaries turned on or off in |
| Orange light off | Auxiliaries turned off |
| Green light on | Machine on cycle |
| Green light blinking | Machine not on cycle |
| Green light off | Machine not ready |

10.2ELECTRICAL CONNECTION




Make sure that the cable of the Perfect Binder is connected to electricity network with the specified features.


Turn on the main switch located on the left side of the machine, turn right to achieve the position 1= (ON).

10.3PNEUMATIC CONNECTION


Connect the pneumatic power source following the procedure:




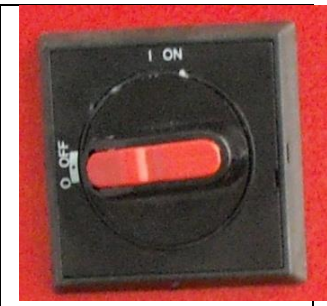
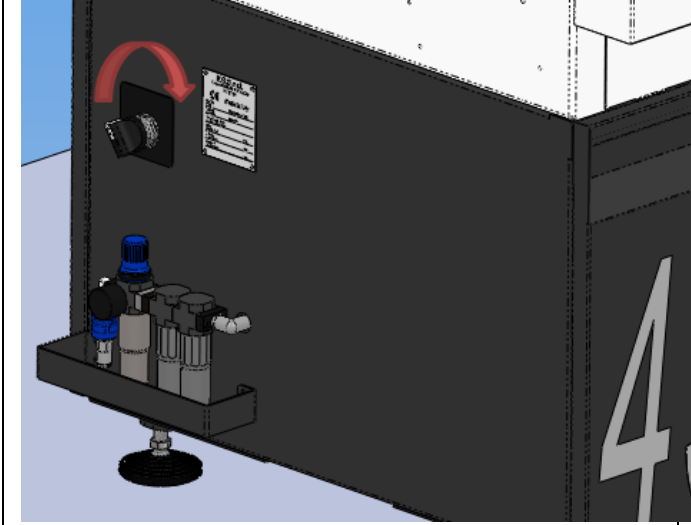




Connect the hose 0.39in (10mm external diameter) to the quick of the binder.

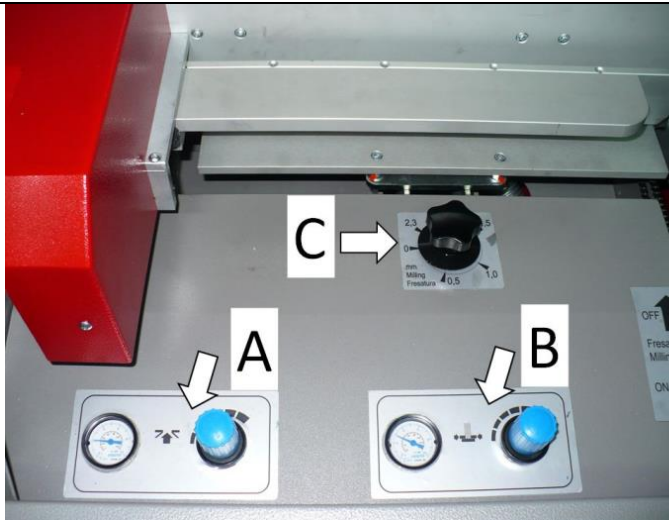


To disconnect the hose of the machine, it is necessary to rotate the blue part of the sleeve. With this procedure you will flush the air from the machine. When you have finished, it will be possible to pull out the sleeve pushing upwards the blue part and pulling out the sleeve downwards. The sleeve has a seal system that once pulled out does not allow air passage

| | |
|---|--|
|  | <p>Danger! Risk of collision due to uncontrolled movements of the hoses subjected to passage of compressed air.</p> |
|---|--|

10.4 DESCRIPTION OF THE GROUPS

| | | | | |
|---|--|--|---|---|
|  | <p>Position OFF</p> <p>Main switch open. The machine is off.</p> |  | | |
|  | <p>Position ON</p> <p>Main switch closed. The machine is on.</p> |  | | |
| <table border="1"><tr><td data-bbox="138 1519 824 2011"></td><td data-bbox="824 1519 1502 2011"><p>1) CLAMP</p><p>2) MILLING STATION</p></td></tr></table> | | |  | <p>1) CLAMP</p> <p>2) MILLING STATION</p> |
|  | <p>1) CLAMP</p> <p>2) MILLING STATION</p> | | | |



A Glue pressure regulator

To adjust the amount of glue coming out of the extruder.

Approximate values (**1 bar = 14.50 psi**)

Pressure = 0 lack of glue (don't use)

Pressure = 1.2 - 1.8 bar (books up to a 0.19in)

Pressure = 1.8 - 2 bar (books 0.19 - 0.39in)

Pressure = 2 - 3 bar (books 0.39- 1.18in)

Pressure = > 3 bar (books 1.18in - 1.96in)

B Pressure regulator for nipping station

Allows to adjust the force to press the book laterally.

Pressure = 0 - 3bar the nipping station does not work

Pressure = 4 bar medium force

Pressure = 6 bar max force

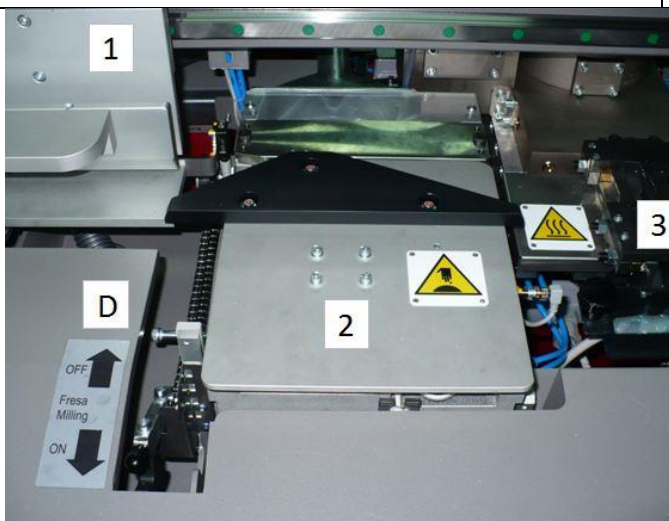
C Milling height regulator

Allows to adjust the milling

position = 0 only notching

position = 0.5 - 1 the best milling and notching situation

position = 2.3 max. milling and notching



1) CLAMP

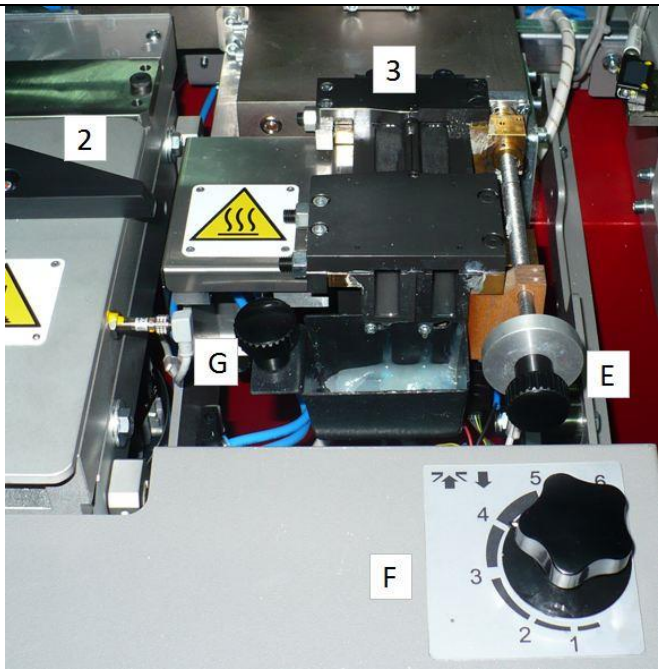
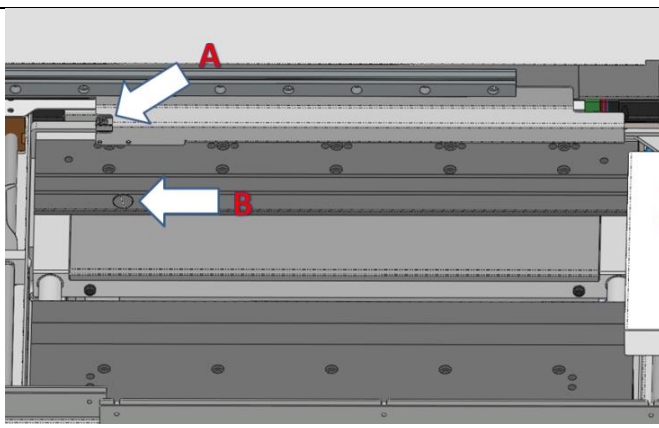
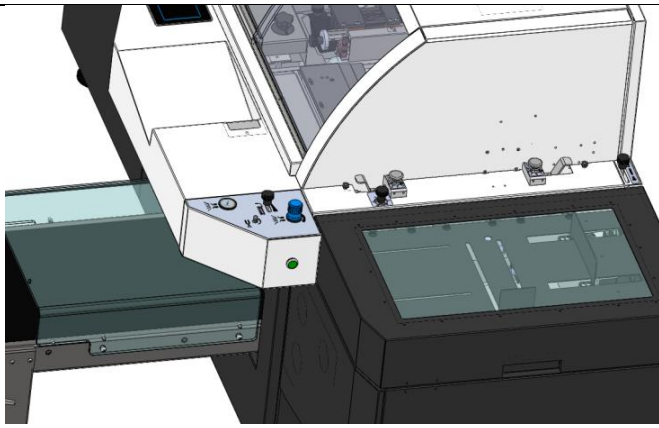
2) MILLING STATION

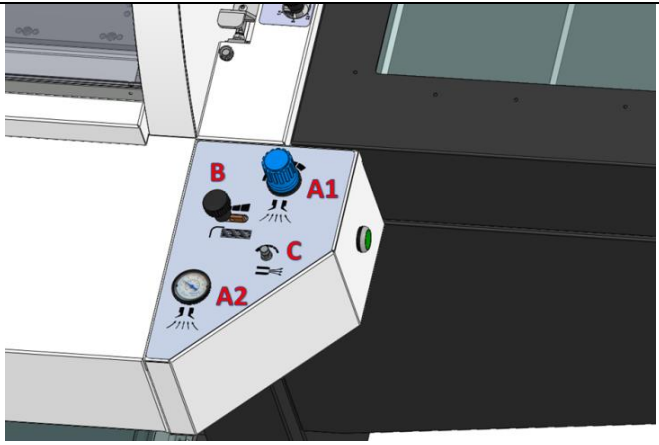
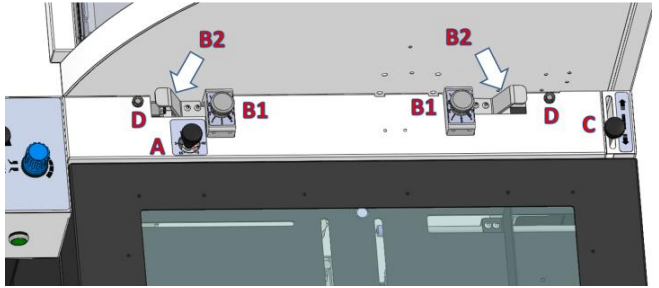
3) GLUE SYSTEM

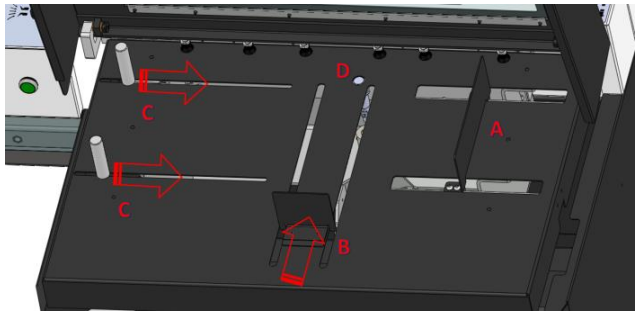
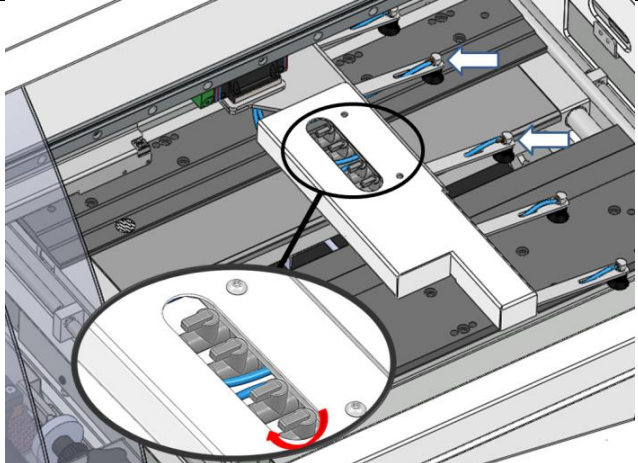
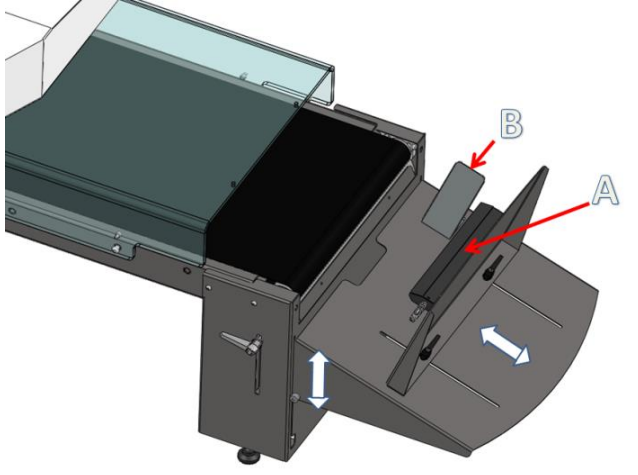
3 D) Exclusion lever for the Milling Station group

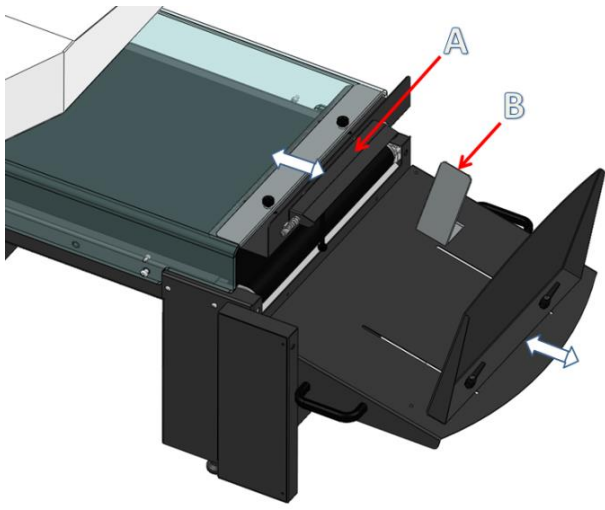
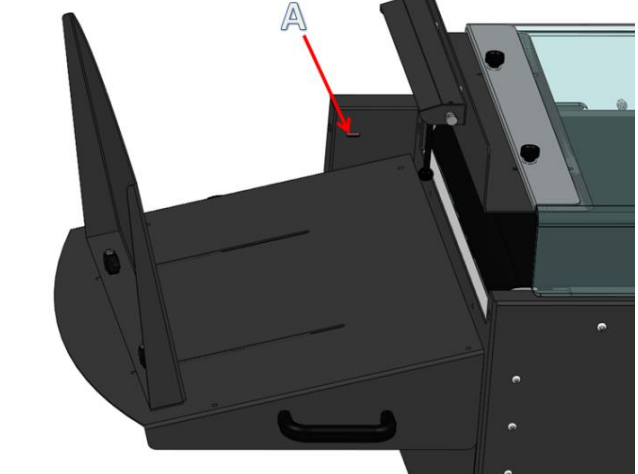

Lever in position ON = working


Lever in position OFF = off, and lowered.

| | |
|---|--|
|  | <p>2) MILLING STATION</p> <p>3) GLUE STATION</p> <p>E) Rear guide adjustment for gluing internal side. Set on 1 for book block made of single sheets. Set on >1 for sewn book block.</p> <p>F) Adjustment for glue station-book block distance. Set on 1 minimum distance (little glue) Set on 6 max distance (much glue) Suggested set: between 3 and 4.</p> <p>G) Tank for glue collection.</p> |
|  | <p>NIPPING STATION</p> <p>A Sensor for cover presence</p> <p>B Reflector sensor for cover presence.</p> |
|  | <p>Cover feeder and its adjustments:</p> |
| | <p>A1 Intake pressure adjustment.</p> <p>A2 Intake pressure manometer.</p> <p>B Adjustment lever for split blades</p> |

| | |
|--|--|
|  | <p>C Adjustment for flow rate of front air blows.</p> <p>D Buttons to lower/raise the cover feeder surface.</p> |
|  | <p>A Height adjustment for cover feeder surface.</p> <p>B1 Depth adjustment for creasing. 1= does not crease Higher numbers increase scoring.</p> <p>B2 Lever to raise the creasers. It is possible to insert between the tag and the knob a part of the cover you are working on, in this way you can crease several kinds of covers with the same depth only replacing the part of the cover.</p> <p>C Height adjustment of front air blows.</p> <p>D Knob to be removed in case of misfire.</p> |


| | | | | | | | | | |
|---|--|----------------------|-------------------------------|---|---|---|---|---|--|
|  | <table><tr><td>A</td><td>Lateral rear edge (motorized)</td></tr><tr><td>B</td><td>Removable front-lateral hedge to facilitate cover insertion.</td></tr><tr><td>C</td><td>Lateral front hedge (manual) to containment the covers.</td></tr><tr><td>D</td><td>Sensor for cover presence.</td></tr></table> | A | Lateral rear edge (motorized) | B | Removable front-lateral hedge to facilitate cover insertion. | C | Lateral front hedge (manual) to containment the covers. | D | Sensor for cover presence. |
| A | Lateral rear edge (motorized) | | | | | | | | |
| B | Removable front-lateral hedge to facilitate cover insertion. | | | | | | | | |
| C | Lateral front hedge (manual) to containment the covers. | | | | | | | | |
| D | Sensor for cover presence. | | | | | | | | |
|  | <p>In the two suckers indicated by white arrows it is not possible to exclude vacuum.</p> <p>For the other four, it is possible to eliminate vacuum, rotating the correspondent valves (see enlargement), following the rotation indicated by red arrow you can close the valve.</p> | | | | | | | | |
|  | <table><tr><td colspan="2">STD EXIT BELT</td></tr><tr><td>A</td><td>Frontal blowing system. It is magnetic, with possibility to adjust position and quantity of the air dispensed through the built-in valve.</td></tr><tr><td>B</td><td>Lateral hedge, magnetic, with support function.</td></tr><tr><td></td><td>Manual system to adjust height and depth</td></tr></table> | STD EXIT BELT | | A | Frontal blowing system. It is magnetic, with possibility to adjust position and quantity of the air dispensed through the built-in valve. | B | Lateral hedge, magnetic, with support function. | | Manual system to adjust height and depth |
| STD EXIT BELT | | | | | | | | | |
| A | Frontal blowing system. It is magnetic, with possibility to adjust position and quantity of the air dispensed through the built-in valve. | | | | | | | | |
| B | Lateral hedge, magnetic, with support function. | | | | | | | | |
| | Manual system to adjust height and depth | | | | | | | | |

|  | <table><tr><th colspan="2">STACKER EXIT BELT</th></tr><tr><td>A</td><td>Frontal blowing system. It is magnetic, with possibility to adjust position and quantity of the air dispensed through the built-in valve. Support with depth adjustment.</td></tr><tr><td>B</td><td>Lateral hedge, magnetic, with support function. Automatic system to adjust height and manual system to adjust depth</td></tr></table> | STACKER EXIT BELT | | A | Frontal blowing system. It is magnetic, with possibility to adjust position and quantity of the air dispensed through the built-in valve. Support with depth adjustment. | B | Lateral hedge, magnetic, with support function. Automatic system to adjust height and manual system to adjust depth |
|---|--|-------------------|--|---|--|---|--|
| STACKER EXIT BELT | | | | | | | |
| A | Frontal blowing system. It is magnetic, with possibility to adjust position and quantity of the air dispensed through the built-in valve. Support with depth adjustment. | | | | | | |
| B | Lateral hedge, magnetic, with support function. Automatic system to adjust height and manual system to adjust depth | | | | | | |
|  | <table><tr><td>A</td><td>Automatic system to adjust height, this is regulated by a lateral sensor. Once you have filled the stacker, the machine send an alarm to the A62 (Books Stacker Full). To rise again the plane, wave fast your hand in front of the sensor "A"</td></tr></table> | A | Automatic system to adjust height, this is regulated by a lateral sensor. Once you have filled the stacker, the machine send an alarm to the A62 (Books Stacker Full). To rise again the plane, wave fast your hand in front of the sensor "A" | | | | |
| A | Automatic system to adjust height, this is regulated by a lateral sensor. Once you have filled the stacker, the machine send an alarm to the A62 (Books Stacker Full). To rise again the plane, wave fast your hand in front of the sensor "A" | | | | | | |
|  | <p>On the back</p> <p>Gate access to the tanks.</p> <p>The machine makes movements only with the door closed.</p> | | | | | | |

| | |
|---|---|
|  | <p>5) GLUE TANK</p> <p>6) CLEANER TANK</p> <p>L) Glue pressure tap</p> <p>-- closed</p> <p> open</p> <p>H) Chips aspiring tube</p> |
|---|---|

10.5 CHIPS ASPIRATOR

The chips aspirator is located inside the cabinet of the Perfect Binder and is electrically connected to the binder herself. When the binder is delivered, the chips aspirator is ready, mechanically (aspiration tube) and electrically connected, he switches on and off together with the Milling Station.

| | |
|---|---|
| Front side picture: chips aspirator (see the arrow) | |
|  | |
| <p>Aspiration tube</p> <p>In the back of the Perfect Binder, connected to the back preparation station.</p> | <p>Switch</p> <p>It must be in “on” position (I = ON) during the operation of the Perfect Binder.</p> |








Every day the chips aspirator must be emptied and cleaned to be ever efficient

10.6PUR TANK OPENING AND CLOSING AND GLUE LOADING.

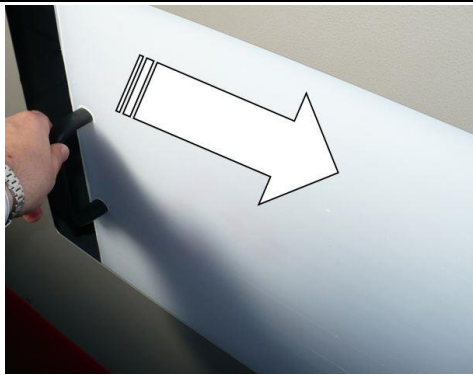
10.6.1 OPENING OF THE PUR TANK

To access the glue tank it is necessary to open the sliding door provided with handle.
The opening of this protection put the machine in a state of emergency and reduces the pressure of the glue tank while the Cleaner tank remains at a pressure of 2 Bar about.
The machine can't work with the back door open.

WARNINGS ON THE OPENING OF PUR TANK

| | |
|---|--|
|  | Wear hand protection, all parts are at high temperatures. |
|  | Wear protections for face, respiratory mask suitable for glue and protection glasses |
|  | Never open the tank when it is COLD. Possibility of breaking the seal gaskets and because of this The air moisture would enter and remain trapped in the tank causing premature aging (curing) of the PUR glue with probable clogging and maintenance need. |
|  | Avoid to open the PUR tank with no reason. |
|  | Limit the opening time. Close the tank as soon as possible |

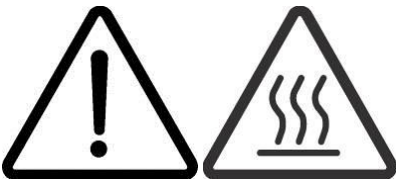
Please follow scrupulously the sequence below.



Open the sliding door on the rear part using the handle.
The machine goes to emergency state and reduces the pressure in the glue tank, while the cleaner tank is at 2 bar (29 PSI) about.



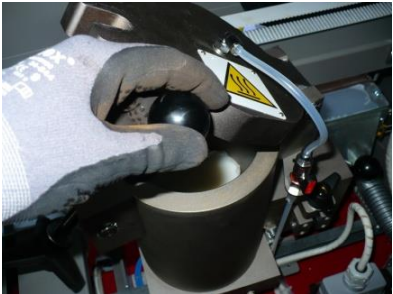
4) Loosen the block knob. Rotate it anticlockwise.
Pay attention to high temperatures. Use protective gloves.



5) Recline the block knob until the rest position.
In this way the cap can be opened.


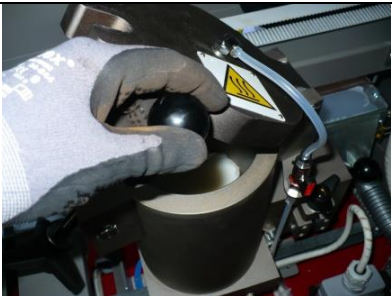


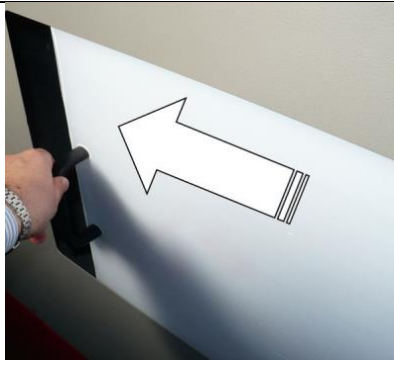


6) Lift the cap to the maximum opening grabbing the lateral knob

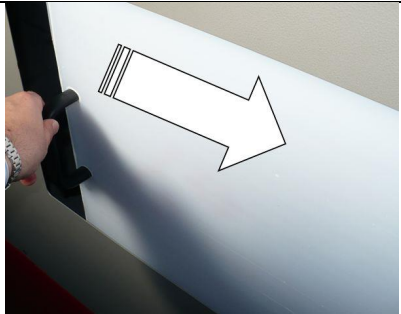

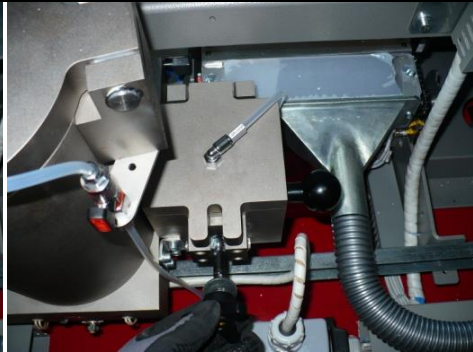


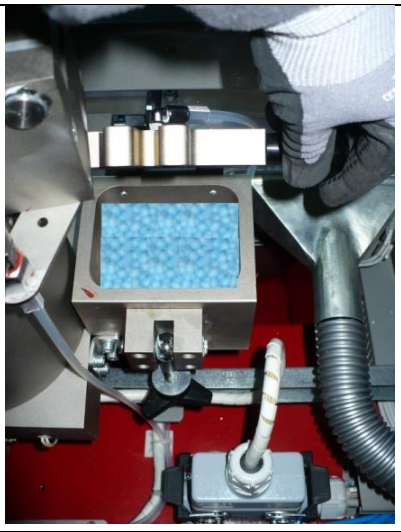
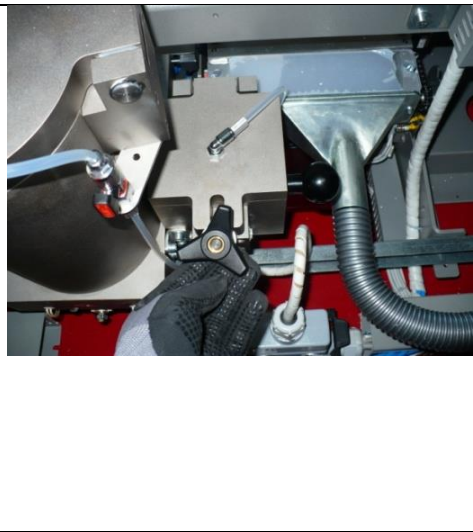



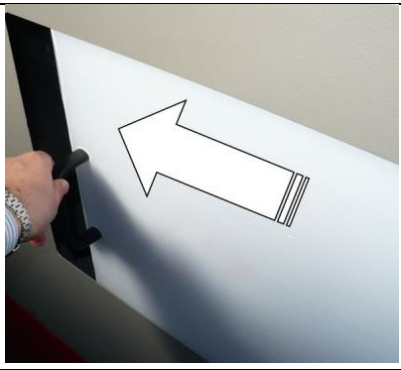
10.6.2 PREPARATION AND PUR GLUE LOADING

| | | |
|---|--|---|
|  | | <p>Take a package of glue, verify the integrity of the aluminium colour pack, and check the expiration date printed in the package</p>  <p>Please read the SAFETY cards of the used glue, and follow all the instructions of the manufacturer.</p> |
|  | | <p>Cut the foil, by using a sharp tool.</p>  |
|  | | <p>Remove completely the foil.</p> |
|  | | <p>Insert the cartridge into the tank. Attention! High temperature! Use protective gloves.</p>  |

| | | |
|--|---|--|
|  |  | <p>Close the cap.</p> |
|  |  | <p>Lift the knob, paying attention to high temperature components. Turn the knob clockwise vigorously to tighten the tank.</p> |
|  | | <p>Close the sliding door on the back of the machine with the handle.</p> |

10.6.3 CLEANER LOADING

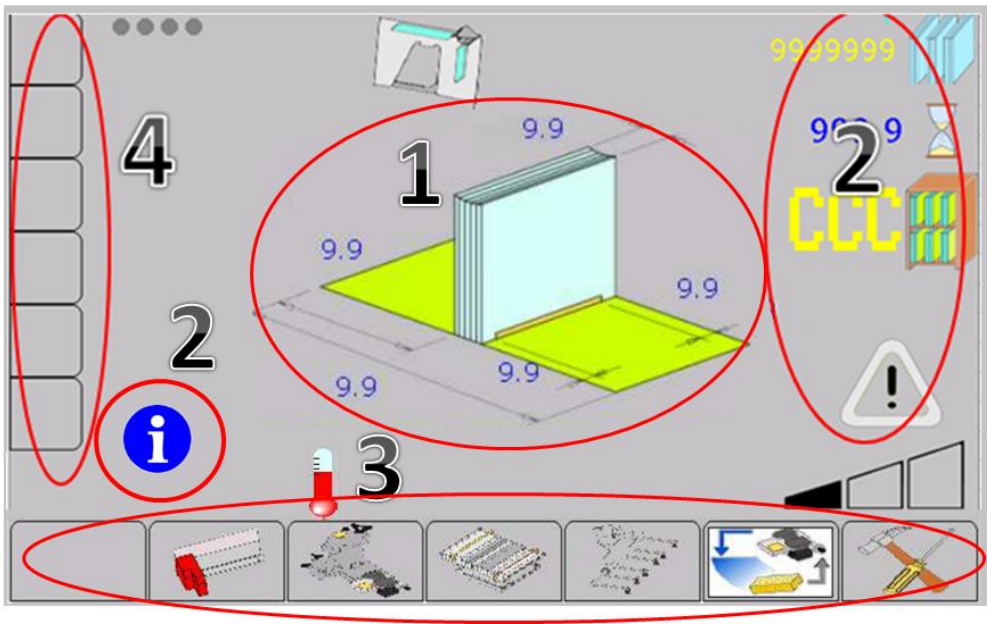
| | |
|---|--|
|  | <p>Open the sliding door on the back of the machine with the handler. Attention! High temperature! Use protective gloves.</p> <div data-bbox="573 470 974 642"></div> <p>Read carefully the SAFETY cards of the used cleaner and follow all the instructions of the manufacturer.</p> |
|  |  <p>By loosening the knob of the cleaner tank, you will notice an air leak; this is normal as the machine continues to provide air to the tank.</p> |
|  |  <p>Fill the tank with cleaner to about 3 / 4 of its volume by using a small container.</p> |
|  |  <p>Close the cap using the knob on the side and pay attention to the high temperature components. Lift the locking knob.</p> |

| | | |
|---|--|---|
|  | | <p>Tighten the knob until the noise of escaping air disappears.</p> |
|  | | <p>Close the sliding door in the back of the machine with the handle.</p> |

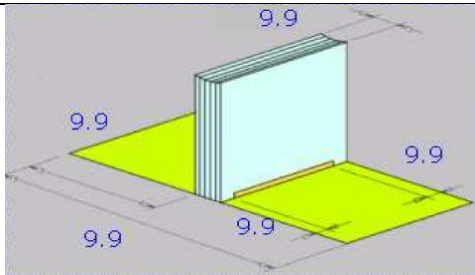
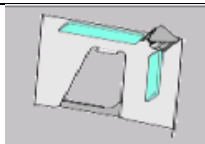
11 FUNCTIONS OF THE PERFECT BINDER

11.1 START UP PAGE

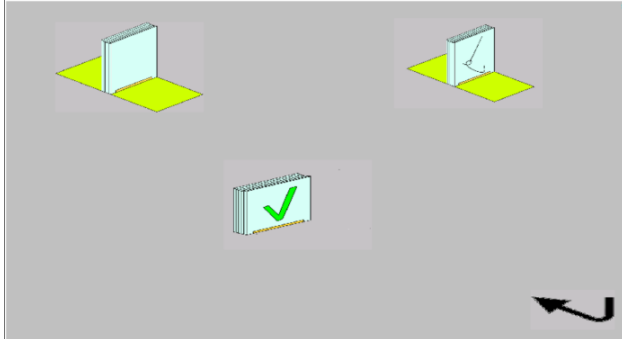
Sectioning

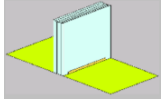

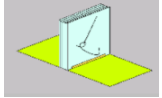


Area 1



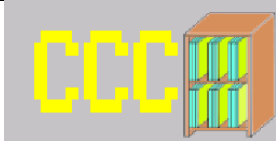


| | |
|---|--|
|  | <ul style="list-style-type: none">-Selector for book type-Front glue stop-Rear glue stop-Rear cover set-Height cover set-Book thickness |
|  | <p>Optional: Thickness detection for the book.</p> <p>Position a book onto the measurement table and press the key, the machine will modify the clamp dimension and also the dimensions of the glue station and scoring tools.</p> |

Press the picture of the book. In the first page it will appear the dialog box for selecting the type of book work. See below.



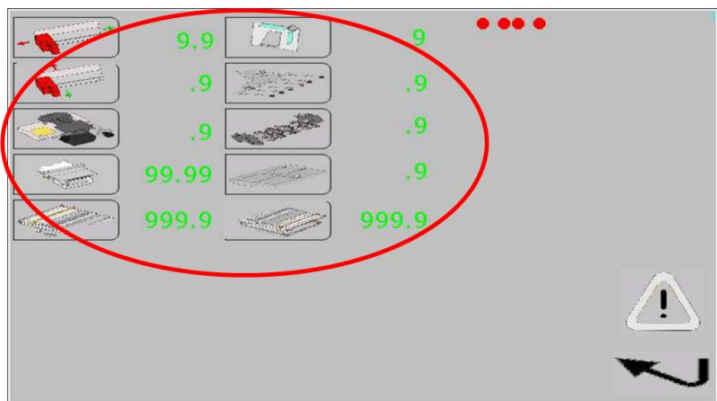
| | |
|---|--|
|  | Button for the production of books with cover. |
|  | Button for the production of book blocks to verify glue spread. In this case nipping station, cover feeder and discharge are disabled. To remove the book from the clamp you need to press the green button. |
|  | Button for the production of sewn books with cover. In this mode the machine works only if the milling cutter is switched off and the jogger is set to 0. |

Area 2

| | |
|---|--|
|  | Meters display |
|  | Selector for book residence time in the nipping station. |
|  | Management page for working JOB. |
|  | Speed selector 1-2-3 |
|  | Alarms Red blinks in case there are alarms or warnings. |



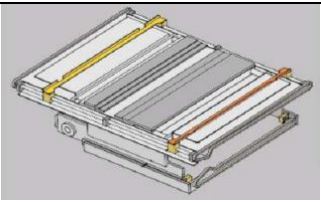
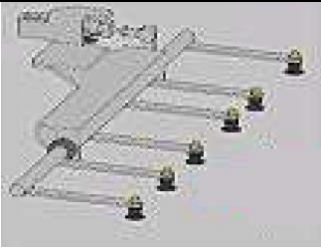

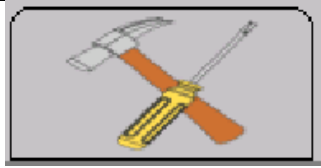
When this symbol appears and blinks it means that some axis is not in the right position.
Pressing it, you open the dialog box below.

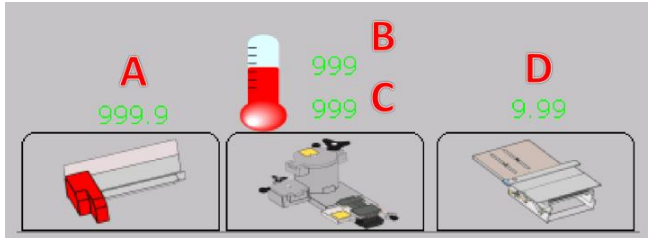


| | |
|--|---|
| | <p>Grey icons indicate that the reset for the axes has not been done.</p> <p>The icons changing color from yellow to green indicate that the axis has done the reset, but it is not in working position.</p> <p>The green icons indicate that the axes has done the reset and it is in work position.</p> |
| | <p>Open the dialog box for alarms presently in that moment.</p> |


Area 3

| | |
|--|----------------------------|
| | <p>Clamp set up</p> |
| | <p>Glue station set up</p> |

| | |
|--|---|
|  | Nipping station set up |
|  | Cover feeder set up |
|  | Cleaning procedure with CLEANER or GLUE loading |
|  | Advanced set up |

| | | |
|---|---|---|
|  | A | Indicate the arrival position for the book block compared to the cover. |
| | B | Current temperature for the premelter |
| | C | Current temperature for glue station |
| | D | Current position for nipping station height |

Area 4

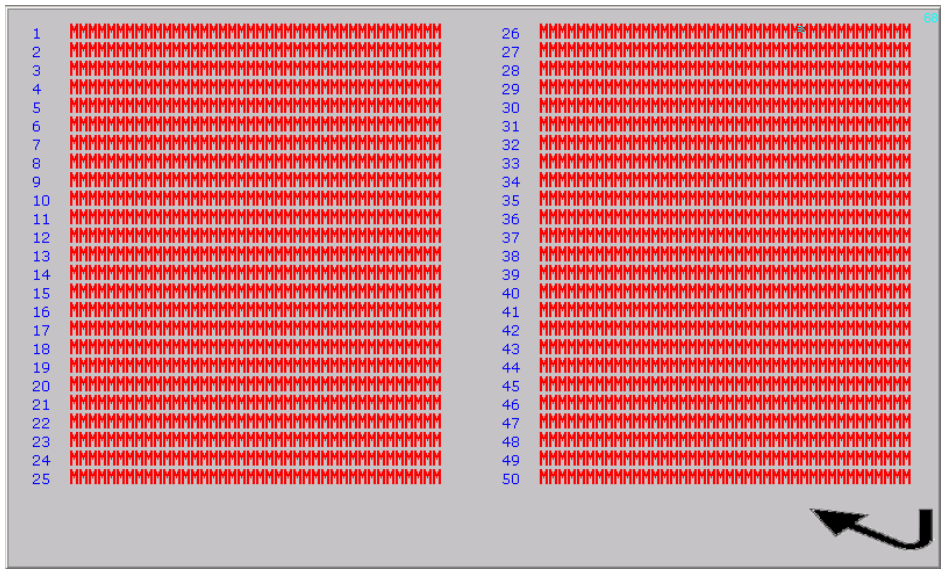
| | |
|---|---|
|  | Groups status bar If red, turned off If yellow, value modified in the advanced set up |
|---|---|

11.1.1 DISPLAY FOR PRODUCTION METERS



| | |
|--|--|
| | <p><i>Meter of total production:</i> Meter showing all the items produced during the life of the machine. It is not possible to reset it. Pressing on the icon in the picture you will visualize the correspondent number.</p> |
| | <p><i>Meter of partial production:</i> Meter showing the items produced. It is possible to reset it pressing the RESET button. Pressing on the icon in the picture you will visualize the correspondent number.</p> |
| | <p><i>Meter of produced items:</i> Meter showing the items produced in the day. It is possible to reset it pressing the RESET button. Pressing on the icon in the picture you will visualize the correspondent number.</p> |
| | <p><i>Item to produce:</i> Meter showing the items to produce. Press the blue number and insert the desired quantity. To remove this function, you need to set the number of books to produce = 0. Pressing on the icon in the picture you will visualize the correspondent number.</p> |


11.1.2ALARMS PAGE



List of Warnings and Messages :




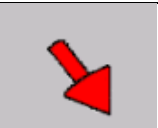
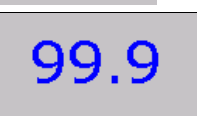


| N° | Warnings | Description |
|-----|----------------------------|---|
| A01 | Machine Emergency | Verify that the emergency button is not pressed and press green button. |
| A02 | Fault Drive Arm | Driver error for cover feeder arm. |
| A03 | Fault Drive Carriage | Driver error for carriage engine control. |
| A04 | Fault Drive Delivery Arm | Driver error for delivery arm. |
| A05 | Trip Safety Light Curtain | The SAFETY barriers are occupied with the machine in movement. |
| A06 | Inspection Door Open | Rear panel for loading/inspecting glue tank is open, close it and press START. |
| A07 | Encoder Error Side Jogger | Encoder error for cover guide of cover feeder. Verify there are no obstructions for the movement, reset the alarm and press START |
| A08 | Encoder Error Suctions Bar | Encoder error of the cover feeder arm. Verify there are no obstructions for the movement, reset the alarm and press START |
| A09 | Error Carriage Encoder | Encoder error of the carriage. Verify there are no obstructions for the movement, reset the alarm and press START |
| A10 | Error Clamp Encoder | Encoder error for the clamp. Verify there are no obstructions for the movement, reset the alarm and press START |
| A11 | Error Glue Nozzle Encoder | Encoder error for the nozzle. Verify there are no obstructions for the movement, reset the alarm and press START |
| A12 | Error Press Encoder | Encoder error for the nipping station height adjustment. Verify there are no obstructions for the movement, reset the alarm and press START |

| | | |
|-----|--------------------------------------|--|
| A13 | Error Cover Encoder | Encoder error for frontal guide for cover on the nipping station . Verify there are no obstructions for the movement, reset the alarm and press START |
| A14 | Error Table Encoder | Encoder for thickness survey. Make sure you have not left anything under thickness detection device and reset the alarm and press START. |
| A15 | Encoder Error on Back Cover | Encoder error for the rear guide of cover on the nipping station. Verify there are no obstructions for the movement, reset the alarm and press START |
| A16 | Encoder Error Creasing | Encoder error on the creasing adjustment . Verify there are no obstructions for the movement, reset the alarm and press START |
| A17 | Hight Temperature Glue Premelter PUR | The temperature measured on the premelter is 41 ° C higher than the set one. Wait for system to cool. |
| A18 | Low Temperature Glue Premelter PUR | The temperature measured on the premelter is 35.6 ° C lower than the set one. Wait for the system to heat. |
| A19 | Hight Temperature Glue Nozzle | The temperature measured on the nozzle is 41 ° C higher the set one. Wait for system to cool. |
| A20 | Low Temperature Glue Nozzle | The temperature measured on the nozzle is 35.6 ° C lower than the set one. Wait for the system to heat. |
| A21 | Wait Heating in Progress | Heating in progress. This alarm occurs when the system is warming up or during the warm-up timer when the measured temperature and the set temperature differ by a delta greater than 104 ° C. |
| A22 | Machine with Cleaner | At shutdown of the machine the head cleaning has been made with the automatic cycle of the cleaner. Use the loading glue cycle, load the glue. The machine with this alarm does not work. |
| A23 | Perform Maintenance of NEEDLES !!! | The nozzle valve is not working properly. Call technical support. |
| A24 | Hight Temperature Glue Premelter EVA | The temperature measured on the premelter EVA is 41 ° C higher than the set one. Wait for system to cool. (OPTIONAL) |
| A25 | Low Temperature Glue Premelter EVA | The temperature measured on the premelter EVA is 35.6 ° C lower than the set one. Wait for the system to heat. (OPTIONAL) |
| A26 | Hight Temperature Glue Pipe EVA | The temperature measured on the glue pipe EVA. EVA is 41 ° C higher than the set one. Wait for system to cool. (OPTIONAL) |
| A27 | Low Temperature Glue Pipe EVA | The temperature measured on the glue pipe EVA is 35.6 ° C lower than the set one. Wait for the system to heat. (OPTIONAL) |
| A28 | Cover Press Protection not Closed | The front protections of the machine are not closed. Verify closure of frontal protection. |
| A29 | Cover Feeder Protection not Closed | The cover feeder protection is not closed. Verify closure of cover feeder protection. |
| A31 | Book Tickness Out Range | The book thickness measured is less than 0.79 in or more than 2in. (OPTIONAL) |
| A32 | Slave Module Comm Error | Error communicating with the slave PLC, reset the alarm, if it persists, call technical support. |
| A33 | Remove Book from Clamp | The clamp needs to make a placement so reset alarm and press START. |
| A34 | Insert Book in Clamp | START button is pressed without having placed the book in the clamp. |
| A35 | Photoce.Book in Clamp Obstructed | Clean photocell and the reflector and remove obstructions. |
| A36 | Photocellula Glue Obstructed | Clean photocell and the reflector and remove obstructions. |

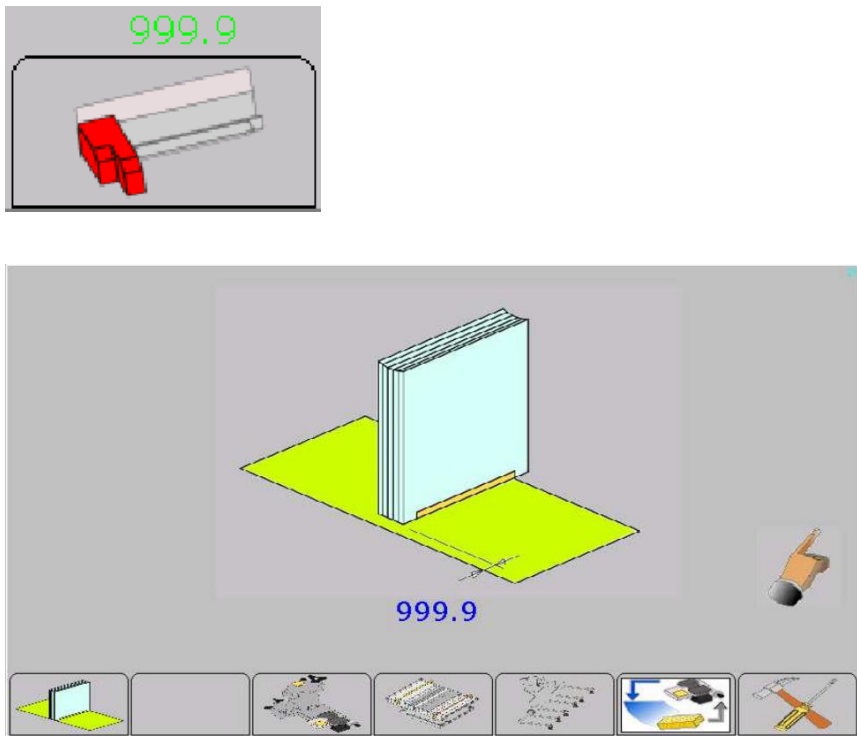
| | | |
|-----|-------------------------------------|--|
| A37 | Jogger Out of Position | Jogger not in position, the alarm occurs when the cutter is excluded and the jogger is not put in the zero position. Set the jogger to zero position. |
| A38 | Mill Door not Closed | Protection of the cutter is not closed. Verify that the cover closes and if necessary clean the guide. |
| A39 | Mill Group Out of Position | Milling station is not in place, make sure that the lever is or ON or OFF position. |
| A40 | Group Up/Down Press not in position | Height adjustment of the press is not in right position. Press START |
| A43 | Thermal Switch QM13.01-02-03 | Thermal overload of one of the following motors, milling, plane ascent covers, discharge conveyor. It is necessary to enable them by hand inside the electrical panel.  Before doing this, verify everything and disconnect the power from the machine. |
| A44 | Wrong Reading Glue Photocell | Photocell has read two pulses, do not insert two books or clean the clamp. |
| A45 | TUTORIAL NOT COMPLETED | Complete the tutorial and continue. |
| A46 | No Air Pressure | Air pressure fault to the machine. Verify that the manometer at the entry is at 6 bar (87psi) or that the compressor is suitable. |
| A47 | PLC Battery Low | |
| A48 | End of Production | End of production appears when the copy counter has reached the predetermined number of books. |
| A49 | Lack of cover on nipping station | |
| A61 | Creasing Setpoint Out of Range | Check that the setpoint plus additional corrections is not less than 0.79in or more than 2in |
| A62 | Books Stacker Full | Remove books from stacker (OPTIONAL) |
| A64 | Error Double Cover | Remove the covers in excess from the press. (OPTIONAL) |
| A65 | Error on Cover Pick-up | Error in picking up covers. It appears at third time. Verify vacuum pressure, split blades, power and front blows position. |
| A66 | Cover Jam | Remove the cover from the transit area on creasers. |
| A67 | Cover Front Setpoint too Small | Check the difference between the length of the cover and position of the rear guide is not less than 4.72in or more than 12.79in |
| A70 | Please Remove Covers Pack | Necessary to allow the movement of the cover guide on the cover feeder plane. |
| A71 | Photocell Discharge Book Obstructed | Verify the guide for releasing the book |
| A78 | Timeout Press Opening/Closing | Up / down movement of the nipping station too slow or not made. Increase the pressing pressure. |
| A79 | Timeout Contrast Opening/Closing | Movement of the plane spine book too slow or motion not completed. Verify there are not obstructions or glue. |
| A80 | Timeout Pick Place Rotation | Rotation of the delivery arm not completed Verify the release guide. |

11.2 PARAMETERS FOR SINGLE AXES (GROUPS)

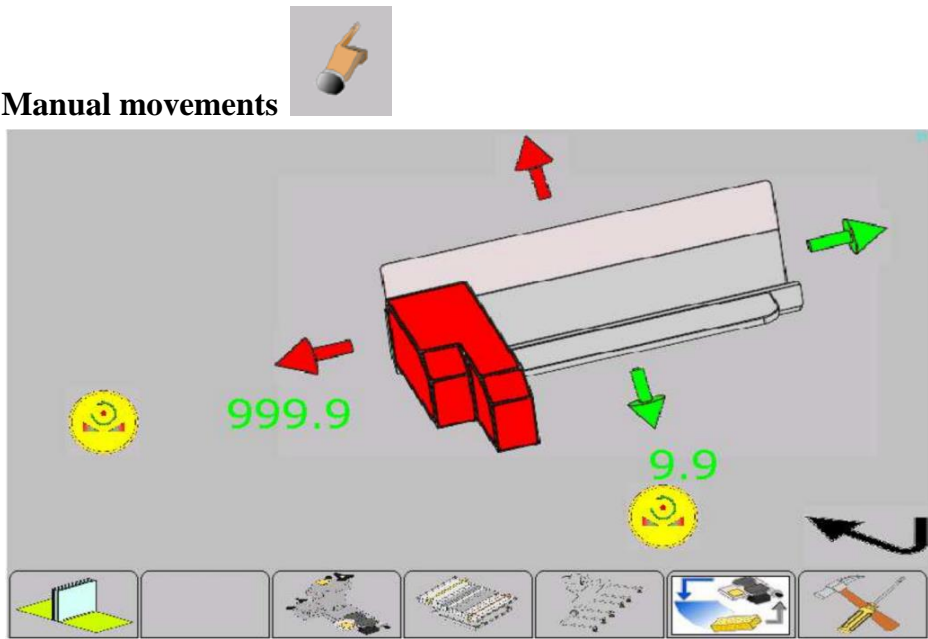
Standard symbols that you will find in the following pages.

| | |
|---|---|
|  | Access to manual movement page |
|  | Axes preset |
|  | Group movement in the direction indicated by the green arrow. If you push the green arrow, the dimension increases. |
|  | Group movement in the direction indicated by the red arrow. If you push the red arrow, the dimension decreases. |
|  | The value in blue can be modified by the operator. |
|  | The value in green cannot be modified by the operator. It is the current position of the axes. |
|  | Back to the previous window. |

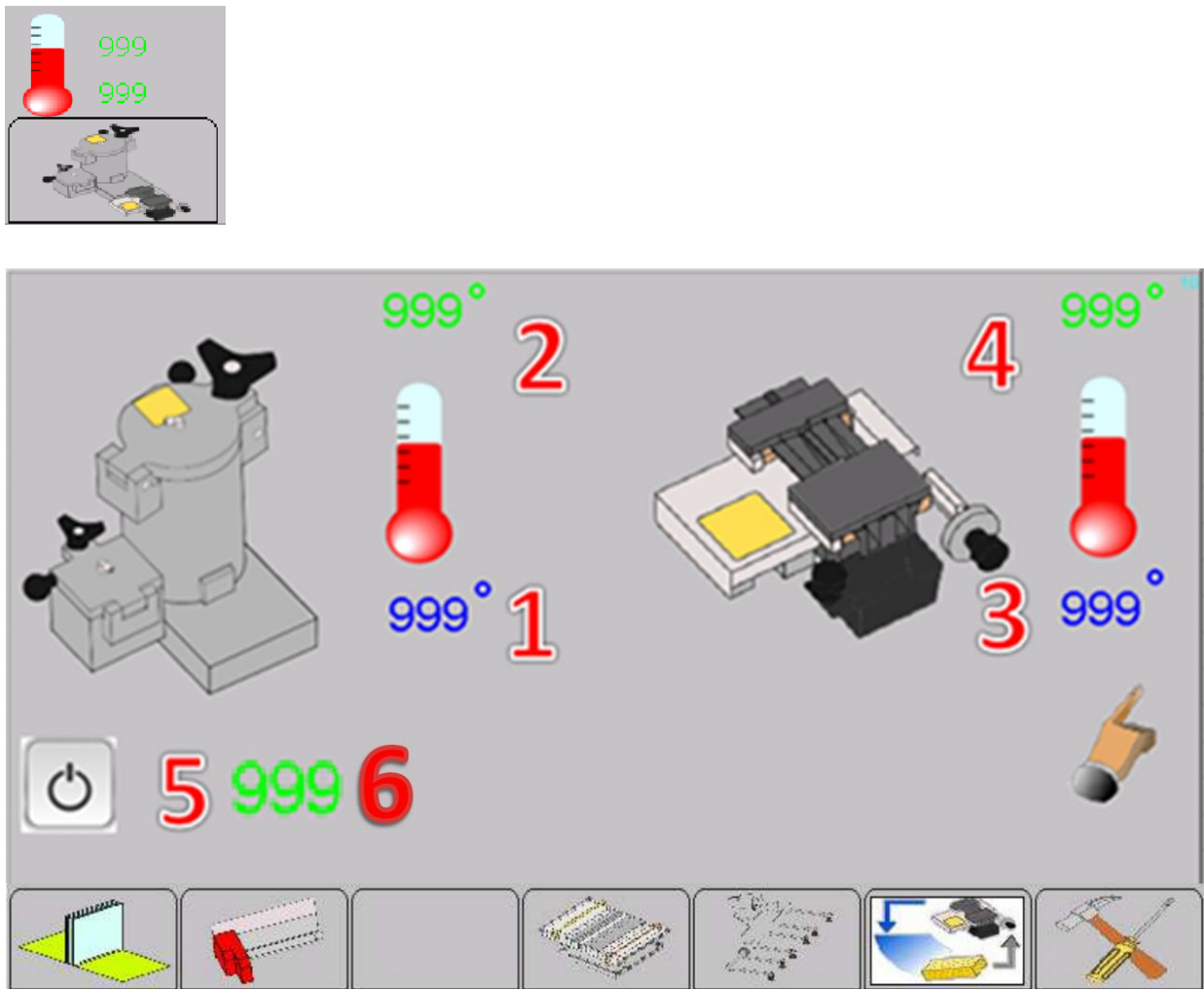
11.2.1 PARAMETERS FOR CLAMP/CARRIAGE



| | | |
|------------------------------|--------------------|--|
| Offset for carriage position | + 0.5in - 0.5in | Offset for the arrival position of the carriage onto the nipping station. This allows to position the book rightmost (positive value) or leftmost (negative value) compared to cover. Entering zero value (0) the book will be aligned to the cover. |
|------------------------------|--------------------|--|



11.2.2PARAMETERS FOR THE GLUE STATION HEAD



Management for working parameters of glue station head

| | |
|---|---|
| 1 | Temperature control for premelter |
| 2 | Current temperature for premelter |
| 3 | Temperature control for the glue head |
| 4 | Current temperature for glue head |
| 5 | Stand by launch |
| 6 | Timer for homogenization the temperatures |

The temperature must be set on the basis of the glue type you are going to use. Refer to temperatures suggested by glue producer.

The premelter temperature must be kept from 41° to 59 ° less than that the extrusion temperature.

During the heating, the indicators will be red and the machine will show the message “Low Temperature Glue Premelter PUR” or “Low Temperature Glue Nozzle”.

When the recorded temperatures correspond to the set temperatures, the indicators will be green.

So the machine will start to move the glue station and the timer for homogenization will start. If the delta between the set temperatures and the recorder one is more than 104 °C, the following message will appear “Wait. Heating in Progress” Until the timer will not finish (15 min), it will not be possible to load the glue or to work. When the number indicated with “6” will go to 900 the procedure is finished. At the end of this process the machine will be ready to start.

The standby status will decrease the temperatures of 86°.

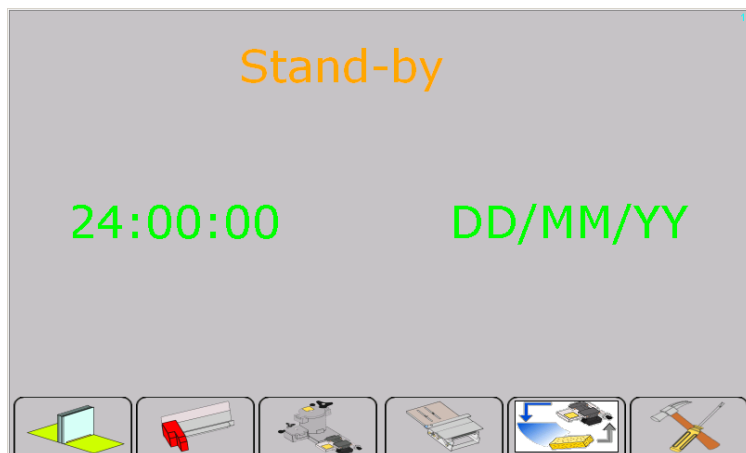
If the machine does not produce any book for more than 30 minutes, the machine automatically goes to standby

To go out from stand by status, hold for at least a second whatever point on display, but not on the icons.

- The head for the extrusion is closed
- The temperatures decrease of 86° in order to protect the glue from unnecessary prolonged heating.

After that, you have to wait for glue station to reach the set temperature.

When the temperature is correct, it will be possible to position the axes and proceed with book production.



Manual movements



MyBinding.com
 5500 NE Moore Court
 Hillsboro, OR 97124
 Toll Free: 1-800-944-4573
 Local: 503-640-5920

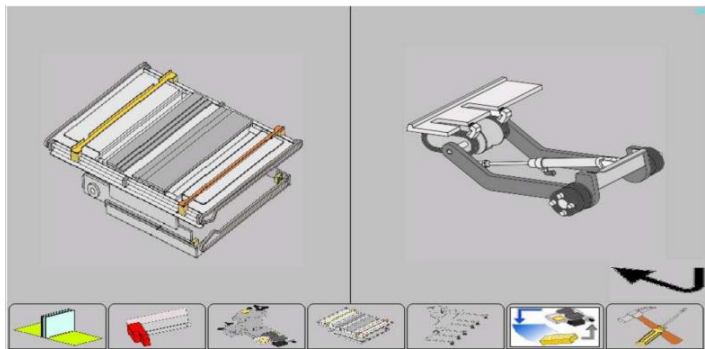
11.2.3PARAMETERS FOR NIPPING STATION

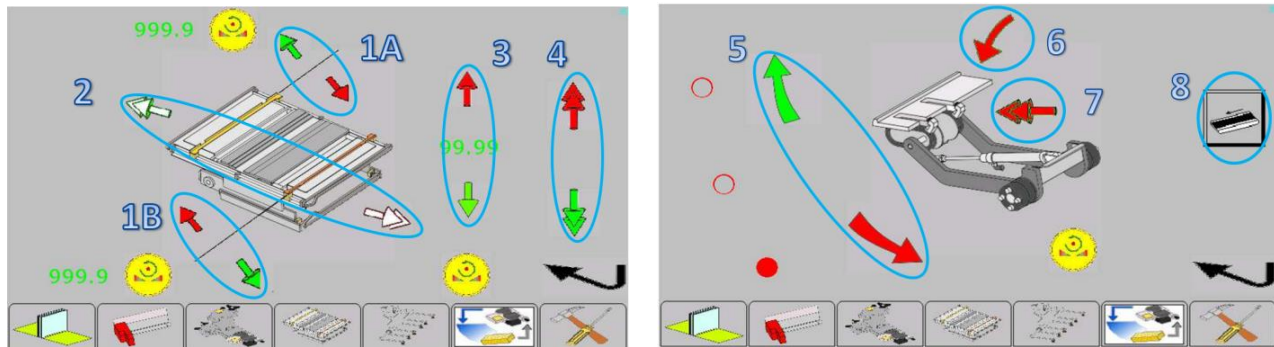


Management of working parameters for nipping station

| | | |
|------------------------|----------------------|---|
| Nipping station height | From 0 mm to 0.059in | Tune the distance between the spine plate and the book. |
|------------------------|----------------------|---|

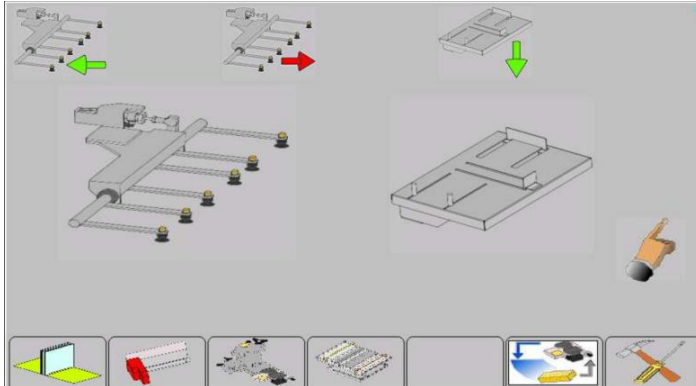
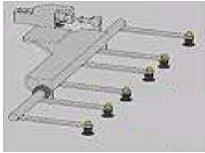
Manual movements






Select the nipping station or the delivery arm.

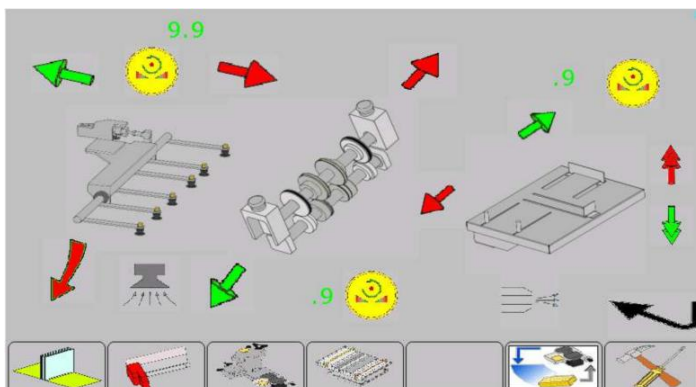
| | |
|-------|---|
| 1A-1B | With these buttons you can move the front and rear guide to support the cover on the nipping station. |
| 2 | With these buttons you can move the spine base plate. |
| 3 | With these buttons can adjust the height of the nipping station |
| 4 | With these buttons you raise or lower the nipping station, you can use it only when the spine base plate is out. |
| 5 | With these buttons you raise or lower the arm |
| 6 | With this button you can rotate the gripping hand |
| 7 | With this button you can close/open the fingers of the gripping hand |
| 8 | With this button you can enable the rotation of the belt. It is necessary to release a book not released in a proper way. |

11.2.4PARAMETERS FOR COVER FEEDER


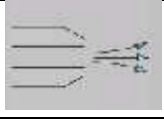


| | |
|---|---|
|  | <p>With this button you can pick up the cover and put it on the nipping station.</p> |
|  | <p>With this button the arm returns in the loading position.</p> |
|  | <p>This button lowers the plane covers. If you open the protective cover the plane stops.</p> |

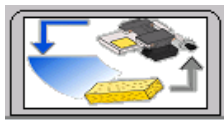
Manual movements



MyBinding.com
5500 NE Moore Court
Hillsboro, OR 97124
Toll Free: 1-800-944-4573
Local: 503-640-5920

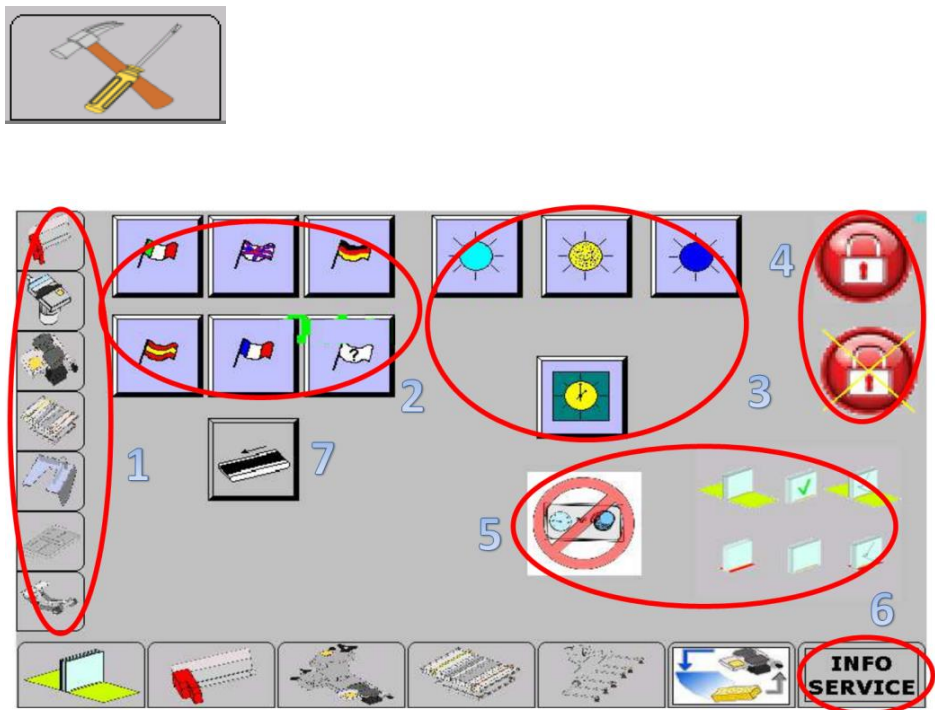
| | |
|---|---|
|  | With this button you can enable the suction, on the sucker. |
|  | With this button you can enable the frontal blower. |

11.2.5 CLEANER AND GLUE LOADING



See the next chapters.

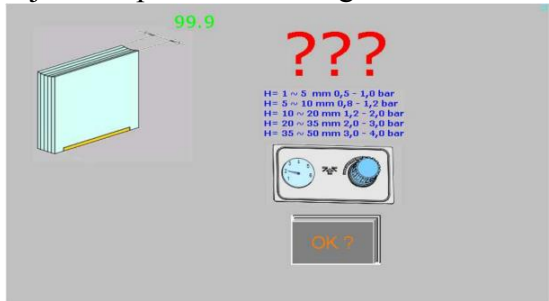
11.3ACCES TO ADVANCED SET UP PAGES



| | |
|----------|---|
| Area 1 | Acces to advanced set up pages |
| Area 2 | Buttons for language selection |
| Area 3 | Buttons to adjust the display brightness and setting the date and time. |
| Area 4 | Buttons to access technical area under password |
| Area 5 | Buttons enabling and disabling tutorial |
| Button 6 | Button to open windows of technical information |
| Button 7 | With this button you can enable the rotation of the belt. |

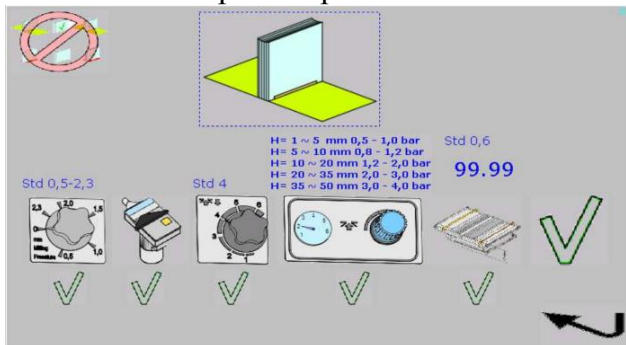


When this function is disabled, the machine does not ask anymore to verify the pressure of the glue when a book has a thickness, compared to the previous, with a difference greater than 10mm. When enabled the machine opens the window below as a reminder you have to adjust the pressure of the glue.








When you disable this function, the machine does not show anymore the tutorial when you change the type of book you want to produce. of work. When enabled, it opens the window below which helps the operator to set the machine.

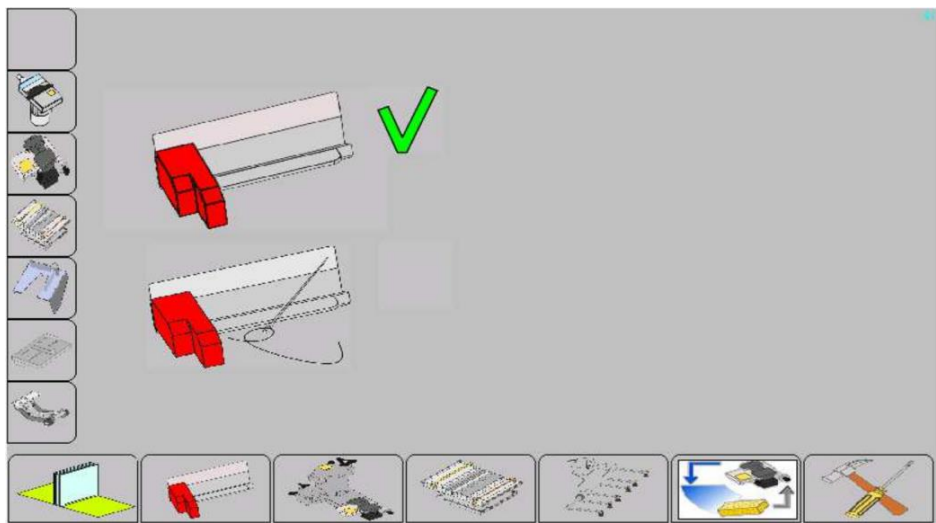


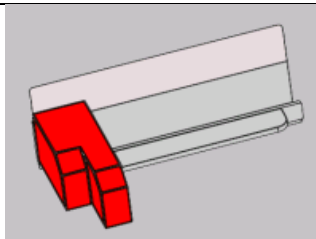
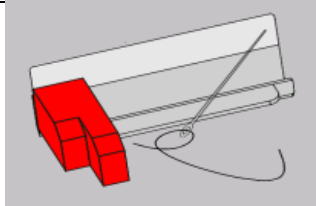
When you push this button the window below appears.



| | |
|---|---|
| 1 | <p>If the icons are gray, it means you have not done the reset for the axis.</p> <p>If the icons change color from yellow to green, the axis has done the reset but it is not in working position.</p> <p>If the icons are green, the axis has done the reset and it is in working position.</p> <p>The green numbers on the side of icons indicate the current position of the axis.</p> |
| 2 | <p>Parameters to be reported to the technical service for remote maintenance.</p> |
|  | <p>Open the window input / output of the PLC to be used for remote maintenance.</p> |
|  | <p>Open the alarm history window.</p> |
|  | <p>Open the window of the alarms currently present.</p> |



11.3.1 ADVANCED SET UP FOR CLAMP



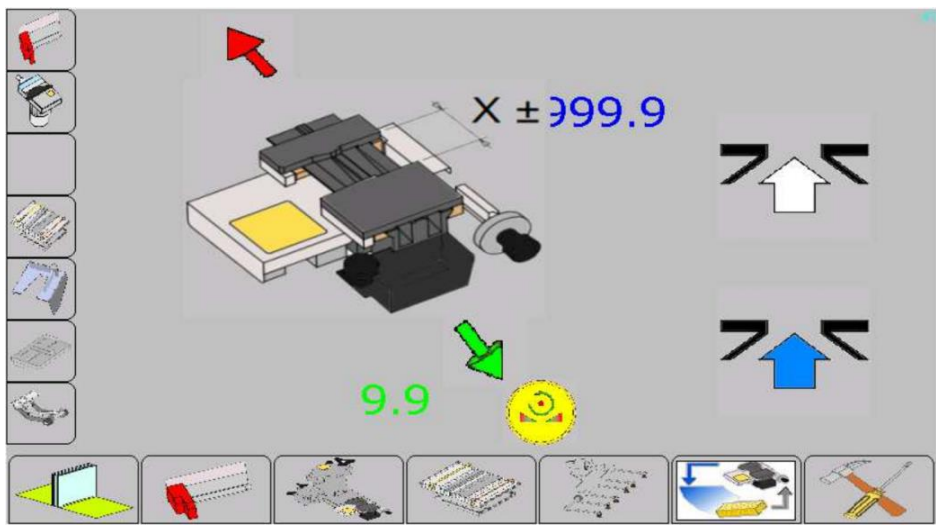
| | | |
|---|--|--|
|  | | Clamp with a standard set up |
|  | | Clamp with a set up for a sewing book. This set up facilitates the insertion of the book inside the clamp. |

11.3.2 ADVANCED SET UP FOR MILLING STATION

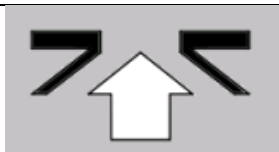
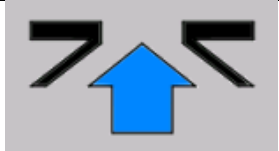
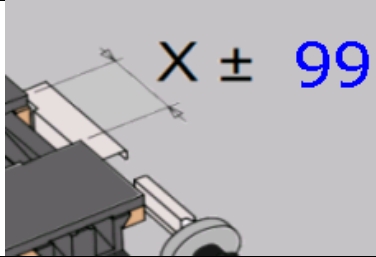


| | | |
|---|--|---|
|  | | Power vacuum cleaner |
|  | | Release of the engine brake on the nipping station NB it works only when the emergency button is pressed. |

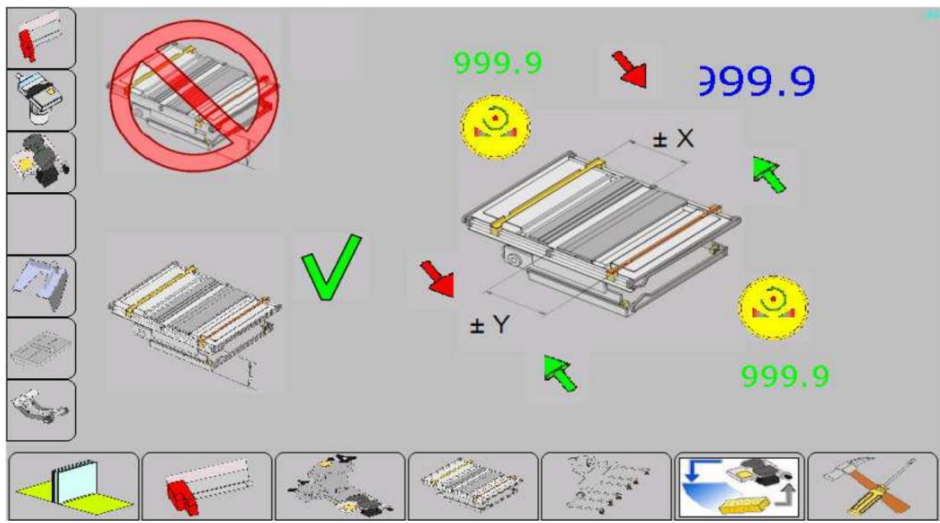
11.3.3 ADVANCED SET UP FOR GLUE HEAD



Manual operation for glue station:

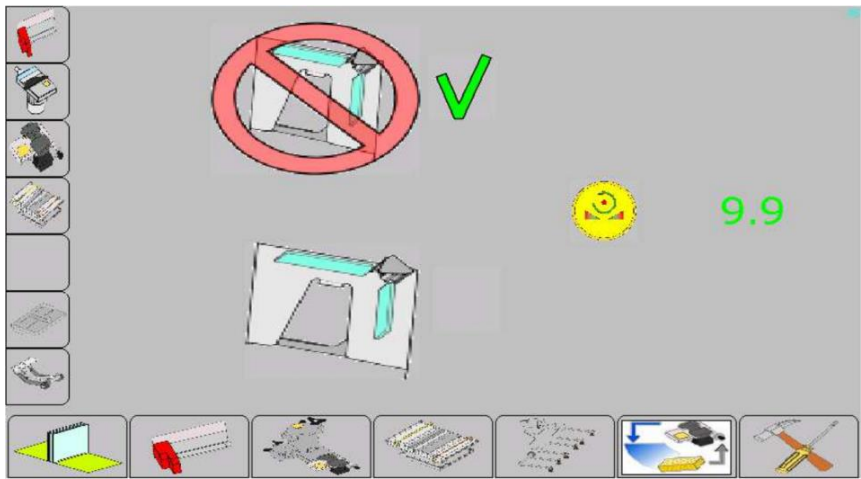
| | |
|---|---|
|  | <ul style="list-style-type: none">• If you press and release rapidly, it opens and close the nozzle of the glue head.• If you hold it spills out the glue NB. First of all, set the glue pressure |
|  | With this key it is possible to activate cleaner spillage. |
|  | Offset value for opening the glue head compared to the default value. |

11.3.4 ADVANCED SET UP FOR NIPPING STATION



| | |
|--|---|
| | Nipping station disabled |
| | Nipping station enabled |
| | Value to move back and forth the cover on the nipping station. Max. value $\pm 0.059\text{in}$ |

11.3.5 ADVANCED SET UP FOR THICKNESS SURVEY

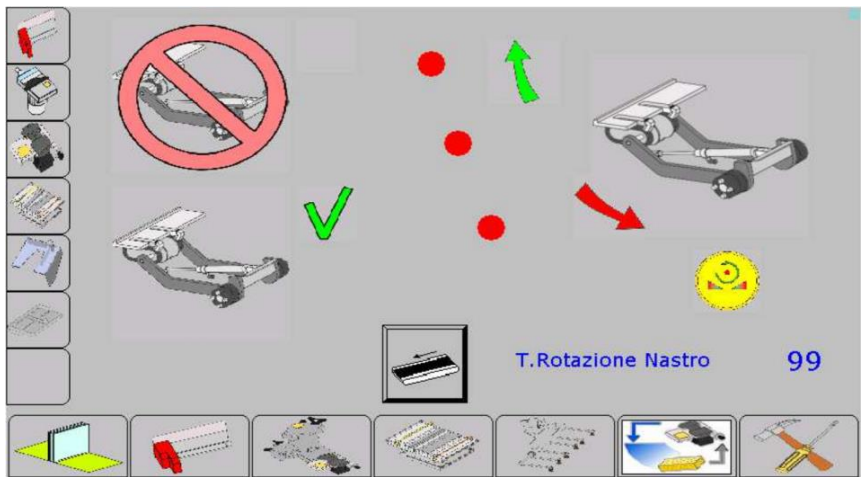



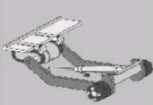


11.3.6 ADVANCED SET UP FOR COVER FEEDER



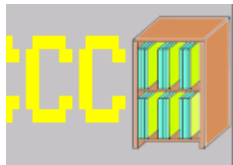
Offset compared to the default value. Max. value ± 0.5 in

11.3.7 ADVANCED SET UP FOR DELIVERY ARM

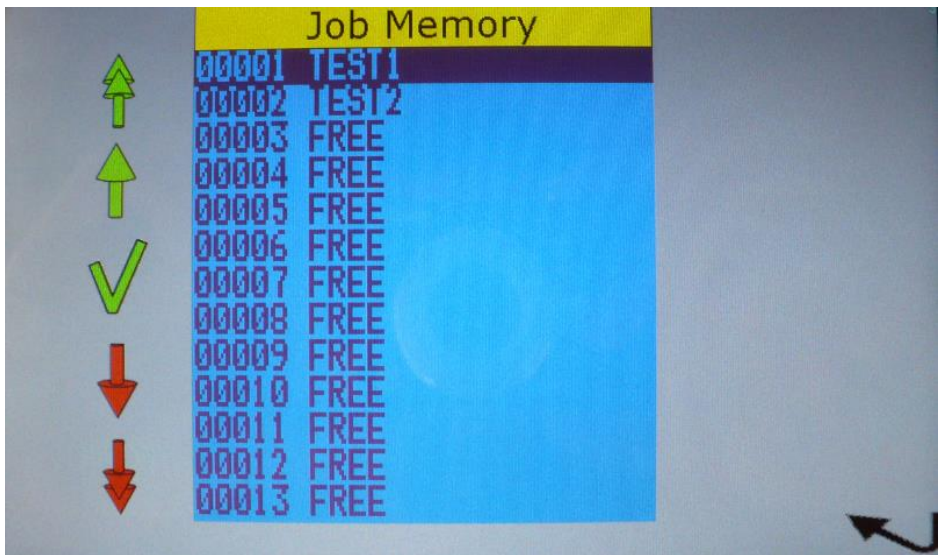


| | | |
|--|--|-------------------------------|
|  | | Delivery arm disabled |
|  | | Delivery arm enabled |
|  T.Rotazione Nastro 99 | | Rotation time of the belt. |
|  | | Activation for belt rotation. |




11.4MANAGEMENT PAGE FOR WORKING JOB



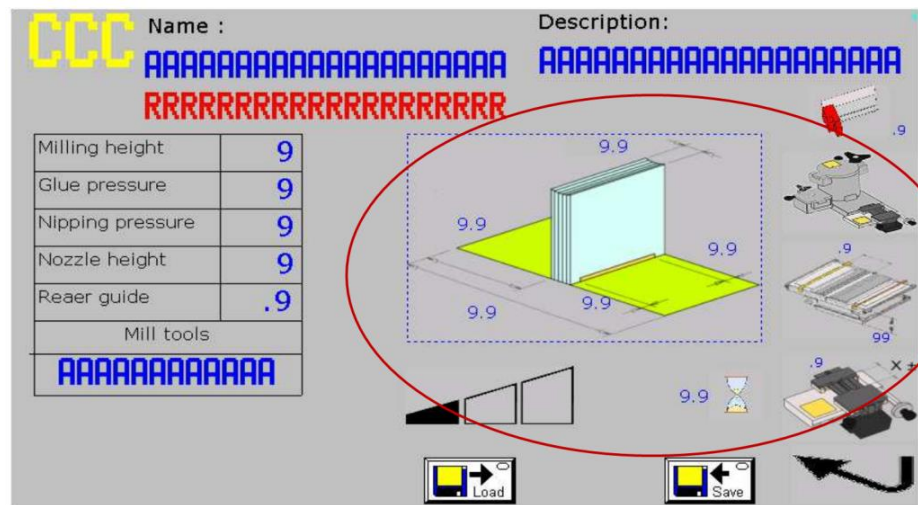
11.4.1MANAGEMENT OF THE JOBS



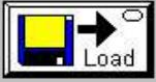

It is possible to save until 100 working JOBS.

| | |
|---|--|
|  | To move from previous memory job to the next one |
|  | To move from ten previous memory job to the next ten |
|  | Selection of memory job |

When you select the working JOB the window below appears.







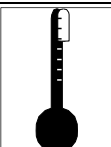
The circled values are the current settings of the axes, they are not editable.
All other texts written in blue can be edited, they help the operator to set the machine in the correct way.

| | |
|---|--|
|  | To load the values of memory job in the machine. |
|  | To save the current values in the memory job. |




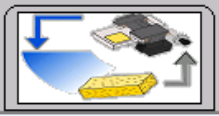
12 PREPARATION OF THE MACHINE TO PRODUCE A BOOK.

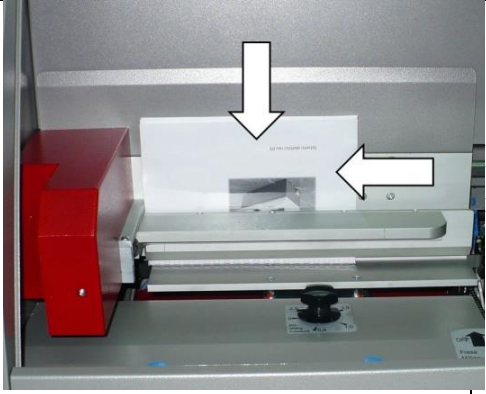
12.1 CHECKS TO BE DONE BEFORE STARTING THE JOB

Before to use the binder perform the following controls:

| | | |
|--|---|---|
| |  | The operator must have read and understood this manual, including the important information concerning the SAFETY. |
| |  | Make sure you have appropriate clothing to work and, if necessary, also safety clothing. |
| |  | Ensure that the binder is properly powered and connected to ground (PE) |
| |  | Ensure that the pneumatic system of the binder is properly fed and if the main switch on the factory is open. |
| | | Verify that the chips aspirator is connected to the binder and its power switch is in position 1 = ON. |
| | | Check that in the tank there is a minimal amount of glue to allow to process several books, otherwise insert a new cartridge of glue inside the tank. |
| | | Tank for glue collection flushed. |
| | | Ensure that the binder is clean and without books or covers, especially: Clamp, Jogger, Milling Station, PUR head, Press. |
| |  | Check that the settings for temperatures are correct for the used glue and that have been achieved the correct values to work. Refer to the technical sheets of the glue/cleaner manufacturer. |
| | | Verify that the values of temperatures have reached their work values. Both temperature indicators must be lit. |
| | | If necessary, remove the layer of Blue-Cleaner from the PUR head. |

12.2SWITCHING ON THE MACHINE


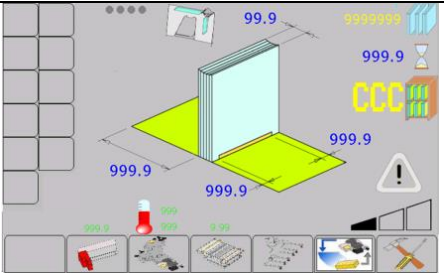
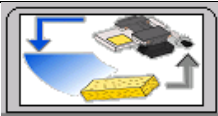
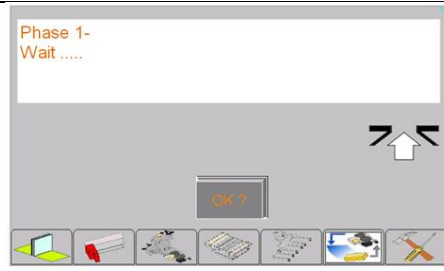


| | | |
|----|---|---|
| 01 |  | Switch on the machine using the main switch. Move the switch to ON position |
| 02 |  | Verify that the pressure indicated on manometer is correct. MIN 6 bar |
| 03 |  | Open the valve on premelter. The valve with the lever on vertical position means open. |
| 04 | | Verify the chosen temperatures |
| 05 | | Make a general reset, pressing START button |
| 06 | | Position the axes, pressing START button |
| 07 | <div>Press the button </div> | Launch the procedure, the machine do a series of cycles opening and closing the glue valve. At a later stage, follow meticulously the procedure below. |

| | | |
|----|--|--|
| 08 | | To produce a milled book, set the milling depth. |
| 09 | | If you have to produce a not milled book, act on the leverage that allows to lower the milling station. |
| 10 | | Key the parameters of the book thickness, cover, front and rear glue stop. |
| 11 | | Set the required speed |
| 12 | | Set the glue pressure |
| 13 | | Set the nipping station pressure |
| 14 |  | Load the book block in the clamp as indicated by the arrows in the picture and press the START button. |
| 15 | | The machine will draw the cover from the cover feeder, it will close the clamp, the clamp will start moving passing over the milling station and the glue station. When the clamp will reach the right position, the nipping station will apply the cover. During pressing time the clamp will remain on the nipping station, the nipping station lows, the delivery arm take the book and it will release it on the release belt. In the meantime the clamp will go back to loading position and another cover will be drawn. |

12.3GLUE REFURBISHMENT PROCEDURE

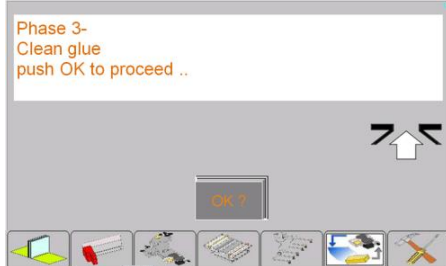
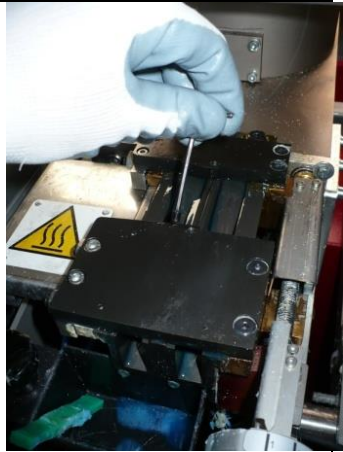
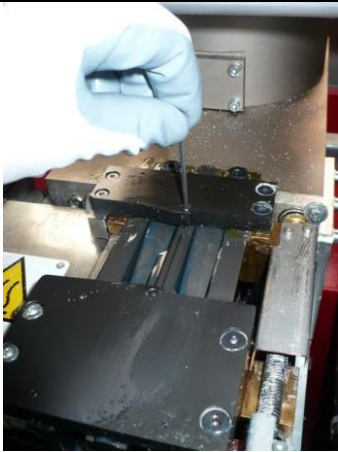
The glue refurbishment procedure must be done every time the machine is switched off with the procedure END OF JOB.


In case the machine has been switched off with the END OF JOB procedure, it will be possible to start working only doing a glue refurbishment. An error message appears “Machine with Cleaner”.

| | |
|---|--|
|  | Primary condition: machine in temperature tank valve open in vertical position |
|  |  Hold the button for few seconds to start the GLUE REFURBISHMENT procedure |
|  | The glue head opens |
|  |  |

Remove the grub screws using the allen key you have (pay attention to the temperature) and set the pressure of the glue at 1 bar.

Press **OK**



Press the button  until the traces of Blue cleaner disappear.



Help yourself with the calibrated blade you have.

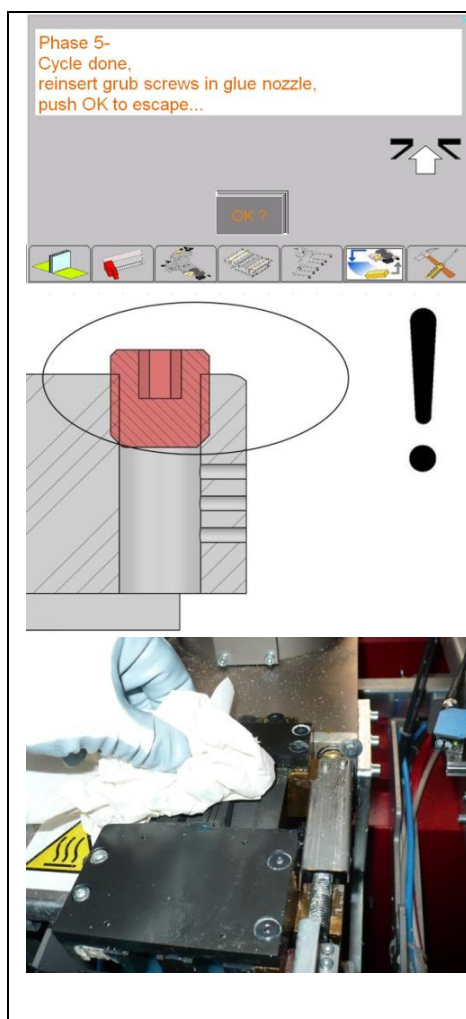


Using the green palette you have, make the spilled material to flow into the collection tank.

Once the procedure is over, press **OK**



During this phase the machine automatically closes the head and fills the lateral passages with glue. Once the procedure is over, the head opens again.



Replace the grub screws using the allen key you have (pay attention to the temperature). Press **OK**.

Attention! Grub screws max. protrude 1 mm

Clean very well all the excess of material spilled out using the palette and paper towel.

Press **OK**. Now the machine is ready to work.

13 CLEANING THE MACHINE

When the machine works using PUR glue, it is imperative and essential an accurate cleaning of the glue.

The dried glue is no more fusible.

Residue of glue during the drying process can cause blockages or an incorrect and not uniform extrusion of the glue.

The glue group must be kept clean with the deposits of glue, PUR glue residues harden over time and cause damages to the equipment.

Performing the “End of job cleaning” it is possible to save the machine turned off containing PUR glue for 2 weeks.

CLEANING IS COMPULSORY for proper operation of the machine.

"If the machine is **switched off or unused for more than 120 minutes** it is necessary to make the cycle of "End of job cleaning".

EVERY DAY:

END OF JOB CLEANING

ONCE IN THE WEEK:






**EMPTY THE CHIPS ASPIRATOR
CLEANING LATERAL EXTRUDER
CLEANING SPINE EXTRUDER
CLEANING DETAILS**

In case of:


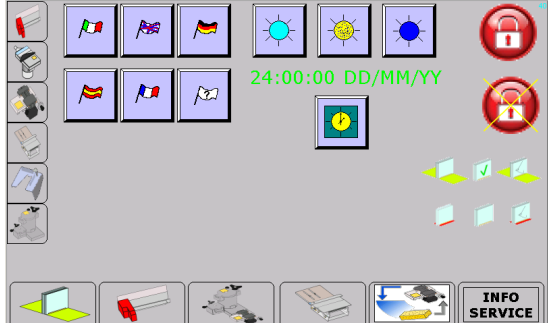

| | |
|-------------------------------------|---------------------------------------|
| Some pages are not glued | Perform the SPINE EXTRUDER CLEANING |
| The glue on the side is not uniform | Perform the LATERAL EXTRUDER CLEANING |

13.1“END OF JOB” CLEANING

| | |
|---|--|
|  | <p>To switch off the machine at the end of the day you must eject the remaining glue inside of the extruder.</p> <p>To do it you must activate the automatic procedure that allows executing a safe switching off.</p> <p>Hold for a few seconds the BUTTON  to start the procedure.</p> |
|  | <p>During this phase the glue group opens and the glue starts to spill.</p> |
|   | <p>Press  until all the glue traces disappear. For this operation help yourself with the calibrated blade.</p> <p>Use the green spatula included and make the glue to flow in the collection tank. Try to remove as much as possible of the released cleaner.</p> |
| <p>Screw the grub screws using the same included allen key (Pay attention to the temperature).</p> <p>Press OK.</p> |   |

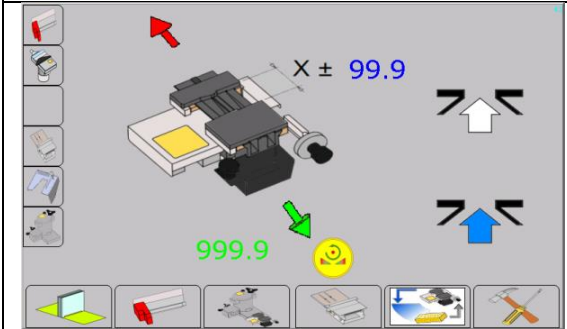
| | |
|---|--|
|  | <p>During this phase the machine closes the head automatically and clanc the lateral passages of the glue. Once this operation is over, it opens again the head.</p> |
|  | <p>Use the green spatula included and make the glue to flow in the collection tank. Try to remove as much as possible of the re-leased cleaner.</p> |
|  | <p>During this phase the glue station closes</p> |
|  | <p>Replace the grub screws using the allen key you have (pay atten- tion to the temperature)</p> <p>Press OK</p> |
|  | <p>Close the rear valve</p> <p>When the valve is horizontal, it is closed.</p> <p>Now the machine is ready to be switched off.</p> <p>If you do not complete this cycle the machine will emits an acoustic warning signal.</p> |

13.2PROCEDURE TO CLEAN THE EXTRUDER FOR THE SPINE GLUE.

| | |
|---|--|
|  | <p>Press the Button “Manual movements”.</p>  |
|  | <p>Press the key dedicated to the glue head</p>  |
|  | <p>Press reset  to open the head until reset position.</p> |
|  | <p>Insert the calibrated blade into the slot extrusion until you touch the bottom and move it along the slot to remove or release any possible obstructions.</p> |



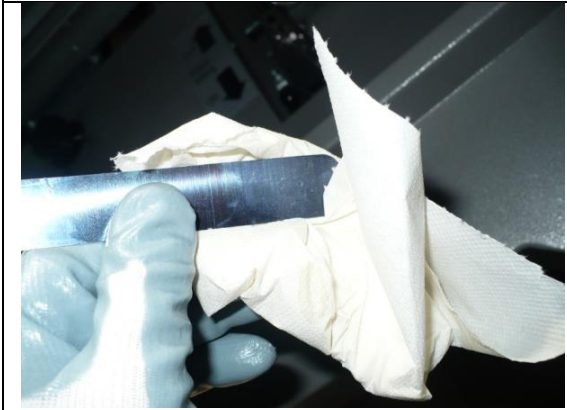
Adjust the value of the glue extrusion pressure to 1 bar (14.5psi).



Hold the key for few seconds until you do not see the glue spilling.

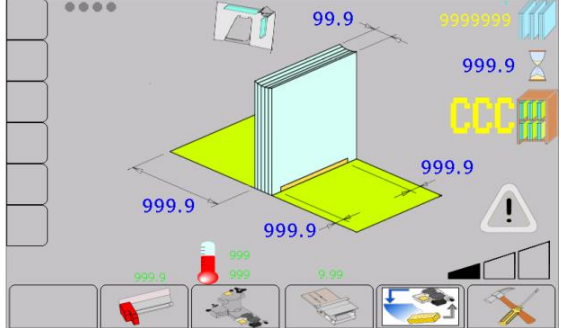
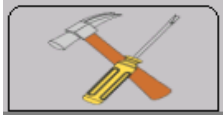
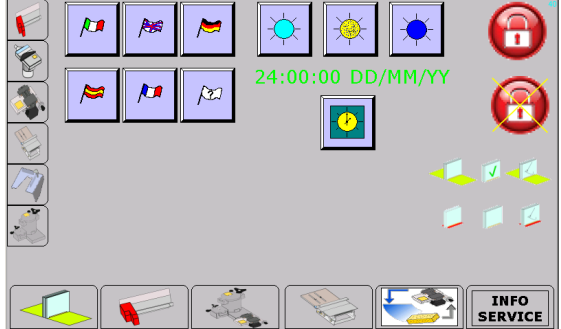

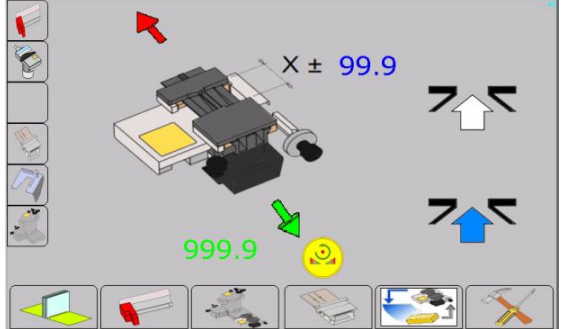

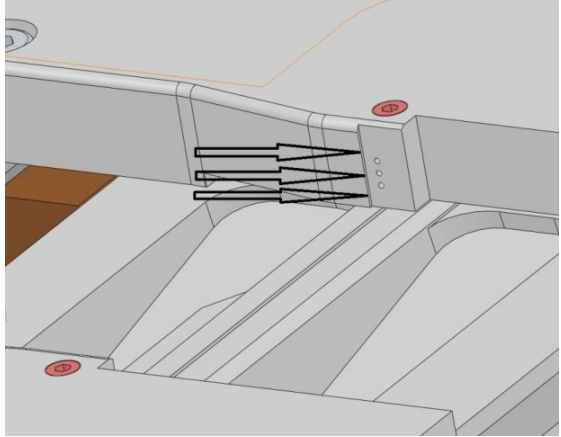
Verify that the glue extrusion is uniform and continuous; otherwise, insert the calibrated blade and repeat the cleaning operation.

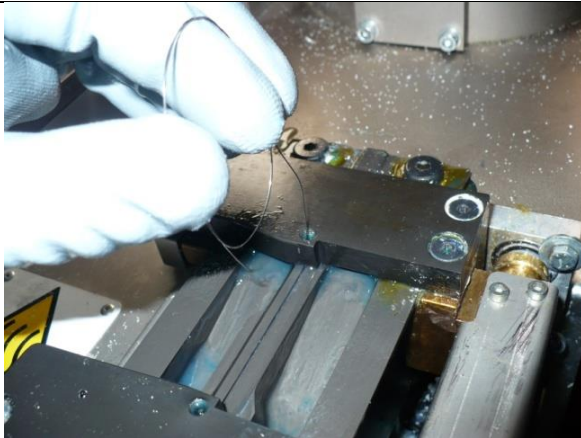
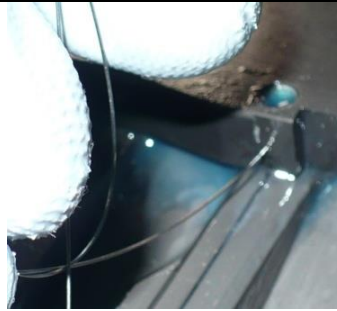
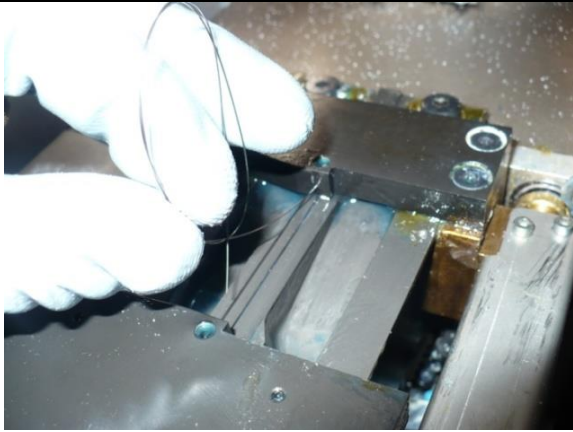
The tank pressure will go down after 10 seconds of inactivity.



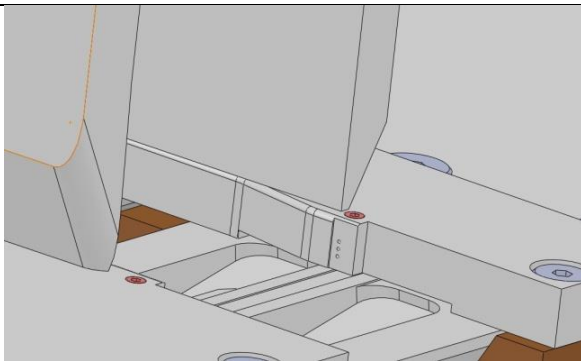
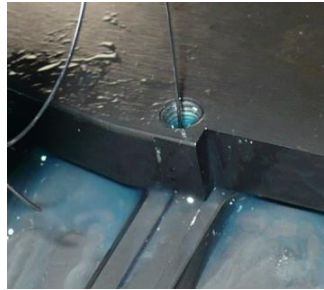
Clean the blade carefully.
When the glue is fully cured the blade will useless.

13.3 PROCEDURE TO CLEAN THE GLUE LATERAL EXTRUDERS

| | |
|---|--|
|  | <p>Press the Button “Manual movements”.</p>  |
|  | <p>Press the key dedicated to the glue head </p> |
|  | <p>Press reset  to open the head until reset position.</p> |
|  | <p>The glue spread on the side of the book is extruded through 3 small channels located on the plates containing the book.</p> <p>To have a correct extrusion of the lateral glue, you must remove the grub screw and insert in the 3 holes the included wire. Repeat the same operation on both the retaining plates of the book.</p> |

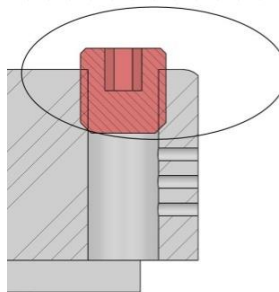


Pass the thread also in the main conduit until you enter into the slot below the retaining plates of the book.

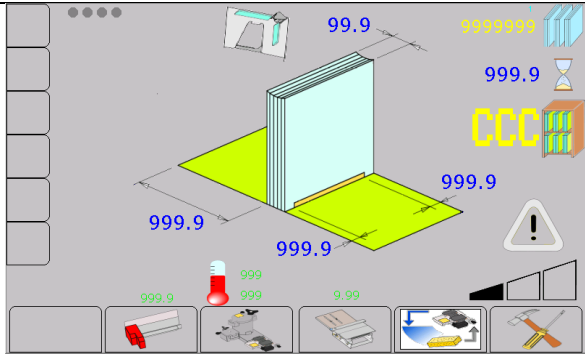

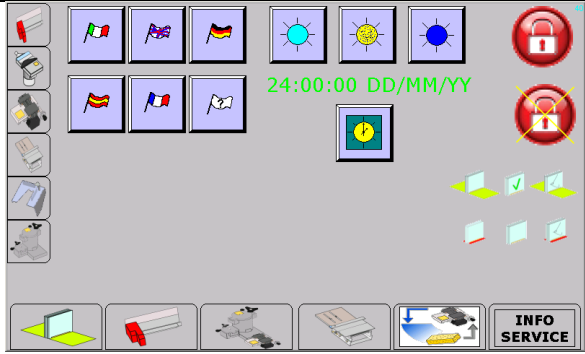
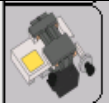
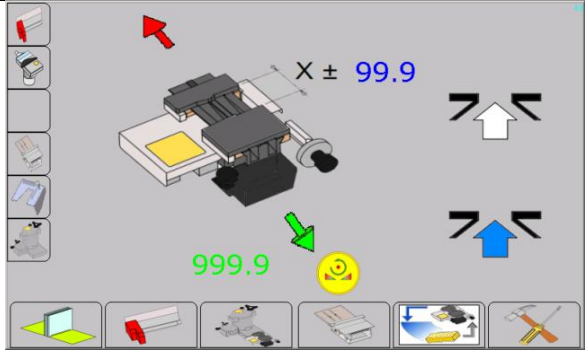

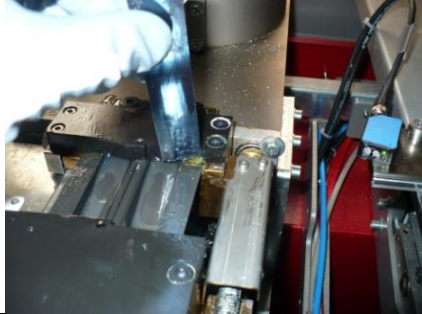


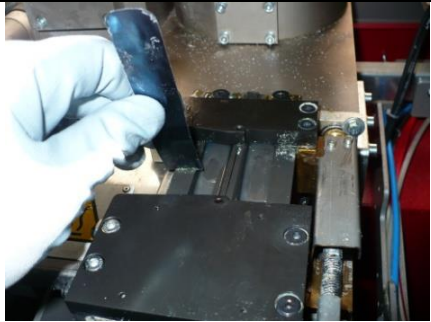


Be careful. When you replace the grub screws, they cannot protrude otherwise you cause a collision with the nipping station.

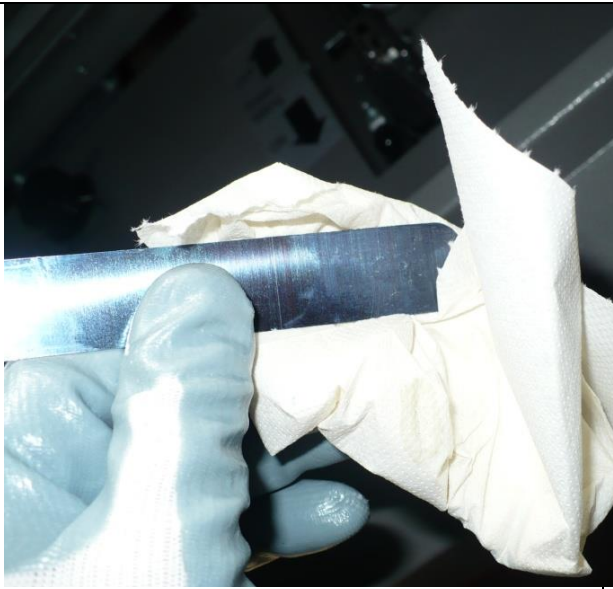
Attention! Headless screws max. protrude 0.039in



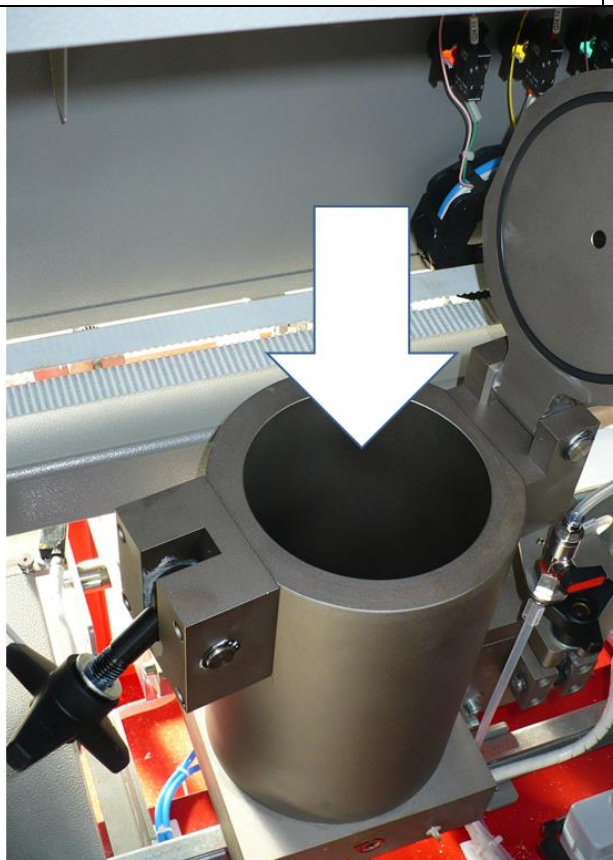
13.4DETAILS CLEANING

| | |
|---|---|
|  | <p>Press the Button “manual movements”</p>  |
|  | <p>Press the head key</p>  |
|  |  <p>Press reset to open the head to the reset position</p> |
|  | <p>Use the blade or a suitable tool to remove all the visible traces of residual glue.</p> |

| | | |
|---|--|--|
|  | | |
|   | | <p>If necessary you can use liquid solvents to get a better cleaning of the surface.</p> <p>During the use of liquid solvents refer to the safety instructions provided by the solvent manufacturer.</p> |



Clean carefully all the used tools, otherwise they become unusable later.



Clean periodically the glue tank. Please pay attention to **HIGH TEMPERATURE**, use rags that do not leave any remain. Use scraping off tools that do not damage the internal surface of the premelter. Avoid that parts of cured glue remain inside the premelter. These would occlude the nozzle.
If the premelter is too dirty or crusted, please call the assistance to wash it with proper solvents.

14 Problems - Solutions

14.1 CHIPS ASPIRATOR – LESS VACUUM:

- Verify that the Plexiglas inspection, located on the Milling Station, is free.
- Verify that the chips aspirator tank is empty.
- Verify that the chips aspirator tube is not full of chips.
- Verify that the aspirator filter is clean.
- Verify that the hose is connected.

14.2 CLAMP – IT DOES NOT START:

- Verify the presence of the book in the clamp.
- Verify that the emergency switch is disabled.
- Verify that the barriers are completely free.
- Verify that the photocell detecting the book and the related reflector are clean.
- Verify that the photocell or the reflector of the press is free from books, pieces of paper or dust.
- Verify that the clamp jaws are free from residual glue.
- Verify the air pressure in the machine
- Verify that clamp is in the right position.
- Verify that the carriage is in the right position.

14.3 IRREGULAR GLUE START / STOP:

- Clean the photocell and the reflector positioned between the jogger and the milling station.

14.4 MILLING STATION – IRREGULAR CUT AND NOTCHING:

- Verify that the Milling disk is not broken or damaged. This could happen by the management of books already bound with glue (FORBIDDEN). ***IF K.G.S. FIND OUT THAT YOU HAVE MILLED BOOK ALREADY BOUND WITH GLUE, K.G.S. WILL VOID THE GUARANTEE.***

14.5 COVER PLATE MILLING STATION – IT DOES'T OPEN / CLOSE CORRECTLY:

- Remove the 4 screws by using a allen key number 4. Remove the cover plate of the milling station releasing the elastic cord. Clean inside of the milling station box.
- Shorten the elastic cord by a node close to the interior of the Milling Station box, increasing the strength of the plate closure

14.6 HEAD - OUT OF TOO MUCH OR LITTLE GLUE:

- Verify the air pressure of the glue group.
- Verify that the head shutter is free, using the provided blade.
- Verify that the side holes are free, using the provided steel wire.
- Verify that the injectors are working properly (they must move back and forth 0.12-0.16in).

- Verify the presence of glue in the tank.
- Verify that the glue in the tank is not cured.
- Verify that the tank valve is open.
- Verify the position of the internal lateral jaw: it must be 0.10 tenths back from the edge of the clamp.
- Verify the head height: if it comes out a little glue lower the head and increase the air pressure of the glue group, if it comes out too much glue raise the head and lower the air pressure of the glue
- Verify that the glue is not deteriorate

14.7 NIPPING STATION

- Press so much: lower the air pressure of the press group or the spine height.
- Round spine: increase the press height.
- Edge pinched: contact technical support.
- Not uniform spine: contact technical support.

MyBinding.com
5500 NE Moore Court
Hillsboro, OR 97124
Toll Free: 1-800-944-4573
Local: 503-640-5920