

Horizon BOOK BINDER **BQ-260/260L**

Important Information

- This manual is designed to help you to install, operate and maintain Perfect Binder BQ-260/260L. Read, understand and keep this manual in a safe and convenient place.

- Do not operate BQ-260/260L until you read and understand the instructions in this manual.

- Horizon International Inc. shall not be liable for incidental consequential damages resulting from : improper or inadequate maintenance by customer; unauthorized modification or misuse; operation outside of the environmental specifications for the product.

- Horizon International Inc. pursues a policy of continuing improvement in design and performance of the product. Therefore, the product design and specifications are subject to change without prior notice and without our legal obligation.

- All rights are reserved. No part of the manual may be photocopied, reproduced or translated to another language without the prior written consent of Horizon International Inc.

Safety Precautions

- The signal word **WARNING** indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

- The signal word **CAUTION** indicates a potentially hazardous situation which, if not avoided, may result in damage on machines. It may also be used to alert against unsafe practices.

- Read and understand all safety instructions with signal word such as **WARNING** and **CAUTION**. If safety instructions are ignored, personal injury will result.

- Horizon International Inc. cannot anticipate every possible situation that might involve a potential hazard. The instruction in this manual and warning labels on the machine are therefore not all inclusive.

- All equipment shall be locked out or tagged out to protect against accidental or inadvertent operation when such operation could cause injury to personnel. Do not attempt to operate any switch, valve, or other energy isolating device where it is locked or tagged out.

- Do not operate the machines with any covers being removed.

- Some of the drawings in this manual shows the machine uncovered for explaining the detail or inside of machine.

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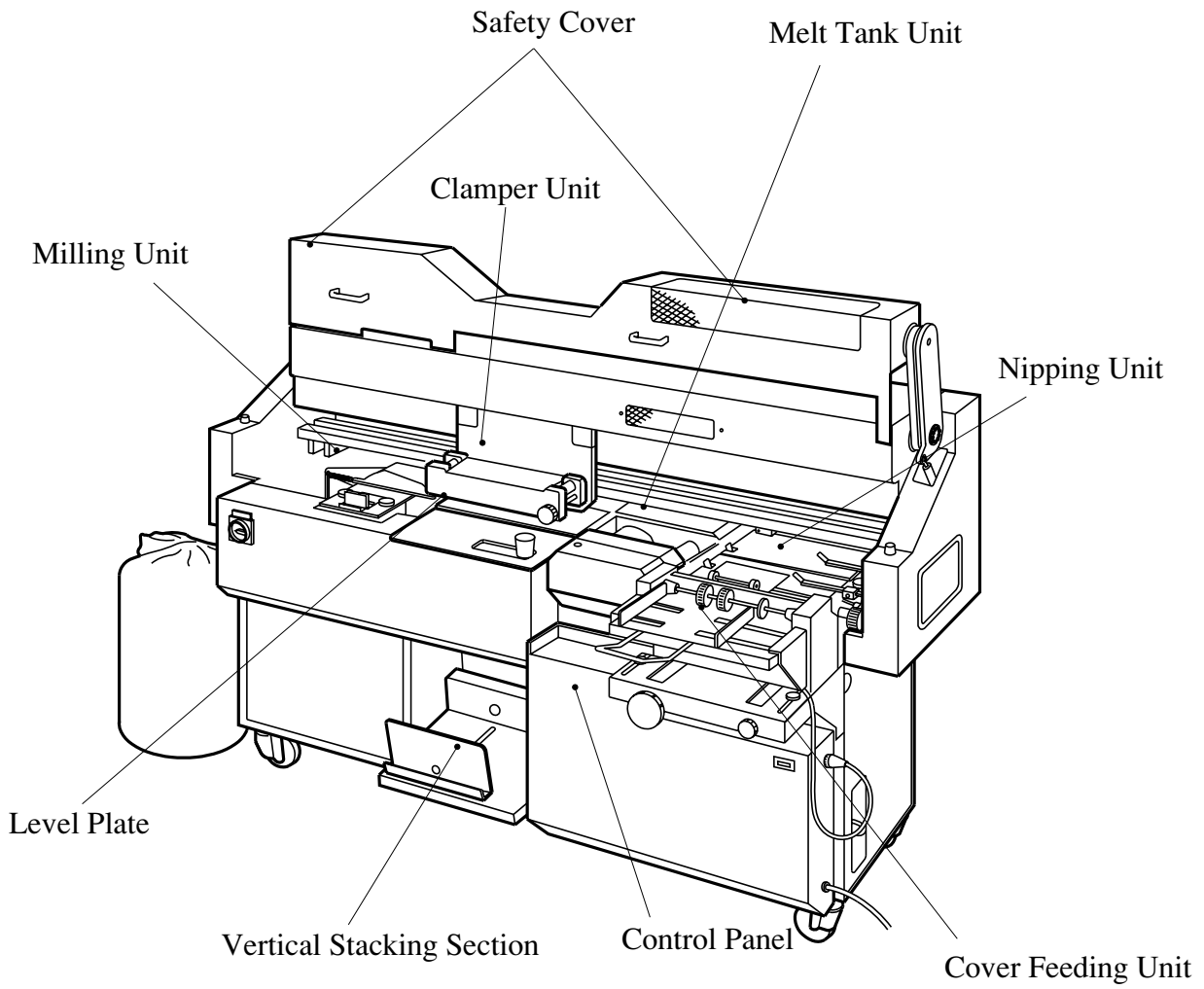
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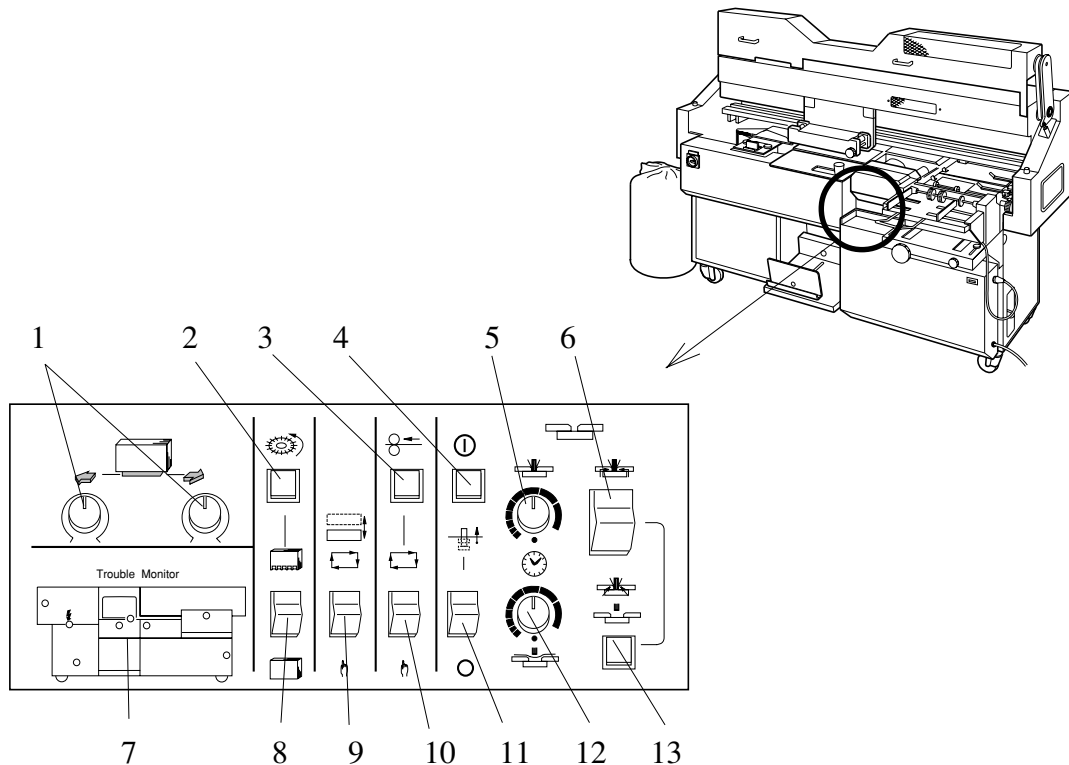
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1-1 General View of BQ-260



1-2 Control Panel



1. Gluing Length Adjusting Knobs

Used to adjust spine glue length.

2. Milling Start Button

Used to start to rotate milling cutter.

3. Cover Single Feed Button

Used to feed one cover sheet from cover feeder with automatic cover feeding mode.

4. Nipper Up/Down Button

Used to raise or lower nipper unit for setting up nipping unit.

5. Nipping Time Control Knob

Used to control nipping time.

6. Nipping Mode Select Switch

Used to select nipping mode. Three different modes, With milling binding mode, Signature binding mode and Pad binding mode can be selected.

7. Trouble Monitor

(Please refer to next page.)

8. Milling Mode Select Switch

Used to select milling mode, with milling or without milling.

9. Level Plate Mode Select Switch

Used to select reset mode of Level Plate after one complete cycle of binding automatic or manual.

10. Cover Feed Mode Select Switch

Used to select cover feed mode, automatic or manual

11. Clamper Pin On/OFF Switch

Used to turn on/off clamper pin which holds stock in clamper when without milling mode is selected..

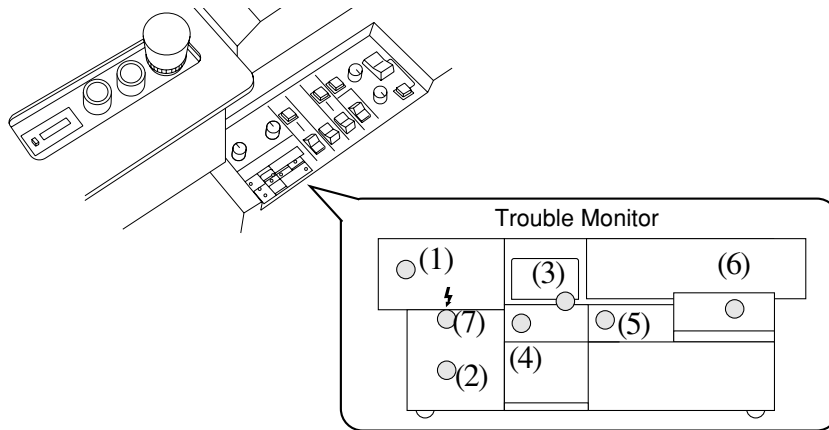
12. Nipping Delay Time Control Knob

Used to control nipping delay time length.

13. Pad Binding Lamp

This lamp turns on when pad binding mode is selected.

1-2 Control Panel



Trouble Monitor

Indicates incorrect point on BQ-260.

When one of them turns on except power lamp, BQ-260 can not be started.

Each LED turns on when :

(1) safety cover opens.
- Close safety cover.

(2) milling cutter does not rotate although with milling binding mode is selected.
- Depress milling cutter start button to rotate milling cutter.

(3) level plate opens.
- Depress start button to reset level plate.
(4) emergency stop switch is depressed.
- Pull up emergency stop switch to re-

lease it.

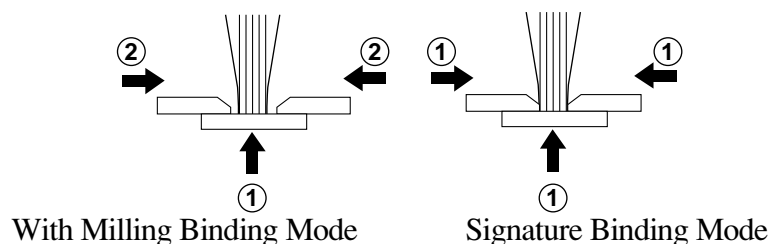
(5) glue is not ready for biding.
- Wait until glue will be melted.

(6) cover is not fed to stopper.
- Feed cover completely until it gets stopped against stopper.

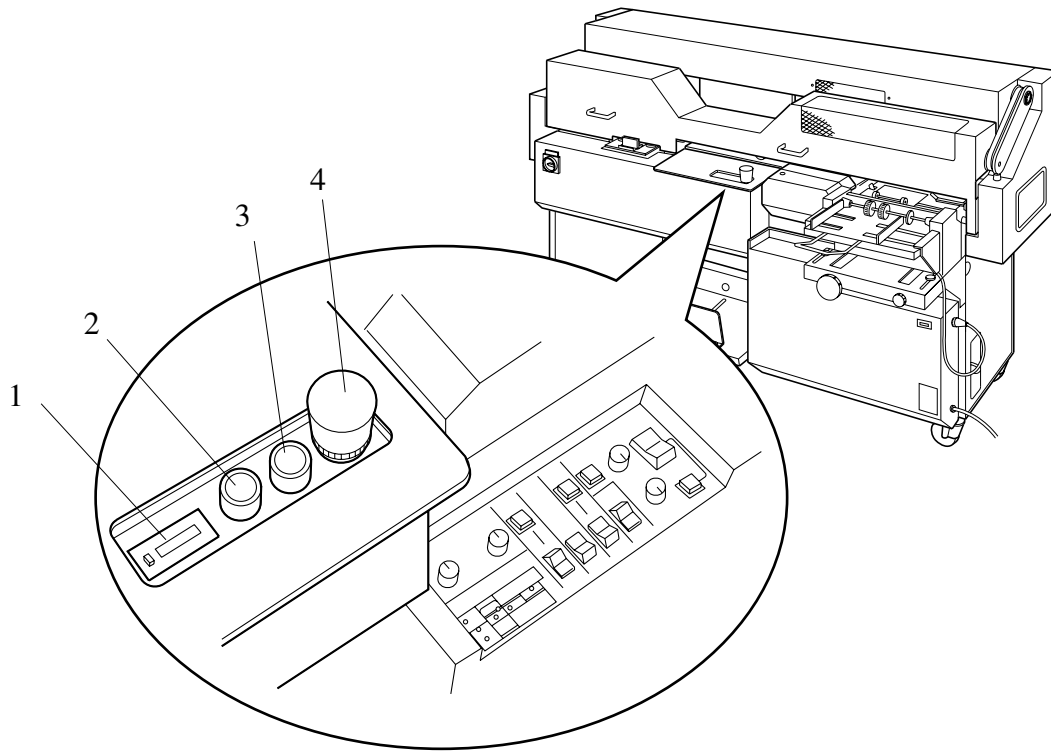
(7) main power is on.

NOTE : Difference of Nipper Movement

Nipping unit has two different movements, with milling binding mode and signature binding mode. In with milling binding mode, nipper plate raises at first and then front and back nipper jaws nip stock. So, this binding mode is suitable for binding milled stock or cut sheet stock. In signature binding mode, nipper plate and two nipper jaws raise and nip stock at same time. So this binding mode is suitable for binding signature which spine is shaped thicker because of folded edge. Book spine will be formed too sharp or destroyed when spine is pressed at first as in with milling binding mode. Binding quality or book spine shape bound with signature binding mode is not affected so much by folding.



1-3 Operation Panel



1. Counter (with reset button)

Used to count amount of binding. When reset button is set at far side, number in counter can not be reset.

2. Level Plate Button

Used to open and reset level plate manually when level plate switch is set at manual operation mode.

3. Start Lamp and Start Button

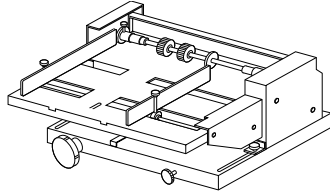
Lamp indicates that BQ-260 is ready to bind.

4. Stop Button

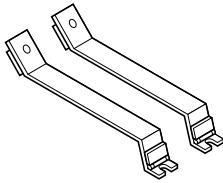
1-4 Accessories and Tools

Check all accessories are supplied with your BQ-260 when you open package.

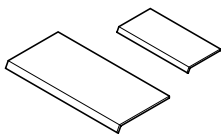
1. Cover Feed Unit (1 set)



2. Feed Roller Cleaner (2 sets)

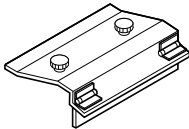


3. Support Plates for Cover Feeder Unit

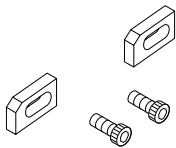


(Large 1 pc
Small 1 pc)

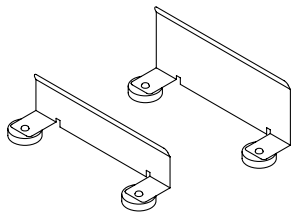
4. Small Cover Stopper (1 pc)



5. Small Cover Position Register (2 sets)

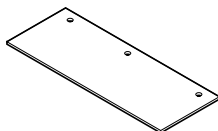


6. Clamper Support Guide

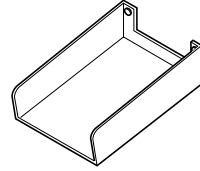


(Large 1 pc
Normal 1 pc)

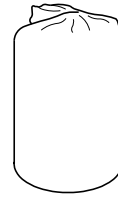
7. Space Plate (1 pc)



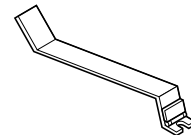
8. Drain for Glue Replacement (1 pc)



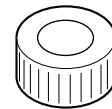
9. Dust Bag (1 pc)



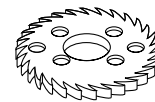
10. Cover Feeding Supporter (1 pc)



11. Cover Feed Roller (1 pc)



12. Milling Cutter (1 pc)



13. Grease (1 pc)

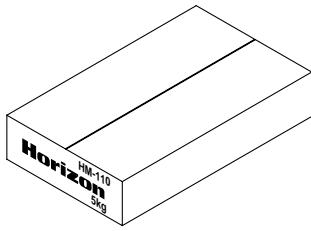


14. Chain Oil (1 pc)

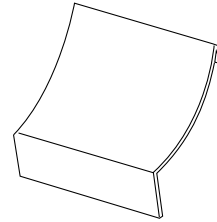


1-4 Accessories and Tools

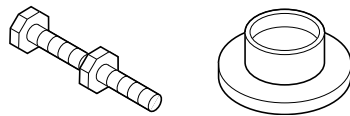
15. Hot Melt HM-110 (5 kg)



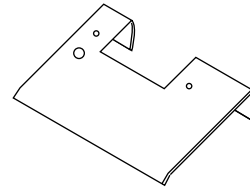
17. Shooter for small book (1 pc)



16. Mount Base with Leveling Bolt (3 sets)



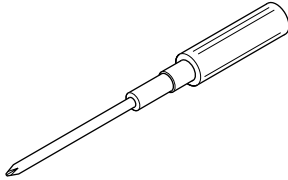
18. Feed Cover (1 pc)



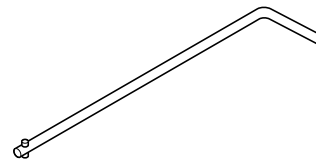
1-5 Accessory Tools

Check all tools supplied with your BQ-260 when you open package.

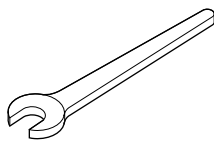
1. Screw Driver (1 pc)



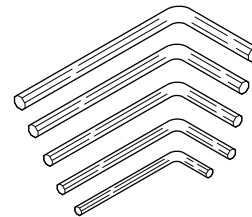
5. Special Wrench (1 pc)



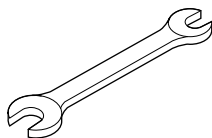
2. Spanner (30 mm) (1 pc)



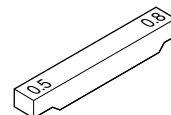
6. Allen Wrench (2.5, 3, 4, 5, 6 mm)
(1 pc of each)



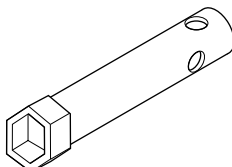
3. Spanner (13/17 mm) (1 pc)



7. Roughening Cutter Height Gauge (1 pc)



4. Pipe Wrench (30 mm) (1 pc)



2. Installation Instructions

2-1 Installation Instructions	10
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2-1 Installation Instructions

2-1-1 Installing Place

This section shows condition of installing place for BQ-260.



WARNING

*Weights of BQ-260 is about 500 kg.
Pay attention enough to transportation.
BQ-260 could fall down or catch a
person with something like wall.*

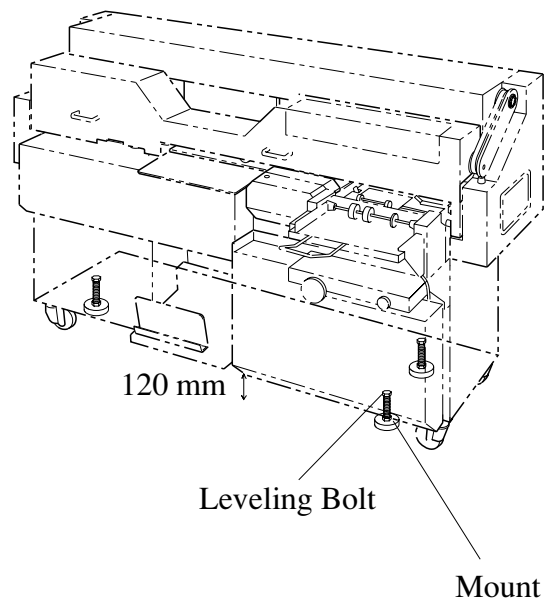
1. Select a flat, rigid floor free from vibration.
2. Select a place free from direct exposure to sun light.
3. Select a place free from extremely high temperature and humidity.

2-1-2 Installing BQ-260

This section shows how to install BQ-260.

Necessary Tools : Spanner (19 mm)

1. Place BQ-260 on installation place.
2. Place 3 mount base under levelling bolts.
3. Turn leveling bolts with spanner clockwise until bottom of BQ-260 is 120 mm in height.
4. Fasten 3 lock nuts on 3 leveling bolts.



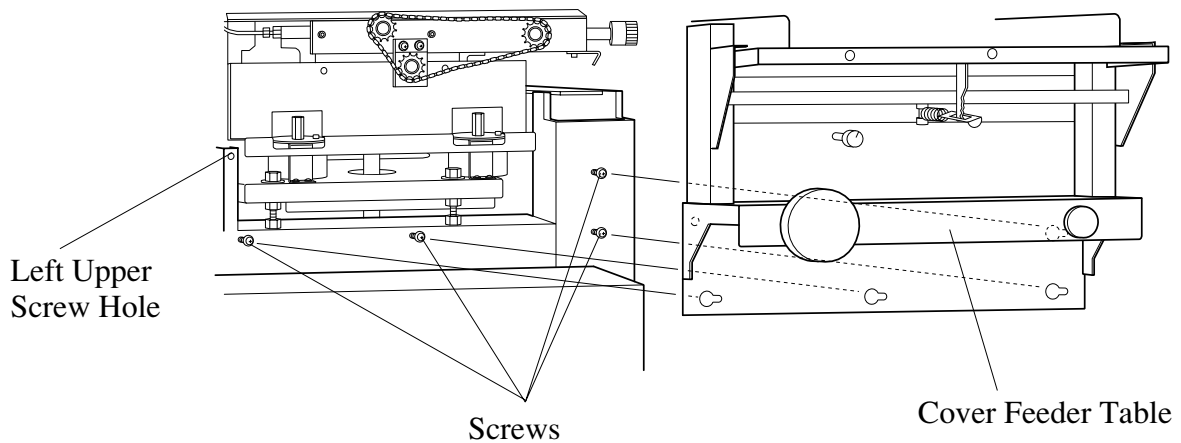
2-1 Installation Instructions

2-1-3 Installing Cover Feeder Unit on BQ-260



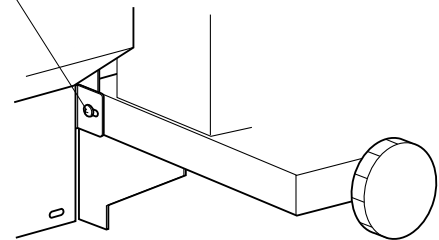
WARNING

Perform cover feeder unit installation with two persons.



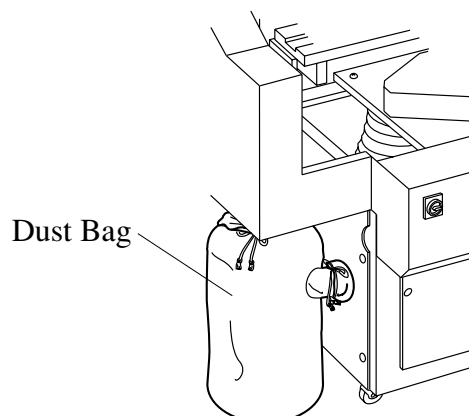
1. Loosen five fix screws.
 - Remove upper left screw.
 - Loosen other four screws.
2. Attach cover feeder unit.
 - Attach cover feeder unit so that cover feeder table is hung on four screws.
 - Install upper left screw and tighten all five screws firmly.
3. Connect cover feeder cable.
 - Connect cover feeder cable to BQ-260 power control box.
4. Fix side screw.
 - Open control panel.
 - Fix side screw on cover feeder.

Side Screw



2-1-4 Attach Dust Bag

- Attach dust bag on blower pipe at left side of BQ-260.
- Fix strings on both small and large openings.



2-1 Installation Instructions

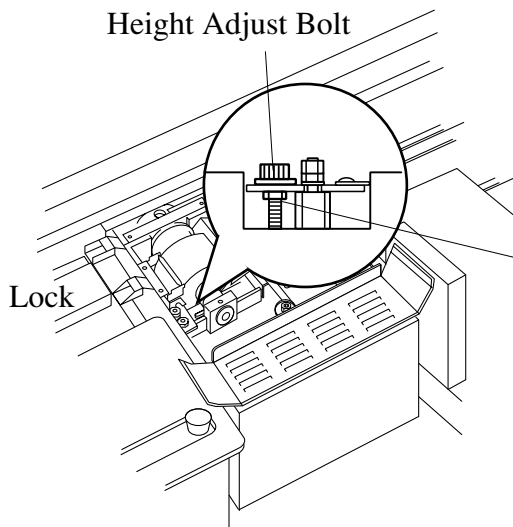
2-1-5 Releasing Transport Lock Nut

Melt Tank lock nut is installed to prevent melt tank moving up and down during transportation.

1. Loosen melt tank lock nut.

NOTE

- *It is not necessary to remove transport lock nut. Remain it loosen.*
- *Remain height adjust bolt loosen unless melt tank height adjustment is required.*



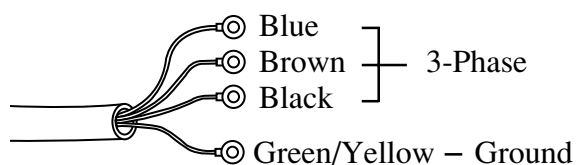
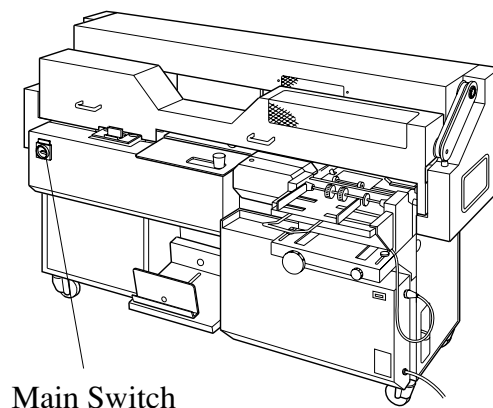
2-1-6 Connecting Power Cord

This section shows how to connect power cord on BQ-260.

⚠ WARNING

- *Be sure to depress stop button to prevent sudden work of BQ-260.*
- *Confirm voltage and frequency to be used on your BQ-260 are correct.*

1. Depress stop button.
2. Make sure that power switch is off.
3. Turn off main power or breaker in your shop.
4. Attach power cord to 3-phase power source.

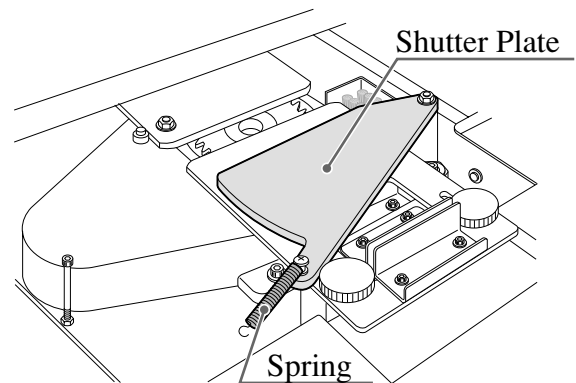


2-1 Installation Instructions

5. Turn on main power or breaker in your shop.

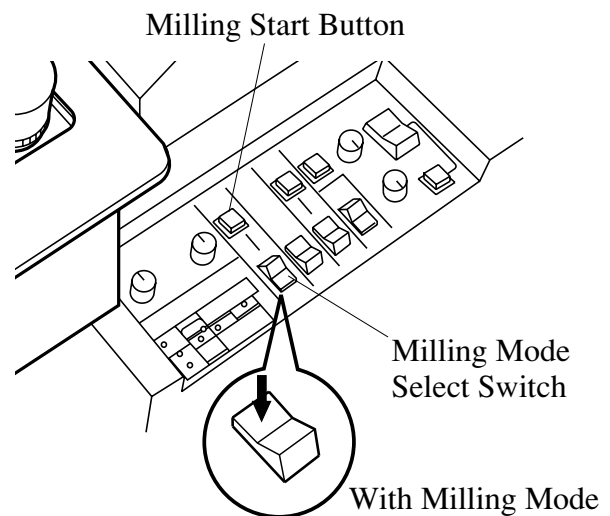
6. Turn on power switch on BQ-260.

7. Remove the spring and open the shutter plate.



8. Pull up stop button.

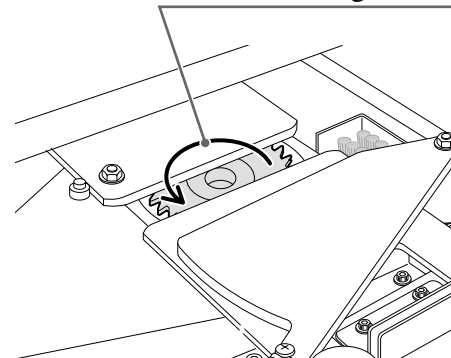
9. Depress milling mode select switch to far side to select with milling mode.



10. Depress milling start button.
- Blower will start at the same time.

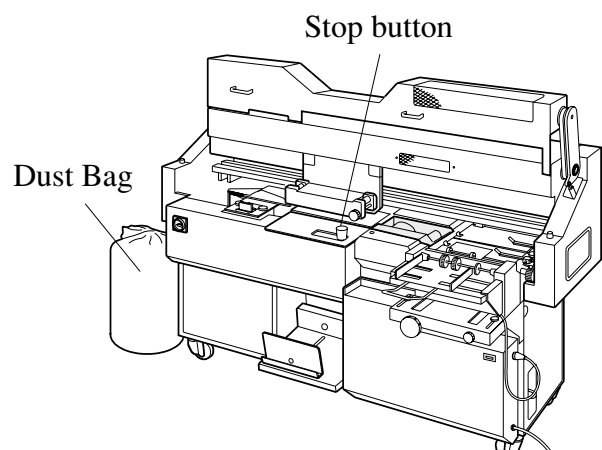
11. Depress milling mode select switch to near side to stop the milling cutter, watching the rotating milling cutter from above.
- Check the rotating direction of the milling cutter.
- The milling cutter should rotate counter-clockwise.

Normal Rotating Direction



12. If the milling cutter rotates clockwise, stop immediately and perform as follows:
- Turn off power on BQ-260 and main power or breaker in your shop.
- Change wiring on 3-phase terminal and perform step 5 through 12.

13. Depress stop button after connecting power cord correctly.



3. Before Starting Operation

3-1 Safety Device Function Check	16
3-2 Every Day Check Up	20

3-1 Safety Device Function Check

This section shows how to check safety device function. Check all safety device function before starting operation on BQ-260.

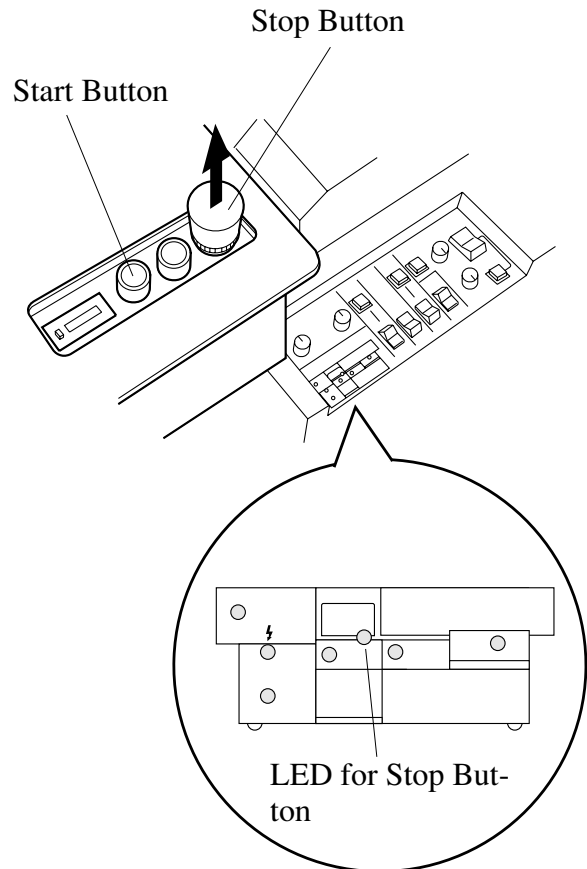
3-1-1 Stop Button



WARNING

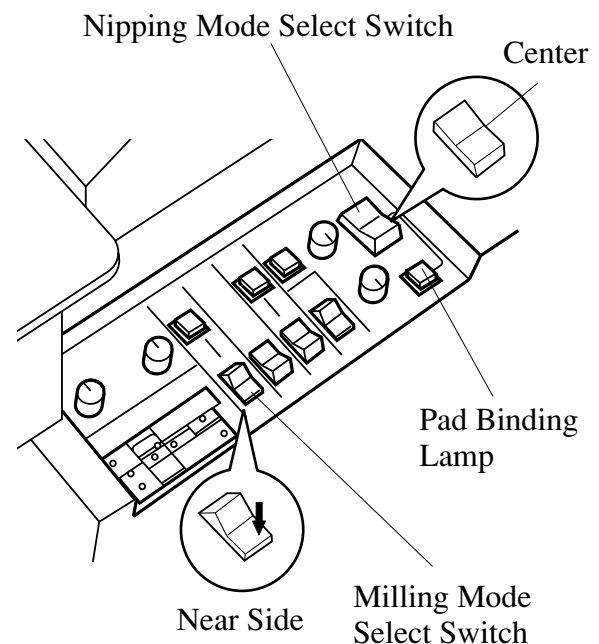
Do not touch clamper while clamper is moving. Moving clamper can cause severe personal injury.

1. Pull up stop button. LED on monitor for stop button turns off.



2. Set nipping mode select switch to center position to select pad binding mode.
 - Pad binding lamp on control panel turns on to indicate that pad binding is selected.

3. Select without milling mode with milling mode select switch.
 - Confirm lamp on start button is ON.

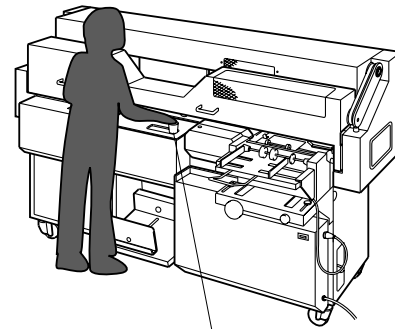


NOTE

Depress level plate control button when start lamp is not on.

3-1 Safety Device Function Check

4. Check emergency stop function.
 - Stand in front of operation panel.
 - Hold top of stop button with your right hand to prepare to depress stop button immediately.
 - Depress start button and depress stop button 1 second after start button was depressed.
 - Clamper will stop in a moment to show that emergency stop function works correctly.

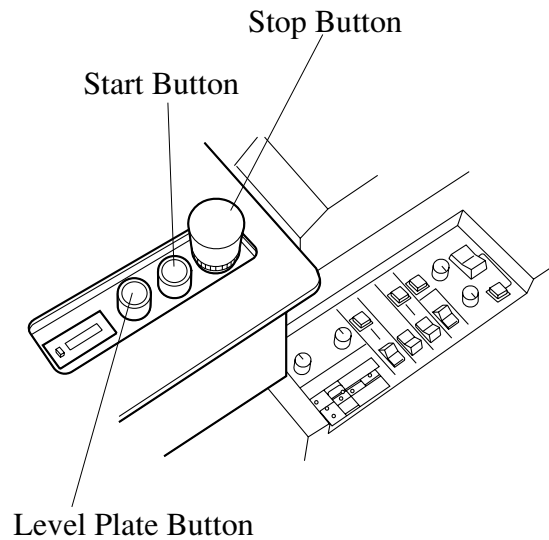


Stop Button

NOTE

When clamper does not stop in a moment even if stop button is depressed, turn off main power and call your local dealer.

5. Move clamper to home position.
 - Pull up stop button.
 - Depress start button to move clamper to its original position. Clamper will stop over nipping unit for 10 seconds.
6. Reset level plate.
 - When clamper returns to home position, depress level plate button once to reset level plate.
 - Start button will turn on to indicate level plate is reset.



7. Depress stop button to prevent BQ-260 works suddenly by mistake.

3-1 Safety Device Function Check

This section shows how to check safety device function. Check all safety device function before starting operation on BQ-260.

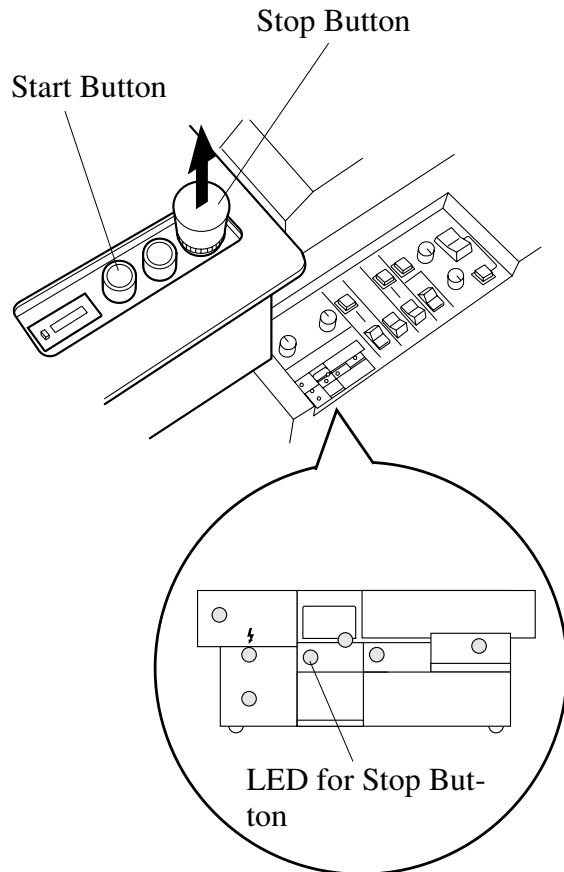
3-1-2 Safety Cover



WARNING

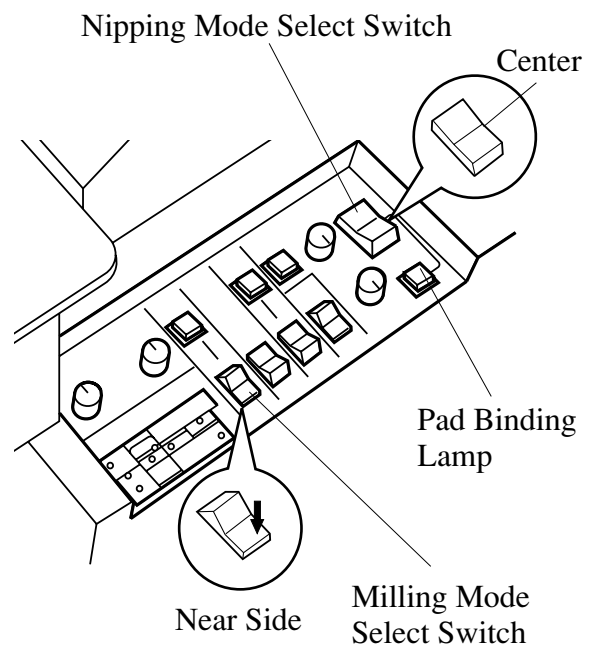
Do not touch clamper while clamper is moving. Moving clamper can cause severe personal injury.

1. Pull up stop button. LED on monitor for stop button turns off.



2. Set nipping mode select switch to center position to select pad binding mode.
 - Pad binding lamp on control panel turns on to indicate that pad binding is selected.

3. Select without milling mode with milling mode select switch.
 - Confirm lamp on start button is ON.



NOTE

Depress level plate control button when start lamp is not on.

3-1 Safety Device Function Check

4. Check safety cover function.
 - Stand in front of operation panel.
 - Hold handle on safety cover with your both hand to prepare to open safety cover immediately
 - Depress start button and open safety cover 1 second after start button was depressed.
 - Clamper will stop in a moment to show that safety cover function works correctly.

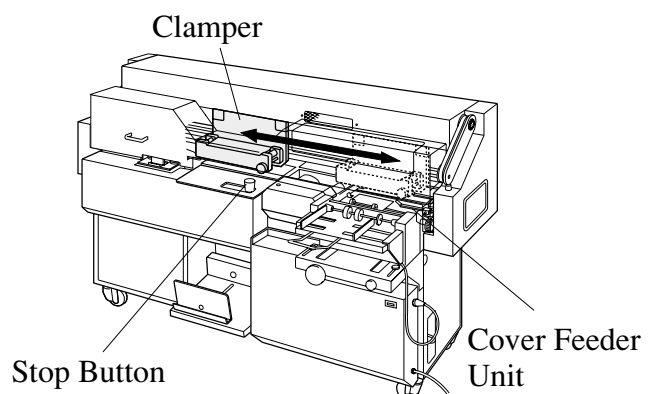
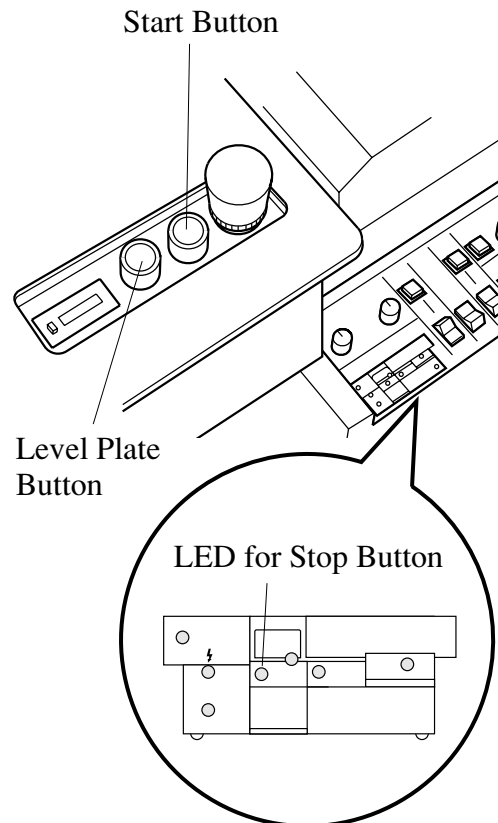
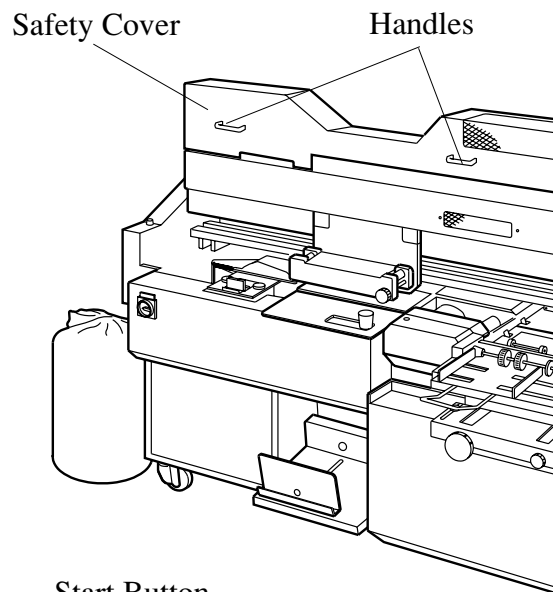
NOTE

When clamper does not stop in a moment even if safety cover is opened, turn off main power and call your local dealer.

5. Move clamper to home position.
 - Close safety cover.
 - Depress start button to move clamper to its original position. Clamper will stop over nipping unit for 10 seconds.

6. Reset level plate.
 - When clamper returns to home position, depress level plate button once to reset level plate.
 - Start button will turn on to indicate level plate is reset.

7. Depress stop button to prevent BQ-260 works suddenly by mistake.



3. Before Starting Operation

3-2 Every Day Check Up

3-2-1 Glue Level Check

Before start binding, glue level in melt tank must be checked.

⚠ WARNING

Keep off your hands or fingers from melt tank. Melt tank is heated up to around 200°C. High temperature can cause severe skin burn.

⚠ CAUTION

Do not supply glue more than Red Line on melt tank glue level scale.

NOTE

Check glue level when glue is melted.

1. When glue lower limit mark in melt tank appears, glue level is not enough for binding.

NOTE

See "7-1 Glue Supply" (Page 62) when you supply glue.

3-2-2 Level Plate Cleaning Check

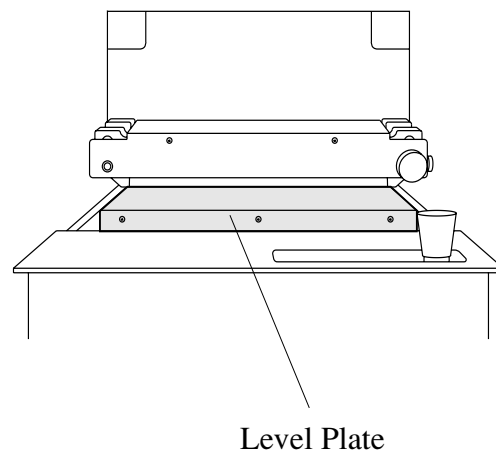
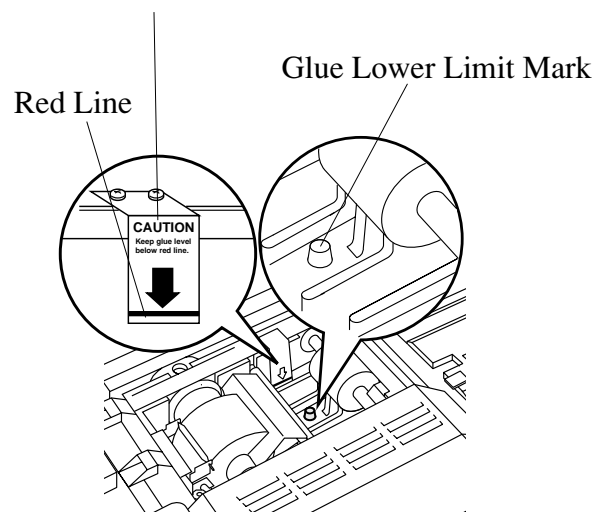
Before start binding, surface of level plate must be cleaned.

1. Check level plate with your eyes whether paper dust or glue stick on level plate.

NOTE

See "7-2-2 Level Plate Clean Up" (Page 64) when cleaning of level plate is necessary.

Melt Tank Glue Level Scale



3-2 Every Day Check Up

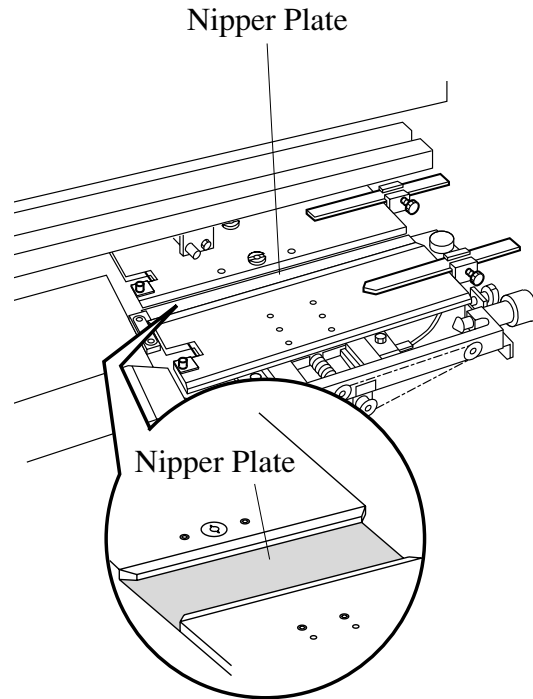
3-2-3 Nipper Unit Check

Before start binding, surface of nipper plate and nipper jaw must be cleaned.

1. Check nipper plate and nipper jaws with your eyes whether paper dust or glue stick to nipper plate and nipper jaws.

NOTE

See "7-2-1 Nipping Plate and Nipper Jaw Clean Up" (Page 63) when you clean nipper unit.



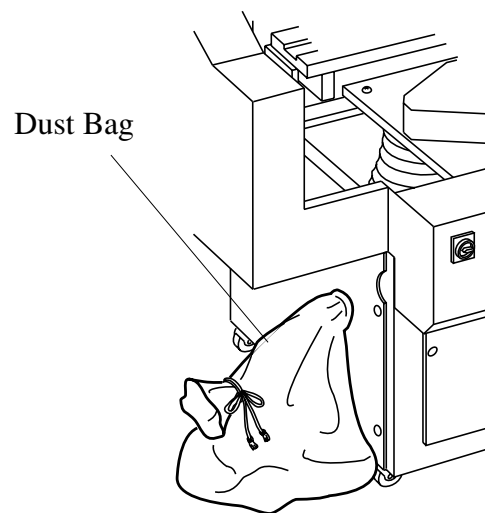
3-2-4 Dust Bag Check

Before start binding, dust bag must be empty.

1. Check dust bag with your hands whether it is empty or not.

NOTE

See "7-3-1 Dust Bag Clean Up" (Page 66) when you clean dust bag.



4. Set Up BQ-260

4-1 Nipper Unit Set Up	24
4-2 Clamper Unit Set Up	28
4-3 Milling Unit Set Up	29
4-4 Cover Feeder Unit Set Up	31
4-5 Vertical Stacker Unit Set Up	38
4-6 Melt Tank Unit Set Up	39
4-7 Operation Switches Set Up	41
4-8 Test Binding	42

4-1 Nipper Unit Set Up

NOTE

When your binding job is pad binding (without cover), nipper unit set up is not necessary to perform. Select pad binding mode with nipping mode select switch. Then proceed to "4-2 Clamper Unit Set Up" in Page 28.

4-1-1 Nipper Unit Set Up for Stock Thickness

This section shows how to adjust nipping width against stock thickness.

WARNING

Do not touch melt tank unit when adjusting nipper unit. Melt tank is heated up around 200°C. High temperature can cause severe skin burn.

1. Select either with milling or without milling binding mode by nipping mode select switch.

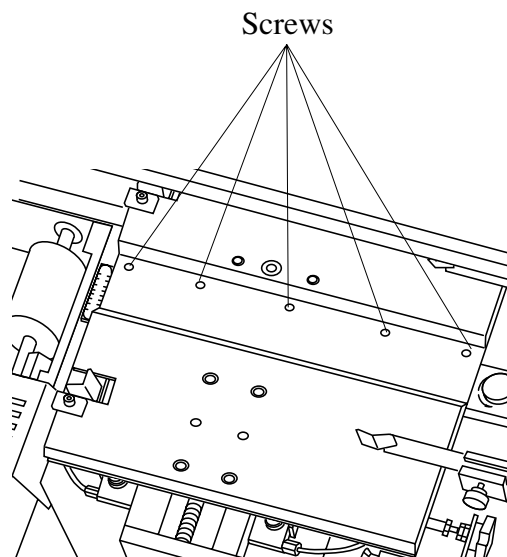
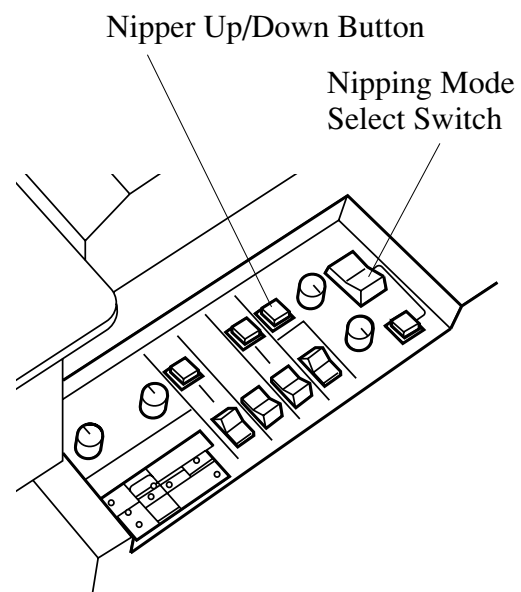
Near Side : for signature binding
Far Side : for with milling binding
Center : for pad binding

2. Depress nipper up/down button to raise nipper plate. Nipper plate stop at upper position.

NOTE

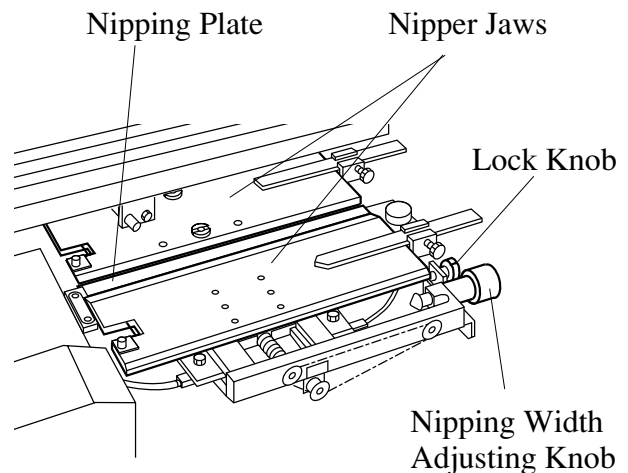
*- Nipper jaw's width must be adjusted when nipper unit is at upper position.
- When nipper up/down button is depressed with nipper being up position, nipper unit will be down.
- Nipper is at lower position when 5 screws on nipper plate appear.*

3. Depress stop button.

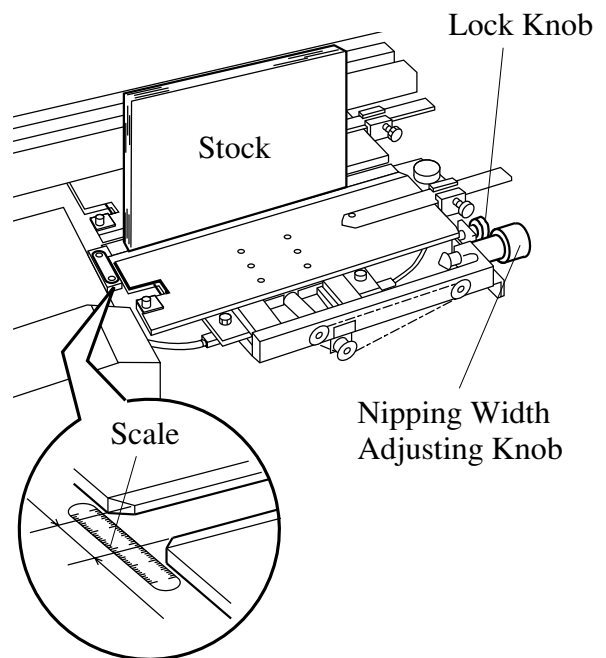


4-1 Nipper Unit Set Up

4. Hold 2 handles on safety cover with your both hands and open safety cover.
5. Turn fix knob counterclockwise to unlock nipping width adjusting knob.
6. Turn nipping compression adjusting knob counterclockwise to open nipper jaws until stock can be placed on nipper plate.



7. Place stock on nipper plate.
8. Turn nipping width adjusting knob clockwise to nip stock.
9. Read scale on nipping unit. This measurement will be used for setting up clamper.
10. Slightly turn nipping width adjusting knob counterclockwise to release the stock.
 - Nipping width adjusting knob must be turned back clockwise to secure the adjusted width of nipper jaws.



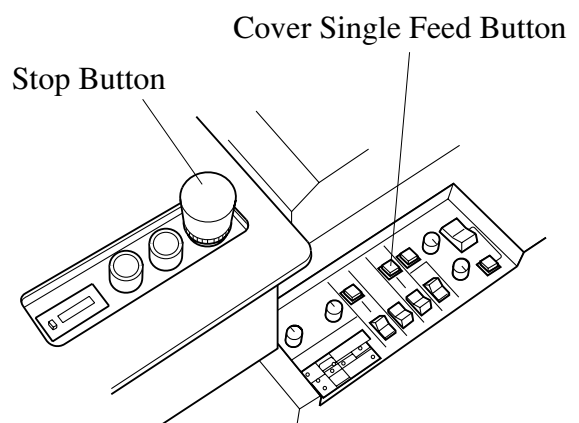
11. Turn fix knob Clockwise to lock nipping width adjusting knob.

12. Close safety cover.

13. Pull up stop button.

14. Depress nipper up/down button to lower nipper unit.

15. Depress stop button to prevent BQ-260 works suddenly by misoperation.



4-1 Nipper Unit Set Up

4-1-2 Cover Positioning Set Up

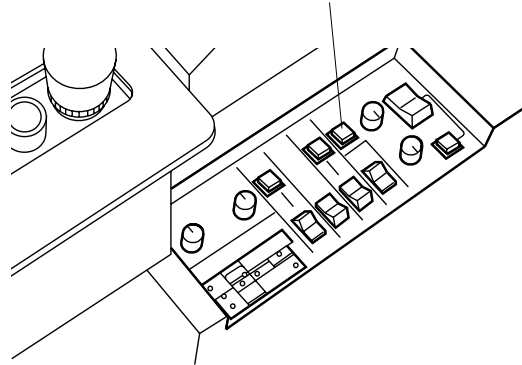
This section shows how to adjust cover stopper and guide.

1. Pull up stop button.
2. Depress nipper up/down button to raise nipper unit. Nipper unit stops at upper position.

NOTE

Set up cover position when nipper unit is at lower position.

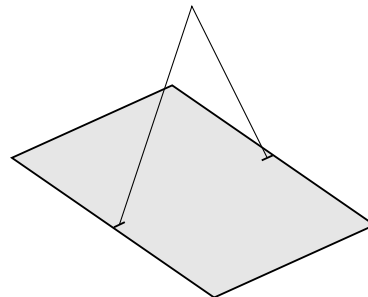
Nipper Up/Down Button



3. Hold handles on safety cover with both hands and open safety cover.

4. Prepare one cover sheet and mark center point inside both edges of cover sheet.

Center Point

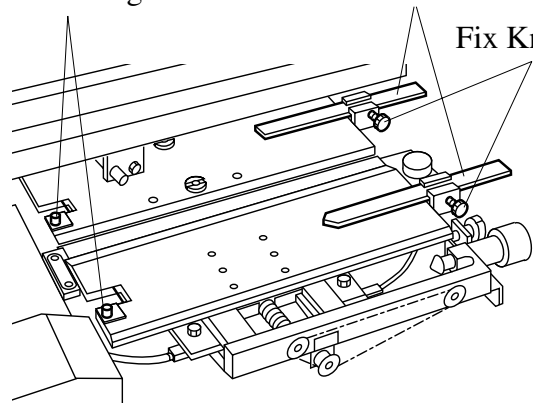


5. Loosen 2 fix knobs for movable cover guide.

6. Slide cover guides right to provide space to place cover on nipper unit.

Cover Registers Movable Cover Guides

Fix Knobs



4-1 Nipper Unit Set Up

7. Place cover inside up on nipper unit, so that far side and left side slightly touch cover stopper and cover registers.

NOTE

Register side of cover must be placed against cover registers.

8. Turn cover stopper adjusting knob so that marks on cover is positioned just on center of nipper plate.

NOTE

Push or pull cover at the same time when cover stopper is adjusted.

9. Slide movable cover guide against cover to fix cover position. And then fasten fix knobs for movable cover guide.

NOTE

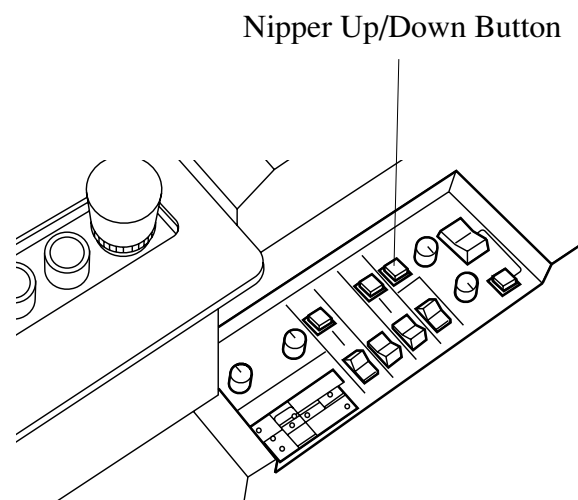
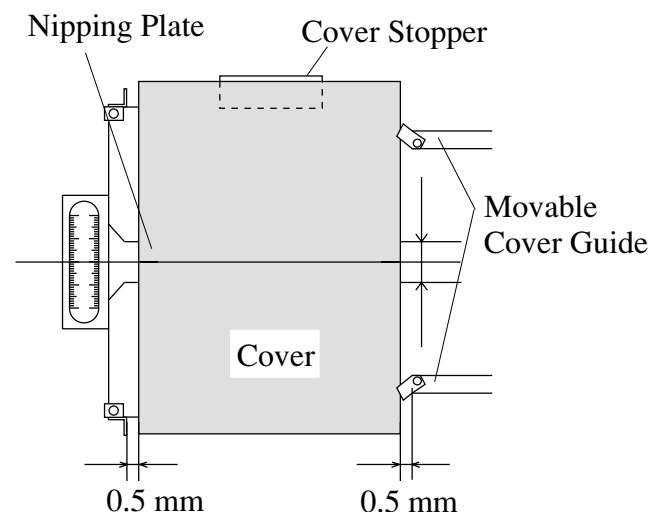
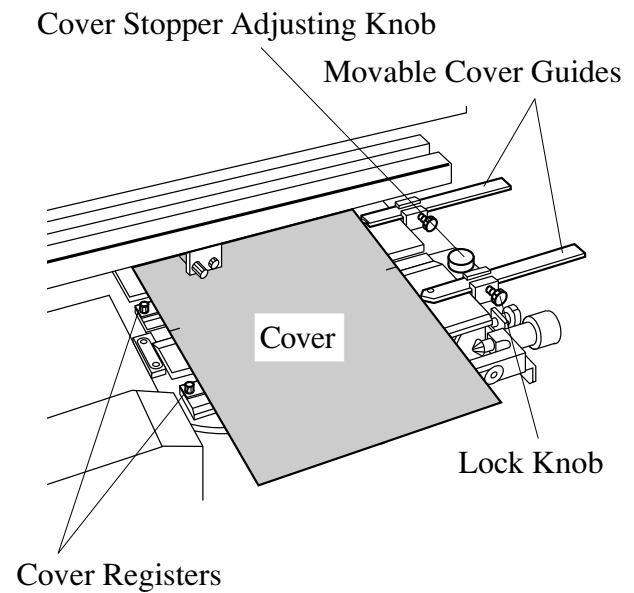
*- Clearance between cover and movable cover guide must be less than 0.5 mm.
- Check whether cover does not bend or does not have play more than 0.5 mm.*

10. Close safety cover.

11. Depress nipper up/down button to lower nipper unit.

NOTE

Cover can be fed only when nipper unit is at lower position.



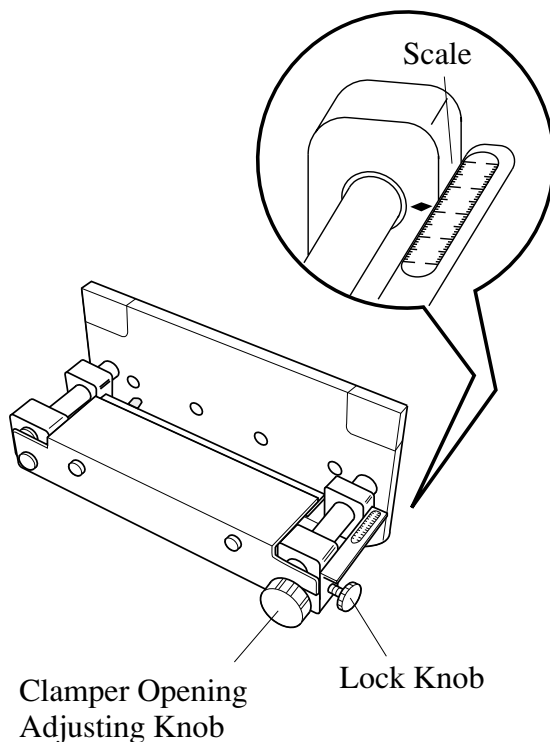
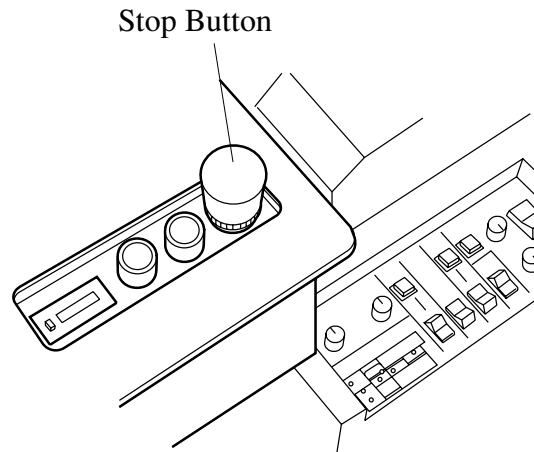
4-2 Clamper Unit Set Up

This section shows how to adjust clamper unit opening.

⚠ WARNING

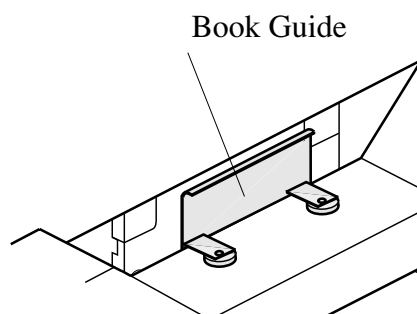
Depress stop button before setting up clamper. Sudden start of clamper can cause severe personal injury.

1. Depress stop button.
2. Hold 2 handles on safety cover with your both hands and open safety cover.
3. Loosen lock knob on clamper.
4. Turn clamper opening adjusting knob to adjust with the same measurement as in nipper unit adjustment.
5. Fasten fix knob on clamper firmly.
6. Close safety cover.



NOTE

- Attach book guide (Accessory) on safety cover when longer stock is placed.
Thinner book binding .. on clamper
Thicker book binding .. on safety cover
- Select guide large or small according to stock size.



4-3 Milling Unit Set Up

NOTE

When milling is not required on your binding, milling unit set up is not necessary to perform.

Select without milling mode and proceed to "4-4 Cover Feeder Unit Set Up" (Page 31).

4-3-1 Milling Guide Set Up

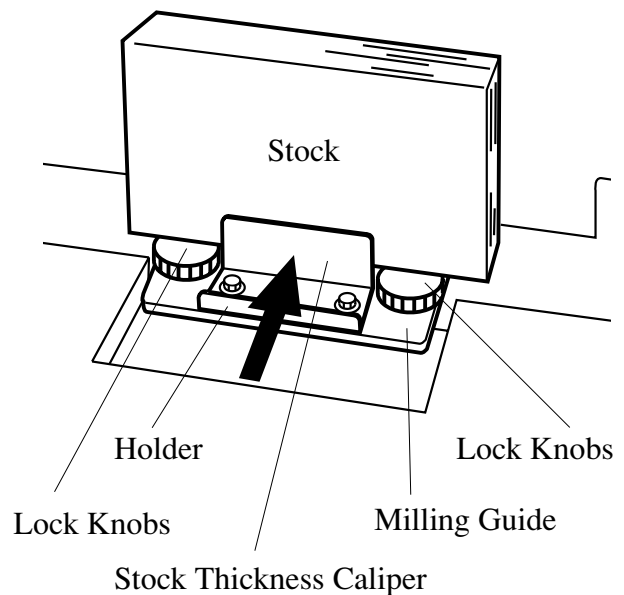
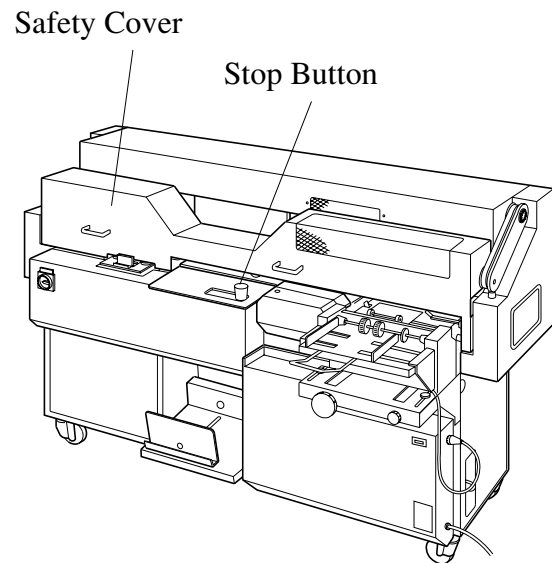
This section shows how to adjust milling guide position.

1. Depress emergency stop switch.
2. Loosen two lock knobs on front milling guide.
3. Hold holder on stock thickness caliper and open stock thickness caliper more than stock thickness.
4. Place stock in stock thickness caliper.

NOTE

Use stock which will be bound.

5. Hold holder on stock thickness caliper and push it to stock so that caliper guides hold stock.
6. Fasten two lock knobs on front milling guide firmly.
7. Take out stock from stock thickness caliper.



4-3 Milling Unit Set Up

4-3-2 Milling Depth Set Up

⚠ WARNING

Be sure to depress stop button before adjusting milling depth and do not touch milling cutter. Sharp cutter can cause severe personal injury.

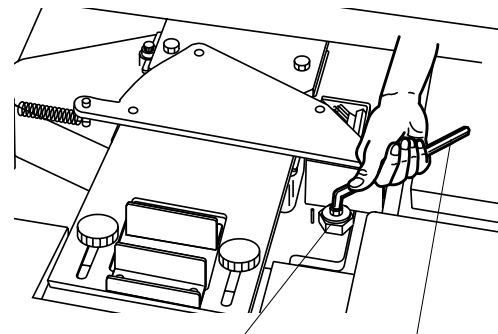
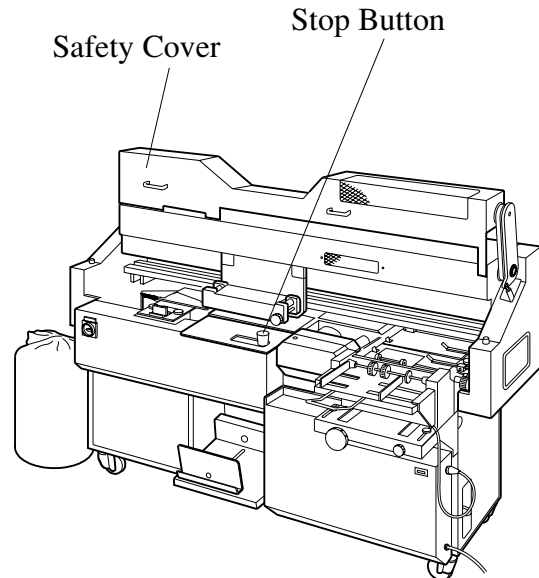
Necessary Tools : Allen Wrench (6 mm)
Pipe Wrench and Special Wrench

1. Depress stop button.
2. Open safety cover.
3. Loosen lock screw on milling depth adjusting bolt with allen wrench (6 mm).
4. Adjust milling depth.
 - Turn milling depth adjusting bolt with pipe wrench to select milling depth.
 - Align number on scale with pointer bar to select required milling depth.

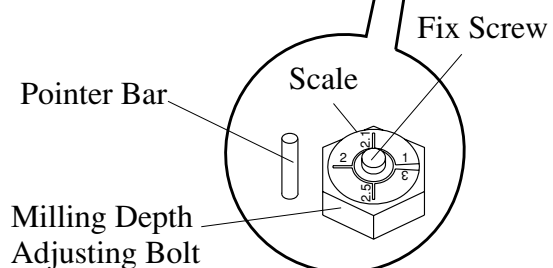
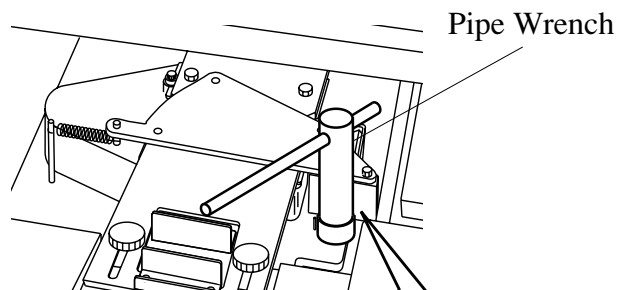
NOTE

- Unit on scale is mm.
- Milling depth is adjusted to 2 mm before shipment.

5. Fasten fix screw on milling depth adjusting bolt with allen wrench.
6. Close safety cover.



Lock Screw Allen Wrench



4-4 Cover Feeder Unit Set Up

NOTE

When your binding job is pad binding (without cover), cover feed unit set up is not necessary to perform. Proceed to "4-5 Vertical Stacker Unit Set Up" in page 38.

4-4-1 Cover Feeder Position Set Up

This section shows how to adjust cover feeder position.



WARNING

Do not set up cover feeder position too close to nipper unit, cover feeder will touch nipper unit.

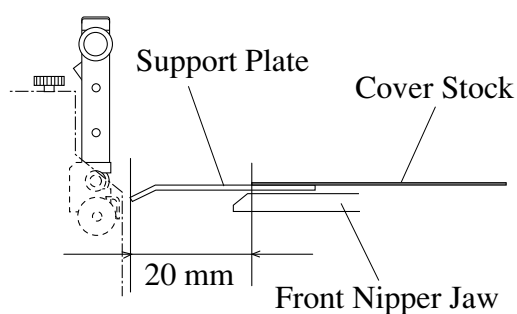
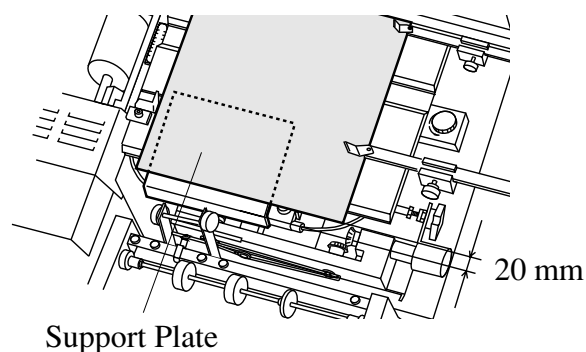
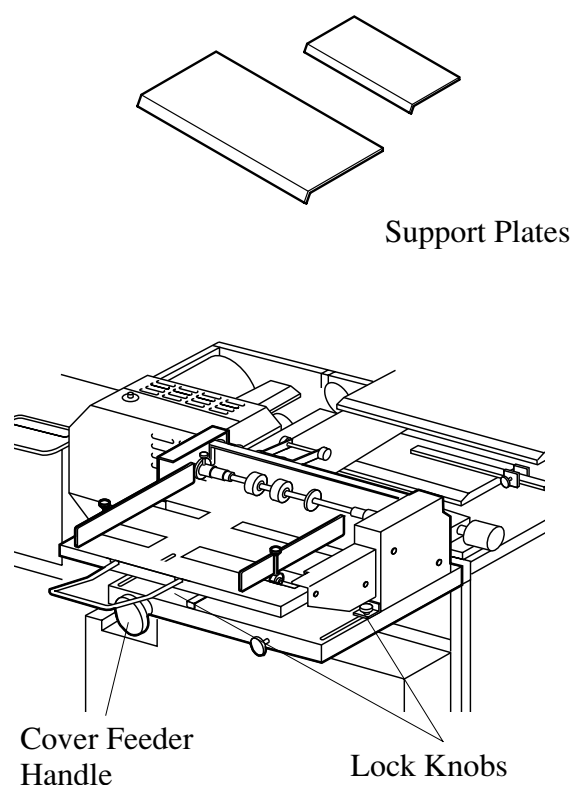
NOTE

See "4-4-2 Cover Feeder Position Set Up for Cover longer than 550 mm" in page 34 when cover is longer than 550 mm.

1. Loosen two lock knobs on cover feeder base and slide cover feeder unit fully to operation side by cover feeder handle.
2. Open safety cover
3. Select support plate according to cover size.
4. Place support plate on front nipper jaw.
 - Support plate must project over 20 mm from front nipper jaw.

NOTE

Support plate is used as a bridge between cover feeder unit and nipper unit.



4-4 Cover Feeder Unit Set Up

5. Slide cover feeder unit to drive side until support rollers will lay on support plate.

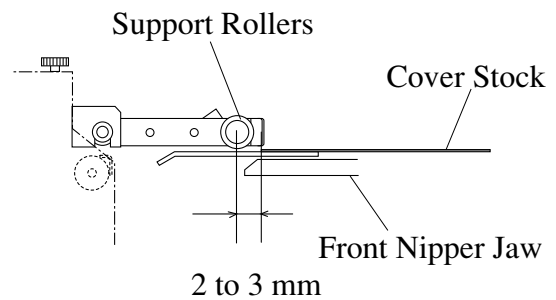
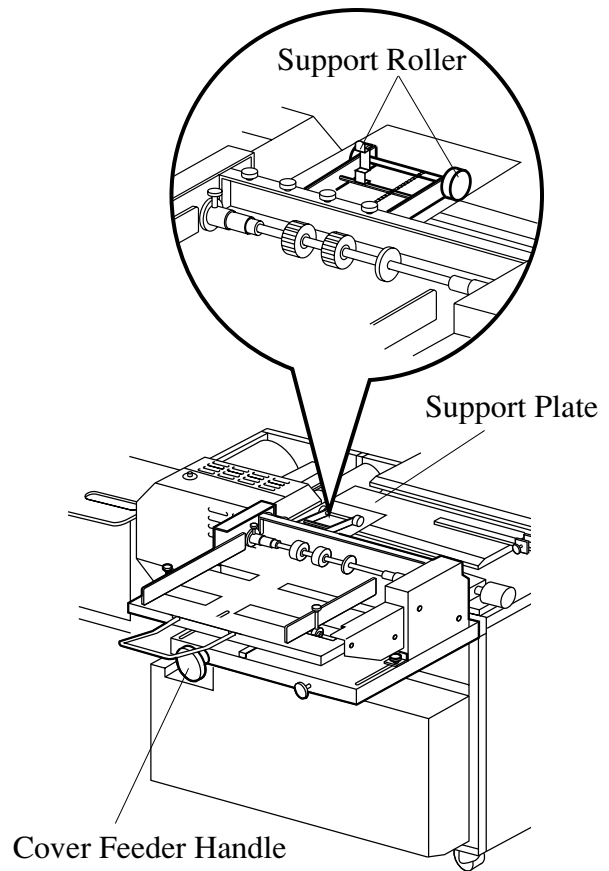
6. Release clip on support rollers to place support rollers on support plate.

7. Place cover on nipper unit so that far side edge touches cover stopper.

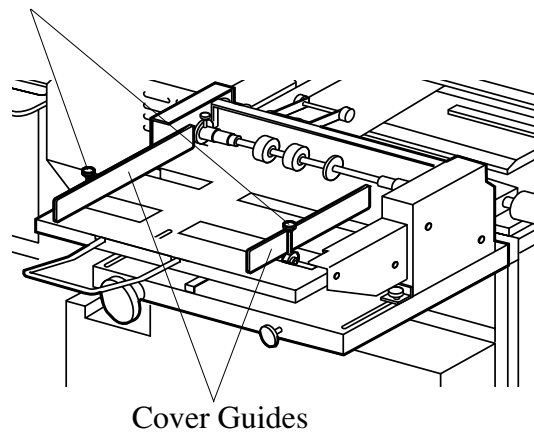
8. Turn cover feeder handle to provide 2 to 3 mm distance between cover edge and feed support roller.

9. Fasten lock knobs for cover feeder unit firmly.

10. Loosen two lock knobs for cover guides and slide left cover guide to left end.



Lock Knobs for Cover Guides



4-4 Cover Feeder Unit Set Up

11. Slide right cover guide to right to make space for cover stock.

12. Fun and true up cover stock well.

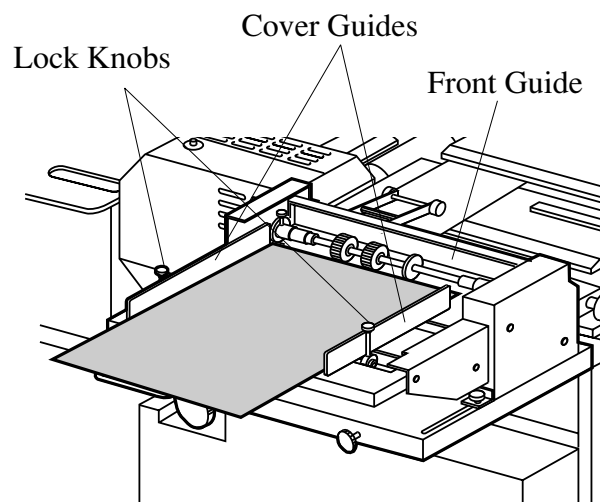
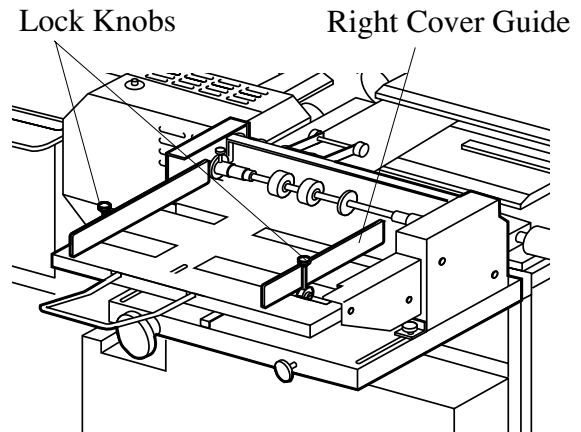
13. Place cover stock on cover feeder table so that left edge of cover slightly touch cover guide.

NOTE

Register side of cover must be placed left side when cover stock is placed on feeder table.

14. Slide right cover guide to left to touch cover stock slightly. Then tighten lock knob.

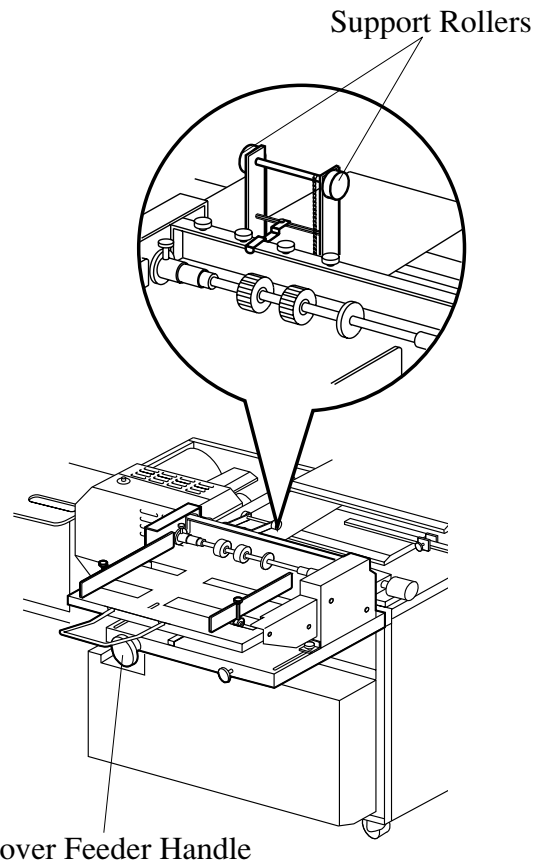
15. Push down table and push in cover stock against front guide.



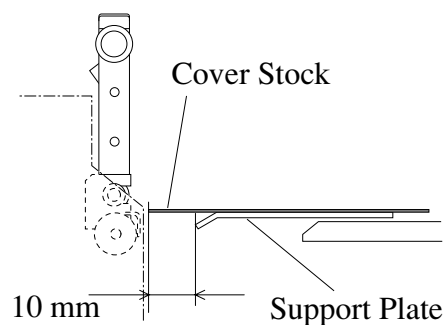
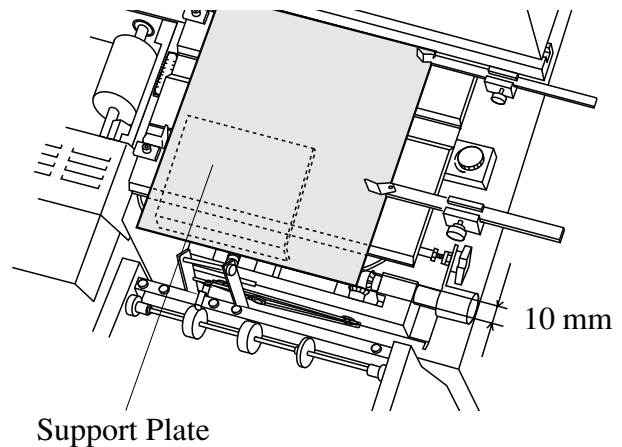
4-4 Cover Feeder Unit Set Up

4-4-2 Cover Feeder Position Set Up for Cover longer than 550 mm

1. Open safety cover.
2. Pull up support rollers and fix it on cover feeder unit with clip.
3. Place cover on nipper unit so that far side edge touches cover stopper.

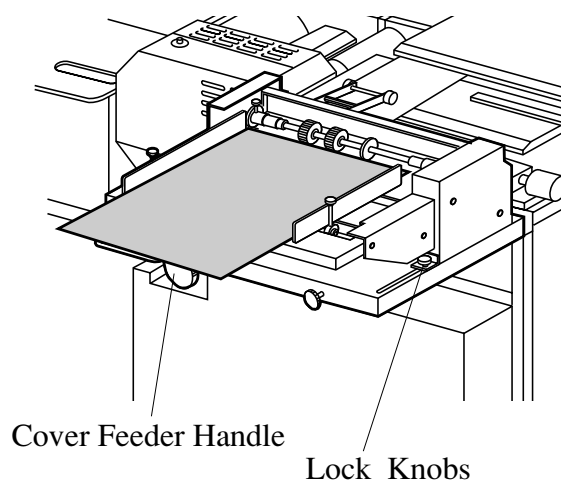


4. Place support plate on nipper unit so that edge of support plate is positioned 10 mm inside of cover.

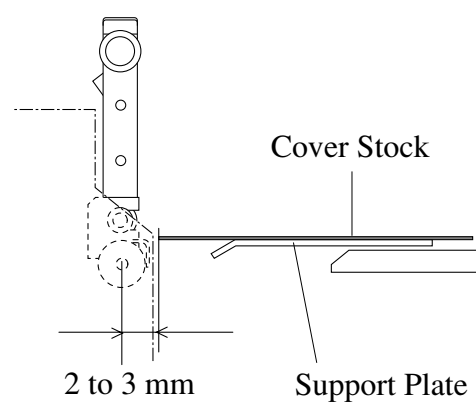


4-4 Cover Feeder Unit Set Up

5. Turn cover feeder handle to adjust clearance between cover edge and transport roller 2 to 3 mm.



6. Fasten lock knobs for cover feeder unit.



4-4 Cover Feeder Unit Set Up

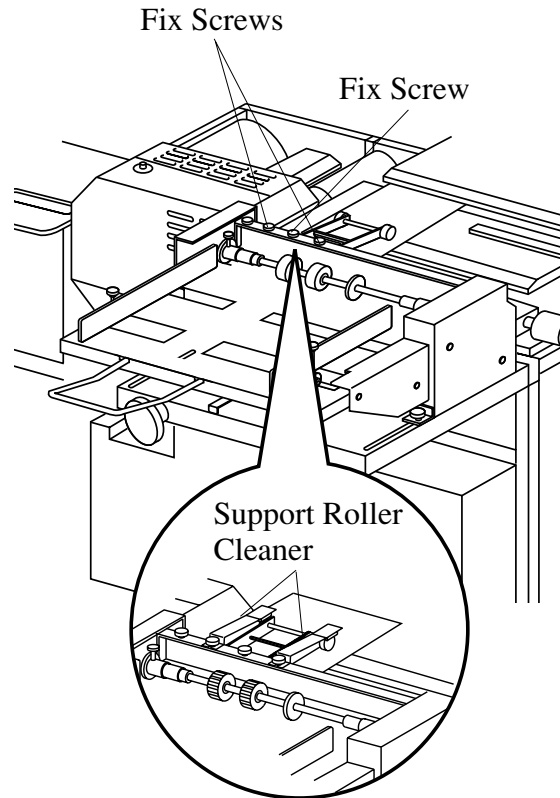
4-4-3 Attachment of Accessories

- To prevent misfeeding of cover caused by dirt on support roller, support roller cleaner is recommended to use.
- To prevent cover moves back, cover feeding supporter is recommended to use.

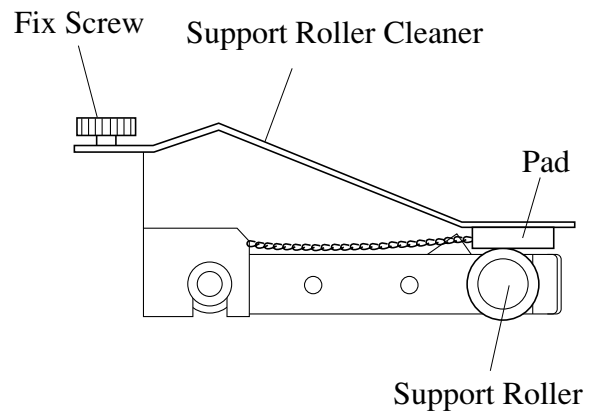
NOTE

Supply a few drops of alcohol on cloth of support roller cleaner.

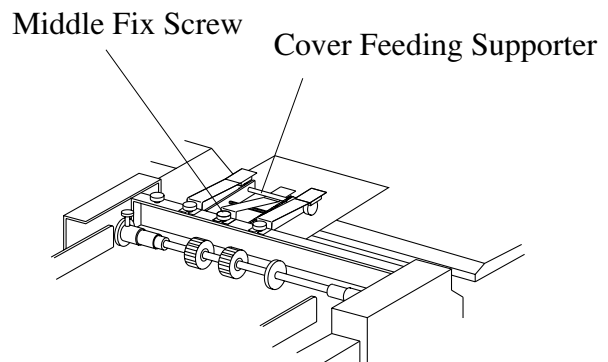
1. Loosen fix screws on feed support roller cleaners and cover feeding supporter.



2. Place support roller cleaner so that pad is placed on roller and the other end is placed under fix screw. And then fasten fix screw.



3. Attach cover feeding supporter under middle fix screw and fasten fix screw.



4-4 Cover Feeder Unit Set Up

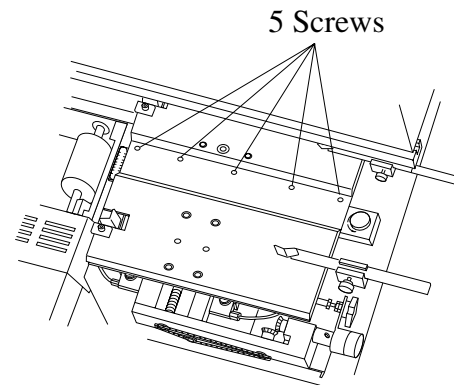
4-4-4 Test Feed of Cover

To confirm proper set up of cover feed unit and nipping unit, cover test feeding must be performed.

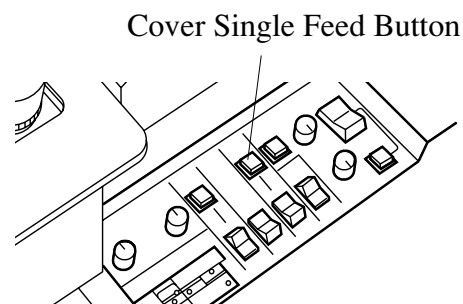
1. Confirm nipper unit is at lower position.

NOTE

Nipper unit is at lower position when 5 screws on nipper unit appear.



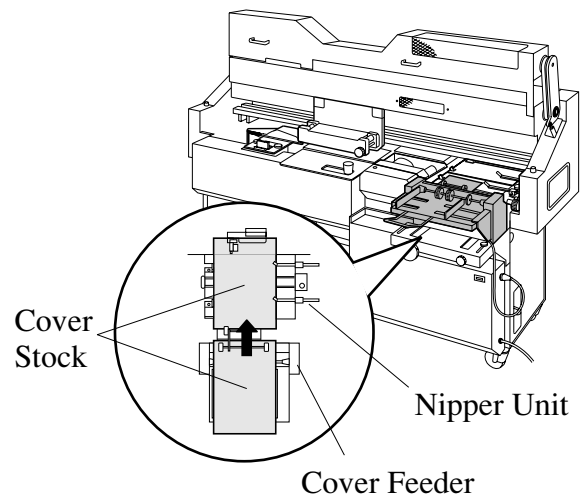
2. Depress cover single feed button to feed a cover to nipper unit.



3. Confirm that cover is fed until it touches cover stopper and feed rollers or two support rollers slightly touch cover edge.

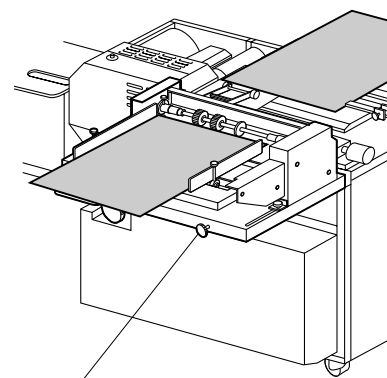
NOTE

- When support rollers/transport rollers and cover make noise or support rollers /transport rollers push cover obviously, slide back cover feed unit.



- When only one support roller touches, cover or transport roller is angled against cover, adjust angle of cover feeder with cover feeder angle adjust knob.

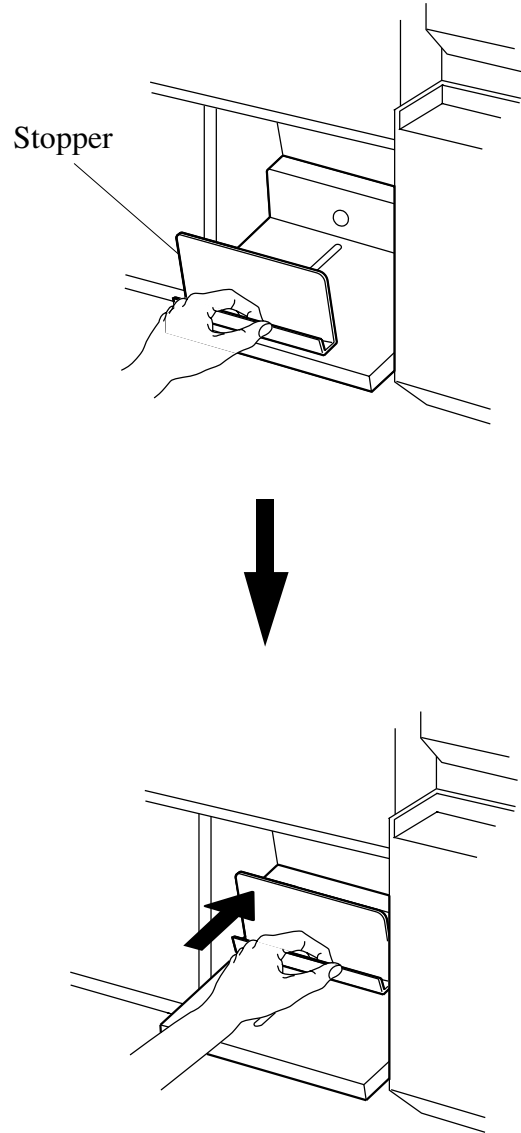
4. Repeat above step 2 and 3 until cover can be fed smoothly.



4-5 Vertical Stacker Unit Set Up

This section shows how to adjust vertical stacker.

- 1.** Push stopper on vertical stacker unit fully inside.



4-6 Melt Tank Unit Set Up

This section shows how to set up glue film thickness and glue temperature.

WARNING

- *Depress stop button before adjusting melt tank.*
- *Wear gloves on your hands when you set up melt tank unit. Melt tank is heated up to around 200°C. High temperature can cause severe skin burn.*

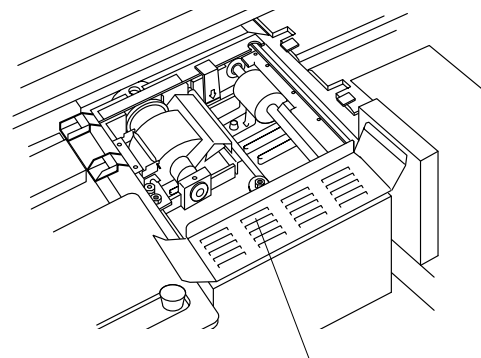
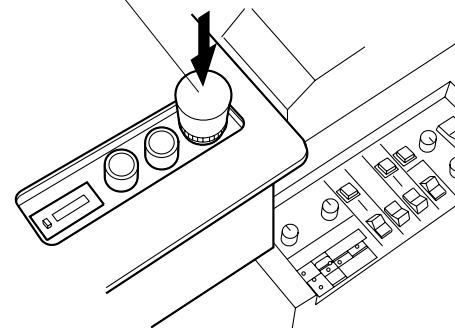
CAUTION

Do not turn glue film thickness adjust screw until glue is ready for binding.

Necessary Tool : Allen Wrench (5 mm)

1. Depress stop button.
2. Open safety cover. And then open melt tank cover.

Stop Button



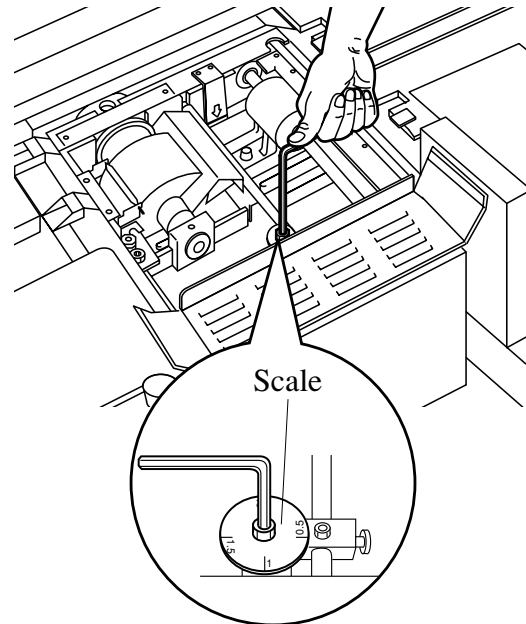
Melt Tank Cover

4-6 Melt Tank Unit Set Up

3. Turn glue film thickness adjust screw with allen wrench to point number 1.5 on scale.

NOTE

Unit on scale is mm. Standard thickness of glue film is 1.5 mm.

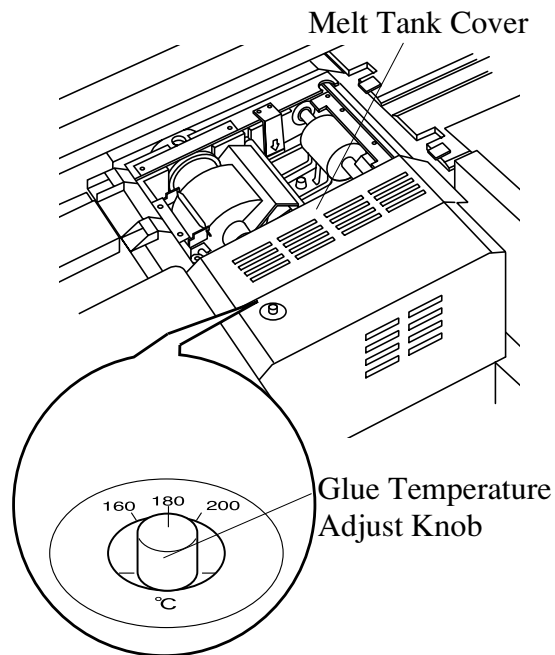


4. Close melt tank cover.

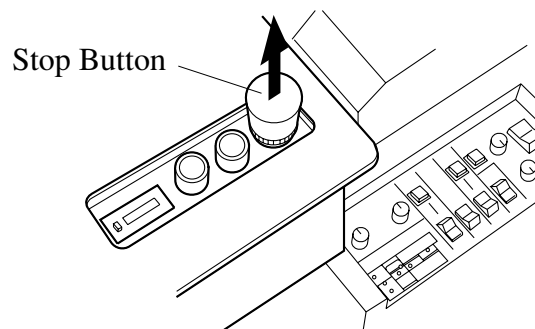
5. Turn glue temperature adjust knob to select glue temperature.

NOTE

*- Unit for temperature used on glue temperature indicator is centigrade degree.
- Standard temperature for glue is 180 degrees.
- Glue applied on book spine will be dry quicker when you set glue temperature lower. Low glue temperature is recommended for applying thick glue film.*



6. Pull up stop button.



4-7 Operation Switches Set Up

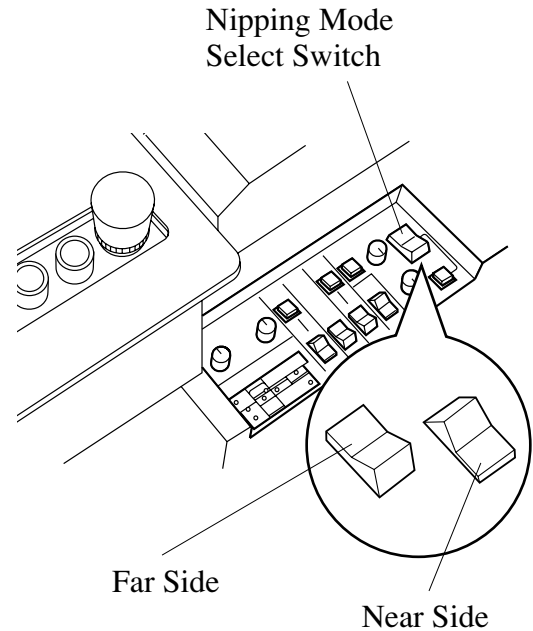
This section shows how to set each switch on operation panel.

1. Select nipping mode with nipping mode select switch.

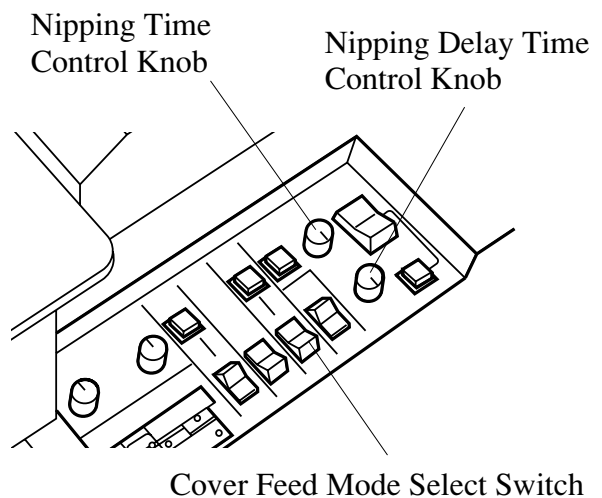
Far Side : With milling binding
Cut sheet binding

Near Side : Without milling binding
Signature binding

Center : Pad binding (without cover)



2. Set nipping time.
 - Turn nipping time control knob and nipping delay time control knob fully counterclockwise.



3. Select cover feed mode with cover feed mode select switch.

Far side : Automatic feed

Near side : Manual feed

4. Select level plate reset mode with level plate reset mode select switch.

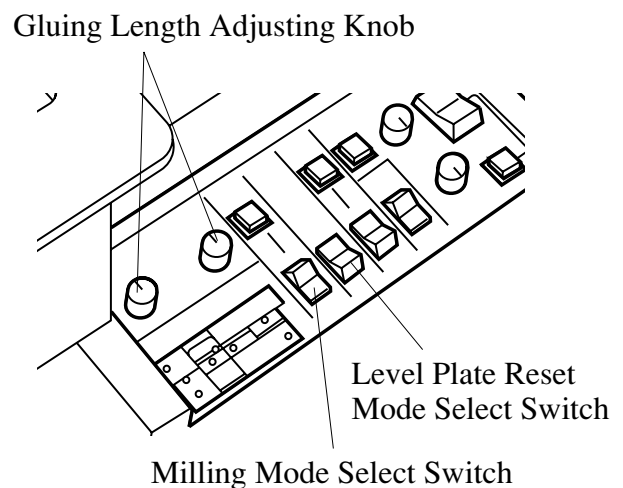
Far side : Automatic Reset

Near side : Manual Reset
(After booklet is removed by hand, reset level plate with level plate button.)

5. Select milling mode with milling mode select switch.

Far side : With Milling

Near side : Without Milling



6. Set both gluing length adjusting knobs at 12 o'clock.

4-8 Test Binding

4-8-1 Test Binding for With Milling Binding

Test binding is necessary to confirm each unit is set up properly.

1. Prepare stock for test binding.

NOTE

Stock for test binding must be same stock as your job.

2. Confirm that cover is fed on nipping unit and LED for cover on monitor is off.

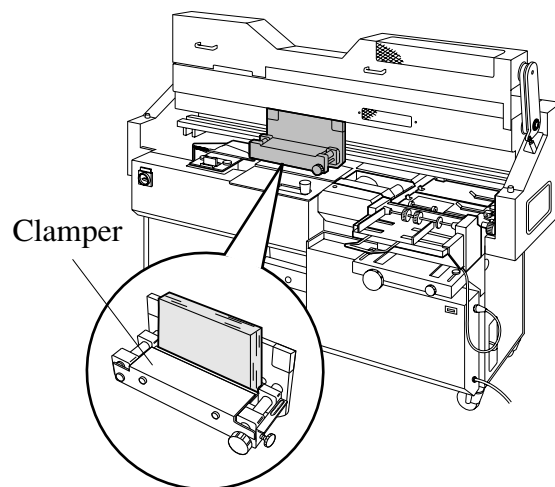
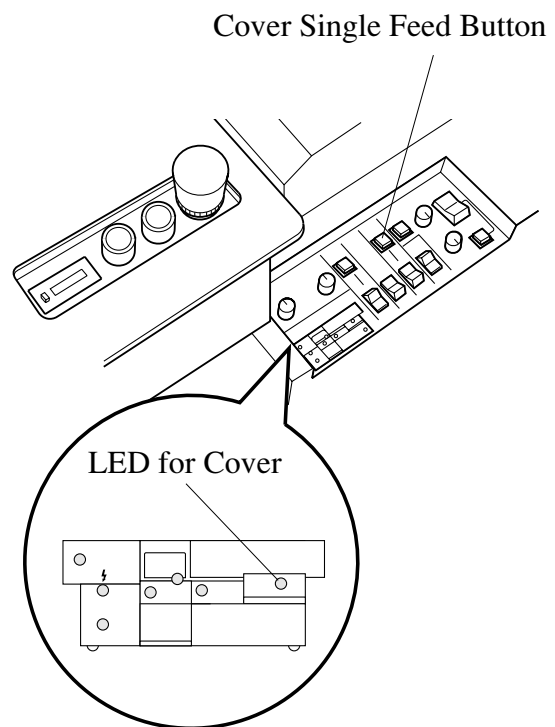
NOTE

When cover is not fed properly on nipping unit and LED for cover on monitor is on, set up cover so that cover edge touches to stopper.

3. True up stock and insert stock into clamper. Left side of stock must touch register shaft in clamper.

NOTE

Left side of stock must be register side. Spine of stock must face down.

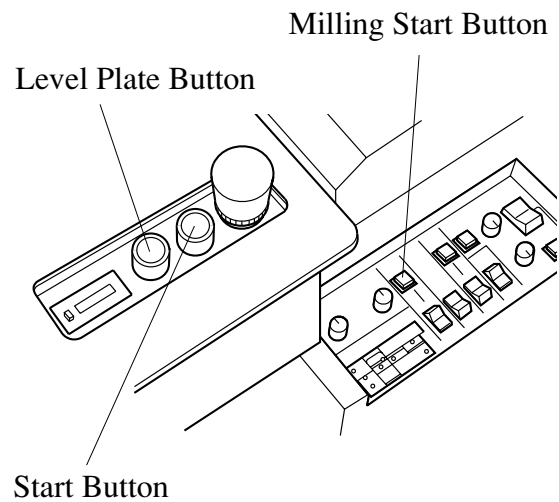


4-8 Test Binding

4-1 When with milling mode is selected, depress milling start button.

- Lamp in milling start button will turn off and milling cutter will start rotating.
- Blower pump will start at same time and dust bag swells with air.

4-2 When without milling mode is selected, lamp in milling start button will not be on.



5. Depress start button.

- Confirm that lamp on start button is on and then depress start button.
- Clamper will start for binding and returns to its home position (start position) after binding.

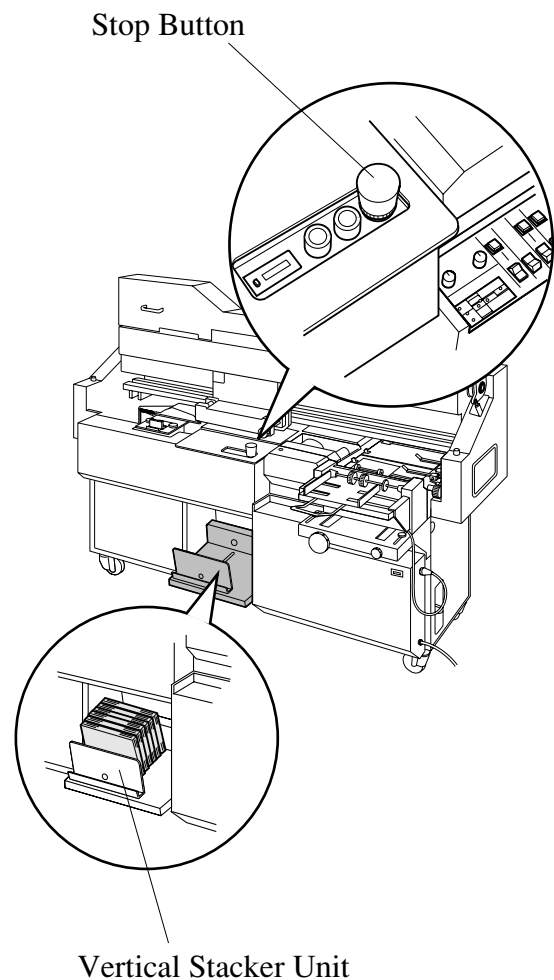
6. Confirm that book is ejected at vertical stacker unit after binding finished.

7. Check binding.

- When binding result does not satisfy your requirement, perform "4-1" to "4-7" (page 24 to 41) again to readjust each unit on binder.

8. Depress stop button.

9. Take out book from vertical stacker unit.



4-8 Test Binding

4-8-2 Pad Binding

Test binding is necessary to confirm each unit is set up properly.

1. Prepare stock for test binding.

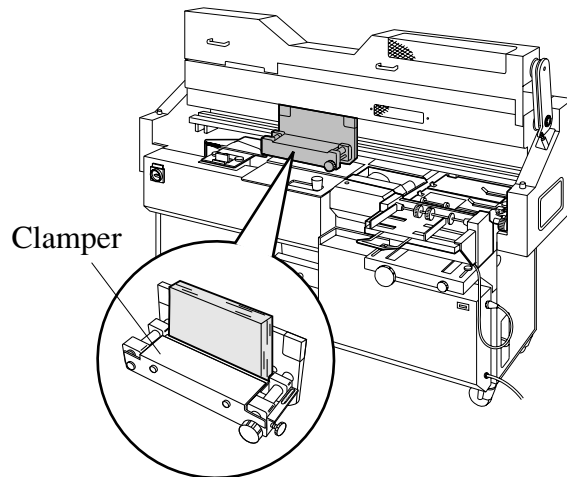
NOTE

Stock for test binding must be same as your job.

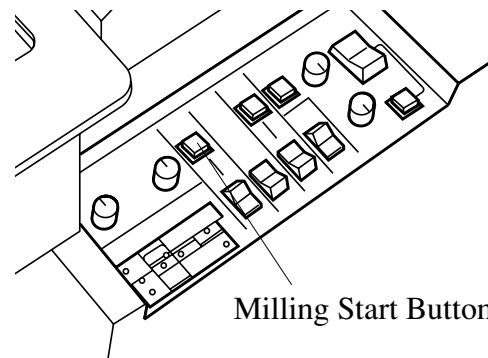
2. True up stock and insert stock into clamper. Left side of stock must touch register shaft in clamper.

NOTE

Left side of stock must be register side for cover and stock. Spine of stock must face down.

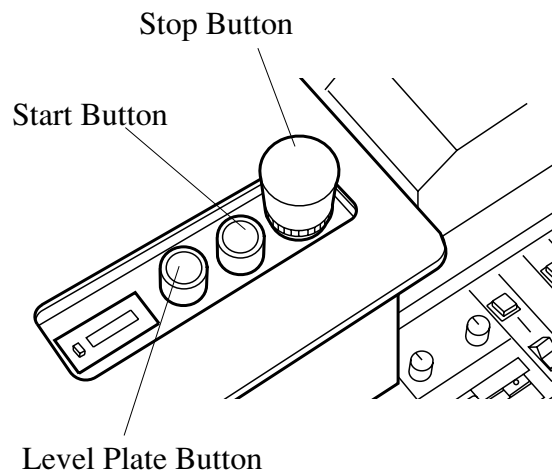


- 3-1 When with milling mode is selected, depress milling start button.
 - Lamp on milling start button will turn off and milling cutter start rotating.
 - Blower pump will start at same time and dust bag swells with air.



- 3-2 When without milling mode is selected, lamp in milling start button will not be on.

4. Depress start button.
 - Confirm that lamp on start button is on and then depress start button.
 - Clamper will start for binding and returns to its home position (start position) after padding.



5. Take out book from clamper and check binding.
 - When binding result does not satisfy your requirement, perform "4-1" to "4-7" (page 24 to 41) again to readjust each unit on binder.

6. Depress level plate button to reset level plate.

7. Depress stop button.

5. Operation Procedure

5-1 With Cover Binding Operation	46
5-2 Pad Binding	48

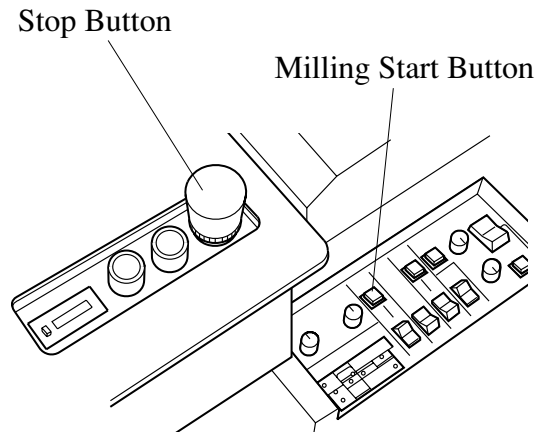
5-1 With Cover Binding Operation

This section shows binding operation for with cover binding.

1. Pull up stop button.
2. Depress milling start button.

NOTE

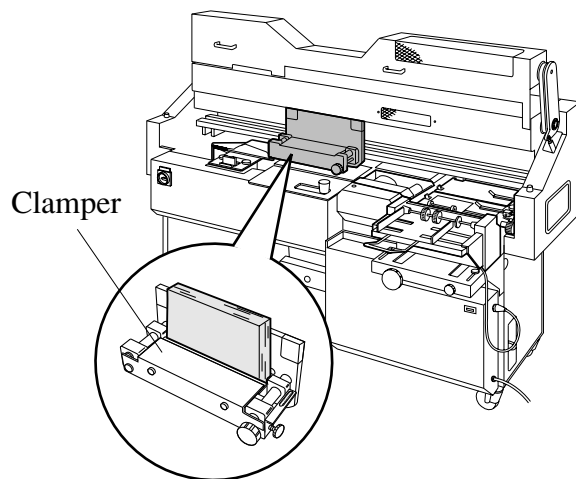
When without milling binding mode is selected, milling start button is not necessary to depress.



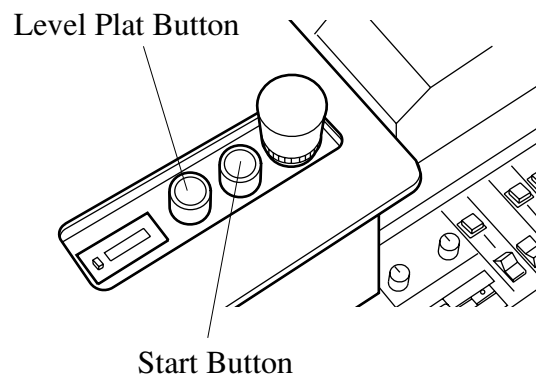
3. True up stock and insert stock into clamper. Left side of stock must touch register shaft in clamper.

NOTE

Left side of stock must be register side. Spine of stock must face down.



4. Confirm that lamp on start button is on and then depress start button.



5-1 With Cover Binding Operation

5-1 Followings are process of binding (with milling).

- 1) Stock is clamped with clamper and transported to milling unit and milled off spine.
- 2) Stock is transported to home position and clamper is automatically opened on level plate to rejog stock.
- 3) Stock is applied glue on melt tank unit.
- 4) Stock applied glue is transported to nipping unit. Nipping unit raises, sticks cover to stock spine and nips them strongly.
- 5) Stock formed spine is transported to home position through over lowered melt tank unit. Cover for next binding is fed on nipping unit at same time.
- 6) Stock is released from clamper and falls into vertical stacker unit.

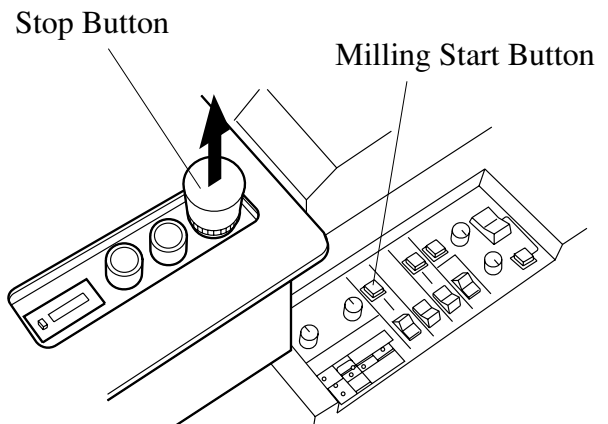
5-2 Followings are process of binding (without milling).

- 1) Stock is clamped with clamper and transported to melt tank unit.
- 2) Glue is applied on spine at melt tank unit.
- 3) Stock applied glue is transported to nipping unit. Nipping unit raises, sticks cover to stock spine and nips them strongly.
- 4) Stock formed spine is transported to home position through over lowered melt tank unit. Cover for next binding is fed on nipping unit at same time.
- 5) Stock is released from clamper and falls into vertical stacker unit.

5-2 Pad Binding

This section shows binding operation for pad binding.

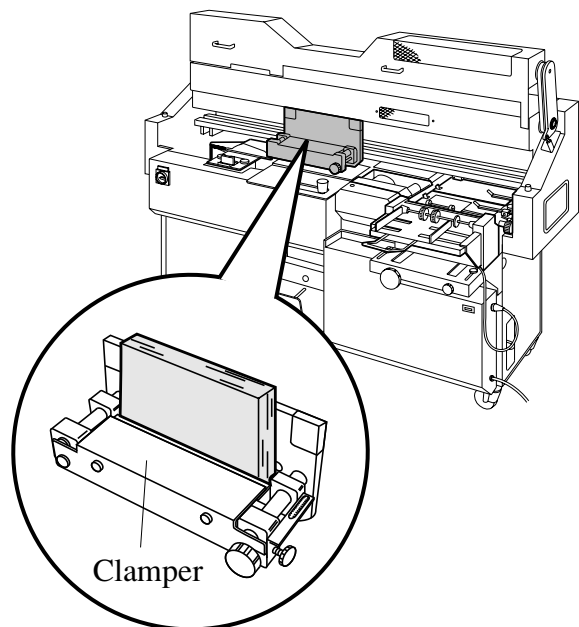
1. Pull up stop button.
2. When milling is required, depress milling start button.



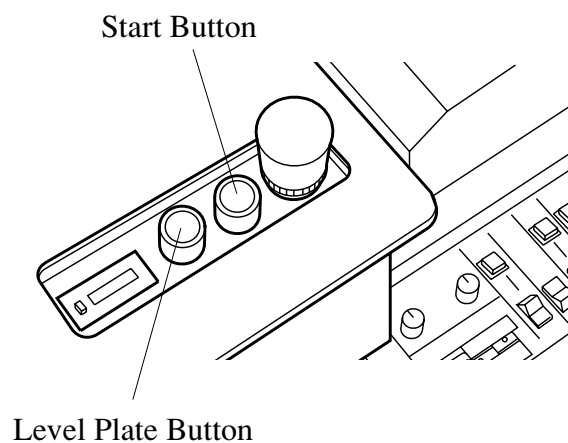
3. True up stock and insert stock into clamber. Left side of stock must touch register shaft in clamber.

NOTE

Left side of stock must be register side. Spine of stock must face down.



4. Confirm that lamp on start button is on and then depress start button.



5-2 Pad Binding

5-1 Followings are process of pad binding (with milling).

- 1) Stock is clamped with clamper and transported to milling unit and milled off spine.
- 2) Stock is transported to home position and clamper is automatically opened on level plate to rejog stock.
- 3) Stock is applied glue on melt tank unit.
- 4) Stock is stopped over nipping unit for several seconds to dry glue.
- 5) Stock is transported to home position through over lowered melt tank unit.
- 6) Stock is released from clamper.

5-2 Followings are process of pad binding (without cover)

- 1) Stock is clamped with clamper and transported to melt tank unit.
- 2) Stock is applied glue on melt tank unit.
- 3) Stock is stopped over nipping unit for several seconds to dry glue.
- 4) Stock is transported to home position through over lowered melt tank unit.
- 5) Stock is released from clamper.

6. Special Binding Method

6-1 Small Size Binding	52
6-2 To Increase Glue Film Thickness	56
6-3 To Adjust Finish Condition of Spine	60

6-1 Small Size Binding

6-1-1 Register Shaft Position Adjustment

This section shows how to set up register shaft when spine length of stock is shorter than 130 mm (5.1").

⚠ WARNING

Depress stop button when you replace register bar position. Clamper can cause severe personal injury.

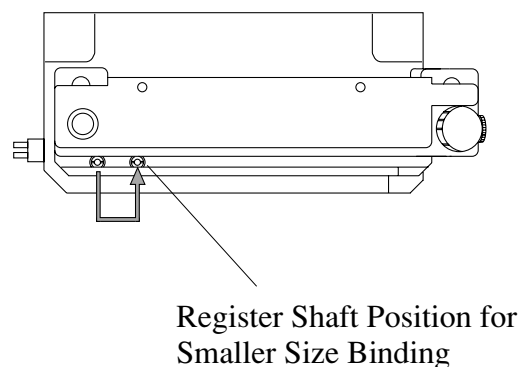
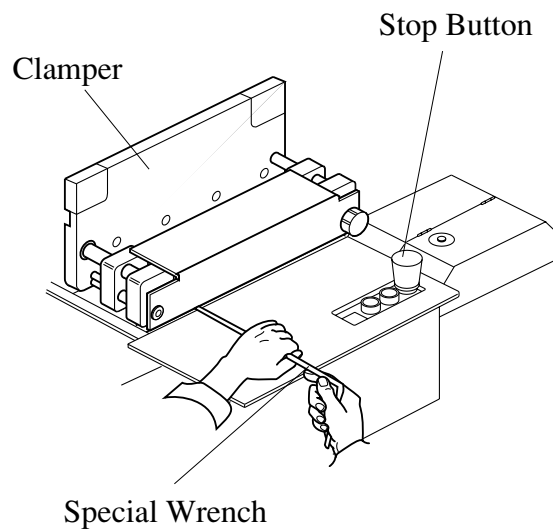
Necessary Tool : Special Wrench
(Accessory)

1. Depress stop button.
2. Remove register shaft in clamper with special wrench.

NOTE

Do not fall removed register bar while it is removed.

3. Fix register shaft with special wrench on position indicated in drawing.



6-1 Small Size Binding

6-1-2 Cover Position Register Block Installation

This section shows how to install register block when spine length of cover is shorter than 130 mm (5.1").

⚠ WARNING

Depress stop button when you attach cover position register blocks. Nipper unit can cause severe personal injury.

NOTE

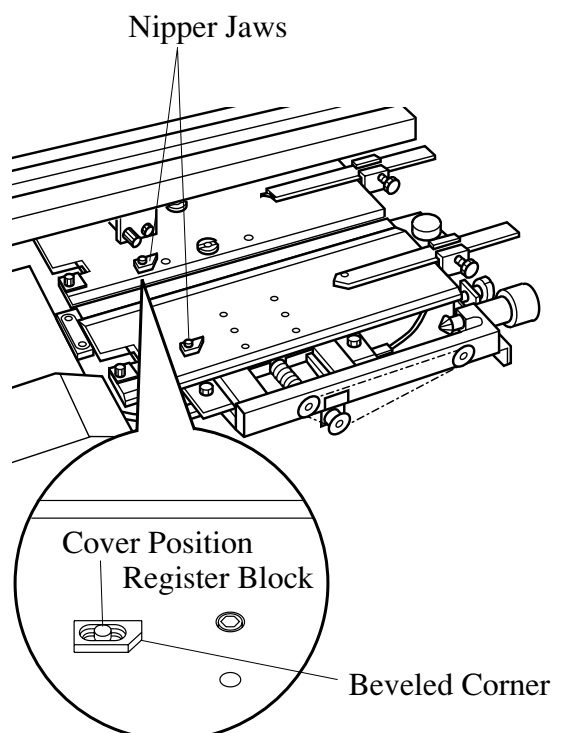
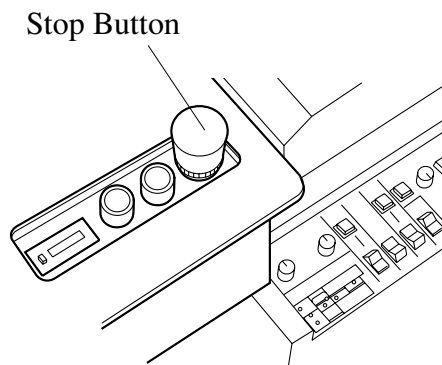
Cover position register block is not required for pad binding.

Necessary Tools : Allen Wrench (3 mm)

1. Depress stop button.
2. Attach cover position register blocks on nipper.

NOTE

- Attach cover position register blocks so that beveled corner faces to right-near side.
- Fix cover position register blocks so that it is parallel with nipper jaw edge.
- Fix cover position register blocks so that screw comes at center of groove.
- The blocks can be slid right and left within 10 mm.



6-1 Small Size Binding

6-1-3 Small Cover Stopper Installation

This section shows how to install small cover stopper.

⚠ WARNING

- *Depress stop button when small cover stopper is installed. Nipper can cause severe personal injury.*
- *Turn off power switch when back cover is opened.*

Necessary Parts : Small cover stopper

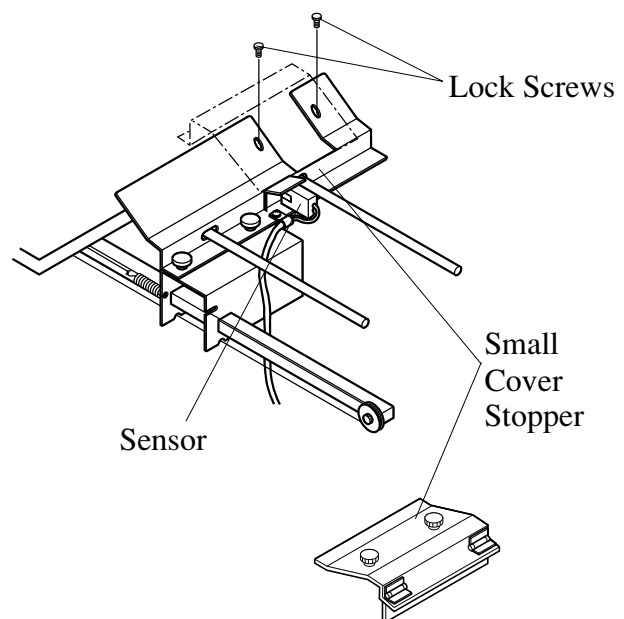
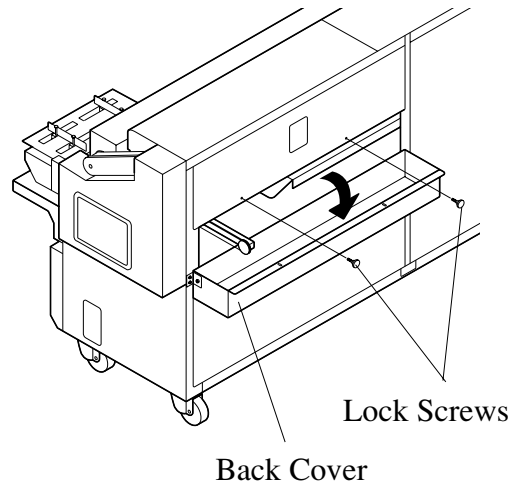
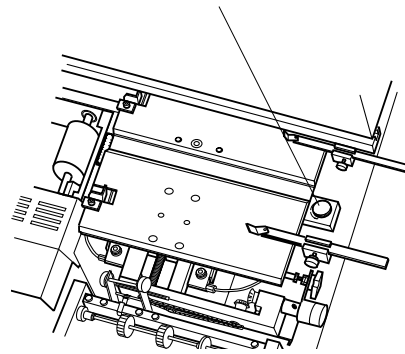
1. Depress stop button.
2. Turn cover stopper adjusting knob fully clockwise.
3. Hold back cover with your hand and loosen 2 lock screws.
4. Open back cover.
5. Fix small cover stopper on cover stopper with 2 lock screws.

NOTE

- *When small cover stopper is installed, cover sensor recognizes as if cover sheet is always placed. Confirm whether cover is fed properly on nipper unit before you start binding.*
- *Cover must be fed manually when small cover stopper is mounted on cover stopper.*

6. Close back cover and fix with 2 lock screws.

Cover Stopper Adjusting Knob



6-1 Small Size Binding

6-1-4 Shooter Attachment

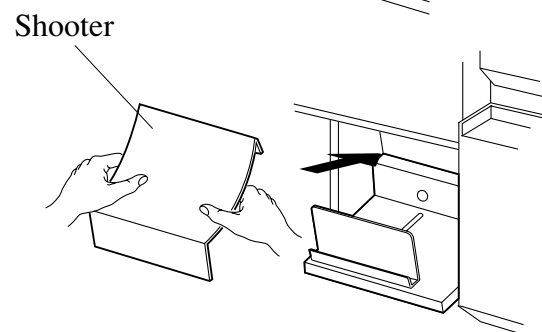
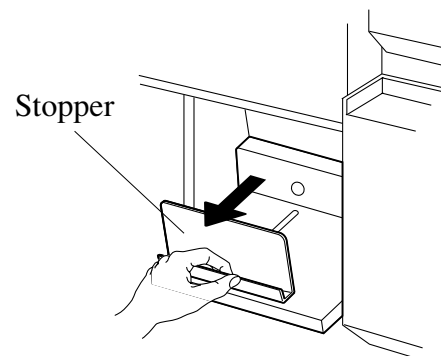
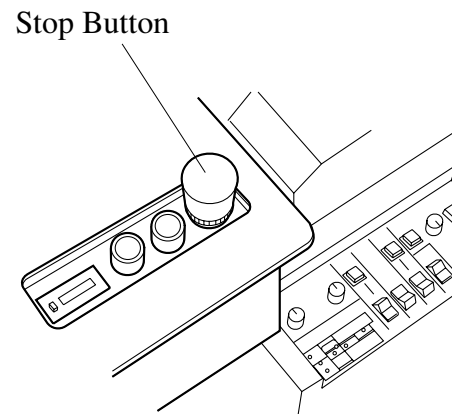
This section shows how to install shooter when spine length of stock is shorter than 160 mm.

NOTE

Any type of binding requires shooter when stock spine length is shorter than 160 mm.

Necessary Parts : Shooter (Accessory)

1. Depress stop button.
2. Pull out stopper on vertical stacker unit fully to near side.
3. Hung shooter on holes on stacker.
4. Keep stopper at the near side position.



6-2 To Increase Glue Film Thickness

6-2-1 Spacer Plate Attachment

This section shows how to install spacer plate on level plate to increase glue film thickness.

⚠ WARNING

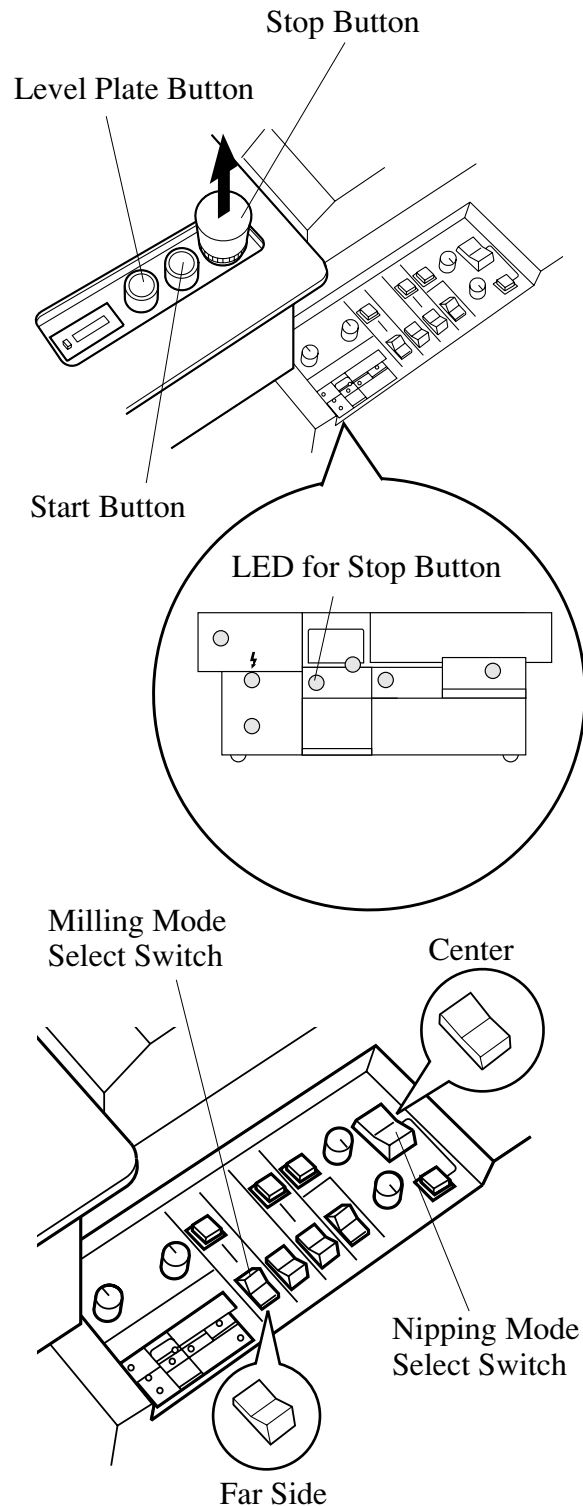
Do not touch clammer when start button is depressed. Clammer can cause severe personal injury.

Necessary Tool : Screw Driver

1. Pull up stop button.
 - LED for stop button on monitor turns off.
2. Set nipping mode select switch at middle position to select pad binding mode.
 - Pad binding lamp turns on.
3. Depress milling mode select switch to select with milling mode.
4. Confirm lamp on start button turns on.

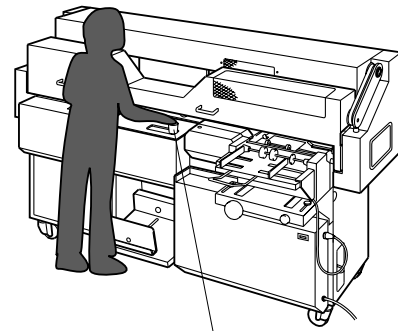
NOTE

Depress level plate control button when lamp on start button does not turn on.



6-2 To Increase Glue Film Thickness

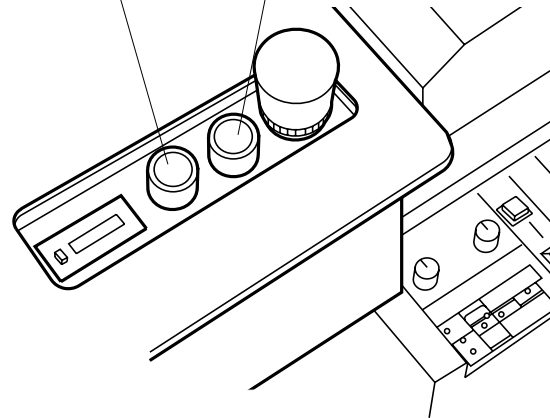
5. Stand in front of operation panel.
6. Place your right hand on stop button.
7. Depress stop button when clamber reaches to nipping section.
8. Confirm level plate is clean.



Stop Button

Level Plate Button

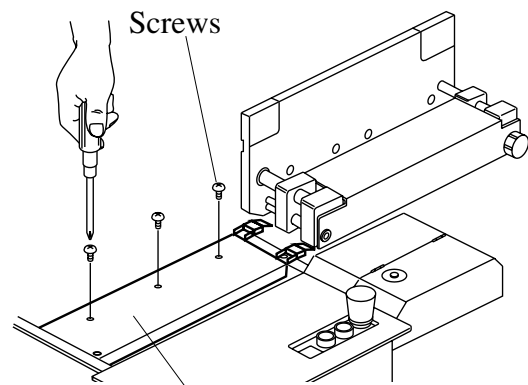
Start Button



NOTE

If it is not clean, see "7-2-2 Level Plate Clean Up" (Page 64) and clean level plate.

9. Loosen 3 screws on level plate with screw driver.

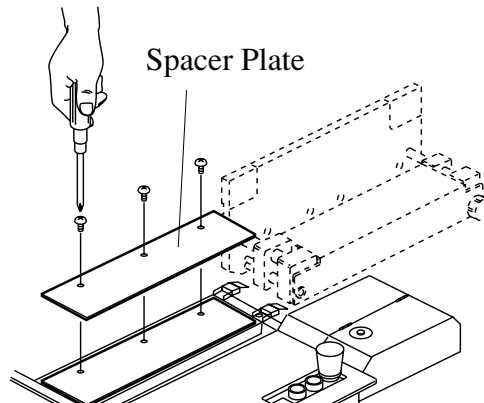


Screws

Level Plate

6-2 To Increase Glue Film Thickness

- 10.** Place spacer plate on level plate and fix spacer plate with 3 screws.

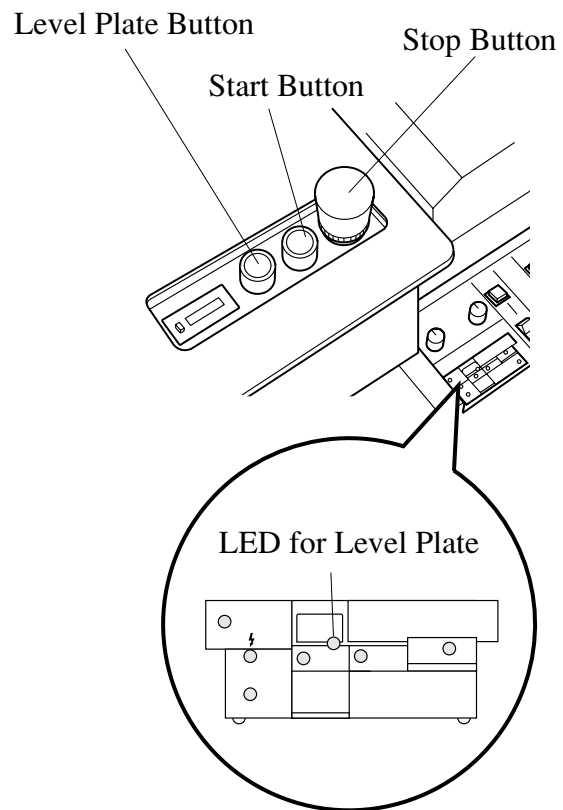


- 11.** Pull up stop button.
- LED for stop button on monitor turns off.

- 12.** Depress start button to move clamber its original position.

- 13.** Depress level plate button once to reset level plate.
- Start lamp will turn on to indicate level plate is reset.

- 14.** Depress stop button.



6-2 To Increase Glue Film Thickness

6-2-2 Melt Tank Height Adjustment

This section shows how to adjust melt tank height to increase glue film thickness by lowering a melt tank unit.

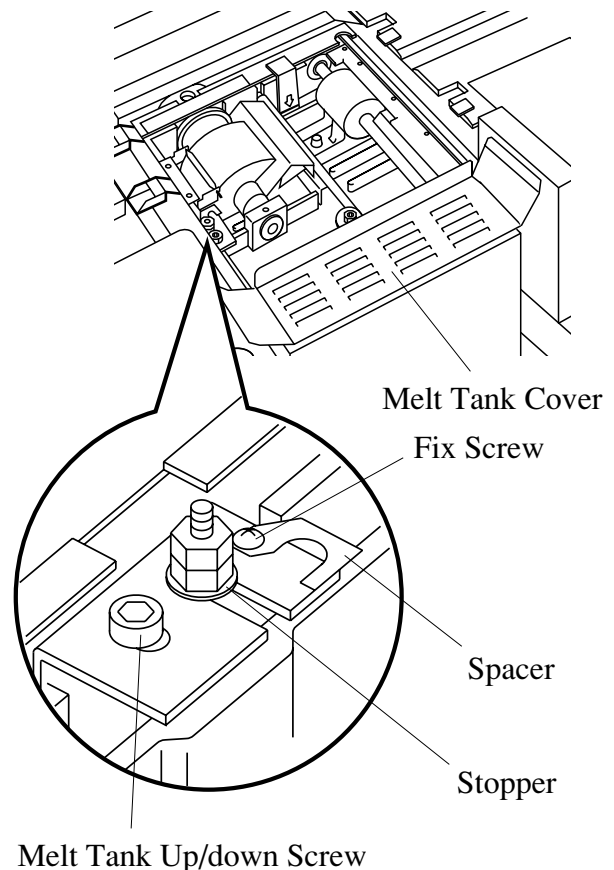


WARNING

Put gloves on your hands when you set up melt tank unit height. Melt tank is heated up to around 200 degrees. High temperature can cause severe skin burn.

Necessary Tools : Allen Wrench (5 mm)
Screw Driver

1. Depress stop button.
2. Open melt tank cover.
3. Turn clockwise melt tank up/down screw with Allen wrench until melt tank rises 1 to 2 mm.
4. Loosen fix screw on spacer until spacer can be moved.
5. Turn spacer clockwise to insert it under stopper. Confirm spacer is inserted under stopper completely and then fasten fix screw with screw driver.
6. Loosen melt tank up/down screw with Allen wrench.
7. Close melt tank cover.



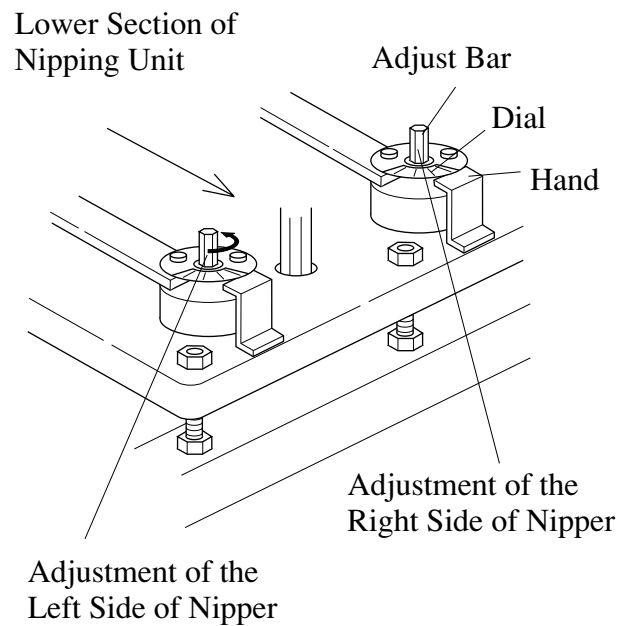
6-3 To Adjust Finish Condition of Spine

This section shows how to adjust finish condition of spine by changing nipping height or angle when the spine corner is too sharp, or spine corner is round.

NOTE

Sheet quality and glue application thickness influence the finish condition of spine.

1. Move cover feeding unit to the front side to provide access space under nipping unit.
2. Turn adjust bar to the required direction with spanner (17 cm).
3. Make sure of the finish condition by test binding. After that, set cover feeding unit.



Dial Number

0 : Standard

- : Nipper lowers by turning adjust bar counterclockwise (arrowed direction) and spine becomes rounder.

+ : Nipper rises by turning adjust bar clockwise and spine becomes sharper.

7. After Binding Finish

7-1 Glue Supply	62
7-2 Clean Up While Power On	63
7-3 Clean Up after Power Off	66
7-4 Clean Up after Power Off	67

7-1 Glue Supply

Glue must be supplied in melt tank when binding finished.

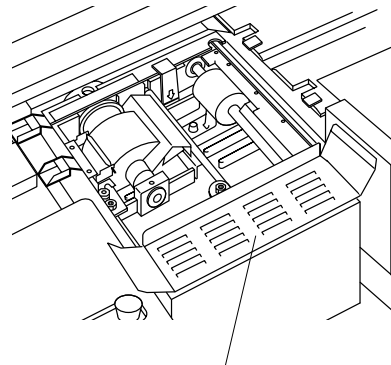


WARNING

- *Put gloves on your hands when you supply glue in melt tank which is heated up to around 200 degrees. High temperature can cause severe skin burn.*
- *Depress emergency stop switch before supplying glue.*

1. Open melt tank cover.

2. Place glue on supply area in melt tank.

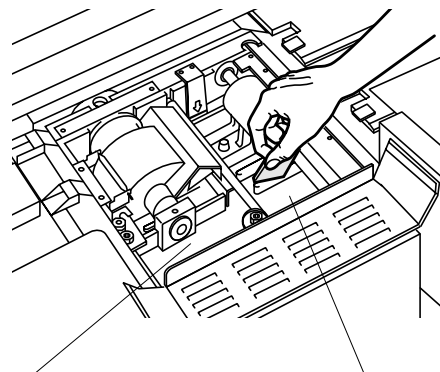


Melt Tank Cover

NOTE

- *Supply glue into melt tank piece by piece not to supply glue over maximum glue level.*
- *Glue level must be lower than RED line on glue level indicator.*
- *Use only Horizon Glue (HM-110).*

3. Close melt tank cover.



Melt Tank

Glue Supply Area

7-2 Clean Up While Power On

7-2-1 Nipping Plate and Nipper Jaw Clean Up

Nipping plate or nipper jaws must be cleaned after binding finished.

WARNING

- Depress stop button before cleaning.
- Put gloves on your hands. You might unexpectedly touch melt tank which is heated up to around 200 degrees. High temperature can cause severe skin burn.

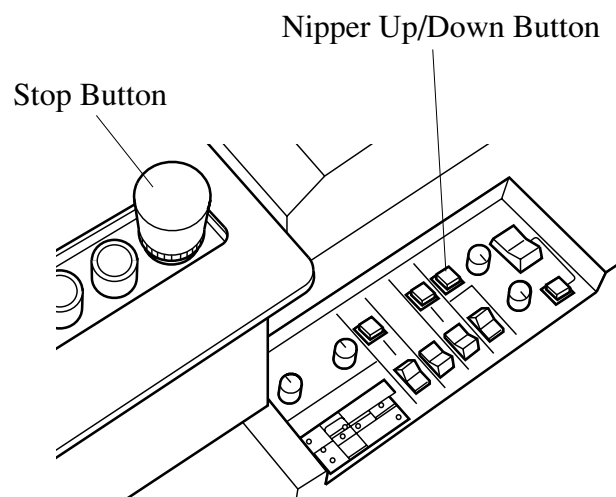
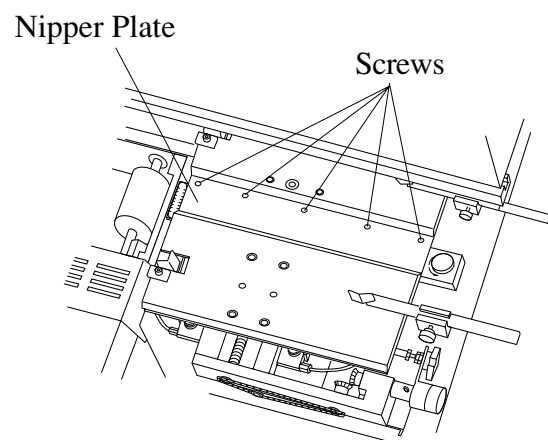
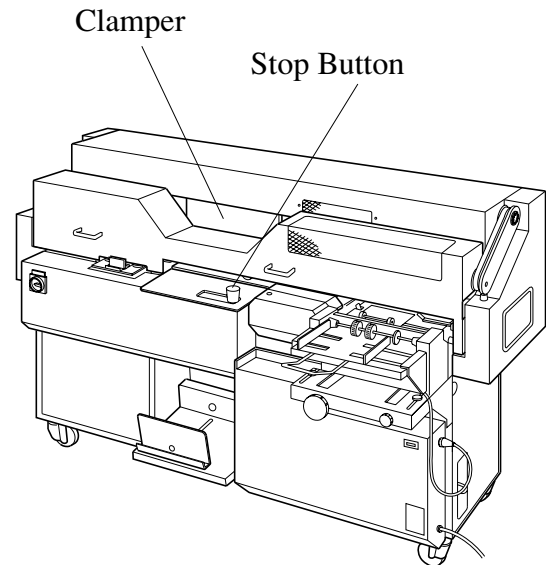
Necessary Tool : Cloth

1. Depress stop button.
2. Confirm clamber stops over level plate.
3. Confirm nipping unit is at lower point.

NOTE

- If nipping unit is at upper position, release emergency stop, close safety cover and depress nipping unit up/down button once to lower nipping unit.
- When nipping unit is at lower position, 5 screws on nipping unit appear.

4. Wipe off dust such as glue or paper dust on nipping plate and nipper jaws with cloth.



7-2 Clean Up While Power On

7-2-2 Level Plate Clean Up

Level plate must be cleaned after binding finished.

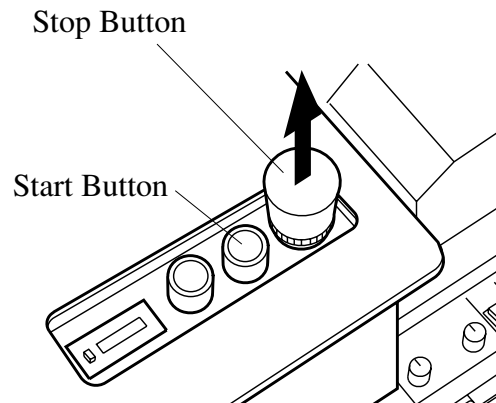


WARNING

- *Depress stop button to prevent personal injury after step 4.*
- *Wear gloves on your hands. You might unexpectedly touch melt tank which is heated up to around 200 degrees. High temperature can cause severe skin burn.*

Necessary Tool : Cloth

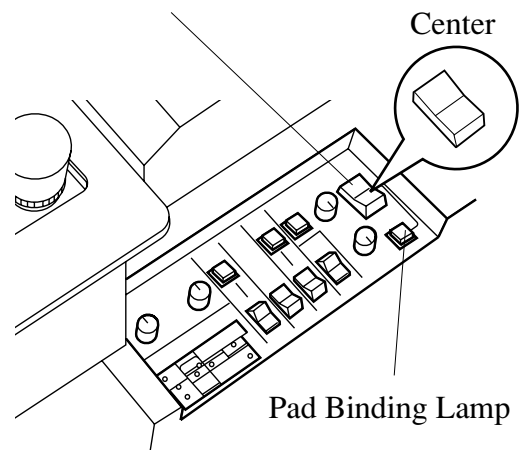
1. Pull up stop button.



2. Select pad binding mode.

- Set nipping mode select switch to center.
- Pad binding lamp in start button will turn on.

Nipping Mode Select Switch

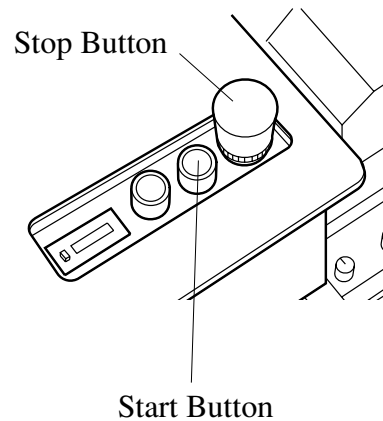


7-2 Clean Up While Power On

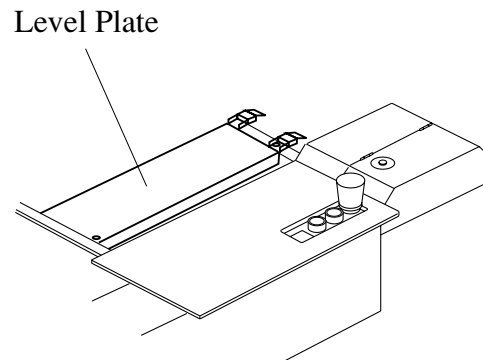
3. Move clamber
 - Depress start button to move clamber to nipping unit. And then depress stop button when clamber come over nipping unit.

NOTE

Application roller in melt tank keeps to rotate even if stop button is depressed. (for about 30 seconds)



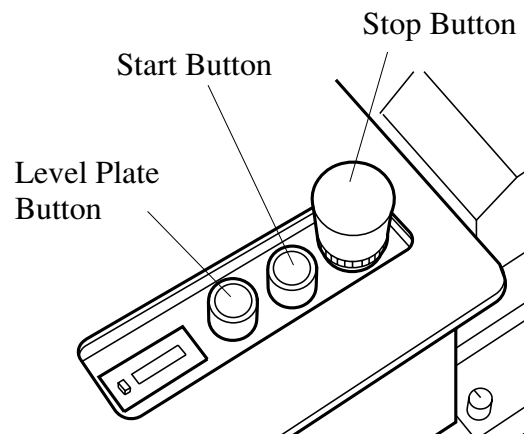
4. Clean level plate with cloth.



5. Pull up stop button.

6. Depress start button to return clamber to home position.

7. Depress level plate control button once to reset level plate after clamber returned to home position.



8. Depress stop button.

NOTE

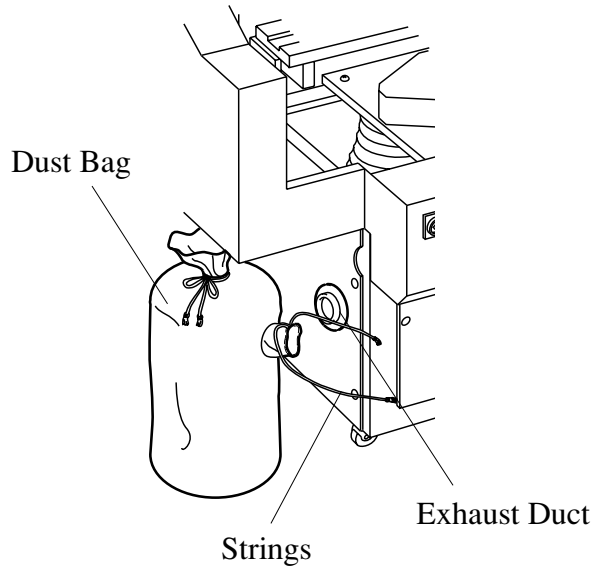
Occasionally application roller in melt tank unit keeps to rotating.

7-3 Clean Up after Power Off

7-3-1 Dust Bag Clean Up

Dust bag must be empty after binding finished.

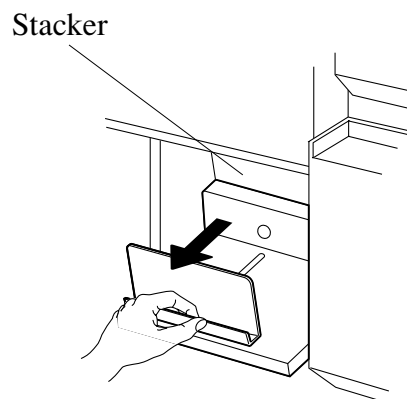
1. Remove dust bag and dump dust from dust bag.
2. Knot strings of dust bag on exhaust duct on BQ-260.



7-3-2 Vertical Stacker Unit Clean Up

Stacker must be cleaned after power off.

1. Pull out stacker fully to outside.
2. Clean stacker with soft cloth.



7-4 Clean Up after Power Off

7-4-1 Milling Unit Clean Up

Milling unit must be cleaned after power off.

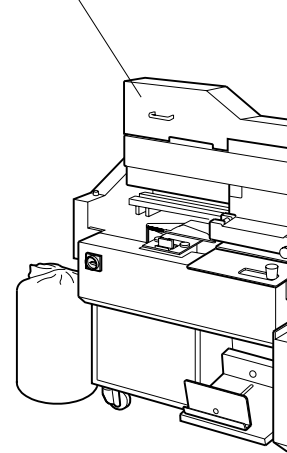


WARNING

Do not touch milling cutter or roughening cutter with your hands or fingers. Sharp cutter can cause severe personal injury.

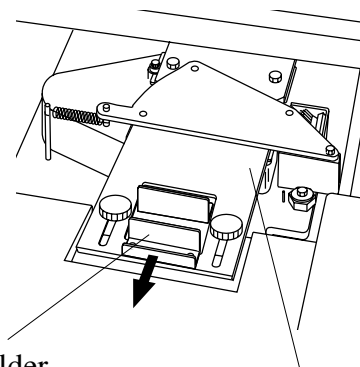
1. Open safety cover.
2. Hold holder on front milling guide and pull front milling guide fully to near side.
3. Clean paper dust on milling unit surface with vacuum cleaner.

Safety Cover



Holder

Front Milling Guide



4. Close safety cover.

7-4 Clean Up after Power Off

7-4-2 Gluing Length Sensor Clean Up

Gluing length sensor must be cleaned after power off.

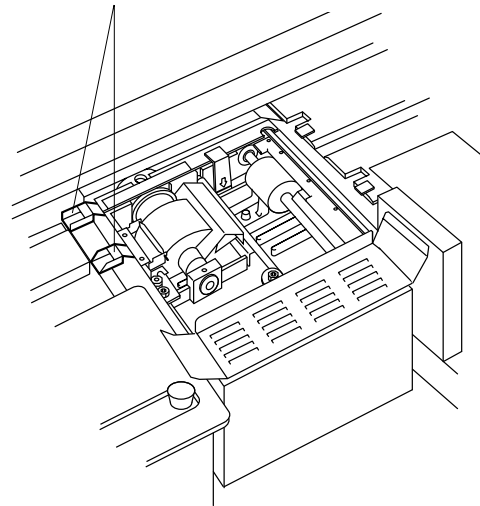


WARNING

- *Clean up gluing length sensor after melt tank cooled down.*
- *Wear gloves on your hand to prevent accidental touch on warm melt tank unit.*

1. Open safety cover.
2. Clean gluing length sensor with soft cloth or brush.
3. Close safety cover after cleaning.

Glue Length Sensor

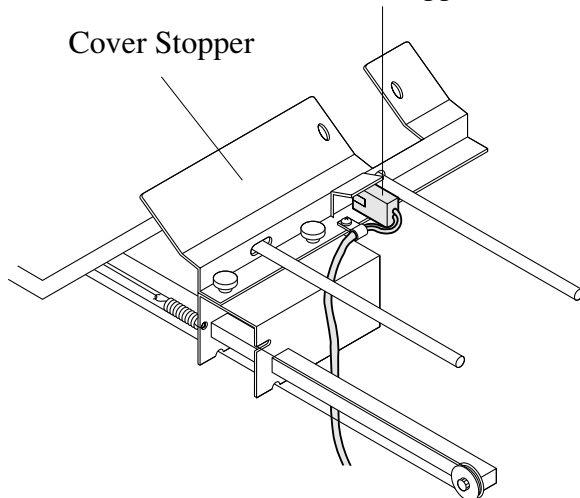


7-4-3 Cover Sensor Clean Up

Cover sensor must be cleaned after power off.

1. Open back cover.
2. Turn cover stopper adjusting knob to move cover stopper most backward position.
3. Clean cover stopper sensor with soft brush.
4. Close back cover after cleaning.

Cover Stopper Sensor



8. Maintenance

8-1 Once A Month	70
8-2 As Required	71

8-1 Once A Month

8-1-1 Lubrication on Melt Tank Unit

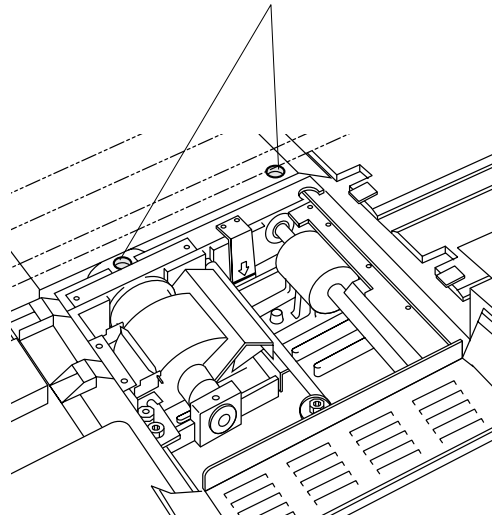
This section shows required maintenance once in a month.

⚠ WARNING

Wear gloves on your hands when melt tank is lubricated. Melt tank is heated up to 200°C.

1. Open safety cover.
2. Lubricate marked parts of melt tank unit with a supplied melt tank chain oil.

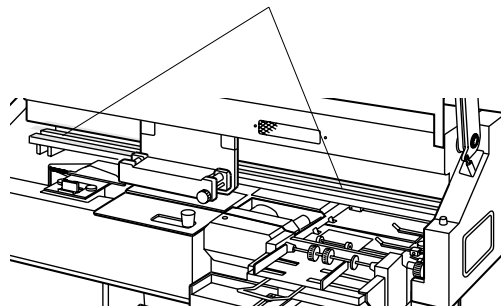
Lubrication Points



8-1-2 Greasing on Clamper Rail

1. Wipe off all dust on clamper rail.
2. Grease both back and front of clamper rail.

Clamper Rail

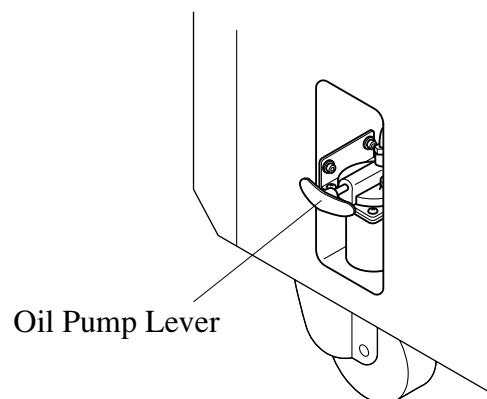


8-1-3 Oiling on Nipper Unit

1. Pull oil pump lever once to lead oil to slide part of nipper unit.

NOTE

It is not necessary to push oil pump lever. Lever will move back automatically.



8-2 As Required

8-2-1 Milling Cutter Replacement

Continuous use of dull milling cutter will effect on binding finish quality. Replace milling cutter as required.

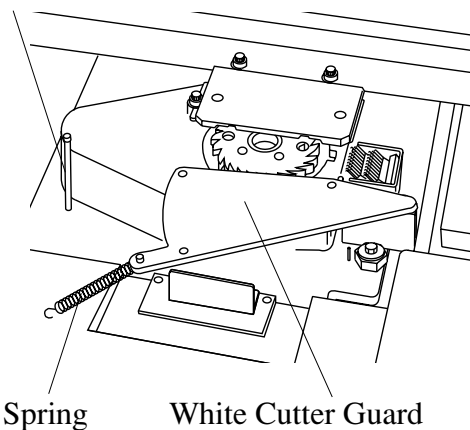
⚠ WARNING

- Turn off main power before replacing milling cutter.
- Wear gloves on your hands when milling cutter is replaced. Cutter will cause severe personal injury.

Necessary Tools : Double-ended Spanner
(13 mm)
Allen Wrench (4 mm)
Thick Cloth

1. Turn off main power.
2. Access to milling cutter.
 - Open safety cover.
 - Remove spring on white cutter guard from hook bolt.
 - Remove both front and rear milling guides.
3. Remove milling cutter.
 - Place thick cloth to hold milling cutter.
 - Loosen four fix screws on milling cutter and remove milling cutter.
4. Install new or resharpened milling cutter with reverse order of removing.
5. Install milling guides.
 - Install rear milling guide so that guide aligned with three positioning pins.
 - Install front milling guide.
 - Hook spring on white cutter guard to cover milling section.

Hook Bolt

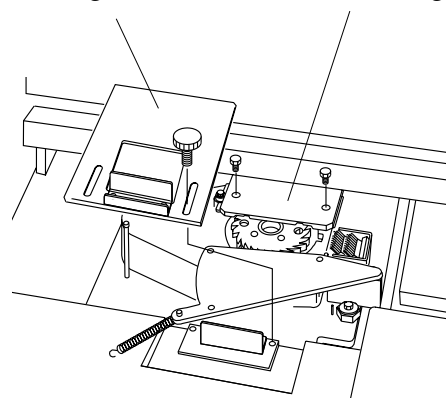


Spring

White Cutter Guard

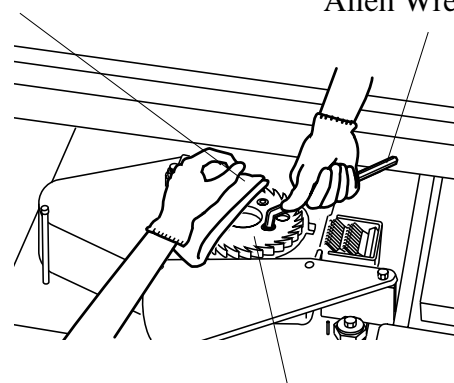
Front Milling Guide

Rear Milling Guide



Thick Cloth

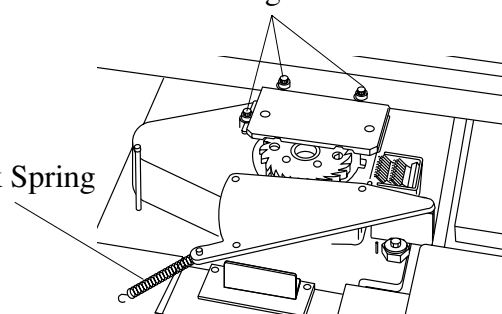
Allen Wrench



Milling Cutter

Positioning Pins

Hook Spring



8-2 As Required

8-2-2 Roughening Cuter Replacement

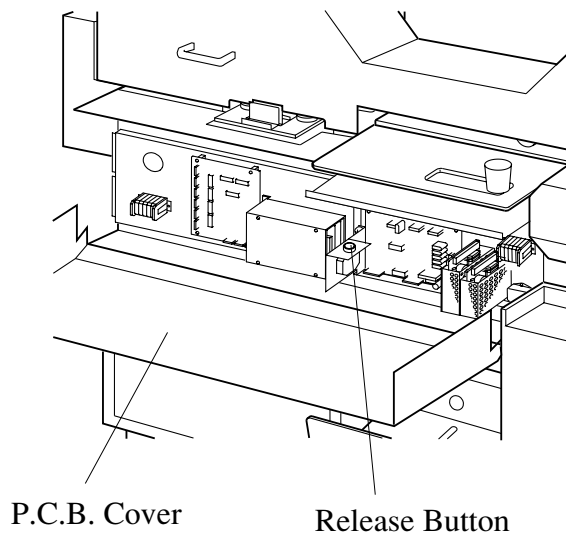
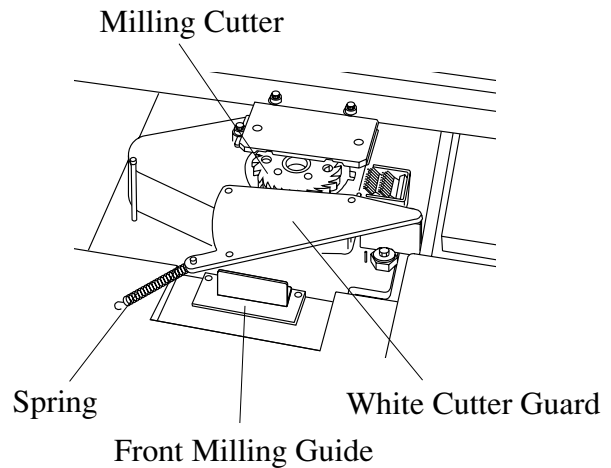
Continuous use of dull roughening cutter will effect on binding finish quality. Replace roughening cutter as required.

WARNING

- Turn off main power before replacing milling cutter.
- Wear gloves on your hands when roughening cutter is replaced. Cutter will cause severe personal injury.

Necessary Tools : Allen Wrench (X mm)
Thick Cloth

1. Turn off main power.
2. Access to roughening cutter.
 - Open safety cover.
 - Open front milling guide.
 - Remove spring on white cutter guard from hook bolt.
3. Open P.C.B. cover.
 - Remove four fix screws and tilt down P.C.B. cover.
4. Depress release button to release brake on milling cutter motor.
5. Turn milling cutter slowly by hand to access to roughening cutter lock screw.



8-2 As Required

6. Remove roughening cutter.
 - Hold tip of roughening cutter with thick cloth.
 - Loosen roughening cutter lock screw with allen wrench.
 - Pull out roughening cutter.

NOTE

- *Spring under roughening cutter will jump out. Remove roughening cutter slowly.*
- *Roughening cutter is reversible parts.*

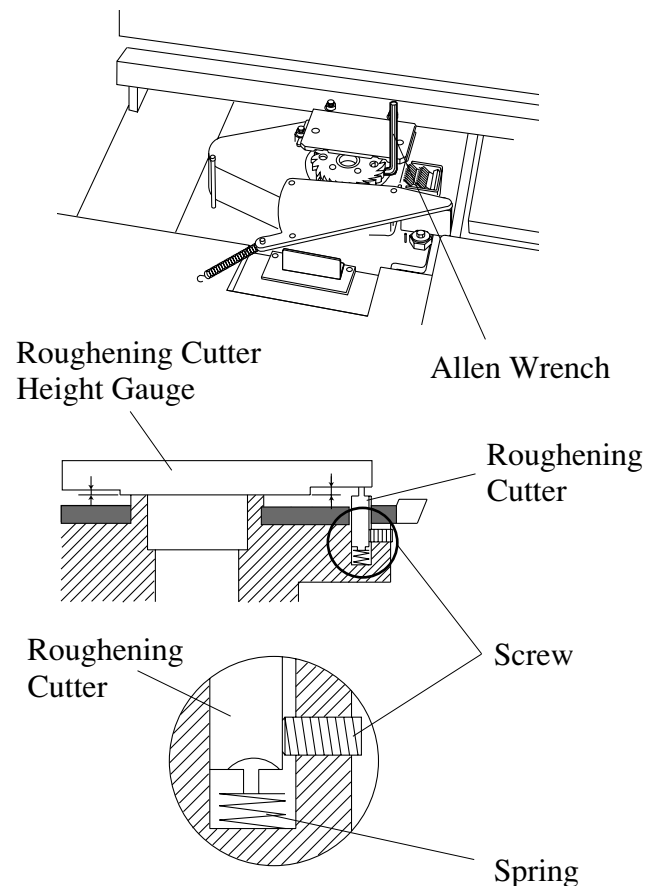
7. Install new or reversed roughening cutter.
 - Push down roughening cutter with thick cloth and fix lock screw.
 - Place roughening cutter height gauge over roughening cutter.

NOTE

Select either 0.5 mm or 0.8 mm for required height of cutter.

- Loosen lock screw once. Roughening cutter will move up. Then fix lock screw firmly.

8. Close all safety and P.C.B. cover.



8-2 As Required

8-2-3 Glue Draining

This section shows how to drain glue in melt tank. Deteriorated glue because of long heating will cause decrease of adhesive strength.

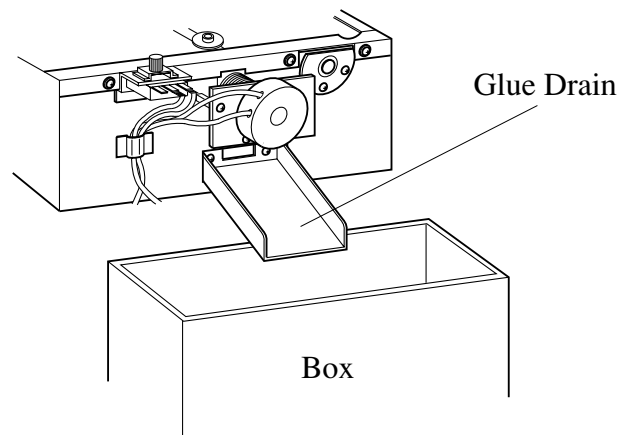
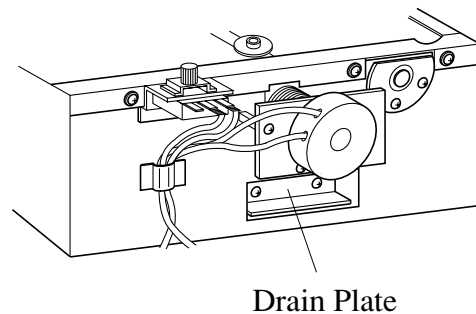
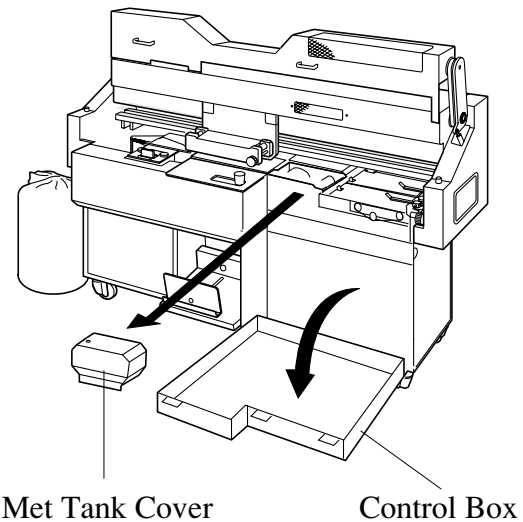
⚠ WARNING

Wear gloves on your hands when glue is drained. Melted glue temperature is 200°C. It can cause severe skin burn.

NOTE

Glue can only be drained when it is melted.

1. Melt glue.
 - Turn on main power and wait until LED for melt tank on monitor turns off.
2. Attach glue drain.
 - Remove melt tank cover.
 - Open control box.
 - Attach glue drain under drain plate.
3. Provide a box for receiving glue (2 liter capacity).
4. Drain glue
 - Remove drain plug. Glue will come out from melt tank.
 - Fasten drain plug after all glue are drained.
5. Close covers
 - Remove glue drain.
 - Close control box, melt tank cover and safety cover.



9. Installation of Suction Cover Feeder CF-260 (Optional Equipment)

9-1 Before You Begin	76
9-2 Set Up and Operation	79
9-3 Trouble Shooting	84
9-4 Installation of BQ-260	86

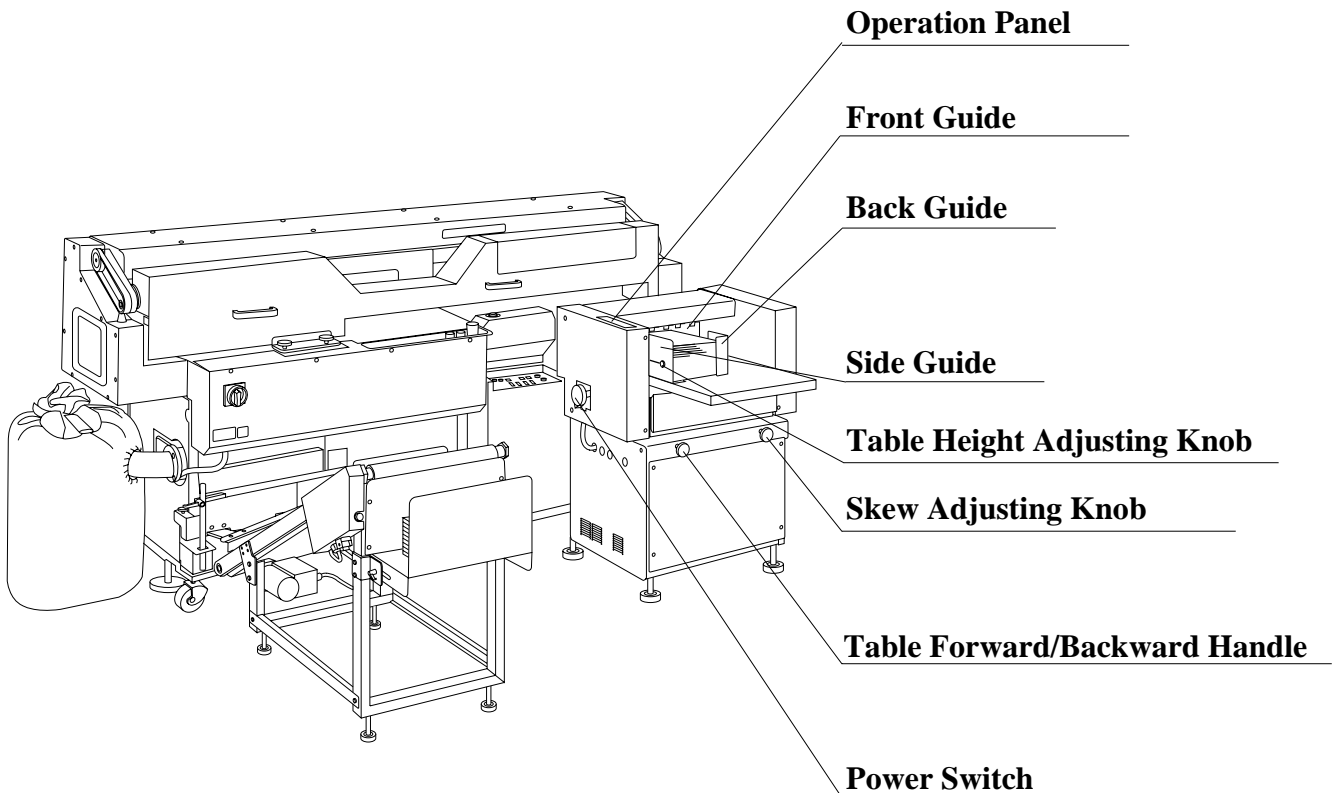
9-1 Before You Begin

9-1-1 Specifications

Model Name	CF-260
Maximum Cover Size	500 ~ 380 mm (19.7" x 15")
Minimum Cover Size	260 ~ 180 mm (10.2" x 7.1")
Cover Pile Height	100 mm (3.9")
Cover Thickness	80 to 300 gsm
Power Source	3-phase 200 V 50/60 Hz, 220 V 60 Hz, 400 V 50 Hz 0.65A
Power Consumption	0.4 kw
Motor	0.2 kw x 1, 25 w x 1, 15 w x 1
Machine Dimension	700 (W) x 690 (D) x 840 (H) mm
Machine Weight	110 kg (243 lb)

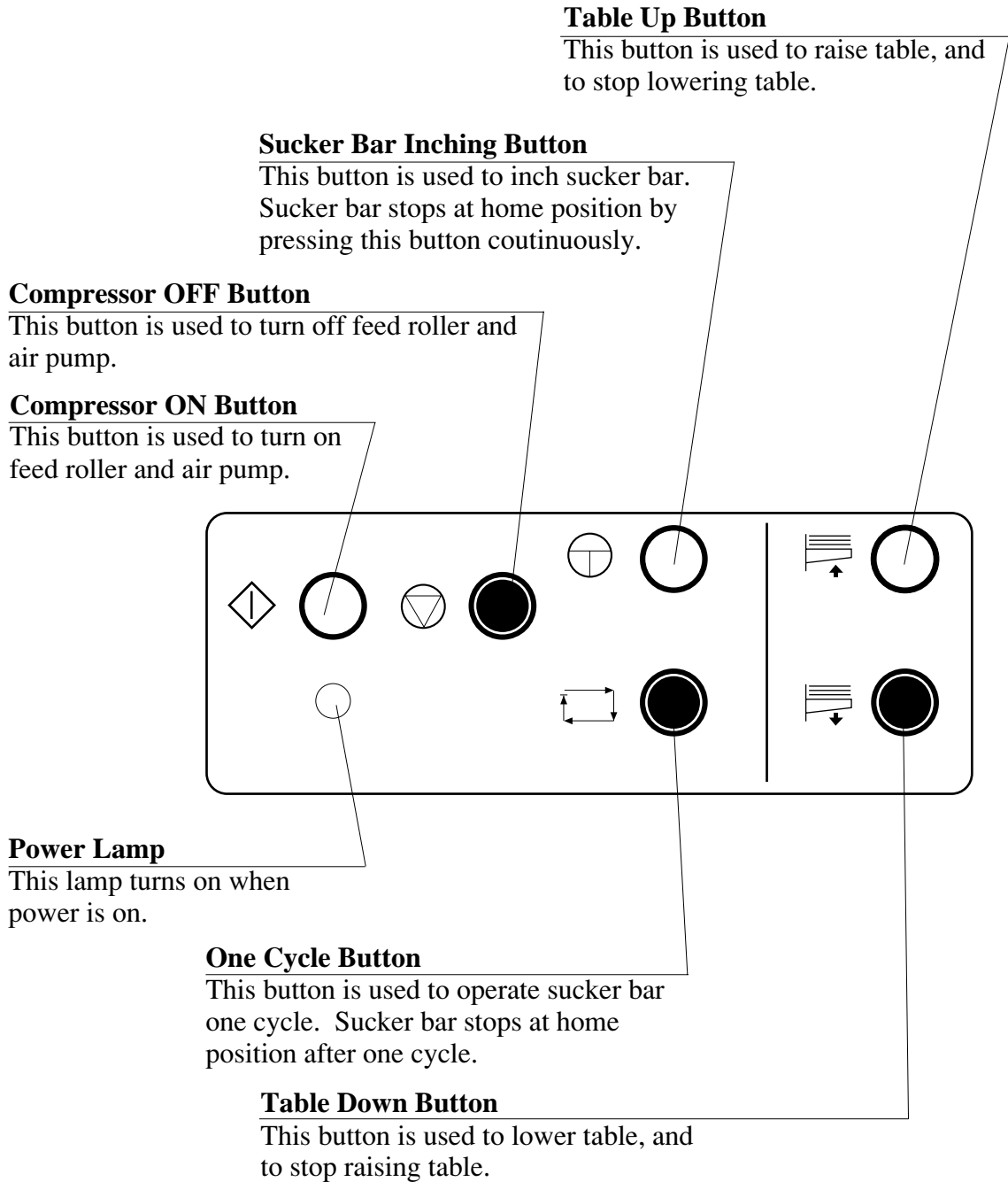
The machine design and specifications are subject to change without any notice.

9-1-2 Machine Descriptions and Functions



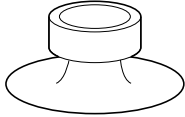
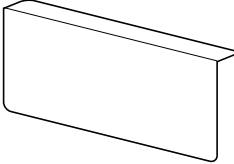
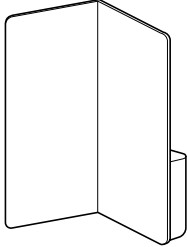
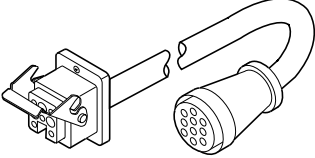
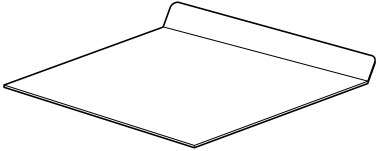
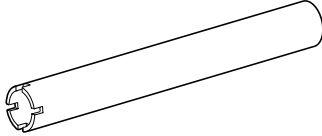
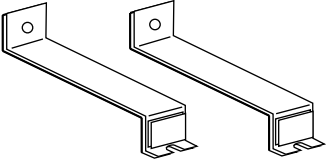
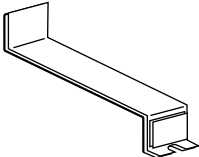
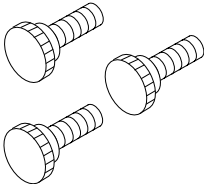
9-1 Before You Begin

9-1-3 Descriptions and Functions of Operation Panel



9-1 Before You Begin

9-1-4 Tools and Accessories

<p>Sucker (M003359-03) 14 pcs</p>	<p>Cover (M032435-00) 1 pc</p>
	
<p>Back Guide (M032433-00) 1 pc</p>	<p>Adapter (A303401-00) 1 pc</p>
	
<p>Support Plate(S) (M032442-00) 1 pc</p>	<p>Sucker Close/Open Tool 1 pc</p>
	<p>(4-010658-00)</p> 
<p>Roller Cleaner(A933417-00) 2pc</p>	<p>Cover Sheet Holder(M032810-00) 1pc</p>
	
<p>Screw(M002000-01) 3pc</p>	
	

9-2 Set Up and Operation

9-2-1 Cover Piling

This procedure shows cover piling before starting binding.



WARNING

Do not touch moving parts. Moving parts may cause severe personal injury.



CAUTION

Do not place books, tools and so on under table. They may cause machine damage.

1. Turn on power switch.
-Power lamp turns on.
2. Press table lower button.
-Table lowers and stops at lowest position.
3. Pile covers so that covers touch front guide and side guide.

NOTE

- Straighten covers before piling. Wavy or curled cover will cause inferior feeding such as misfeed.

- Do not pile covers more than 10 cm.

4. Place back guide at right corner of cover on table.
5. Press table up button.
-Table rises and stops at feeding position.
6. Press one cycle button. Sucker bar moves forward and then stops.

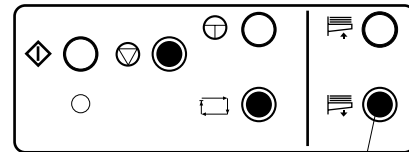
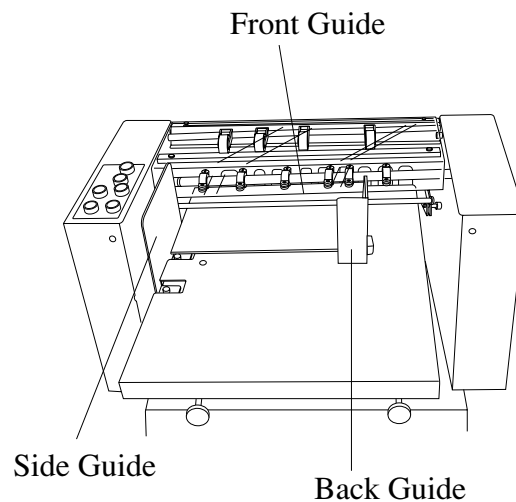
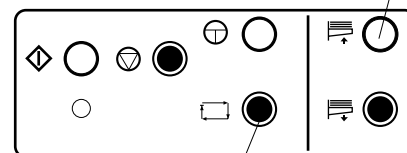


Table Lower Button



Bin Up Button



One Cycle Button

9-2 Set Up and Operation

9-2-2 Open/Close of Sucker Valve

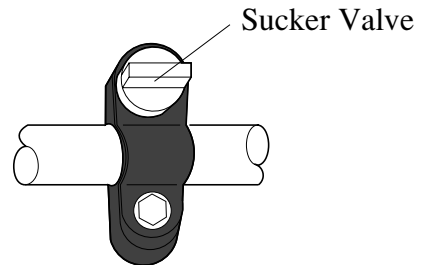
This procedure shows how to set up suckers for different size of cover.

1. Pick up suckers which are going to suck cover.

NOTE

Do not pick up suckers which does not completely placed on cover.

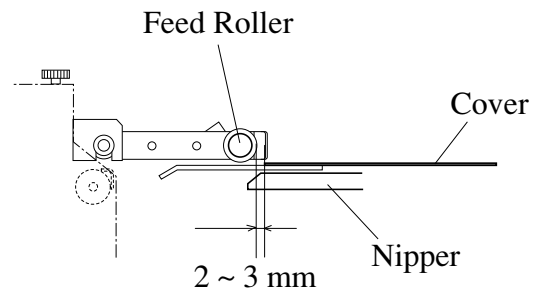
2. Open those sucker valve with sucker open/close tool.
Close other sucker valve.



9-2-3 Cover Feeder Position Set Up

This procedure shows cover feeder set up according to cover size.

1. Set up nipper referring to "4-1 Nipper Unit Set Up"(page 24).
2. Make sure that nipper is at lower position.
3. Place one cover on nipper.
4. Turn table forward/backward handle until the clearance between cover and feed roller is 2 to 3 mm.



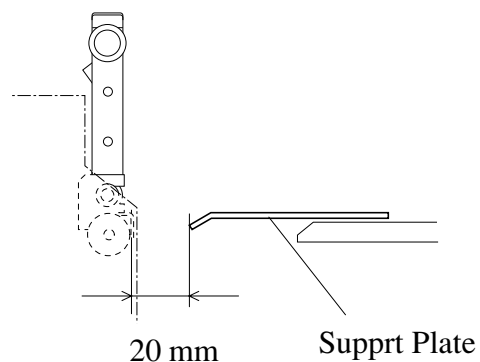
9-2-4 Support Plate Set Up

This procedure shows how to set support plate.

1. Select suitable size of support plate and place it on nipper so that the clearance between cover feeder and support plate is 20 mm.

NOTE

When the size of cover is B4 (10.1" x 14.3") or larger than B4 use the support plate (L).



9-2 Set Up and Operation

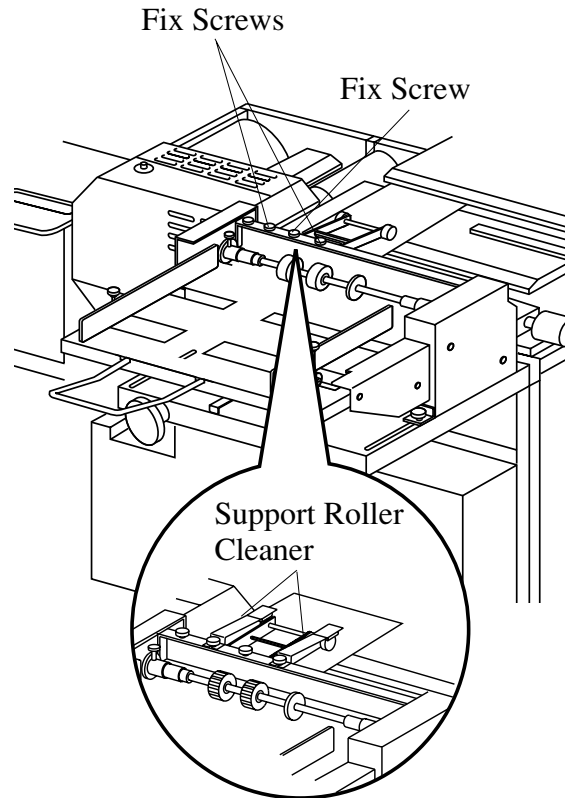
9-2-5 Attachment of Accessories

- To prevent misfeeding of cover caused by dirt on support roller, support roller cleaner is recommended to use.
- To prevent cover moves back, cover feeding supporter is recommended to use.

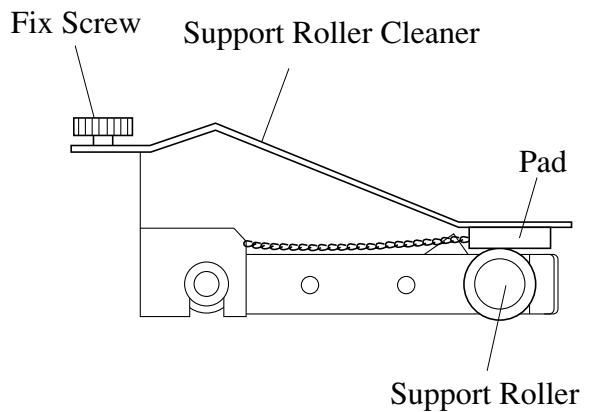
NOTE

Supply a few drops of alcohol on cloth of support roller cleaner.

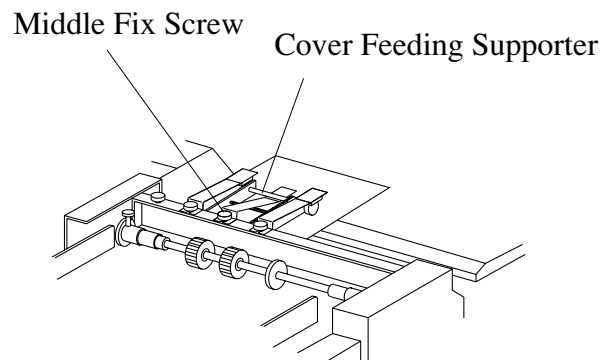
1. Loosen fix screws on feed support roller cleaners and cover feeding supporter.



2. Place support roller cleaner so that pad is placed on roller and the other end is placed under fix screw. And then fasten fix screw.



3. Attach cover feeding supporter under middle fix screw and fasten fix screw.



9-2 Set Up and Operation

9-2-6 Feeding Test

This procedure shows test feeding of cover.

1. Press air pump ON button.
-Rollers rotates and air pump is turned on.
2. Press one cycle button and feed one cover to check the cover is fed on nipper smoothly.
3. If cover is not fed straightly and touches some guides on nipper, adjust cover feeding direction with skew adjustment knob.
4. Try feeding covers a few times. When covers are fed smoothly, leave only one cover on nipper and start binding.

9-2-7 Cover Piling

This procedure shows the cover piling during your binding job.



WARNING

Do not pile cover during binder works. Moving parts may cause severe personal injury.

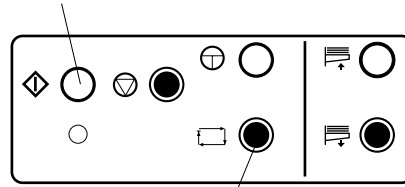


CAUTION

Lower table when cover is piled. Ignoring the procedure may cause severe machinery damage.

1. Press table lower button.
-Table lowers and stops at lowest position.
2. Pile covers so that covers touch front guide and side guide.
3. Press table up button. Table rises and stops at feeding position.
4. Press one cycle button. Sucker bar moves forward and stops.

Compressor ON Button



One Cycle Button

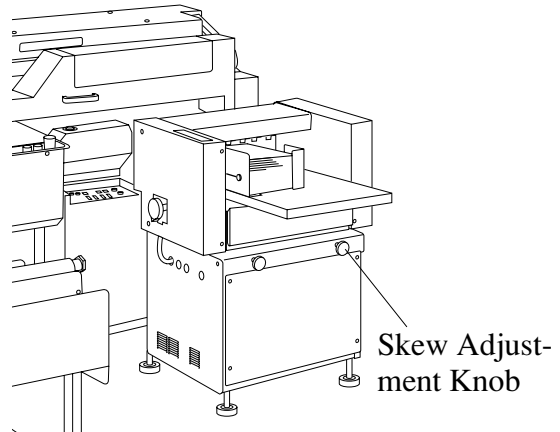
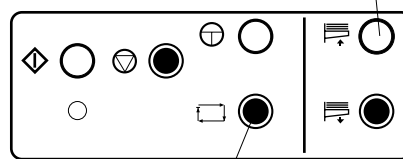


Table Up Button



One Cycle Button

9-2 Set Up and Operation

9-2-8 Binding Finish

Turn power switch off after finishing binding.

1. Press table down button.
- Table lowers and stops at lowest position.
2. Remove cover from table.
3. Turn power switch off.

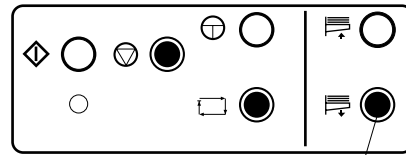
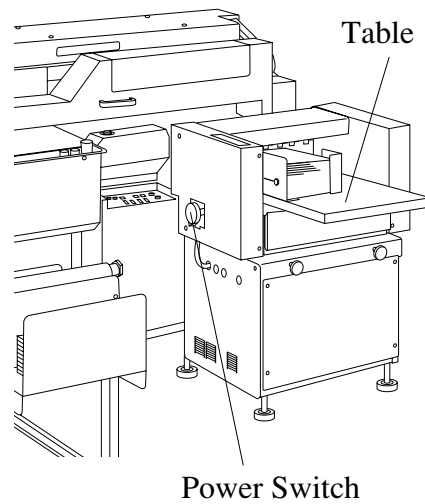


Table Down Button



9-3 Trouble Shooting

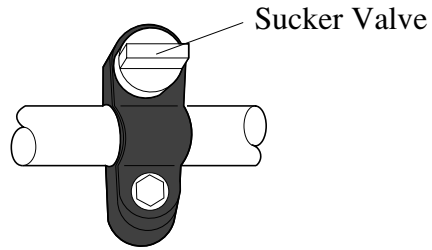
9-3-1 When Misfeed Occurs.

(Cause 1)

Suction air is not enough.

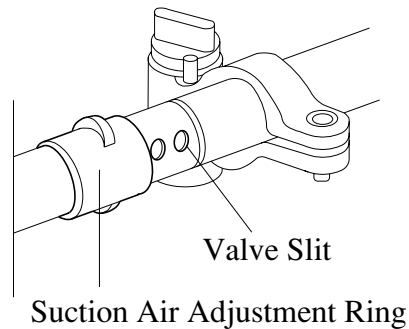
(Countermeasure 1)

Open necessary sucker valve referring to "9-2-2 Open/Close of bSucker Valve"(page 80).



(Countermeasure 2)

Move suction air adjusting ring to the right and close valve slit.

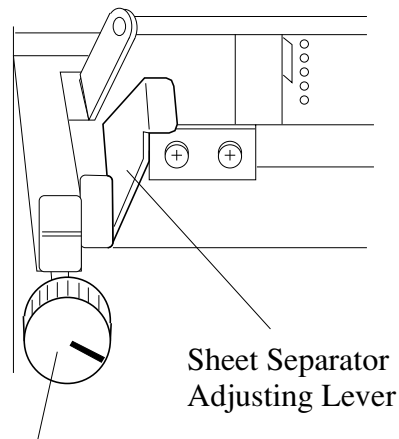


(Cause 2)

Sheet separator is coming out too much.

(Countermeasure 1)

Adjust sheet separator adjusting lever so that sheet separator touches cover properly.

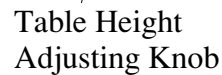


(Cause 3)

Table height is too low.

(Countermeasure 1)

Raise table by turning table height adjusting knob clockwise.



(Cause 4)

Cover is curled.

(Countermeasure 1)

Straighten cover well.

9-3 Troubleshooting

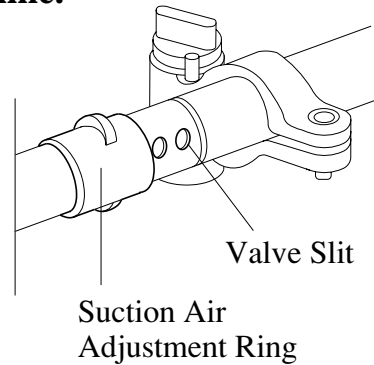
9-3-2 When Two Covers are fed at the same time.

(Cause 1)

Sucker air is too strong.

(Countermeasure 1)

Move suction air adjusting ring to the left and open valve slit.

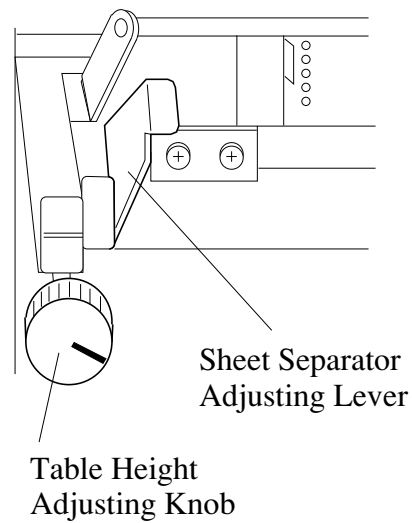


(Cause 2)

Sheet separator position is not close enough to cover.

(Countermeasure 1)

Adjust sheet separator adjusting lever so that sheet separator come out more to cover side.



(Cause 3)

Table height is too high.

(Countermeasure 1)

Lower table by turning table height adjusting knob counterclockwise.

(Cause 4)

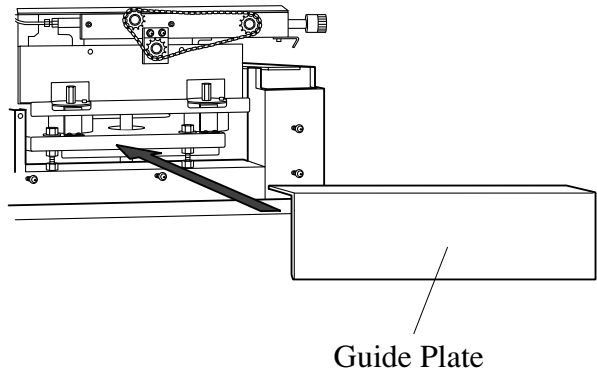
Cover does not touch front guide.

(Countermeasure 1)

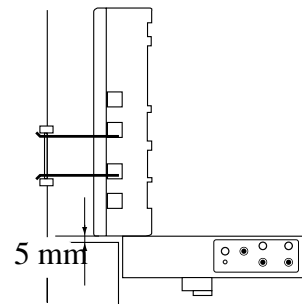
Place cover so that it touches front guide tightly and hold cover corner with back guide tightly.

9-4 Installation of BQ-260

1. Install BQ-260 referring to operation manual for BQ-260.
2. Install guide plate on BQ-260.



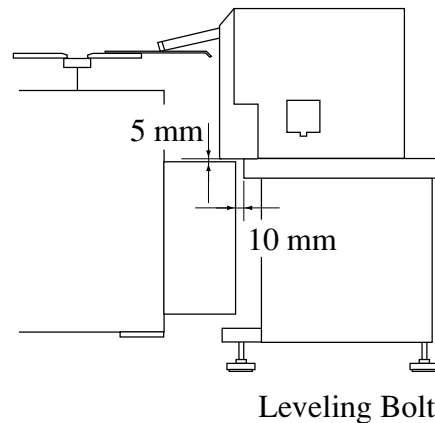
3. Place CF-260 referring to right drawing.
-Fix BQ-260 with leveling bolts.
4. Connect signal cable connector of CF-260 to BQ-260.



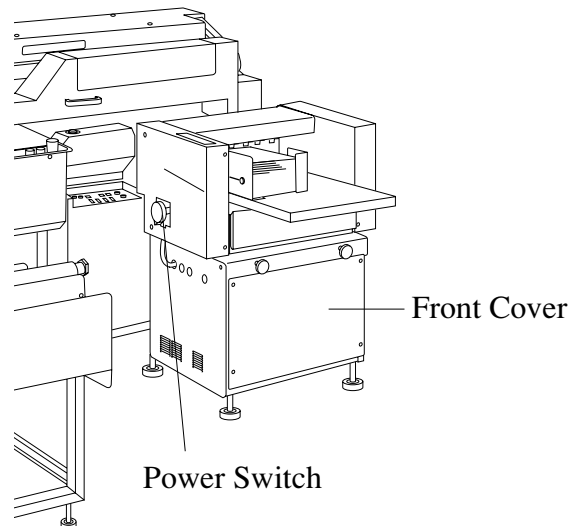
5. Remove front cover.

⚠ WARNING

When removing front cover, do not insert your hands or fingers into inside of machine. Moving parts may cause severe personal injury.



6. Connect power cord with 3-phase electricity.
7. Turn on power switch of CF-260 and press air pump ON button. Check rotating direction of air pump fan. Make sure that air pump fan rotates in correct direction before pressing air pump OFF button .
8. Turn power switch off.
9. If motor fan does not rotate in correct direction, perform from step 7 again after exchange two electrical cord each other .



9. Installation of Suction Cover Feeder CF-260