YH356 Creasing Machine

Operation Manual

Contents

I Products Introduction

1.1 Summarise

This product is a manual paper feeding digital indentation machine, product design according to the industry for indentation processing of various situations, for the plate printing customized multifunctional processing equipment.Its main characteristics are as follows:

（1）The indentation frequency per hour A4 the indentation one piece 3000 pieces/hour.

（2）The professional design and manufacture of indentation die durable, high-precision stepping motor and control system to ensure the precision and quality of indentation.

（3）The operation panel USES a 7-inch color hd touch screen, small machine high configuration, simple and convenient to use.

（4）Do not need to make a template, can complete the card indentation, but also for all kinds of dotted lines and part of the dotted line pressing, plastic or riding on the cover of the film indentation, but also applicable to a variety of other applications.

（5）The machine can handle pull-up products from the largest size to 330×3000mm.

Please read this operation manual carefully before operation. If you encounter any problems during operation, please contact your seller in time.

Thank you for choosing our products!

1.2 Parameter

① Machine Length…………………………………………………………………1200mm

② Machine Width………………………………………………………………500mm

③ Machine Height……………………………………………………………440mm

④ Paper Thickness……………………………………………………70g-450g

⑤ Paper Size………………………………………………Max 330×3000mm

⑥ Creasing Speed（A4）………………………………………3000 per hour

⑦ Minimum Creasing Distance……………………………………………1mm

⑧ Minimum Creasing Size………………………………………………1mm

⑨ Creasing Precision…………………………………………………0.2mm

⑩ Number of creasing per sheet…………………………………………0~20

⑪ Tally…………………………………………Positive and negative count

⑫ Total Count……………………………………creasing count,paper count

⑬ Skew Adjustment………………………………………………±2mm

⑭ Creasing Depth Adjustment…………………………………Stepless variation

⑮ Feeding Way…………………………………………………Manual feed

⑯ Paper receiving tray capacity……………………………………………45mm

㉑ Horizontal Creasing Function………………………………………1mm

㉒ Horizontal Dotted Function…………………………………………12TPI

㉓ Power……………………………………………………220V/50Hz/250W

㉔ Net Weight………………………………………………………50kg

㉕ Gross Weight……………………………………………………………60kg

㉖ Package Size…………………………………………………580×660×620mm

II Safety

2.1 Environment

① Temperature：10℃-35℃；

② Temperature：30％-70％；

③ There is no flammability, corrosive gas or oil mist around it.

2.2 Note

● Please read this book before operation.
● The power source and frequency must be comfirmity to the instruction.
● All the safety covers should be closed, or the switches are cut off the machine can't work.
● Please contact the agent to move the machines.
● Please cut off the power when the machine is cleaned.
● Please pull out the power line when machines will not be used for long time.
● Please install the machine in stable place.
● Don't start the machine with wet hand, especially pull out the plug.
● Don't operate with long hair, loose cloth and touch the machine.
● Don't put anything on the machine, especially on paper feed tray.
● Don't remove or repair the machine except the professional engineers.
● Keep the power on when machine is working.
● Don't let the metal or easy-burning items fall into the machine. It may cause the fire disaster or motor problem. In this case, please cut off the power, pull out the plug and contact technical.

Notice: There is something happened, please cut off the power, pull out the plug and contact the technical immediately.
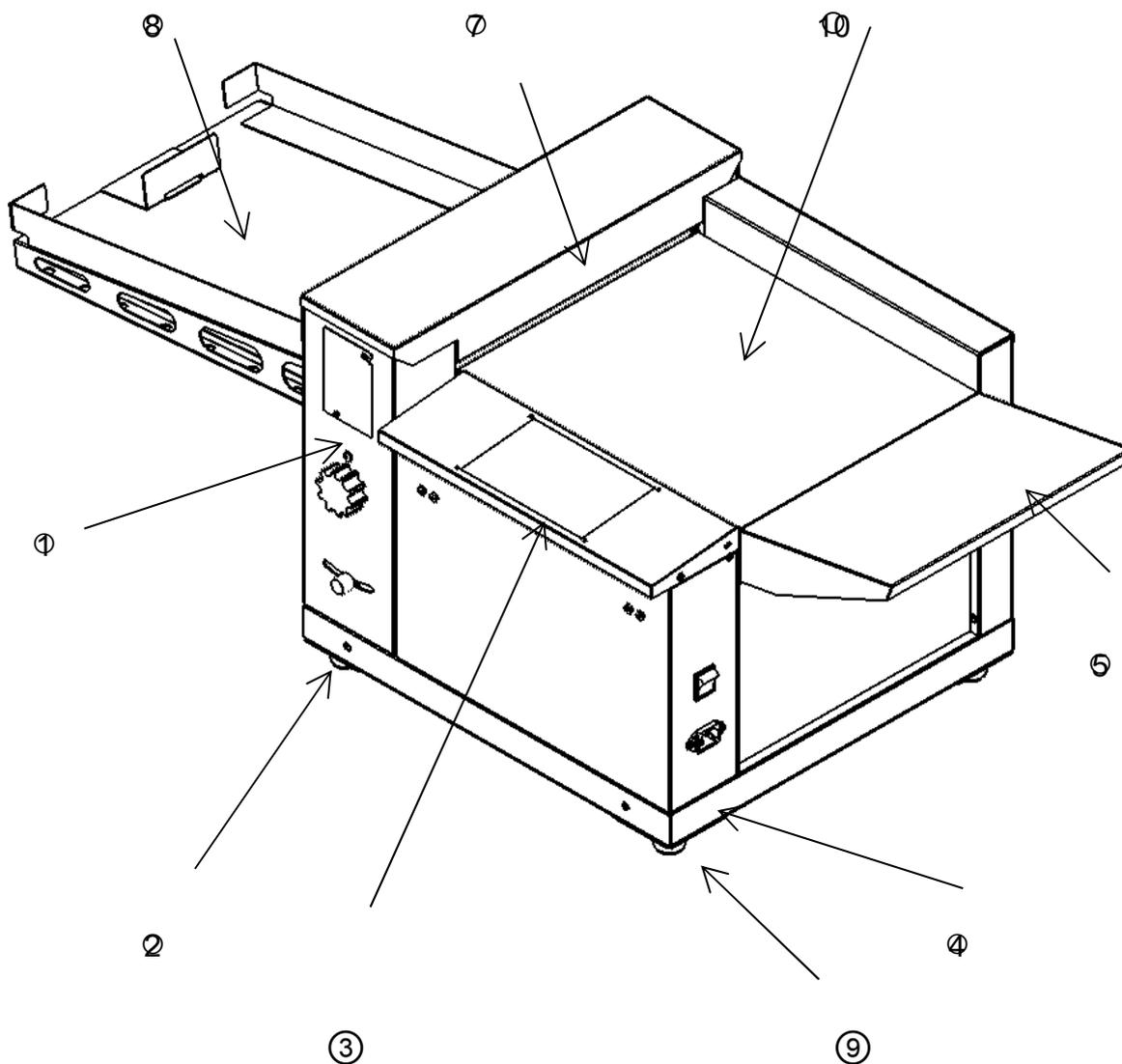
Ⅲ. Main parts

Diagram of creasing machine

FIG. (1)

NO.	Parts	Description	NO.	Parts	Description
1	**Blade cover**		6		

2	Deflection adjustment handle		7	Upper cover plate	
3	Operation panel		8	Collection unit	
4	Power switch		9	Plug socket	
5	Extension board for feed table		10	Supporting board	

Diagram of creasing machine
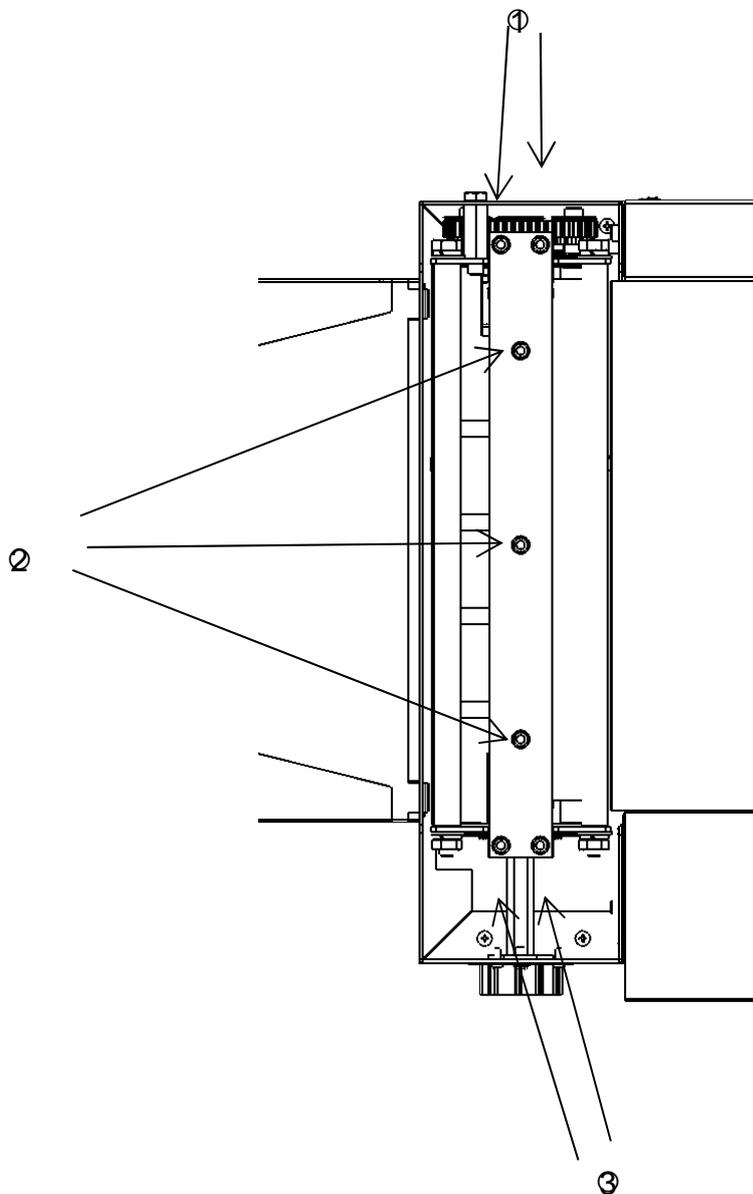
图（3）

NO.	Parts	Description	NO.	Parts	Description
1	Indentation depth adjustment screw		3	Indentation depth adjustment screw	
2	Indentation depth adjustment screw	Different way			

Ⅳ. Machine Installation

4.1 Installation of Back paper-receiving tray

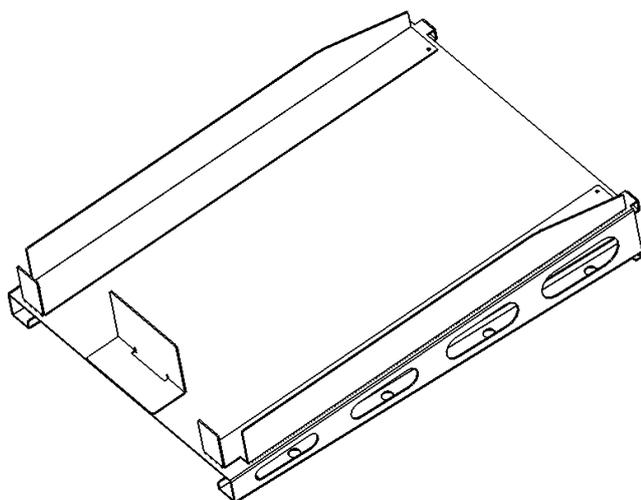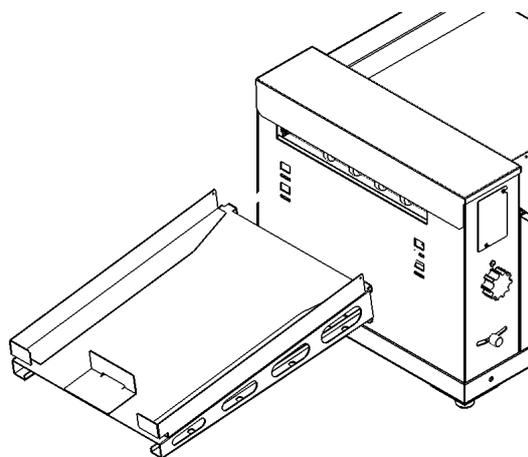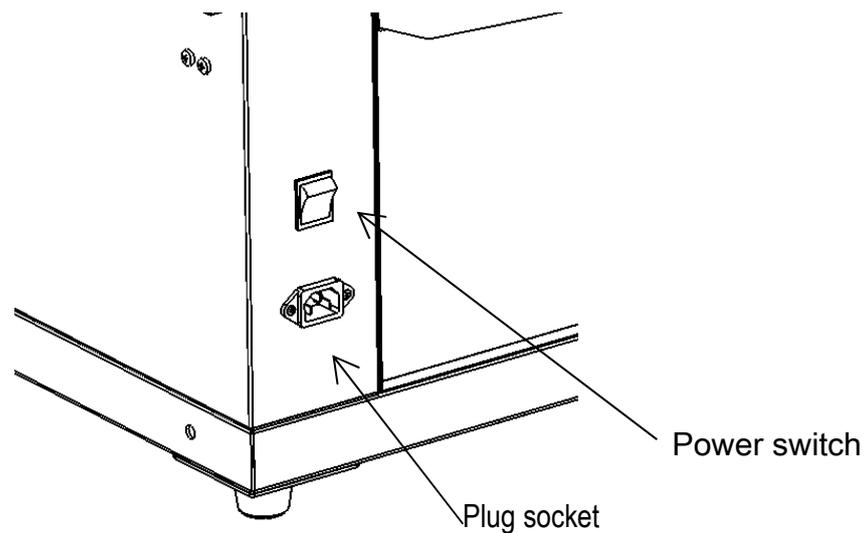FIG.（1）　　　　　　　　　　　　　　　　FIG.（2）

In the figure above, Figure 1 shows the appearance of the paper receiving table after assembly.FIG. 2 shows the installation direction of the paper receiving table. Simply insert the paper receiving table into the hole corresponding to the main machine and hang it.
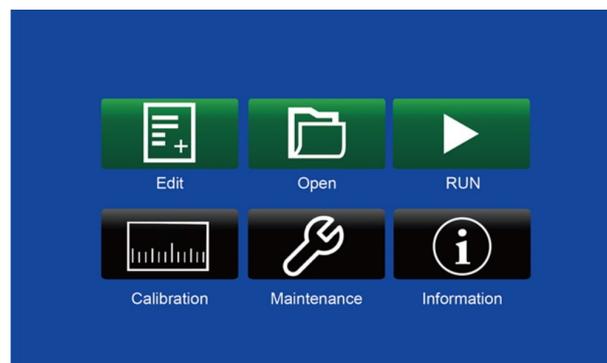
4.2 Power and switch

Power switch

Plug socket

V. Operation

5.1 Operation panel

After the machine is installed correctly, turn on the power switch on the right side of the machine. After the machine is initialized, the following screen will be displayed, waiting for your operation.

5.2 Create indentation data

This machine needs you to enter the indentation data before indentation operation. Click "Edit" in the upper left corner of the screen to call out the new indentation interface.
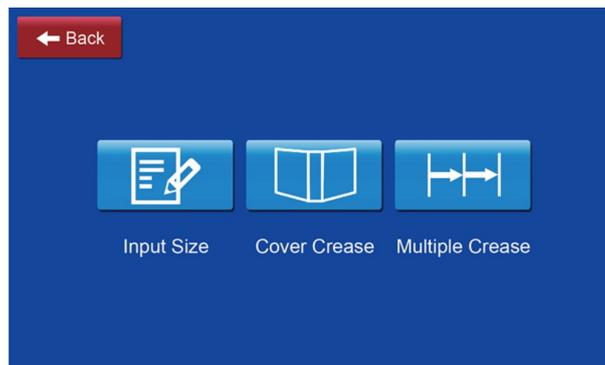
As shown on the left side, the machine provides three operation menu options for new indentation. Click the number on the left side to select various indentation modes as required. After the selection is completed, click the middle picture to enter the data editing screen.

5.2.1 Input indentation data

Enter the "Input ", as follows：

After entering, input indentation data, a total of 20 indentation data can be input, no need to input in order or number size, the system will automatically according to the value size, indentation in turn.

Note: each value entered is the distance from the front of the paper to the indentation, in mm mm, accurate to one decimal point.

After all data input is completed, enter the screen of waiting data storage:

Click the number on the new file name to edit the file name. A total of 20 groups can be edited and entered at will. After completion, click save to enter the screen to be run.
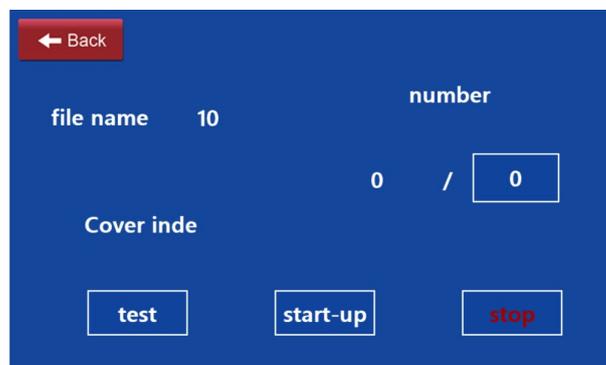
In the screen to be run, parameters such as the running speed (adjustable in 4 levels, with 4 being the fastest and 1 being the slowest) and the number of paper to be indentation can be set. You can first click test press a piece of paper to check the indentation accuracy, and then click Start after confirmation.

5.2.2 Cover crease

"Cover crease" is one of the special functions of this machine. Its advantage lies in that it can realize the reverse indentation of turning the book line and realize the positive and negative indentation at one time. After entering the "cover indentation" function interface, the following screen is displayed:

There are 5 Settings for "cover indentation", namely "edge bleed", "book width",

"book lip", "book thickness" and "book line". According to the actual

situation, the book line can be set as a single line or a double line. After setting,

click OK to enter the storage screen, and save the file name to enter the screen to be

run.

5.2.3 Multiple crease

After entering the "Multiple crease" function interface, the following screen will be

displayed，

"Multiple crease" is a very practical function of this machine, which will bring

great convenience to your operation. As long as you set "Bisection" and "paper

length", click OK to enter the storage screen, and after saving, you can enter the

screen to be run.

5.3 System related Settings

Click the icon in the lower right corner on the standby interface to enter the user

setting screen：

（1）The total amount of press paper, you can check the total amount of press paper.

（2）The total number of indentation, the total number of indentation can be checked.

5.4 Machine detection and error correction

The following functional test operation shall be carried out partly by removing the equipment shell. It is strictly prohibited for non-professional technicians to operate. The failure caused by unauthorized operation is not included in the warranty.
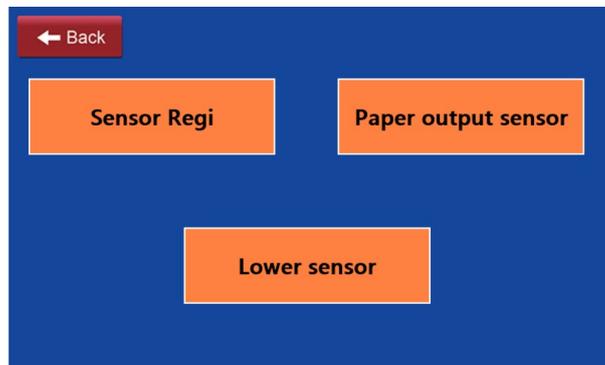
5.4.1 Enter the functional test interface

Click the right center icon on the standby screen to enter the functional test interface as shown in the figure below.
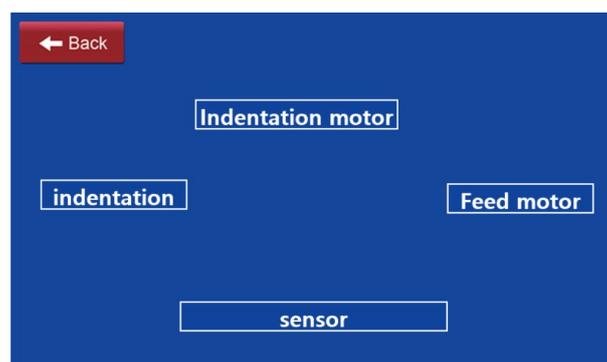
5.4.2 Sensor detection

In the functional test interface, select "Sensor Detection" and enter the sensor detection interface. The following screen will be displayed:


Objects with light blocking appear green, and objects without light blocking appear yellow.

5.5 Creasing accuracy adjustment

On the standby interface, select the icon in the upper right corner to enter the screen of indentation accuracy adjustment. Use A3 paper and set two indentation with large spacing and a certain distance from the end of the paper (it is recommended to set the first indentation of 100mm and the second indentation of 350mm). Correct corresponding parameters according to the actual indentation accuracy deviation.

1. [coefficient] is the distance between two indentation lines. According to the deviation between the set size and the actual size, click + or - to adjust, and the unit of coefficient is mm.

2. [The first line] is to adjust the size of the first indentation. According to the deviation between the set size and the actual size, click + or - to adjust, and the unit of coefficient is mm.
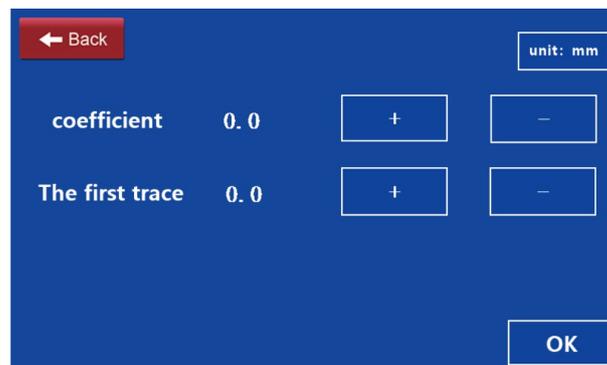
5.6 Adjusting mechanism

5.6.1 Creasing skew adjustment

When the indentation is deflecting, loosen the black five-star handle, adjust the lower deflection adjusting handle, adjust it according to the actual deflection direction, and tighten the black five-star handle after the adjustment.
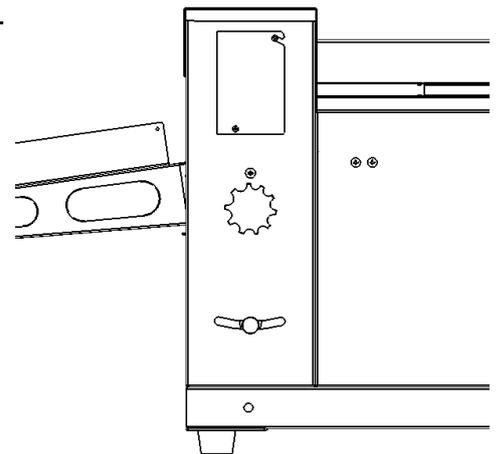
5.6.2 Creasing depth adjustment

The depth of the indentation directly affects the quality of the work, which mainly depends on the gap between the upper and lower dies. The depth of the indentation is also related to the thickness of the paper. The gap may cause indentation unclear.

Too small gap may lead papers breaking up, also may lead the equipment to work mistakenly with two sheets of paper and then stop. When the depth of both sides is not conformity, also it needs to adjust.

Middle 3 screws can't be adjusted the depth in all 7.
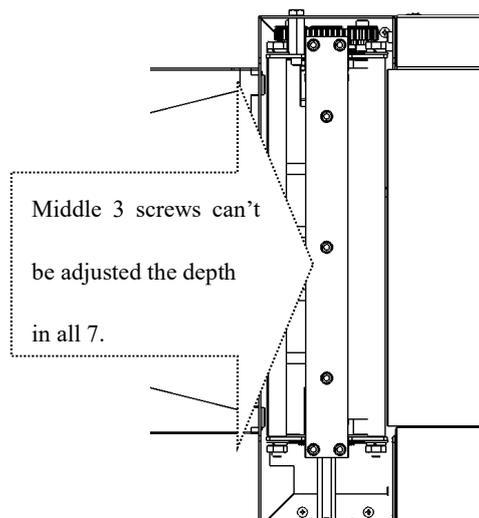
Open the top cover, you can see 14 hexagon socket screws, among which, the 6 screws in the middle connect the mold and beam, which are used by the equipment assembler in the factory assembly process.Note: Please do not adjust

Four on each side are for user to adjust. The user can adjust the depth by turning the screws with the inner hexagon wrench.Turn the screw clockwise to increase the depth and vice versa.Note: Do not adjust too deep

Ⅵ. FAQ

6.1 Creasing blade blocked error

It may happen under follows case:

1.Paper feed too many in one time

2. Creasing depth is adjusted too deep

3. The papers are too thick

Solutions：

1. Turn the machine off, click the button showing direction in the interface, and remove the paper by hand.

2. Take out the papers. If the creasing is too deep, then adjust the depth of creasing.

3. If still not solved, please contact our engineers.

6.2 Paper jam

1. Paper is too thin (The paper out of standard is easily folded)

2. There is some dirty on the papers paths

3.The strong light around the machine may lead the sensor to mistakenly judge it as paper jam.

4. The paper curving or the depth is too deep during working

Solutions:

When the problems happen, you can try to solve it by Forward/ Back button to remove the paper out from mechanism.

Note： Don't make it with too much strength, it may lead the broken of feed rollers

Ⅶ Maintenance

Maintenance is critical to the machine; the necessary maintenance can extend the life of the machine, and can improve the mechanical efficiency. Maintenance work mainly includes two aspects: user maintenance and technical maintenance.

7.1 User maintenance

When the machine is used for a long time, dust or wastepaper accumulates between mechanical parts and adversely affects the use of the machine. So the operator should regularly clean the paper inside and dust. For example, to maintain the machine one time

after working for some production, rubber roller regularly washed with water, to blow away the dust on the feeding sensor and paper-out sensor with gas gun.

Meanwhile, we should make sure that the machine is working under clean and dry environment without direct sunlight.

7.2 Technical maintenance

Regular technical maintenance is also important, mainly by the technical staff, including regular inspection for easy broken parts, replacement of damaged parts, and lubricant　etc.

If this manual is updated continuously, please understand if there is any discrepancy.

Customer information feedback

Dear Customer,

Thank you for choosing our products. In order to improve the quality of our products, we will collect feedback by customers from time to time and make improvements. Thank you for your cooperation and participation.

Company name		Contact person	
Address		Tel	
website		Mobile	
E-mail		Skype	
Requirements			
Suggestions			