



User's Guide

PUR Perfect Binder

Zhejiang Daxiang Office Equipment Co., Ltd.

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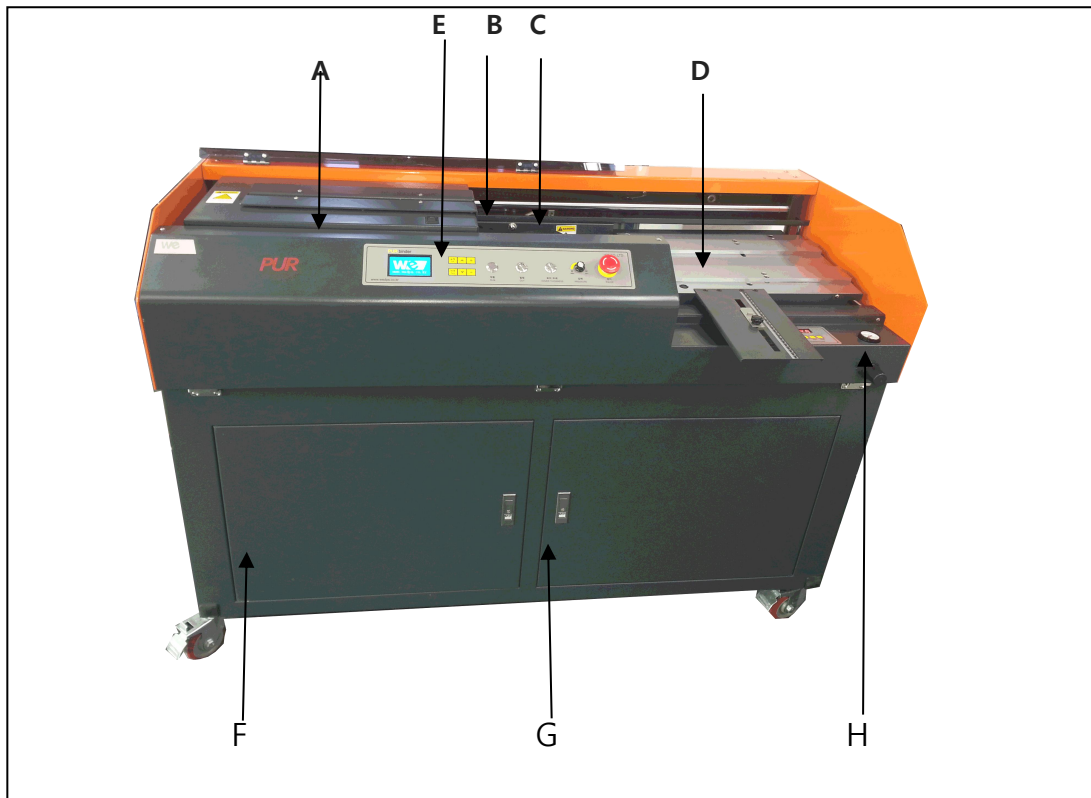
Specifications

- Model : BA3PUR
- maximum binding length : 460mm
- binding thickness : 1mm - 60mm
- weight about 275KG
- Size 1500 × 600 × 1250 mm

- Model : BA4PUR
- maximum binding length : 330mm
- weight about 240KG
- Size: 1450*580*1200 mm

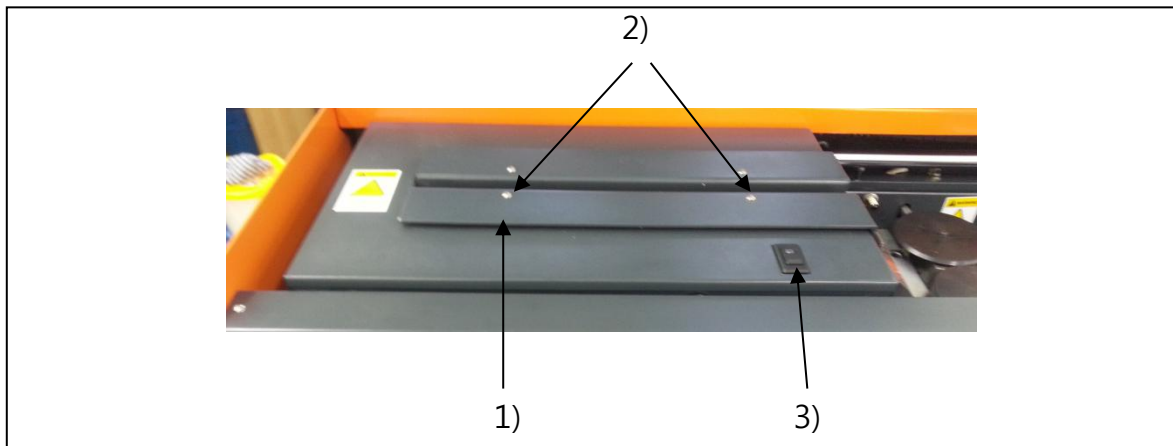
- Pur melt time : 30minutes
- double straight line guide clamp system: digital transmission
 - Pur melt cut off the supply of – nozzle spray system (it can use a system)
 - (Pur melt supply-air shut-off nozzle spray method)
- power supply 220 V / 50 / 60 Hz 3kw

1. PUR structure



- A. Clamp
- B. milling
- C. Pur nozzle
- D. Clamp cover platform
- E. operation panel
- F. Paper dust collecting device
- G. air and dissolving tank Division
- H. Nozzle Pressure Regulator

A. Clamp section



1)Clamp guide parts

The guide parts that keeps the booklet in a stable milling and nipping operation. If there is wastepaper on the bottom of the guide, It should be kept clean.

2)Clamp guide fixing bolt

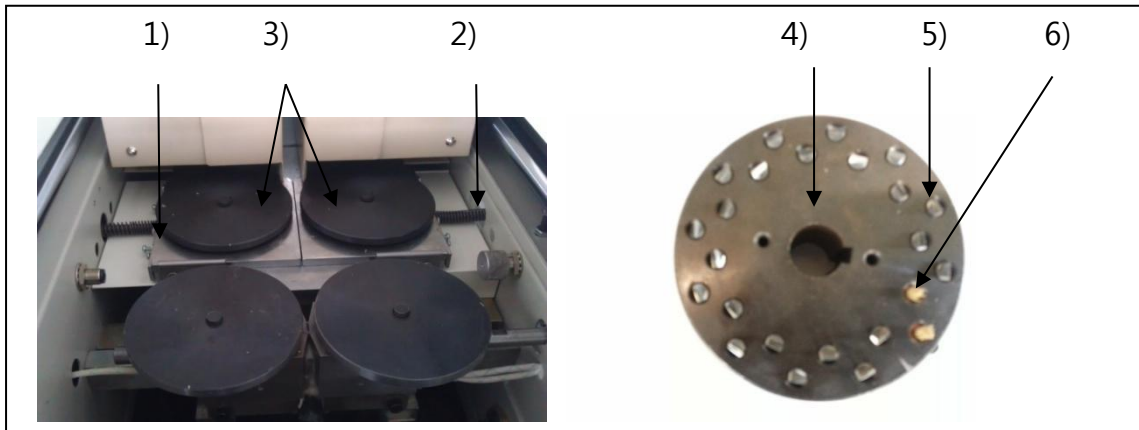
Guide bolts are loosened for cleaning, adjusting, etc., and guide
If reinstalling, tighten the bolts loosely and then tighten the clamp width adjustment switch, Tighten the bolt once again after tightening

3)Clamp width adjustment switch

Switches for adjusting the thickness of workpieces

-

B. Milling part



1) milling cover

You must keep it moving to the left and right.

2) milling cover spring

Be careful when reassembling and make sure the cover is moving well

3) open solar disc

Operated by clamp guide

4) milling Assembly

Careful adjustment of the quality of the pur binding is determined by accurate milling operations.

5) Milling groove blade

It is composed of 22 pieces, but if there are more than 12 pieces, there is no problem in the work.

If there is a problem in the groove of a book, please replace it.

It is good. (If there is no problem in work quality, it can be used continuously.)

6) Equilibrium trowel Soles 0 - 2 Install according to the workpiece.

B-1 How to replace milling groove knife



1) Groove blade installation direction

Install the grooved knife in the direction shown in the figure.

2) Groove knife fixing bolt

3) Home knife play adjusting device

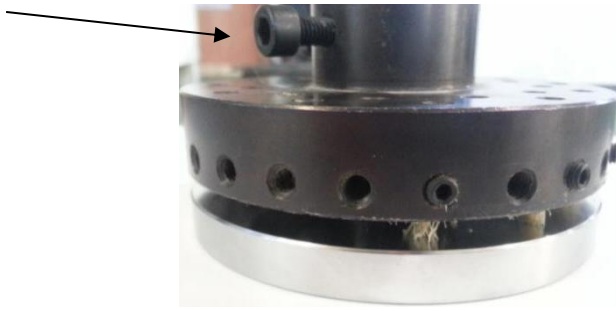
4) How to replace

Place the milling assembly on the groove replacement device and determine its height (fixing bolt A-1).

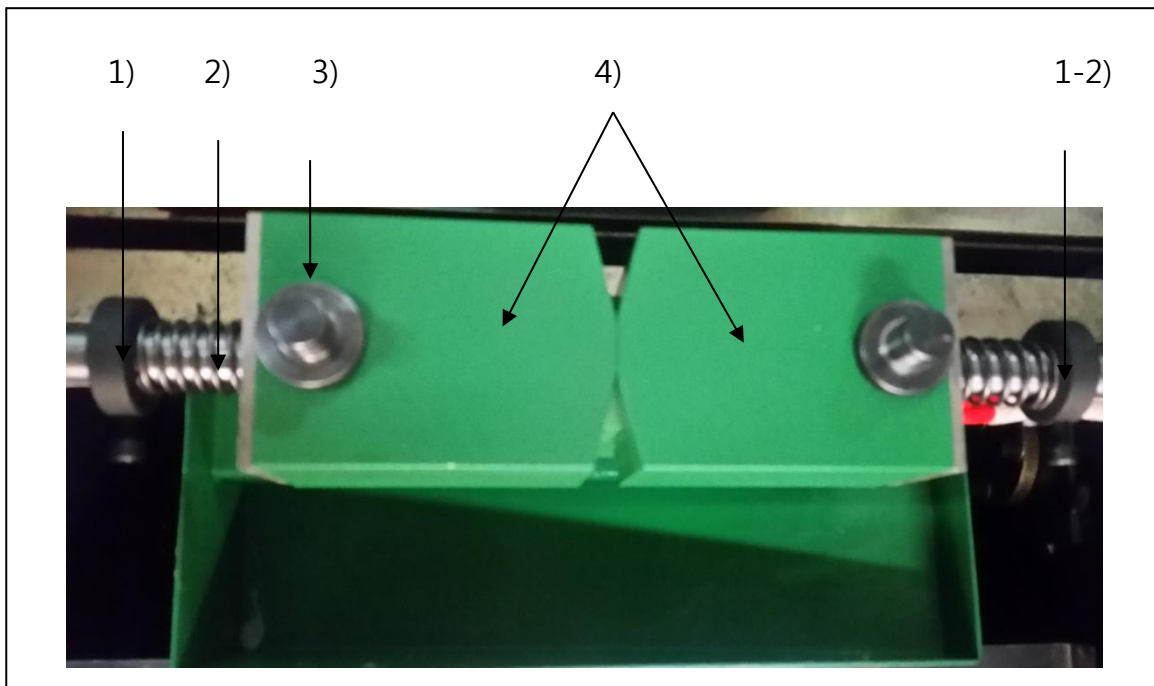
Make sure the groove knife is in contact with the bottom of the replacement device,

Tighten

Fixing bolt A-1



C. Nozzle part (new type)



1) Nozzle opening adjustment device (left, right 1-2)

Normally, when the book thickness is 30mm or less,

When working on very thick (over 30mm) books, loosen the setscrews and open them more.

2) Nozzle cover spring

3) Nozzle open cam axis

If nozzle cleaning is bad, the cam shaft wears out quickly so that it is cleaned and

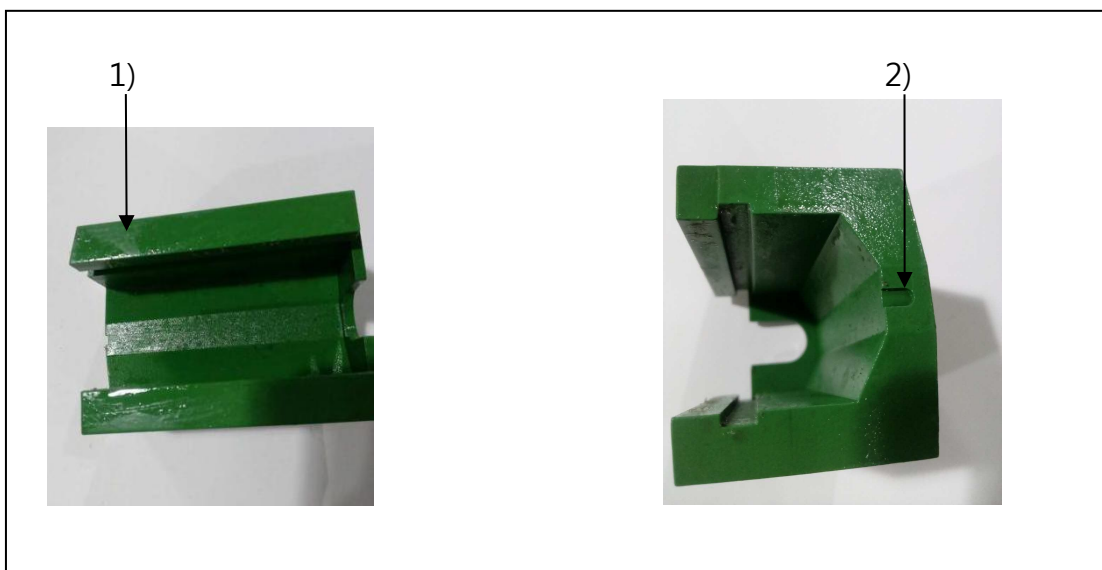
It is important to keep the nozzle.

4) Nozzle cover

It is the most important part of the application

Cleaning before and after work with pur cleaner only gives you regular work. Before work, please use dry towel to clean.

C-1 Inside nozzle cover

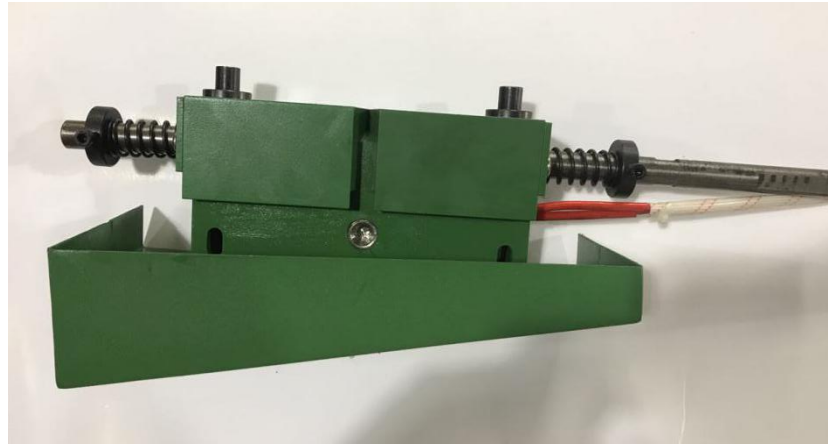


1) Nozzle cover

2) Side glue application device

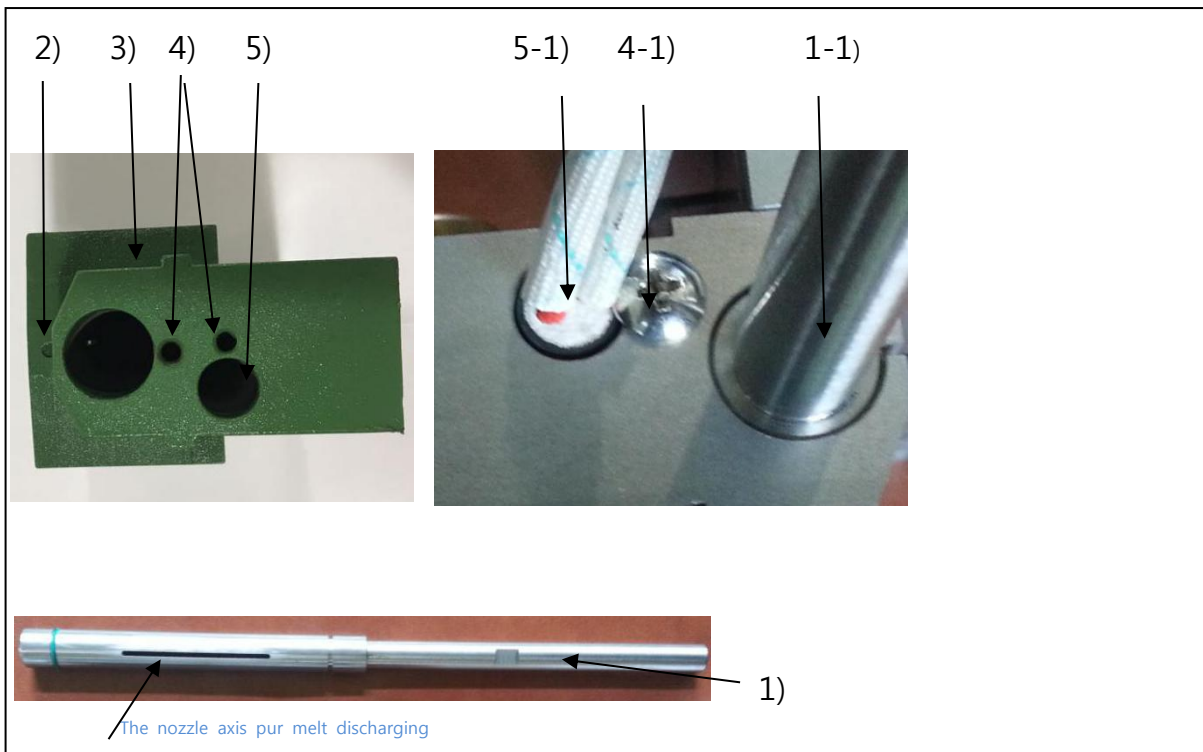
It is a place to paint the side glue, so it needs to work in a clean condition.

Cleaning method is to remove hardened PUR paste by NOT using sharp tool such as awl, Please use by plastic or bamboo.



Nozzle assembly

C-2 Inside nozzle and heat transfer device



1) The nozzle axis

By the rotation of the nozzle shaft (the nozzle axis pur melt discharge part)

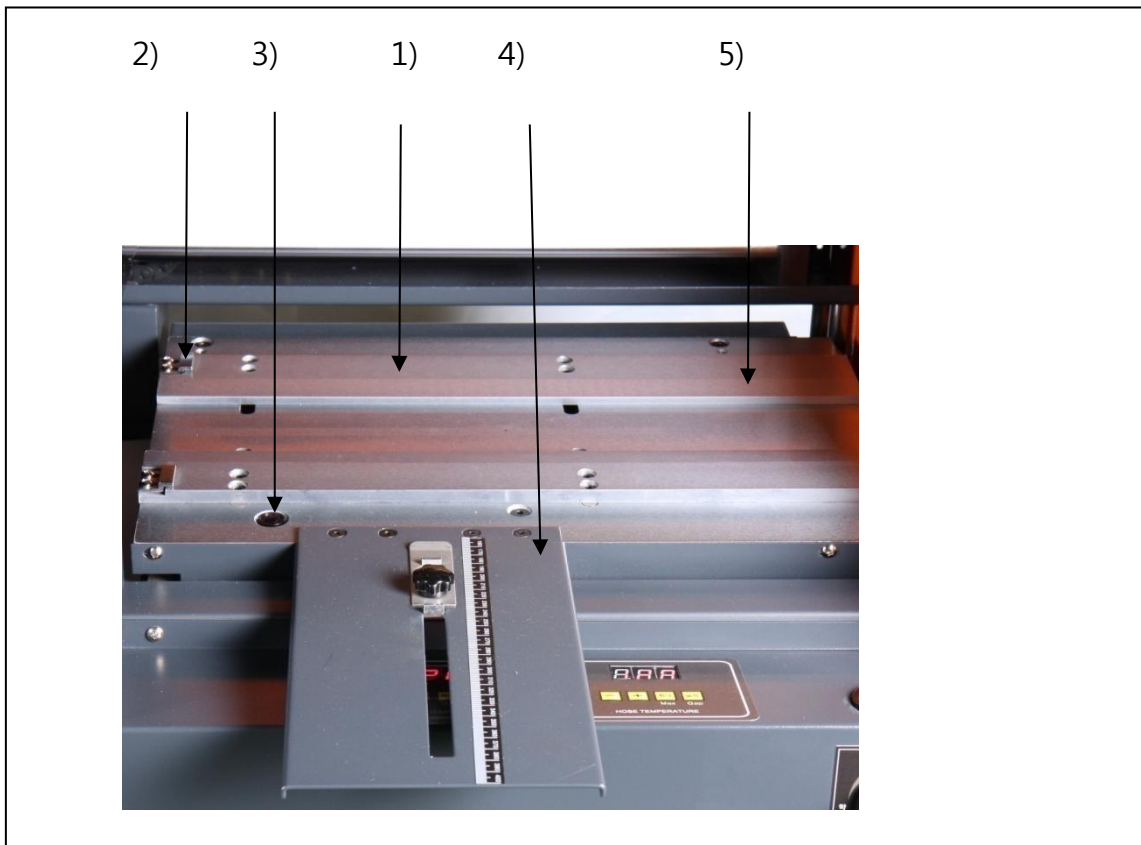
2) PUR melt main supply part

3) Place the nozzle shaft

- 4) Nozzle heater fixing bolt
- 5-1) Nozzle heater
- 5) Nozzle heater installation place

① It is important to check the movement of the nozzle axis because the pur melt is supplied when the nozzles (1) and (2) meet by rotation. It is safe to visually confirm that the grass is supplied and work is required)

D Clamp cover platform



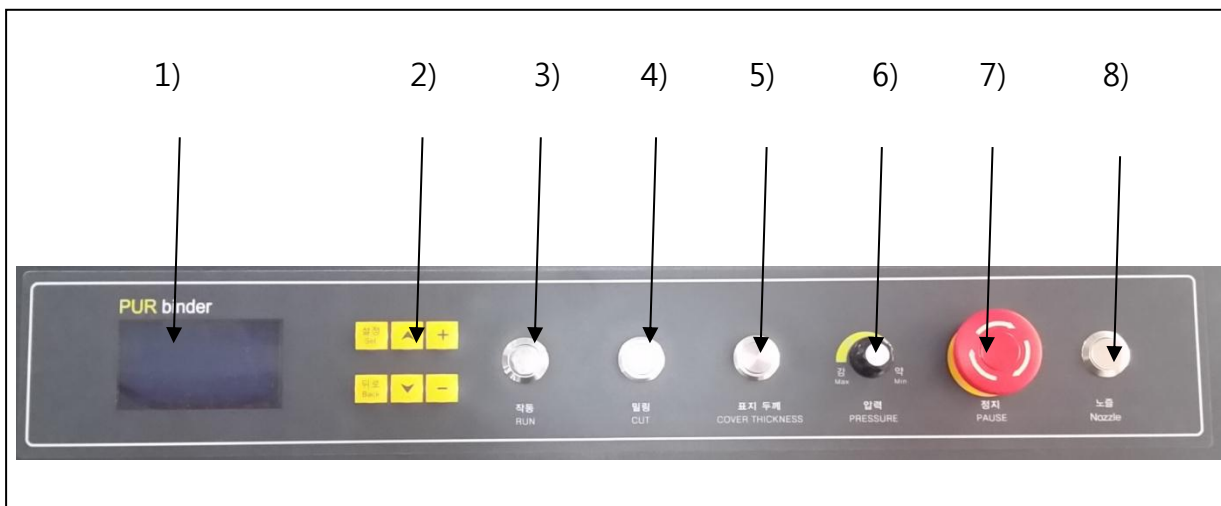
- 1) clamp cover assembly

It is a part that makes books, etc. Using the switches on the front panel

The back is rounded - it makes up to right angle.

- 2) It is possible to adjust 2mm side by side according to need
- 3) When the automatic bookbinding mode is selected, the sensor recognizing the cover
(If there is no cover, it will not be auto start)
- 4) Cover setting guide
- 5) Can be nipped to 8mm height (same as side pool height)

E.operation panel (no 1)



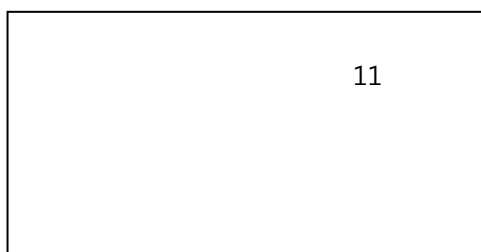
1) Liquid crystal display

Set the work environment Displays the status of the equipment

a) Show work screen

- ✧ Work Mode : auto / hand
- ✧ Glue Temp : 125°C
- ✧ Nip Time : 5 S
- ✧ Counter – 100

b) Show setting screen



```

Work Mode:
Buzzer   :    ON
Count Clr:    No
Auto Agg:    ON

```

- work mode: Manual / Automatic
- Buzzer: beep (all beeps): on / off
- Count clr: Count clear on/off
- AUTO AGG:ON (Wheel auto turn on - Small port spare)

```

Wait Time:    0
GHead Sets:  0
GTail Sets:   0

```

- Wait time: Putting the contents in the clamp means waiting time,

Usually set to 0 seconds

- Ghead sets:Head side full ground setting+ . -
- Gtail sets:Tail pool setting + . -

Give '-' value to the side of the application where you want to apply more grass

```

Set Temp:    41°C
Lag Temp:    5°C
Pro Temp:    100°C
Nip Time:    5 S

```

- Set temp: Nozzle temperature setting

- Lag temp: Set the rising and falling error ranges of the nozzle temperature set above.
- Pro temp: Protection temperature (keep warm) - Start temperature
- Nip time: Setting the nipping time

2) Setting button

Press the <SETUP> key or the SET button to enter the setting mode. The set data starts flashing and the <BACK> key is pressed to confirm the current value. ^, v Select the option to set up or down the key, or turn the screen over, press + to increase the setting value, and - to set the minus value to the setting value.

3) Start button

4) Milling operation ON / OFF selection switch

5) Cover thickness selection switch

When using a thick cover, it is better to attach the book and the cover.

6) Cover clamp pressure knob switch - Bending force adjustment of nipper

Turn the switch to the left to make a strong binding,
The nipping operation is stopped.

7) Emergency stop switch

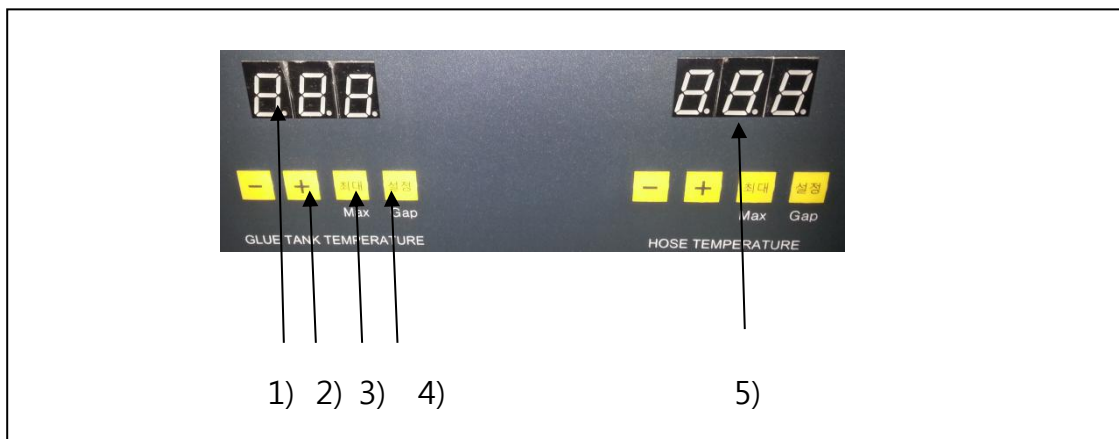
In the event of an emergency.

B. Power is in, but protects pur melt by shutting off all air in working atmosphere.

8) Nozzle manual operation switch

For the smooth operation of the nozzle, operate several times after the temperature rises.

E-1 Operation panel part 2



1) Glue tank temperature (purge tank temperature)

3) Press max key and then temperature control by +, -
Typical pur melt is 125 ° C and can be used up to 190 ° C.

** 4) Do not use key.

5) Hose temperature

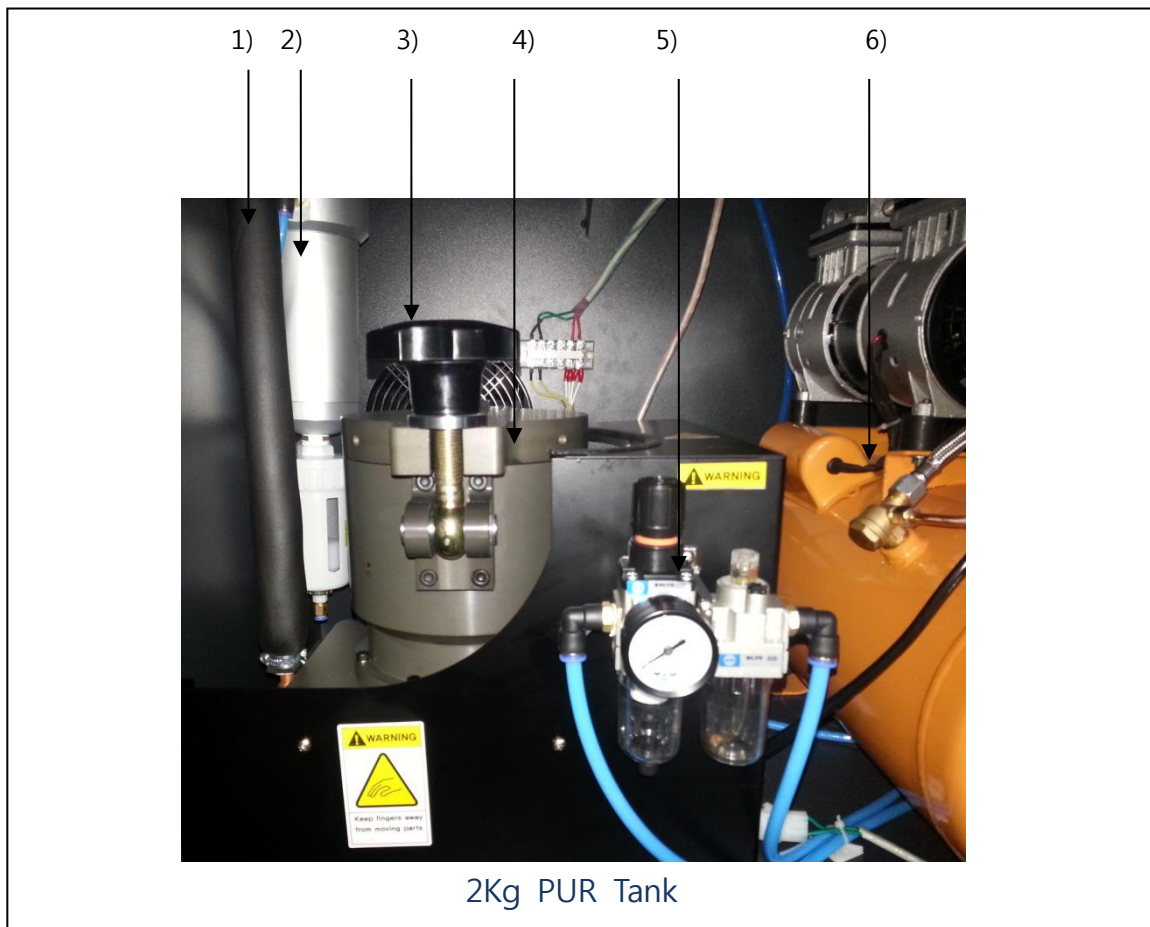
Hose temperature control unit between glue tank and nozzle
It is usually set equal to the Glue Tank temperature.

F. Collector

A device for collecting milled paper powder - If the stock powder is full in the sack

Empty and install the bag again.

G. air and dissolving tank Division



- 1) Pur melt nozzle supply hose
- 2) 2Kg PUR Tank
- 3) Melt tank open handle

After pressing the emergency stop button, turn the tank lid knob to open it.

- 4) Primary air regulator - Set the gauge between 0.5 and 0.6.
- 5) Built-in air compressor - External air supply is also available.

G-1 PUR MELT - PUR GLUE TNAK (2Kg)



- 1) Press the emergency stop button.
- 2) Remove the prepared 2 Kg pur melt and put it in the tank.
- 3) Cover the tank cover and tighten it with the handle.



2. How to use binding machine

A. Preparation

1. Check the level of the machine and install it.
2. Verify that the shipping fixture is removed. (Clamp part)
3. Turn on the power switch to turn on the screen and store the air while the pump is running.
4. Add PUR adhesive to adjust the PUR tank temperature (if necessary) according to the melting point of the paste.

Typically, the hose temperature is 125 ° C

Tank temperature 125 ° C

The nozzle temperature is set at 135 ° C.

B, binding

1. When the power is turned on and the START button is pressed, the machine will operate twice in an empty state.

(During this process, the internal inspection of the electronic and air parts is automatically performed.)

2. Turn the milling button on or off according to the binding requirements.

3. Adjust the pressure according to the thickness of the book. If it is more than 2cm, adjust the pressure.



Part H of the PUR binding machine)

Pull the handle and rotate it to the right to increase the pressure.

After adjustment, Press the knob again to fix it.

How to adjust pressure gauge:

book thickness	supply glue pressure
≤1cm	0.05
≤1-2cm	0.1
≤2-3cm	0.2
≤3-5cm	0.3-0.4

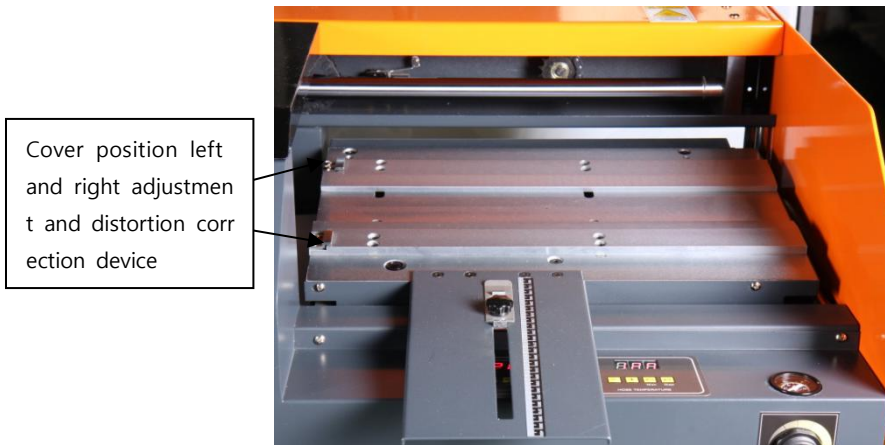
4, Set the cover.

When first binding, adjust the center according to the cover size and adjust the width of the cover.

Tighten and tighten.

(Coverage center adjustment)





5. Adjust the cover clamp pressure knob according to book thickness and cover thickness.

Rotate the switch to the left to create a rectangular book.

When there is no cover, the pressure knob is set to the smallest position (top right).

6. Insert the contents (the book to be bound) and press the OK button.

The clamp clamps the contents and moves to the right, milling, pulling the filler, nipping the cover, and then going back down to complete the binding.

, 7. The machine returns to the standby state.

B-1 Automatic binding

◇ Work Mode : auto / hand

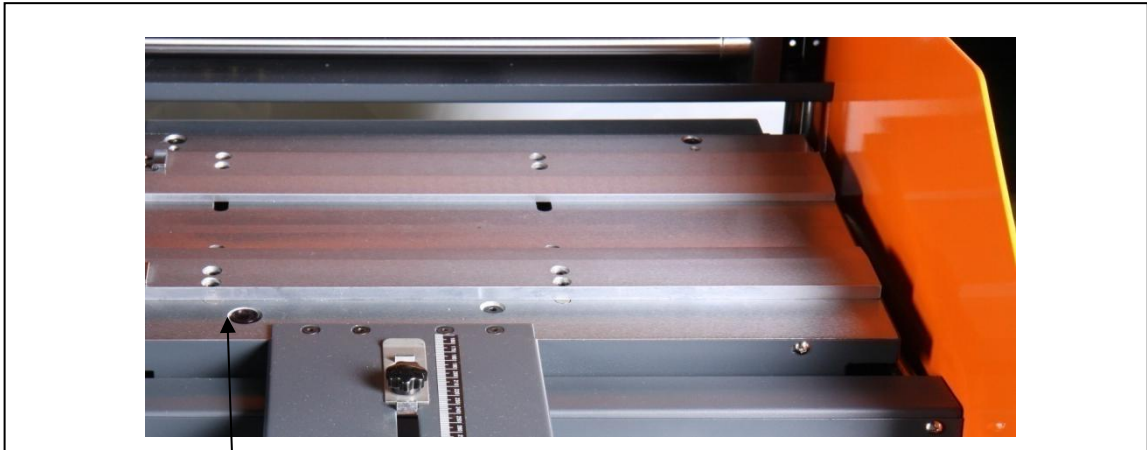
LCD Select Auto mode on the LCD.

1. Set the operation mode to "Auto" by setting the function and set the clamp time according to book thickness.

(For thick books, set the clamp time longer. For thin books, set the clamp time shorter.)

2, the contents (book binding) and the cover will automatically bind the machine.

In the case of hardcover binding that does not require a cover, you can control the binding start by covering the cover sensor with your hand during automatic binding.



👉 Cover sensor: can start auto

3. Daily maintenance

The binding stability and service life of the bookbinder are closely related to the daily maintenance of the actual user. By regularly cleaning the binding machine and applying oil to the working area of the machine, you can increase the service life of the machine.

1). You should periodically lubricate the following areas:

Gear part, two straight bars, cover nipper under clamp, roller center shaft hole at both ends, chain, chain wheel shaft and so on.

2). Clean the pool around the clamp guide under the clamp, the nipper on the marker strip, and the nozzle head area.

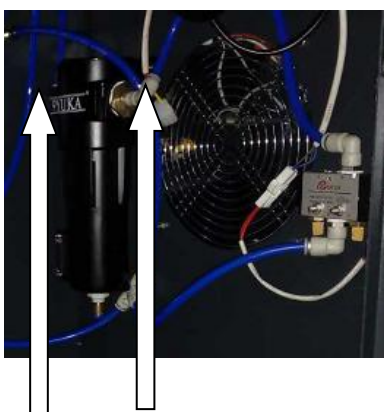
3). You should clean the stowage towel in time, oil the nozzle shaft and moving parts regularly every month, and work with the machine turned off before cleaning.

4). If you are familiar with machine maintenance, check the condition of each part of the screw periodically.

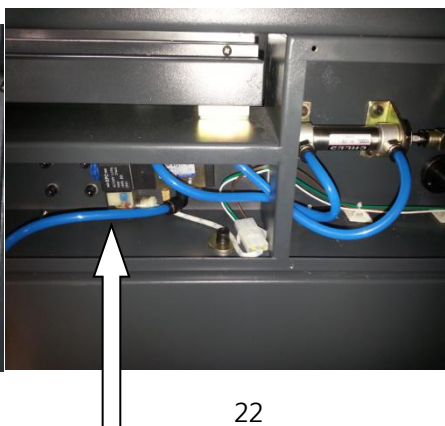
5). Please contact us if you have any questions.

A. Air configuration

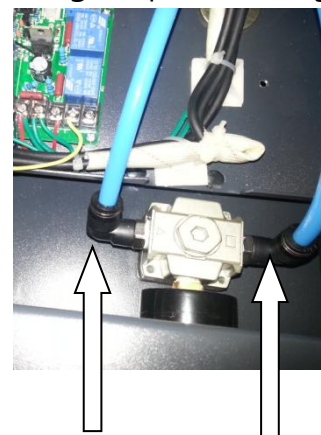
Electric dehumidifier



nozzle air solenoid



gule pressure regulator



A (OUT) B (IN)

E

I(IN)

J(OUT)



F

C

D

E

H

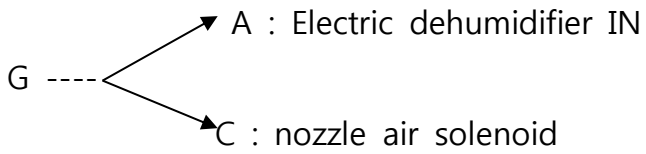
B

A

G

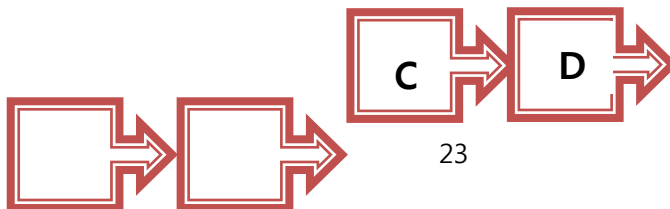
B. air configuration

H ----- G : outside enter air + Three links

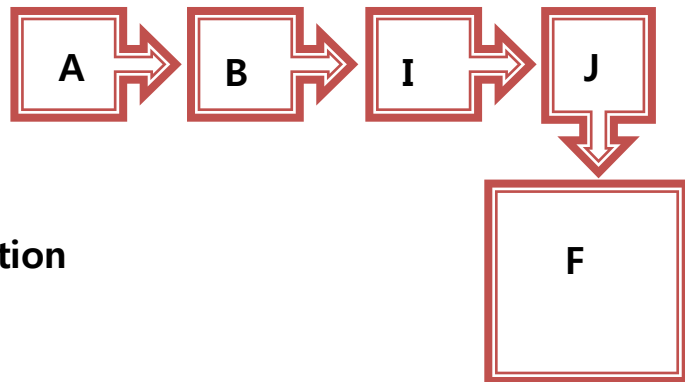


B ----- I : pressure regulator

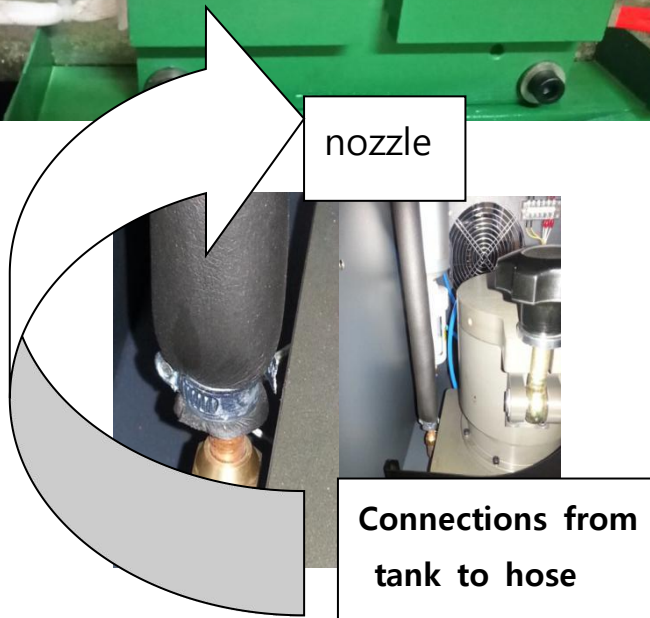
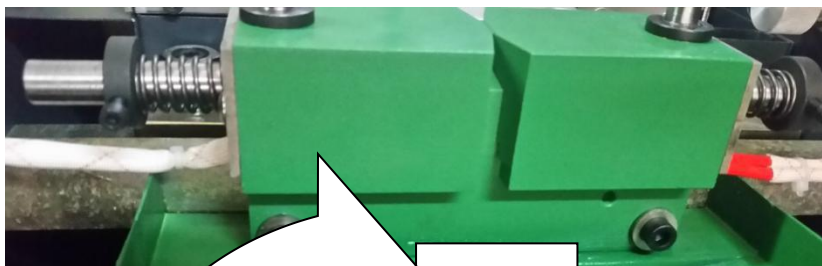
J ----- C.: PUR TANK



H G



C. PUR MELT Configuration



PUR tank

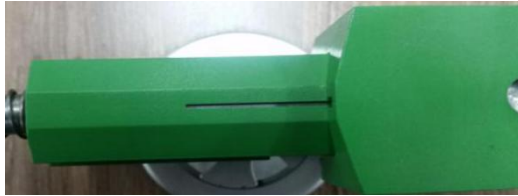
C-1 PUR MELT Nozzle maintenance

- ✦ **maintain cleanliness of nozzle head and make good binding.**
- ✦ **Be sure to wear gloves and be careful about burns in order to perform cleaning work with power on.**

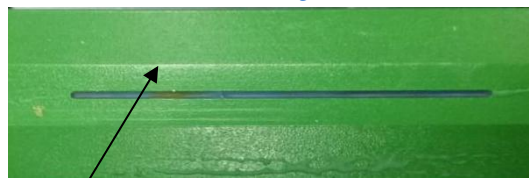
a) Press the emergency switch to turn on all components (pur tanks, air hoses, etc.)

Air is released.

Wipe the exposed pur melt with a dry mop during operation

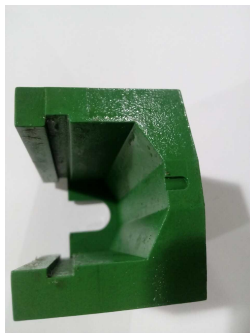


Nozzle assembly



Nozzle

b) Remove the pur melt of the nozzle head



Nozzle cover

c) Remove the melt from the side pool feed and nozzle lid.

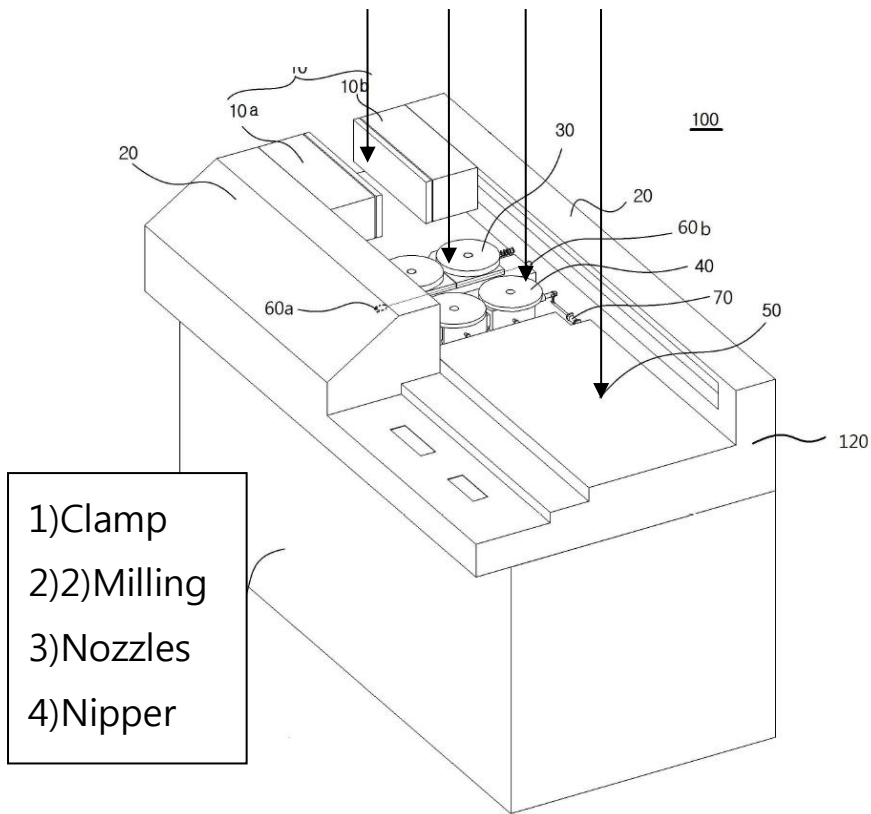
d), It is very important!

If stop the work more than half an hour, please operate below:

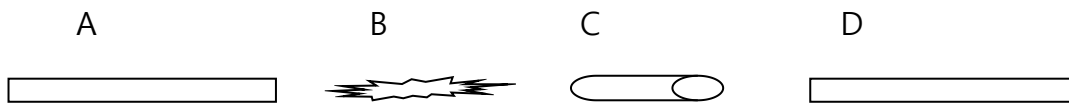
1) Press pause, after supply glue pressure come down to 0, Press nozzle switch 2 minutes (press with 20 seconds, stop 5-10 seconds, and repeat continuously, then shut off.)

D. Height and adjustment of each part

- 1)
- 2)
- 3)
- 4)



- 1)Clamp
- 2)Milling
- 3)Nozzles
- 4)Nipper



Reference height 0 | 0 mm +0.2 or 0.3mm - 0.2~0.4mm -0.2mm

D.The height of the wafers is usually 0 mm in the milling operation, but the wepur has a negative value because the portion B is a scratch shape using a groove knife.