Operating Instructions

Issue no. 2
Sheets 6

Creasing and Perforating Machine GPM 450

Attention

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CONTENTS

1. SAFETY RISKS

a) The operator or the individual appointed for operation cannot use the machine unless they have been trained.

b) It is forbidden to crease and perforate foils, sheet metal or other similar materials.

c) The machine can be only used in enclosed spaces (e.g. offices, shops). It is forbidden to use the machine outdoors.

d) It is forbidden to use the machine when the electric cord is damaged.

e) It is forbidden to use the machine if it makes strange sounds.

f) It is forbidden to connect the machine to voltage different from that indicated on the manufacturer's identification plate.

g) Read all instructions before using the machine.

h) Keep the children away from the machine.

i) It is forbidden to put fingers or hands into the machine when the electric cord is plugged in.

j) Do not replace faulty electrical components with components of different type or different capacity. When replacing a component, the electric cord must be unplugged.

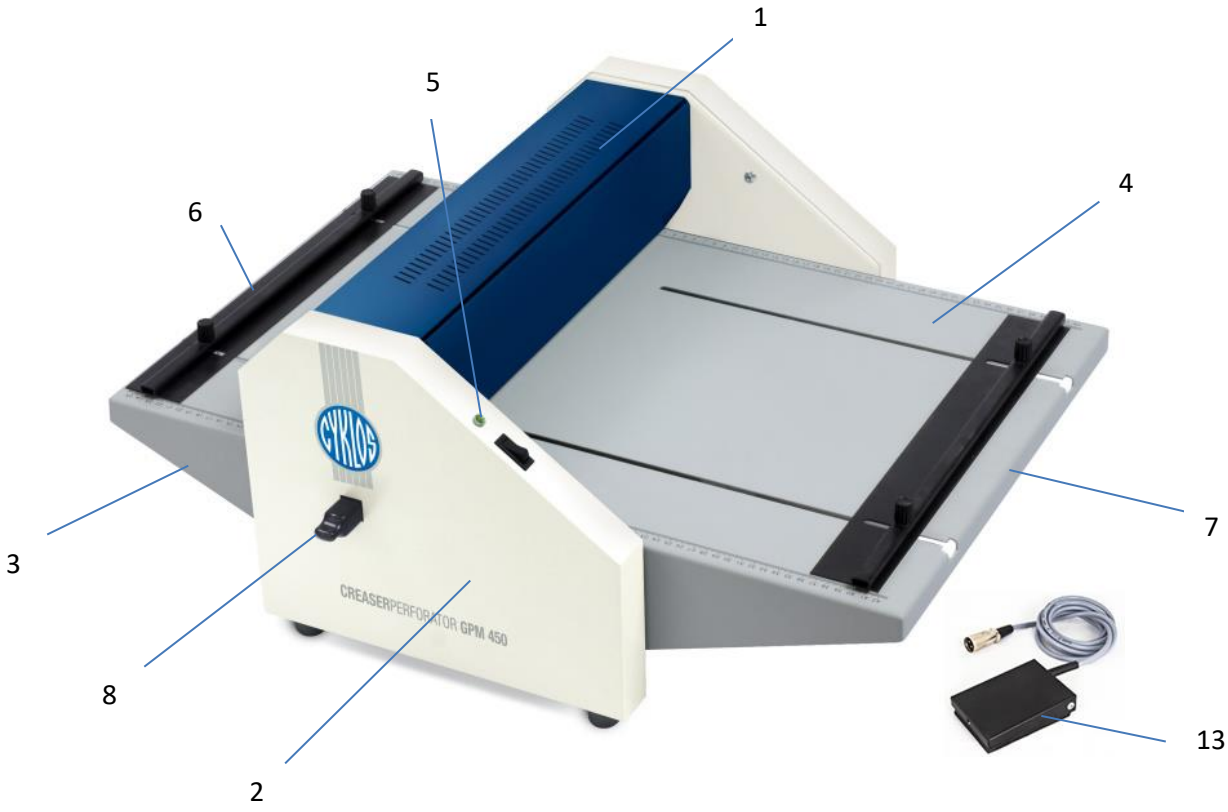
l) Covers can be only dismounted by trained personnel when the machine is unplugged.

2. TECHNICAL PARAMETERS

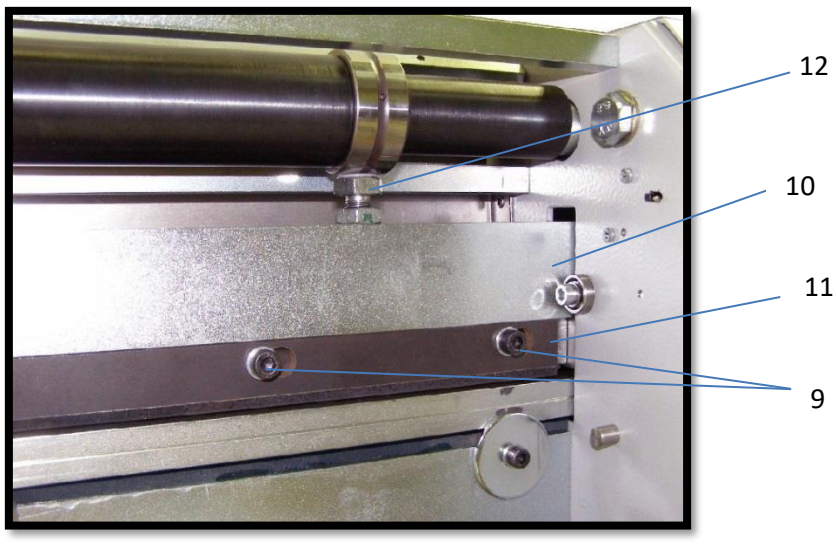
a)	Max. working width	450 mm
b)	Recommended paper grammage	80 – 400 g/m² (creasing, punching) 80 – 250 g/m² (perforating)
c)	Crease width*	**CITO 1.0 mm** – paper thickness < 0.4 mm (mostly 80 – 150 gsm) **CITO 1,4 mm** - paper thickness 0,2 - 0,4 mm (mostly 160 – 250 gsm) **iron channel** - paper thickness 0,4 - 0,5 mm (mostly 250 - 400 g/m²)
d)	Machine dimensions	710 x 590 x 300 mm 660 x 650 x 400 mm (transport dimension)
e)	Machine weight	net 39 kg, gross 42 kg
f)	Voltage / frequency	230 V/50 Hz

*<u>*Note:*</u> Respect the recommended width of creasing channel for different paper thickness. If thick paper is used in combination with a narrow crease, it will result in the paper being pressed into the creasing channel, and the rollers starting to slip in an attempt to release the paper. Use wider crease channel in such case.*

3. MACHINE DESCRIPTION



1 – Top cover
2 – Electric switch
3 – Rear table
4 – Front table
5 – Control indicator
6 – Rear stop
7 – Front stop
8 – Lower crease/perf tool
9 – Upper tool locking screws
10 – Upper bar
11 – Clamp
12 – Tool thrust regulating screws
13 – Foot pedal



4. MACHINE DESCRIPTION, INSTALLATION AND ADJUSTMENT

Electrical creasing and perforating machine is suited for final processing of graphical material up to 450 mm width. Creasing enables to fold paper easily without cracking. Perforation can be done simply by a blade change, and turning the lower tool (8) without further adjustment. Waste-free perforation allows easy paper separation. Millimeter scales, which are used to adjust paper stops, are placed on the sides of the both tables (3, 4). The machine is controlled, either by a hand-operated switch on the cover (2), or by a foot pedal (13).

When the machine is unpacked, it is placed on a solid flat surface. First the rear table (3) has to be installed and secured, and also the foot pedal if needed. Then, after the machine has been plugged in, it is set in a working condition and the control indicator (5) shines constantly.

For perforation the lower tool (8) has to be turned by the smooth (no groove) surface faced upwards and beside that it is necessary to replace the creasing knife with a perforating knife (separate packing). To achieve this, the machine has to be unplugged first. Then we tilt up the top cover (1). There are 5 screws (9) and clamp (11) holding the knife inside the machine. These need to be dismounted. After knife replacement screws should not be tightened completely until the check test is carried out. Plug the machine in, press once electric switch. The knife goes down and aligns itself with respect to the bottom tool. Then plug the machine out again and tighten the screws completely. This way crease/perf knife and lower tool are parallel.

In case of poor quality of perforating, or while having trouble with separation of the paper after perforating has been completed, it is necessary to adjust the pressure of upper bar.

4.1 Adjustment of Upper Bar Stroke

Unless the depth of a crease on both sides of the sheet is identical or unless the sheet is torn away evenly after perforation, the upper bar (10) can be moved down using the tool thrust regulation screws (12). The screws should be loosened anticlockwise by 1/12 (30°) of the revolution (the bar moves downwards) and then secure them with a nut. Try the quality of perforation after each turn of the screw by 30° and, if satisfactory, do not turn the screws any more. When adjustment of perforation is finished, the machine is also to be adjusted for creasing.

5. THE MOST COMMON FAULTS (TROUBLESHOOTING)

- control indicator flickers approx. 1x /sec: the top cover (1) is open or the rear table (3) is pushed out

- control indicator flickers approx. 2x /sec: the upper bar mechanism has been blocked, it is necessary to unplug the machine, to loosen locking nuts and then to turn the tool thrust regulating screw (9) clockwise (approx. 2 turns) and then the upper bar moves up. After the machine has been turned back on, the unfinished working cycle finish automatically. It is necessary to readjust the upper bar (see Section 4.1).

6. MACHINE DISPOSAL

After the end of the service life, it is forbidden to dispose of the machine in the municipal waste. The machine must be disassembled, and metallic, non-metallic, plastic, rubber and electronic parts sorted. These parts are disposed of at the relevant points of recycling. Some parts of the machine can contain hazardous substances that are harmful to the environment and health.