# Formax Atlas-TRIO15 Multi-Function Slitter-Cutter-Creaser

## Instruction Manual

Provided by
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FORMAX®

# Atlas-TRIO15
# Multi-Function Slitter/Creaser/Cutter

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

10/2018

OPERATOR MANUAL

・Use machine only after reading the "Safety Instructions" given below carefully.
・These safety instructions are given to ensure that the machine will be used safely and properly and to prevent operators from sustaining harm and injuries.

## Explanation of markings

| Marking | | Meaning of marking |
|---|---|---|
| ⚠ | Warning | This symbol stands for immediate danger threatening the life and health of persons. Disregarding these instructions may cause severe damage to health and even serious injuries. |
| | Avertissement | Ce symbole signifie un danger immédiat menaçant la vie et la santé des personnes. Le non-respect de ces instructions peut nuire gravement à la santé, voire provoquer des blessures graves. |
| ⚠ | Caution | This symbol stands for an endangering situation that may occur. Disregarding these instructions may lead to slight injuries or damage to property. |
| | Attention | Ce symbole indique une situation qui peut s'avérer dangereuse. Le non-respect de ces instructions peut entraîner des blessures légères ou des dommages matériels. |

## Definition of Symbols and Notes

In this manual the following names and signs stand for possible dangers.

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**Caution**

This symbol stands for an endangering situation that may occur.
Disregarding these instructions may lead to slight injuries or
damages to property.

**Attention**

Ce symbole indique une situation qui peut s'avérer dangereuse.
Le non-respect de ces instructions peut entraîner des blessures légères ou des dommages matériels.

**Note**

This symbol stands for notes, operational hints, and other useful information.They are convenient for exploiting the machine’s functional abilities.

**Remarque**

Ce symbole indique des notes, des conseils opérationnels et d'autres informations utiles. Ces informations facilitent l'exploitation des capacités fonctionnelles de l'appareil.

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## SAFETY INSTRUCTIONS

Explanations of the illustrations used in the Safety Instructions are given as follows:

| **Warning : Avertissement** |
|---|
| 1. Don't open the cover of the equipment.<br>There is a danger of receiving an injury or electric shock.<br>2. Don't touch any rotating part. There is a danger of receiving an injury.<br>3. Don’t put hands inside work area. May result in severe injury. |
| 1. Ne pas ouvrir le capot de l'équipement.<br>En raison du risque de blessure ou de décharge électrique.<br>2. Ne toucher aucune pièce rotative. En raison du risque de blessure.<br>3. Ne pas approcher les mains. Pour réduire les risque de blessure. |

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## Caution : Attention

1. Don't put a hand into the cover or a clearance between parts. There is a danger of receiving an injury.
2. Don't bring a hand, face, hair, sleeves of clothes and the like close to the rotating parts of the machine. There is a danger of receiving an injury.
3. Don't touch the blade point of the cutter. There is a danger of receiving an injury.
4. Turn off the power supply beforehand when setting the feed table. There is a danger of receiving an injury.
5. Turn off the power supply beforehand when removing paper scraps. There is a danger of receiving an injury.
6. Do not exceed the MAX level when stacking the paper. Exceeding it may cause a mechanical failure.
7. Turn off the power supply beforehand when starting maintenance or inspection. There is a danger of receiving an injury.
8. When you install a machine, please install to a place with no dust, and the place which is not influenced with a liquid. It becomes the cause of failure if the installation method is mistaken.
9. When you put a machine into operation, please change into the state where all covers were closed. If it works where a cover is opened, there is fear of an injury.

1. Ne pas placer les mains sur le couvercle ou entre les pièces. En raison du risque de blessure.
2. Ne pas approcher les mains, le visage, les cheveux, les manches de vêtement et autres des pièces rotatives de l'appareil. En raison du risque de blessure.
3. Ne pas toucher la pointe de lame du massicot. En raison du risque de blessure.
4. Couper l'alimentation électrique avant de régler la table d'alimentation. En raison du risque de blessure.
5. Couper l'alimentation électrique avant de retirer les rognures de papier. En raison du risque de blessure.
6. Ne pas dépasser le repère MAX en empilant le papier. Le dépasser peut provoquer une défaillance mécanique.
7. Couper l'alimentation électrique avant de procéder à l'entretien ou à l'inspection. En raison du risque de blessure.
8. Pour installer un appareil, choisir un emplacement dépoussiéré et sec. Une méthode d'installation incorrecte constitue une cause de défaillance.
9. Pour mettre un appareil en marche, mettre tous les capots en position fermée. Si un appareil fonctionne avec un capot ouvert, des blessures sont à craindre.

## Before use

Read this "Operation Manual" carefully before use. In particular, be sure to read "Safety Instructions" (page 2 to page 4) to ensure that the machine will be used properly.

Keep the manual at an appointed place with care so that it may be accessible whenever necessary.

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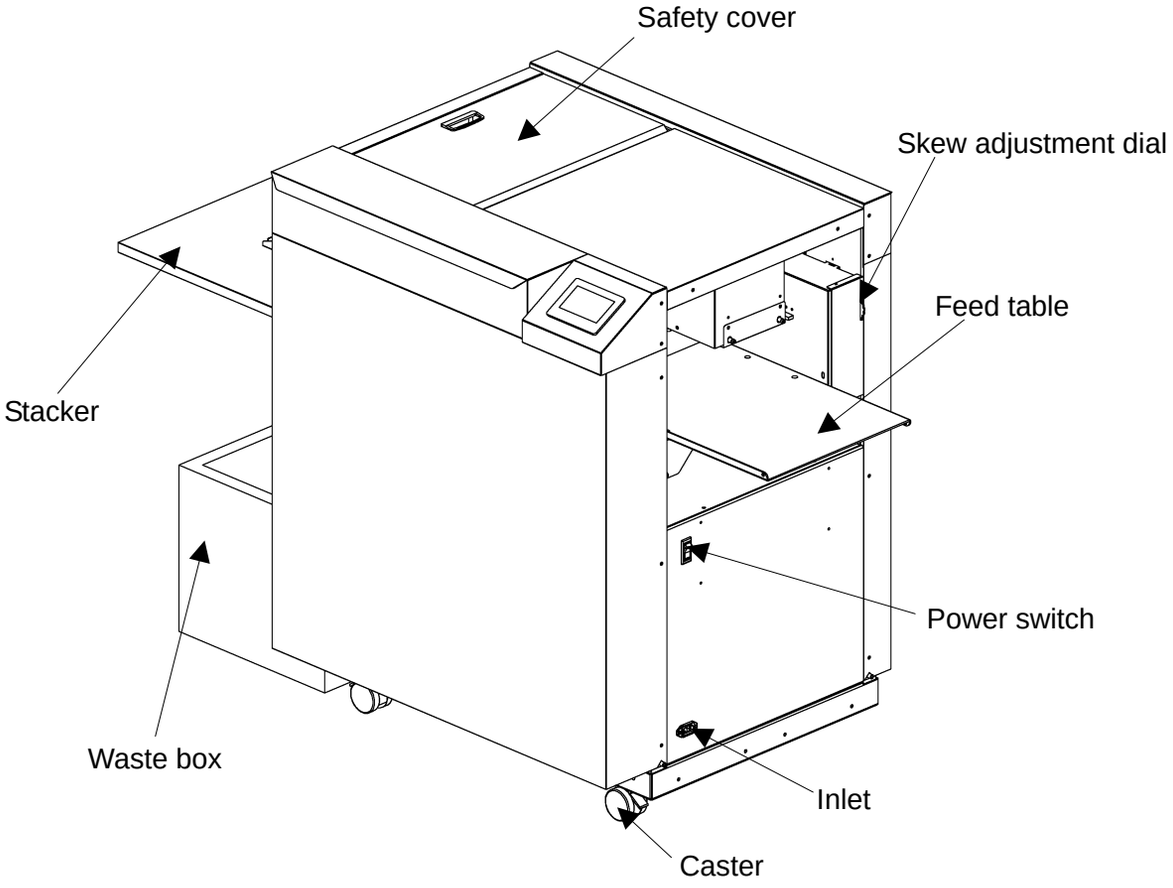
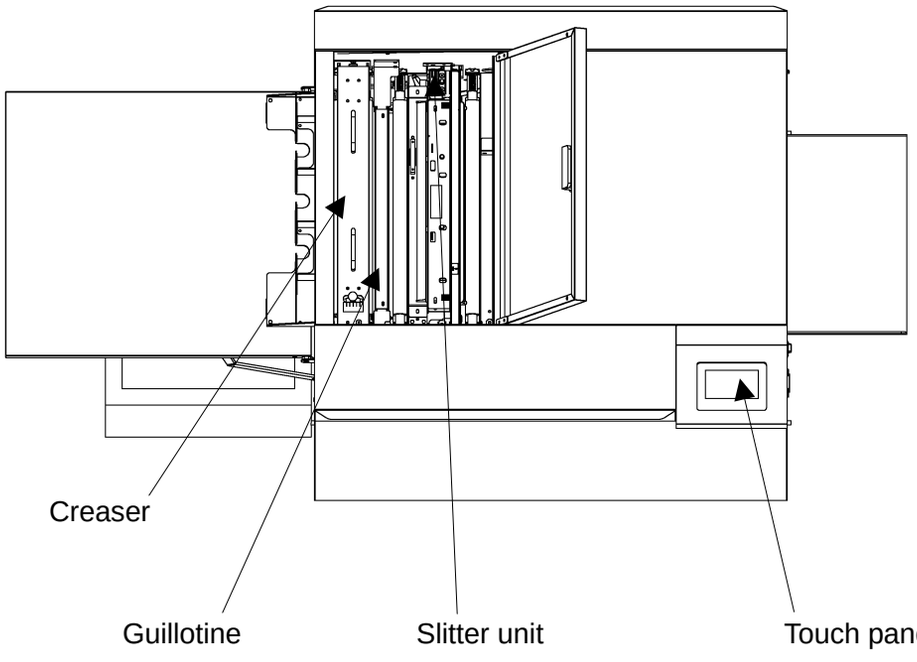
# 1 Introduction

## 1.1 Names of parts

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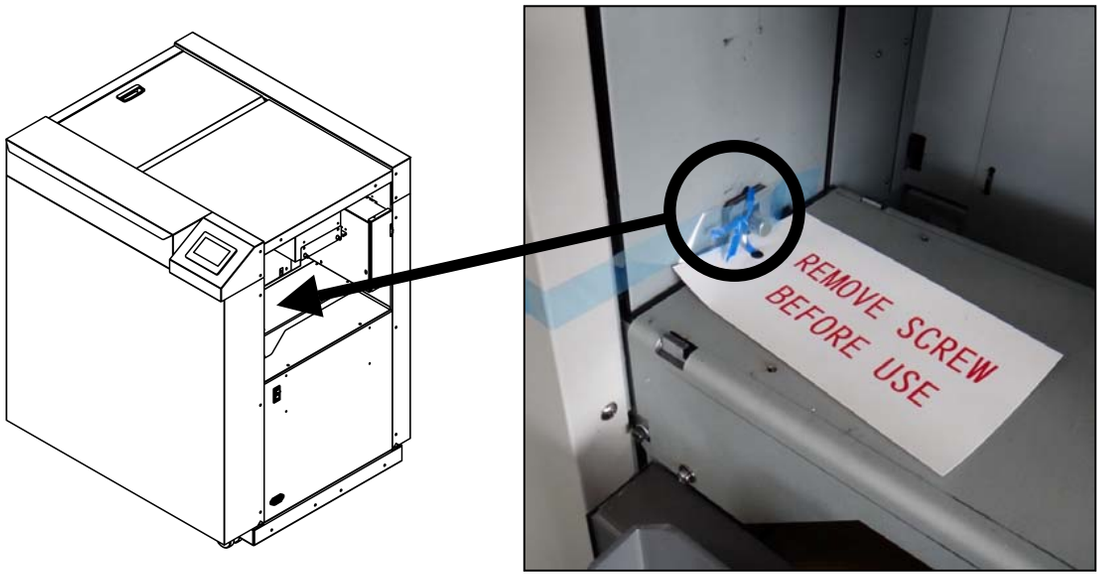
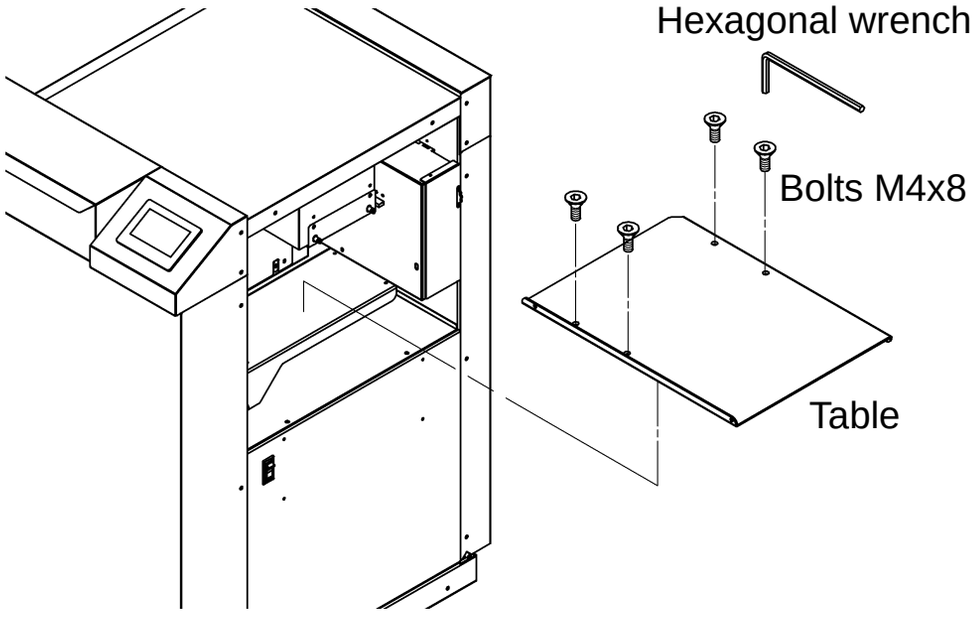
# Table setting

1. Remove screws.




2. Attach the table.

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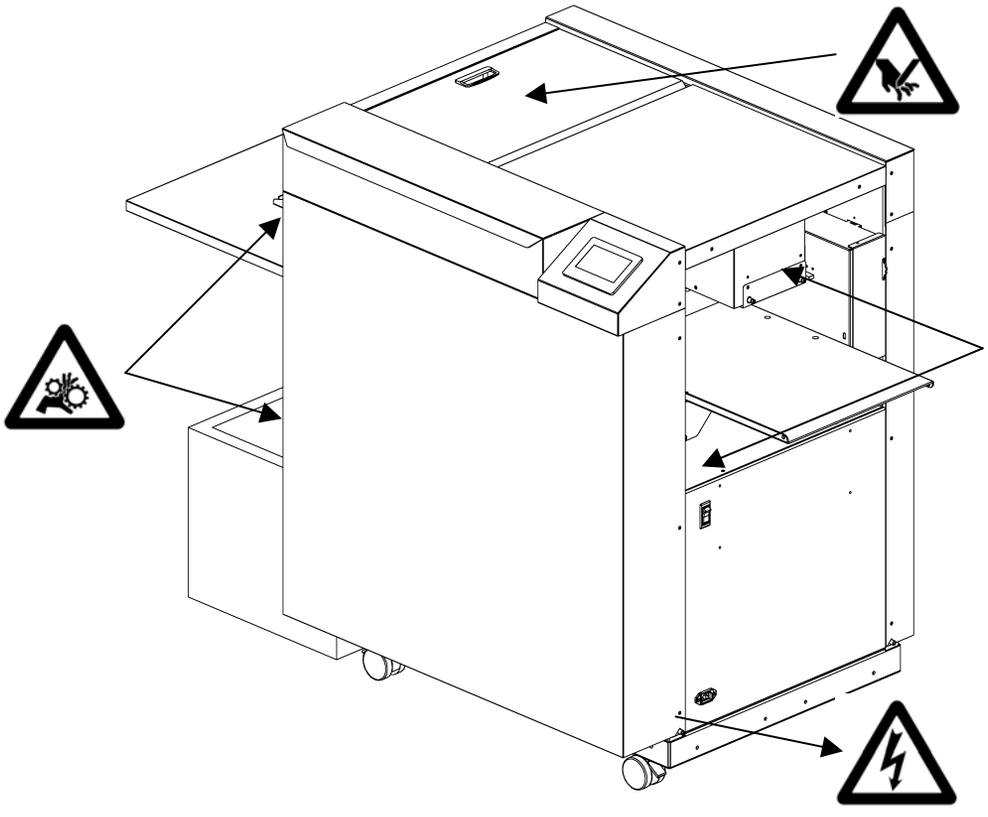

| Warning : Avertissement | | |
|---|---|---|
| | Don't put hands inside work area.<br>May result in severe injury. | Ne pas approcher les mains.<br>Pour réduire les risque de blessure. |
| | Don't touch any rotating part.<br>There is a danger of receiving an injury. | Ne toucher aucune pièce rotative.<br>En raison du risque de blessure. |
| | Don't open the cover of the equipment.<br>There is a danger of receiving an injury or electric shock. | Ne pas ouvrir le capot de l'équipement.<br>En raison du risque de blessure ou de décharge électrique. |

| Caution : Attention | | |
|---|---|---|
| | Don't touch the blade point of the cutter.<br>There is a danger of receiving an injury. | Ne pas toucher la pointe de lame du massicot.<br>En raison du risque de blessure. |

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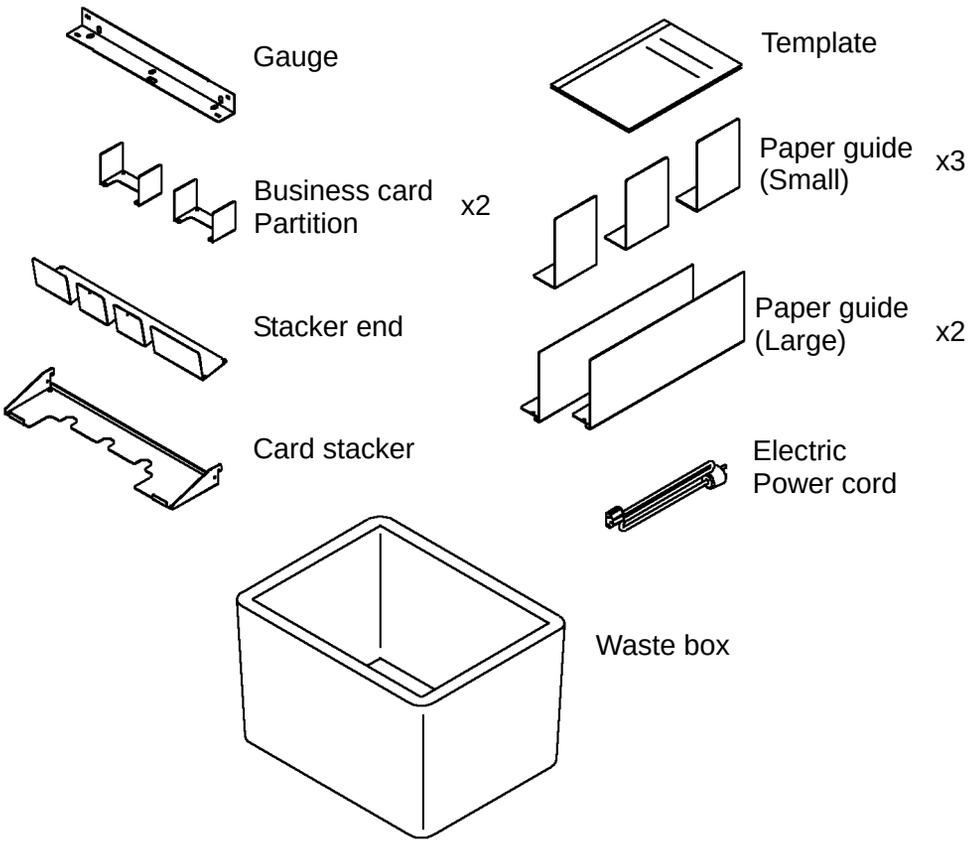
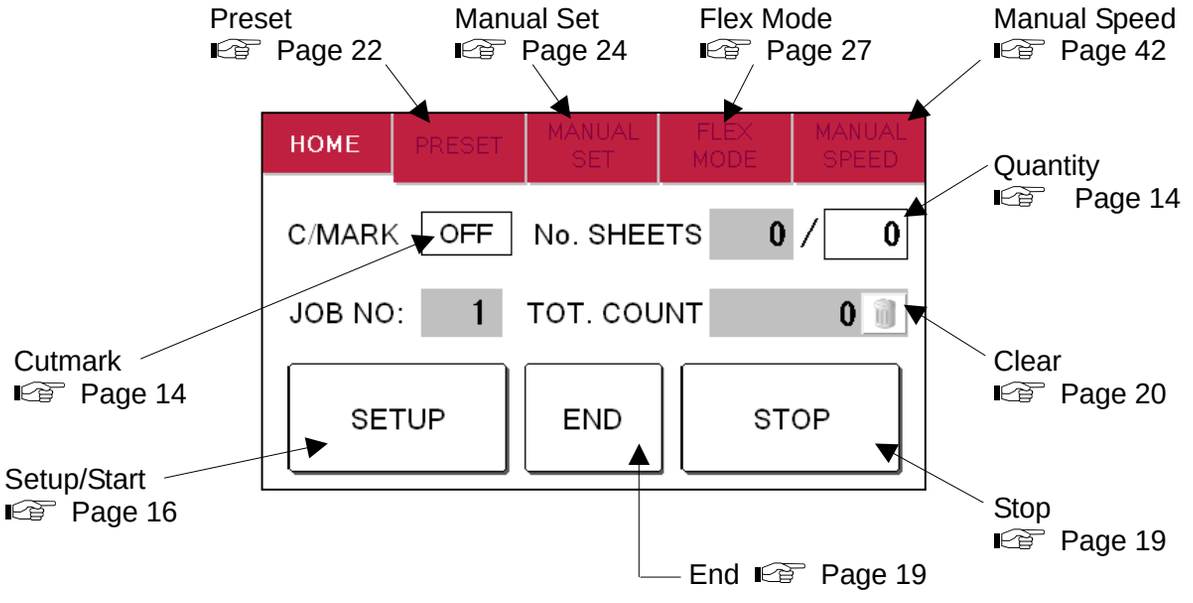
## 1.2 Accessories

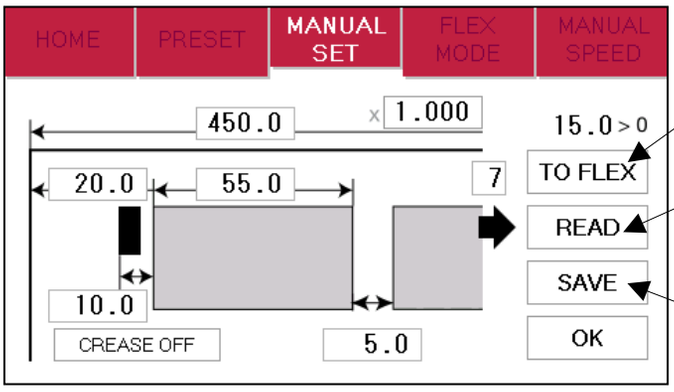



## 1.3 Touch screen

**Home screen**



## Manual Set screen

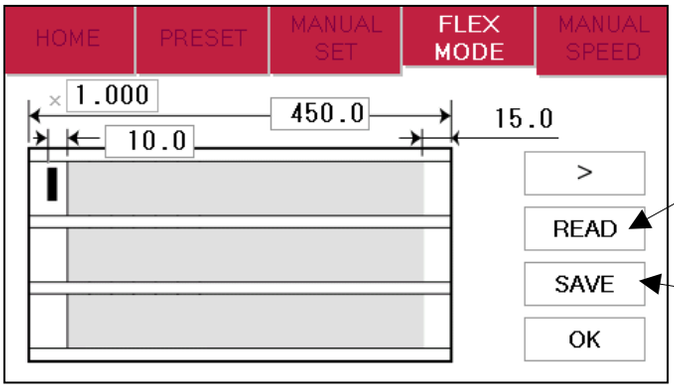



TO FLEX ☞ Page 24

READ ☞ Page 30

SAVE ☞ Page 29

## Flex Mode screen




READ ☞ Page 30

SAVE ☞ Page 29

## Manual speed screen

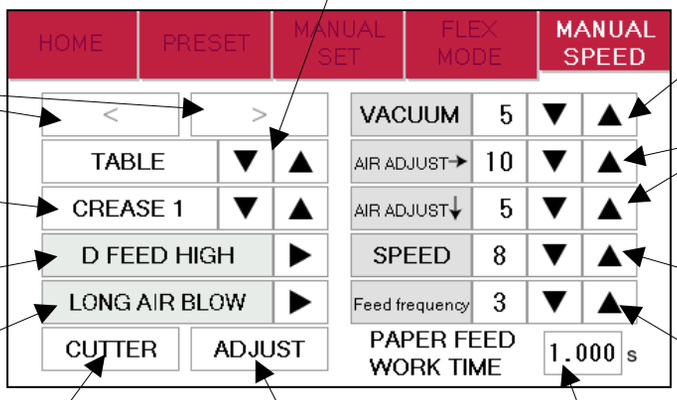



TABLE ☞ Page 42

Inching ☞ Page 42

CREASE ☞ Page 42

Double feed ☞ Page 35

AIR BLOW ☞ Page 34

VACUUM ☞ Page 33

AIR ADJUST ☞ Page 33

SPEED ☞ Page36

Feed frequency ☞ Page35

CUTTER (Guillotine) ☞ Page 42

ADJUST ☞ Page 40

PAPER FEED WORK TIME ☞ Page 34

## 1.4 Paper weight / quality

Use suitable paper stocks which weight is 120 to 350gsm (0.12 – 0.35mm).

These paper stocks are not suitable in use:

- Papers that has heavily electric static charge. It may cause misfeed, double feed or paper jam.
- Papers that are more than 3mm curled or waved. It may cause misfeed, double feed or paper jam.
- Papers that have ink or toner not fused properly. It may cause contaminating the work and the machine.
- Papers that are too slippery. It may cause misfeed or inaccurate results.
- Prints that are shrunk, stretched or skewed inconsistently. It may cause inaccurate results.

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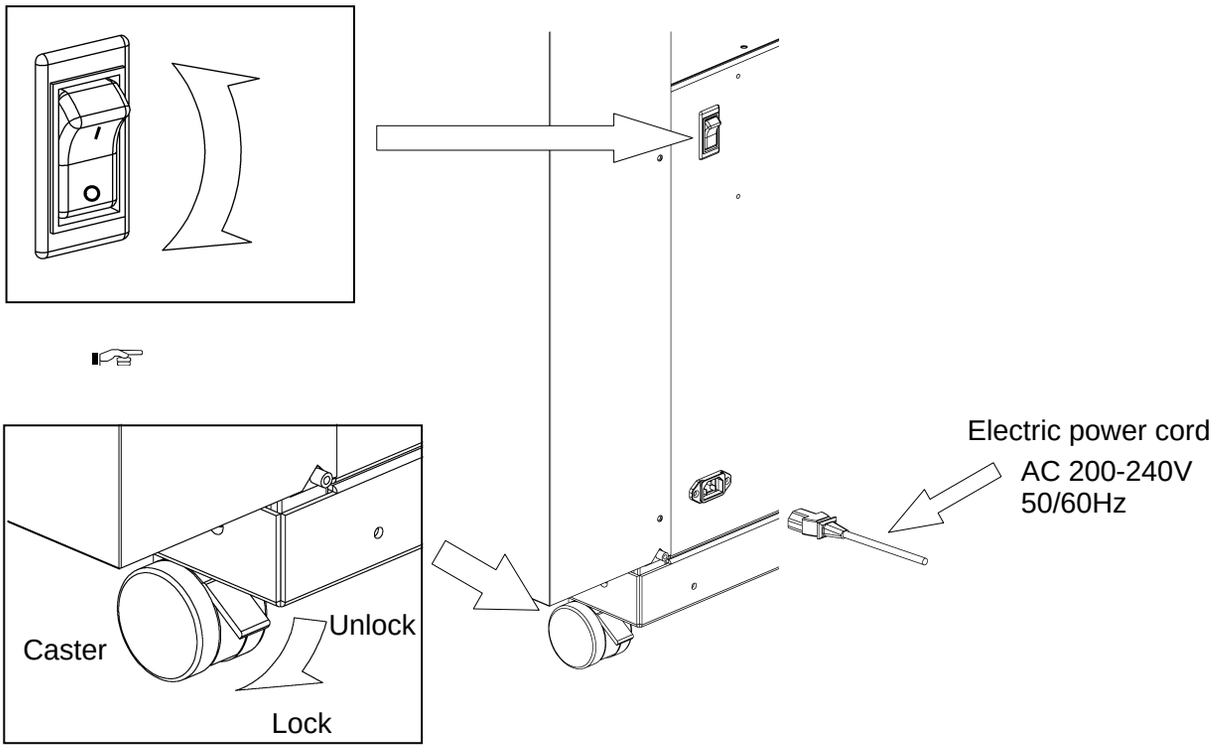
# 2 Operating instructions

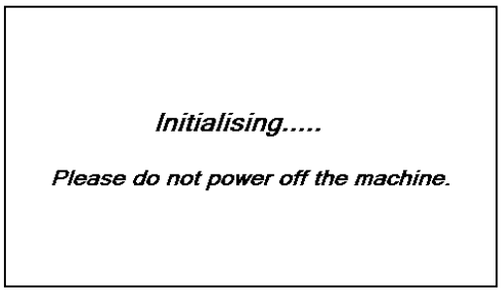
## 2.1 Lock a caster brake

## 2.2 Turning the power on



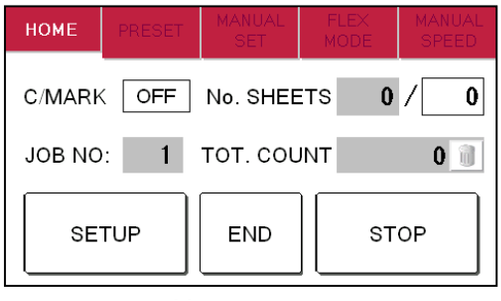

Power on

Opening screen1




Opening screen2

Opening screen3

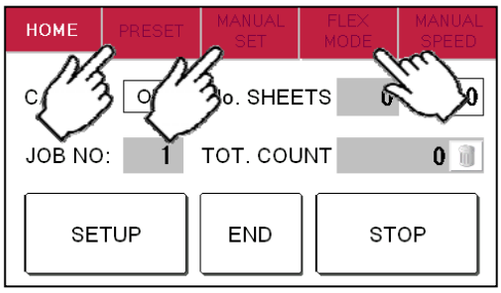



Home screen

## 2.3 Input

① Enter the cut pattern.

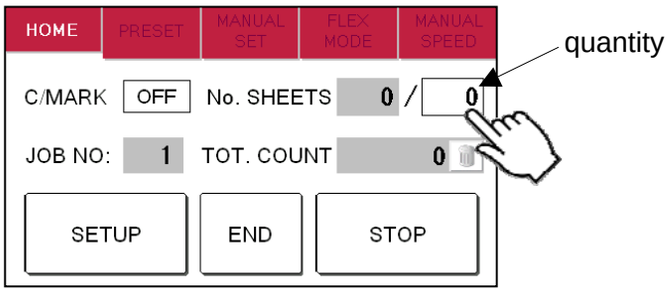
Home screen




② Enter the number of sheets for operation.

After processing the entered number of sheets in quantity, the machine stops automatically. All the sheets on the feed table will feed if “0” is entered in quantity.

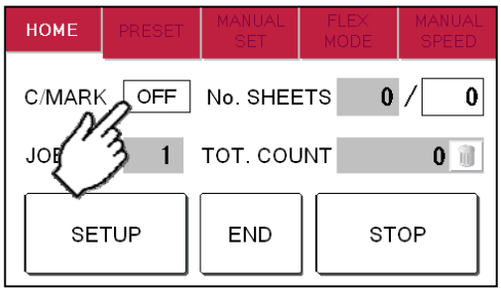
Home screen




③ Touch the screen to have ON to activate cut-mark registration.

When it is on, the machine registers the cut-mark and cross cuts at proper positions even if the image is drifted.

Home screen

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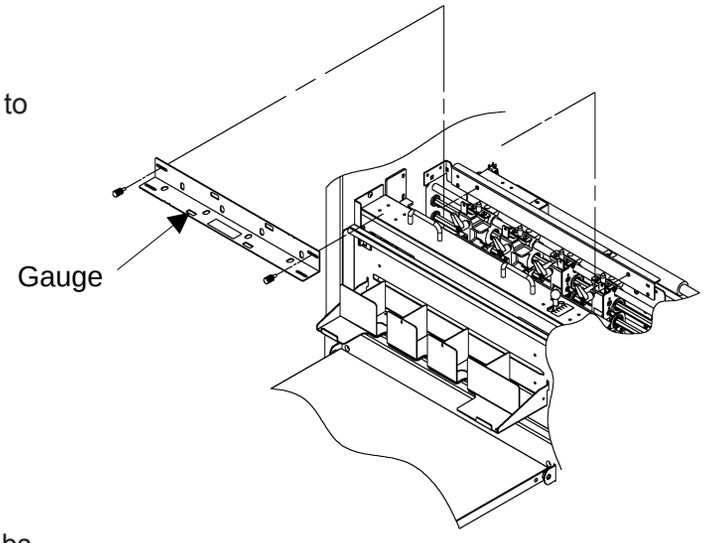
## 2.4 Gauge setting

・Select the right gauge according to desired cut pattern.

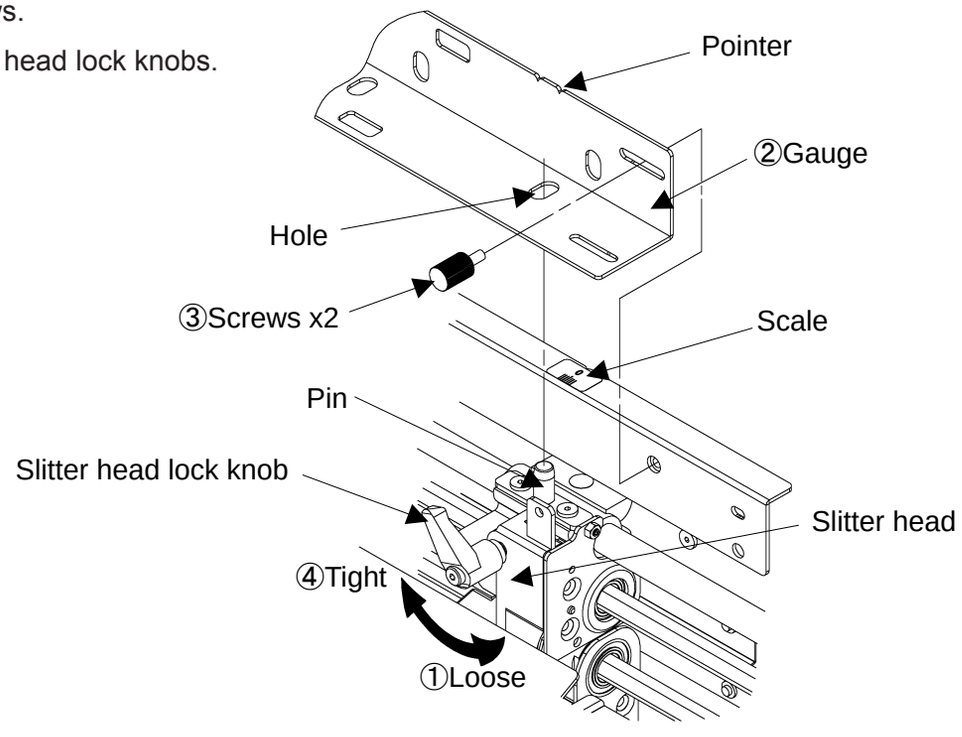



① Loosen the slitter head lock knobs.

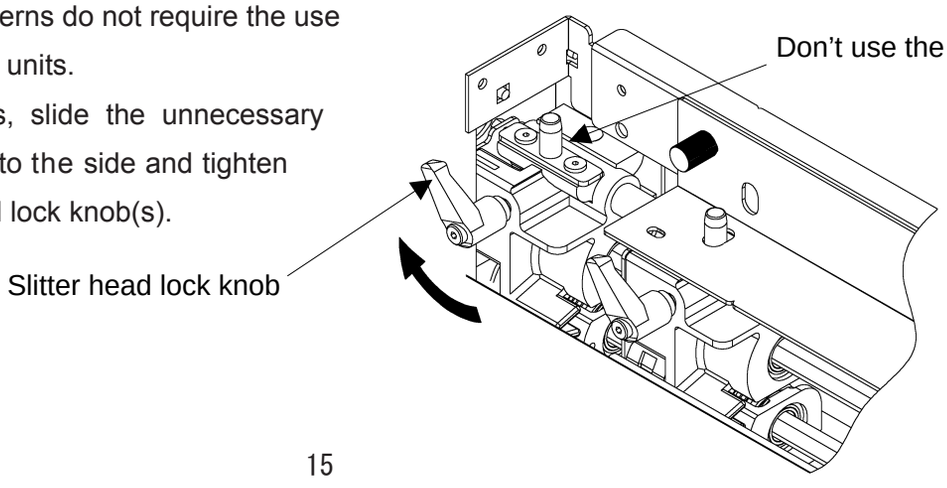
② Slide the slitter head while holding the knob.
Adjust the positions of the slitters so that their pins fit to the Hole on the gauge. Snap the gauge with the labeled side on top and adjust it so that its pointer points 0.

③ Tighten the screws.

④ Tighten the slitter head lock knobs.




・Some cut patterns do not require the use of all the slitter units.
In such cases, slide the unnecessary slitter head(s) to the side and tighten the slitter head lock knob(s).

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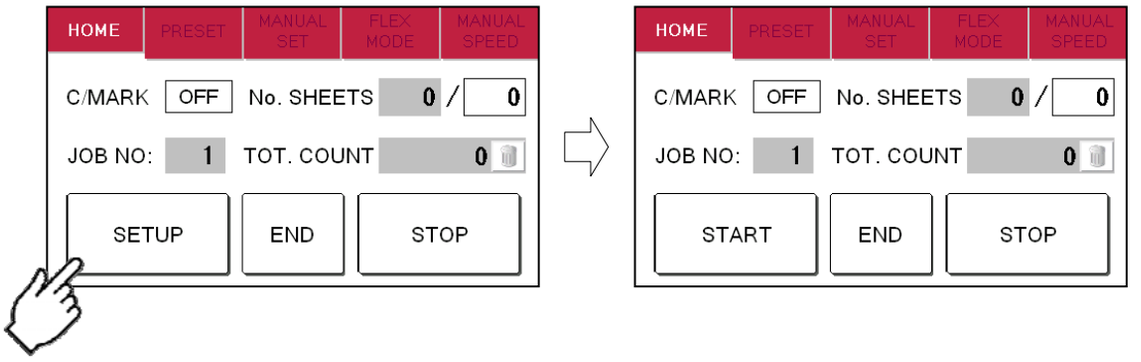
## 2.5 Setup

① With a press of SETUP button, the slitters will move to the positions according to the selected cut pattern.

② At the same time, Feed table will move to the lower end position.

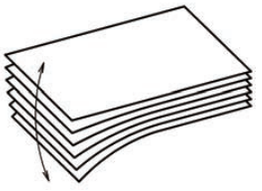
③ START button will be indicated when all slitters are completely set.

Home screen



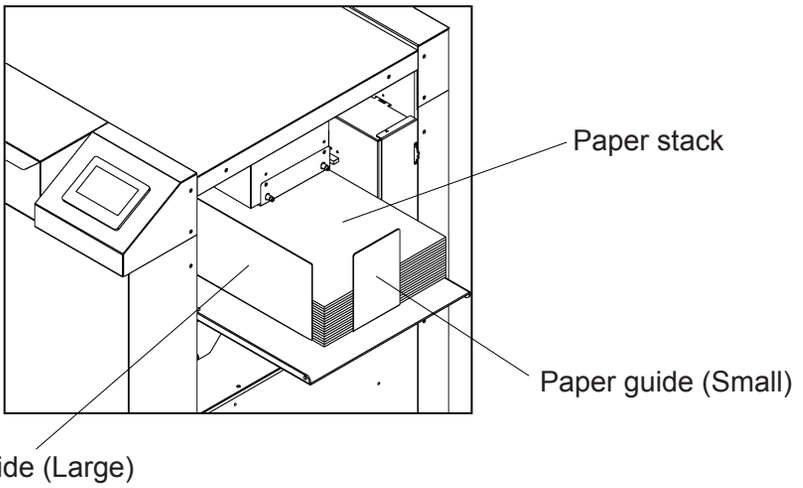

## 2.6 Paper setting

① Press the SETUP button on the home screen. If the feed table is in upper position, it will move down. Press STOP button to stop the table moving.



② Flip through the sheets well before you put them on the feed table.

③ Set the sheets on the feed table. Use the paper guide (Large) and paper guides (Small) to fix the sheets.

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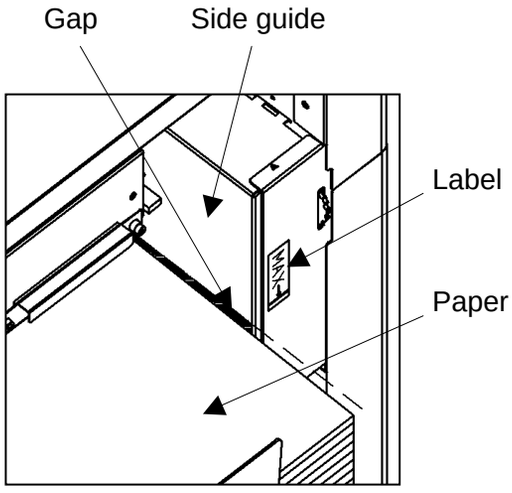
Note.

- Paper loading capacity is 100mm.
- Make sure that the paper stack does not exceed the MAX label.
- It affects finishing accuracy if there is a gap between the side guide and the sheets.



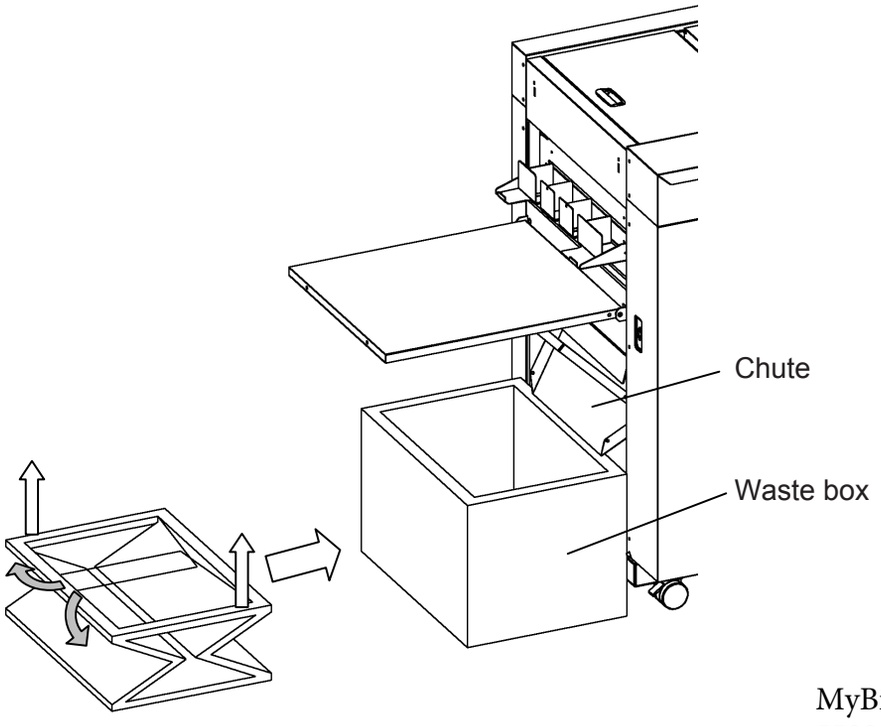

・If the print is skew on the sheets, the angle of the side guide can be adjusted.

☞ Page 36

| ⚠ Warning : Avertissement | |
|---|---|
| | Don't put hands inside work area. : Ne pas approcher les mains.<br>May result in severe injury. : Pour réduire les risque de blessure. |

## 2.7 Stacker and Waste box settings

① Assemble the Waste box. Place the Waste box under the Chute.



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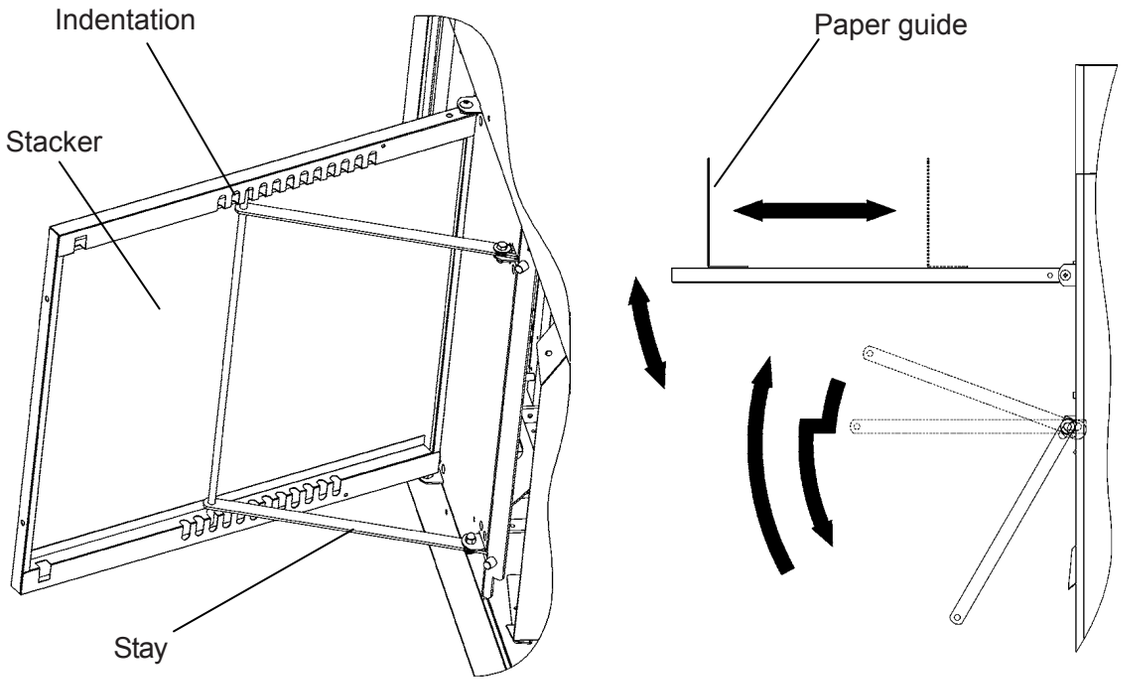
② Open the stacker and set the stays in the indentation of the back of the stacker at an appropriate angle to allow smooth paper ejection.

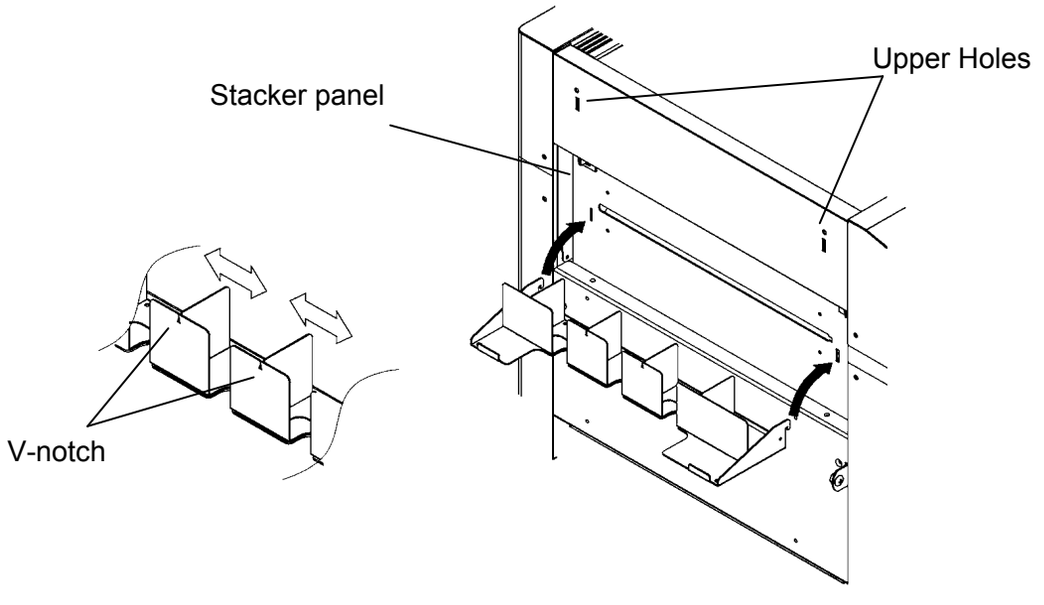
③ Adjust the large paper guide according to the paper size.




④ Hang the business card stacker to the Stacker panel.

⑤ Find the V- notch to see where to put the business card partition.

⑥ When it is not used, it may be hooked to the upper holes in the stacker panel.

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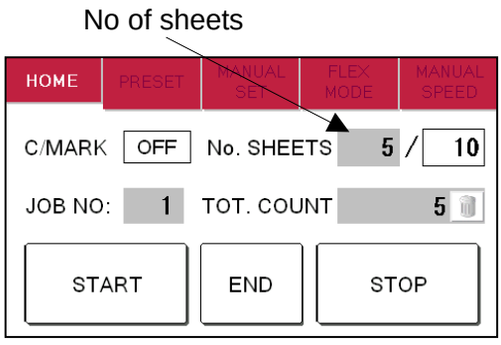
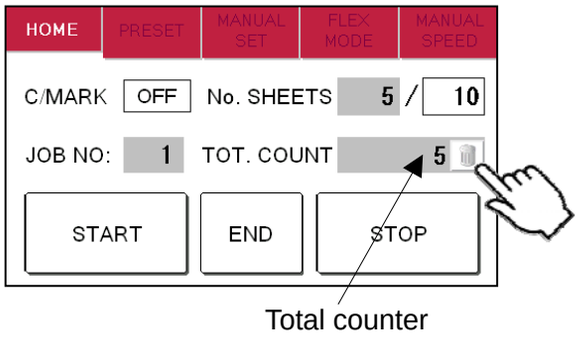



・The counter indicates the number of finished sheet when the machine is stopped with STOP or END button.

・If paper is left in the machine, remove it by inching. (☞ Page 42)




・ The total count of processed sheets are counted. Press and hold to clear the number.

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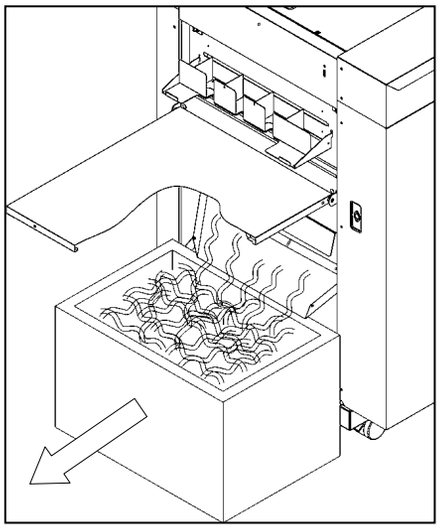
## 2.10 Waste disposal

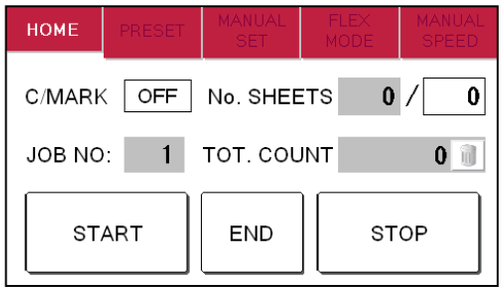
- Dispose the wastes in the waste box appropriately.
- Overloading wastes causes errors or a breakdown.



## 2.11 Power off

- Make sure that the machine is stopped.
- Return to the Home screen.
- Turn off the Power switch.

Home screen

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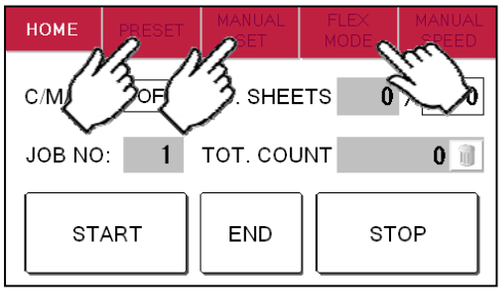
# 3 Cut pattern input

## 3.1 Outline

Home screen




① PRESET

PRESET is a series of cut patterns that are already stored in the machine.

(☞ Template)

② MANUAL SET

In MANUAL SET mode, user programs can be created and stored into the machine.

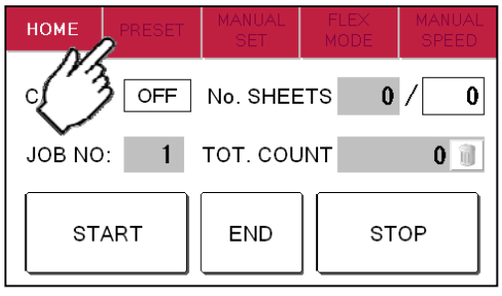
③ FLEX MODE

In FLEX MODE, you can generate user data with a lot of flexibility in layout. And also these data can be stored into the machine.

## 3.2 PRESET

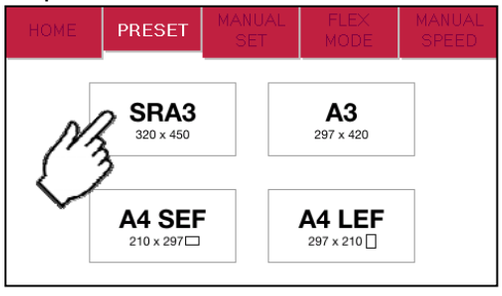
① Press PRESET.

Home screen




② Press the size of the original sheets.

Paper Selection Screen 1

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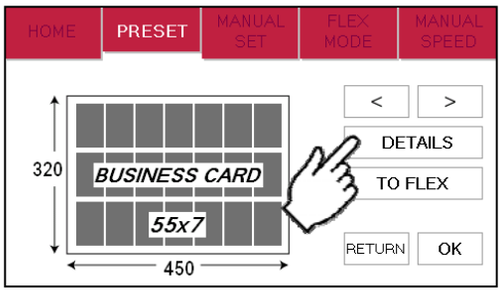
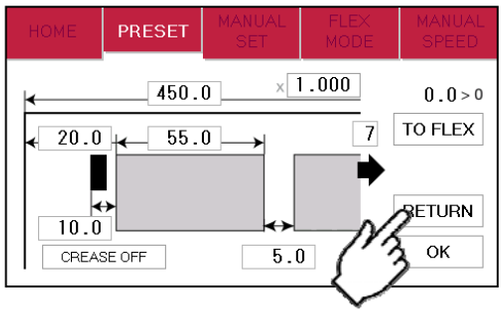
③ Select the cutting pattern.

Cutting Pattern Selection Screen

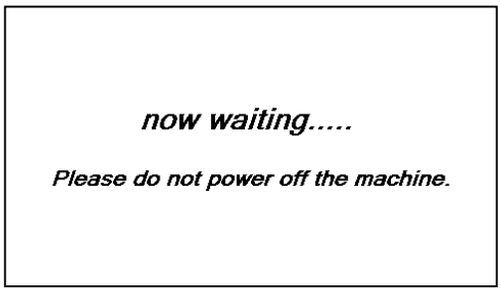


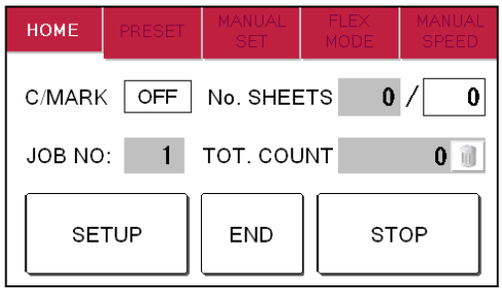

Cutting Pattern Confirmation Screen




| | |
|---|---|
| < > | Cutting pattern switching. |
| DETAILS | Cut pattern can be checked in detail and the measurements can be changed.<br>Refer to MANUAL SET (☞Page.24) for measurement setting procedures. |
| TO FLEX | Copy the selected cutting pattern to FLEX MODE, then move to FLEX MODE screen. |
| RETURN | Return to the previous page. |
| OK | Confirm the cut pattern. |

④ The machine recalls the preset pattern and automatically returns to the home screen.

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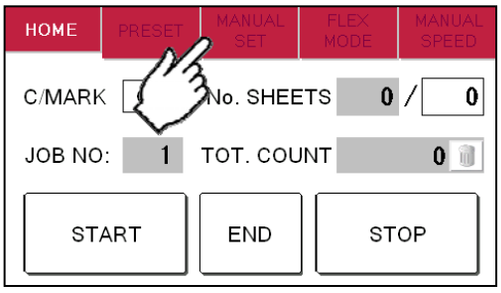
## 3.3 MANUAL SET

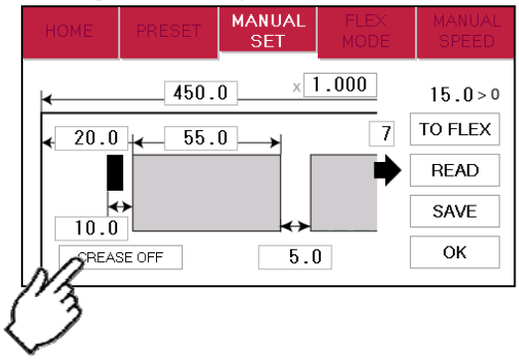
① Press MANUAL SET.

Home screen

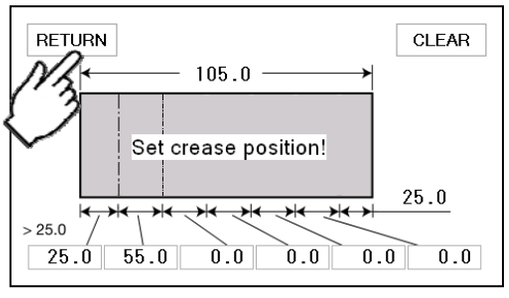



② The screen displays the current cut pattern.

Cutting Pattern Input Screen




Crease Pos. Input Screen

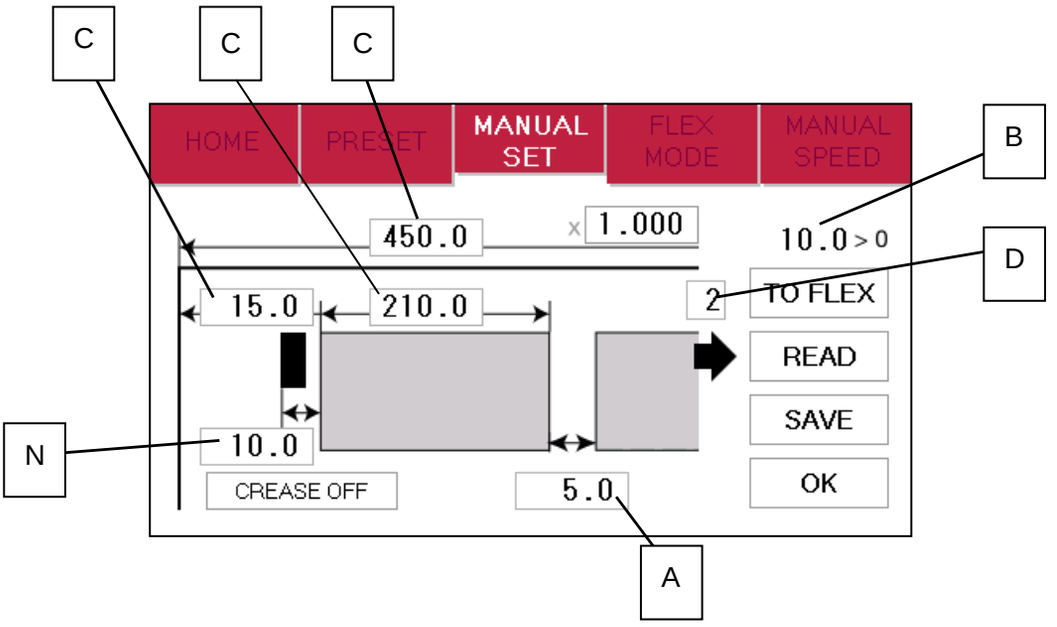


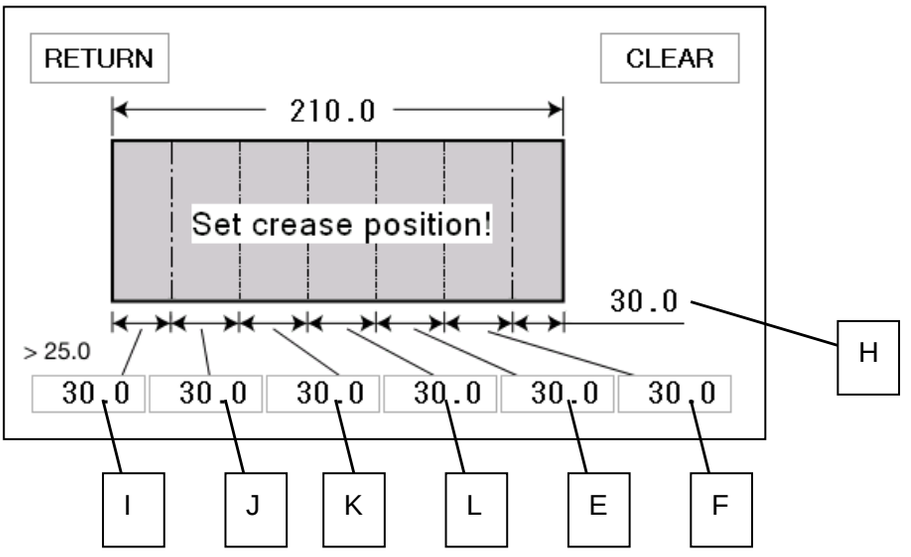

| Cutting Pattern Input Screen | |
|---|---|
| TO FLEX | Copy the selected cutting pattern to FLEX MODE, then move to FLEX MODE screen. |
| READ | Move to User Program Selection Screen. |
| SAVE | Save Cut pattern as inputted into User Program memory. |
| OK | Confirm Cut pattern as inputted. |
| CREASE OFF | Move to Crease Pos. Input Screen. CREASE ON will be indicated in case crease processing is given. |

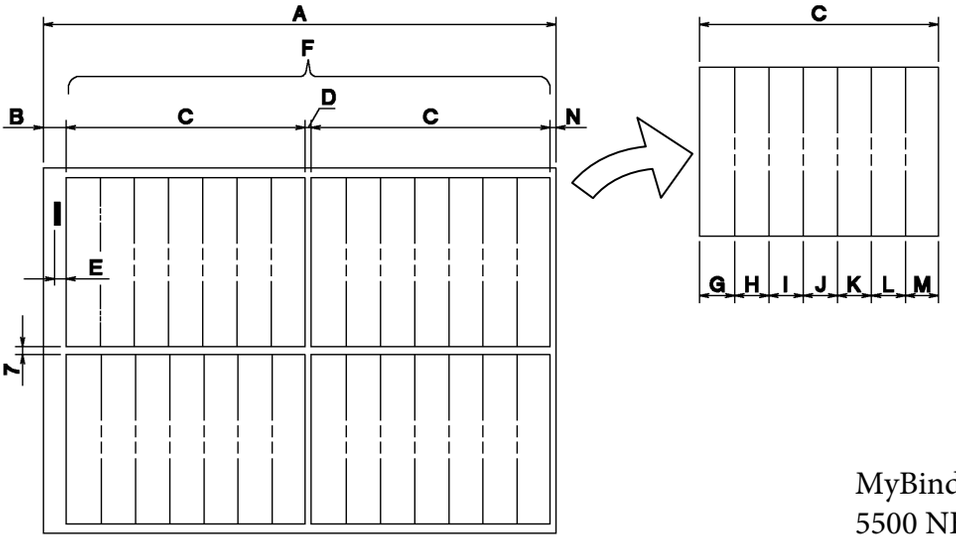
| Crease Pos. Input Screen | |
|---|---|
| CLEAR | All values inputted on Crease pos. input screen will be cleared. |
| RETURN | Confirm values as inputted and go back to Cutting Pattern Input Screen. |

③ Press the number to change the value.

Measurement A-L can be customized. Measurement M-N will be calculated automatically.

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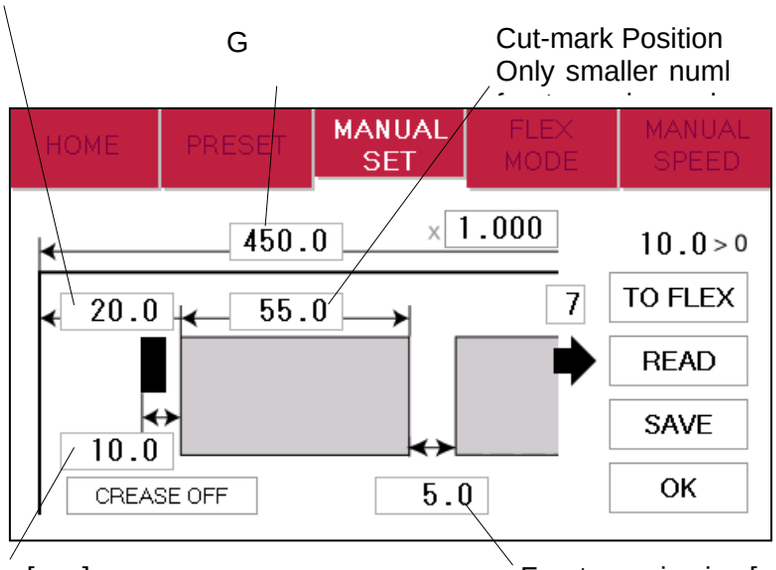
④ There are some limitations in value as shown on below image.

M




Paper size [mm]
210-700

Front margin size [mm]
It doesn't make the first cut if 0 is entered.

・If an error message is displayed. ☞ Page 43

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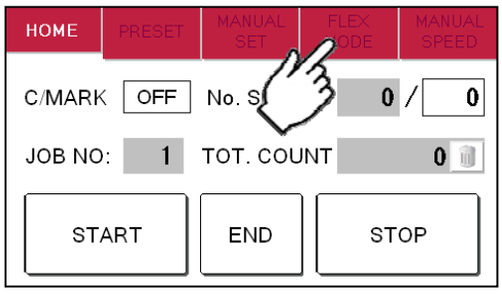
## 3.4 FLEX MODE

① Press FLEX MODE.

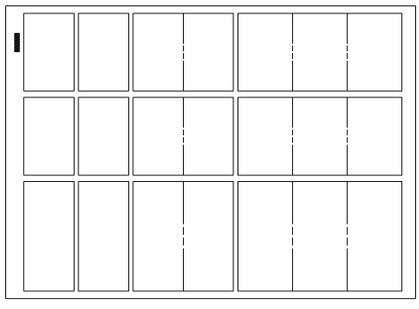
Gutter size[mn
When 0 is entered



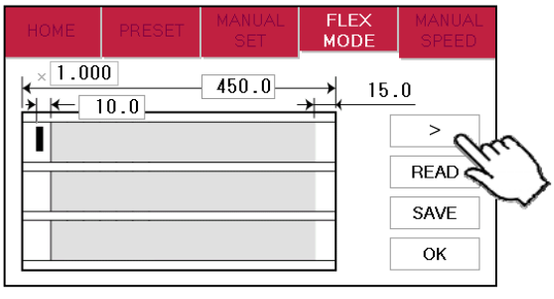

② FLEX mode is an operation mode where you can input up to 20 actions (cross cut, crease) per page. This allows the machine to finish jobs which MANUAL SET cannot finish, such as multiple sizes of cards from a page and pass through pages without any actions.

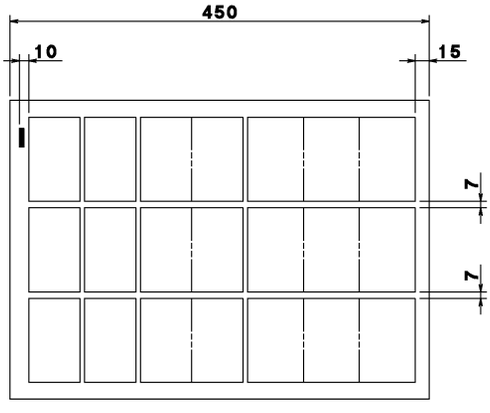
③ This picture on right is an example which will explain how to input values.

_____ Cut size [
50-
_ · · _



④ Press the number to change the value.




⑤ When data input is completed, press [ > ] to the next screen.



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⑥ This screen allows you to input each pitch from No. 1 to No. 20. The adjacent switches are used for selecting no operation, guillotine, or creaser. Every time the switch is pressed, the selected operation changes.

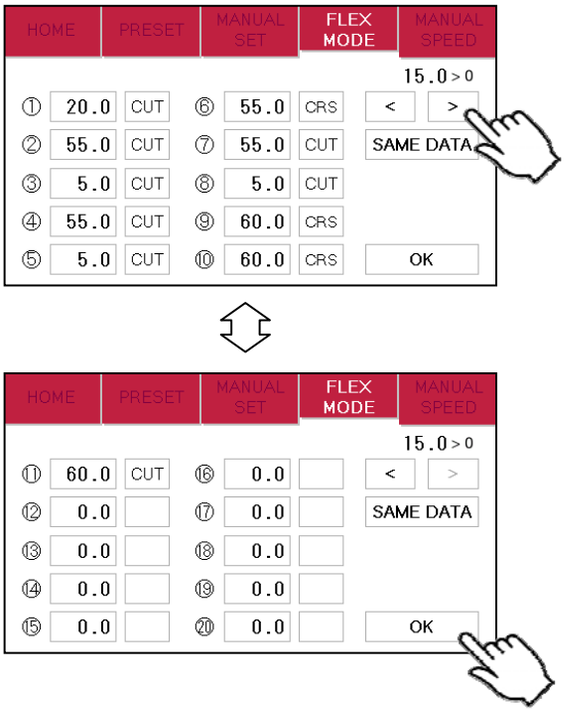
[ ] : No operation　　[CRS] : Creaser

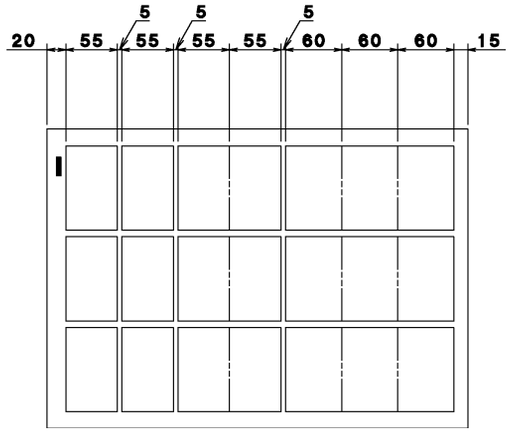
[CUT] : Guillotine

⑦ If the pitch of 0.0 is input, all the pitches after that one are corrected to 0.0 (no operation).

⑧ Pressing [SAME DATA] copies the No. 1 pitch and its relevant operation to No. 2 to No. 20 pitches.

⑨ When data input is completed, press [>] to the next screen.




⑩ When data input is completed, Press [OK] to Home Screen.

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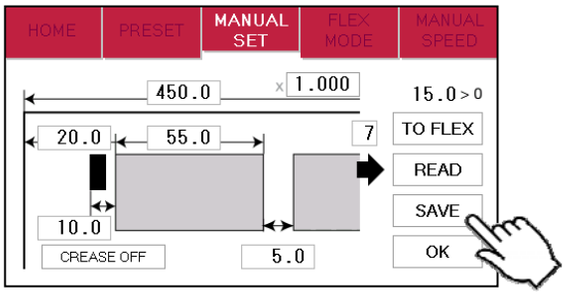
## 3.5 SAVE / READ

- MANUAL: up to 100 jobs can be stored.
- FLEX: up to 50 jobs can be stored.
- SAVE/READ procedures are same in each mode.

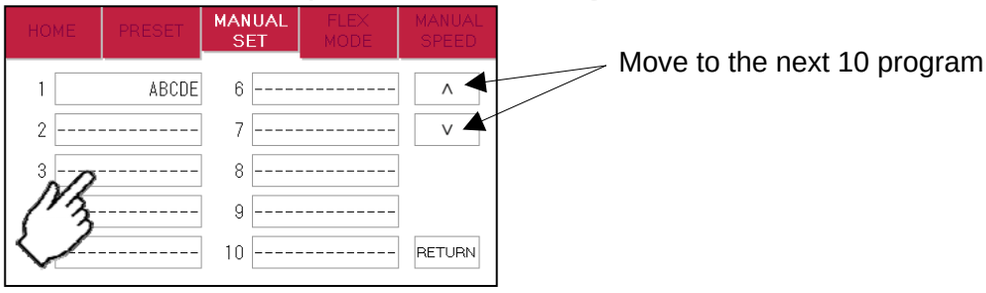
### SAVE

① Can store the contents of the MANUAL SET Press the SAVE.

Cutting Pattern Input Screen

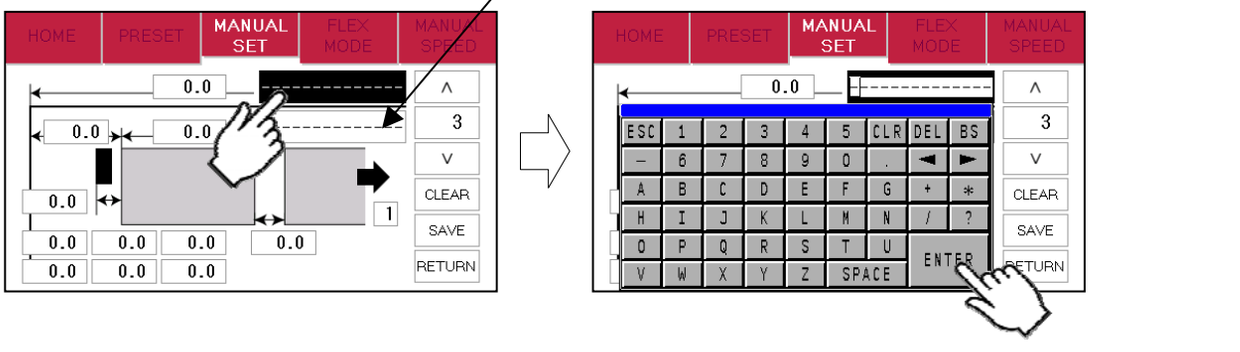



② Press the button in which you wish to make a registration.

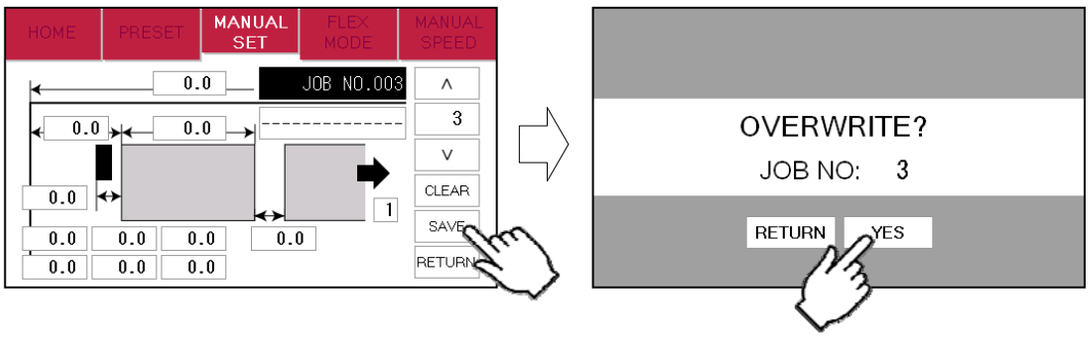



③ Enter the name for registration.

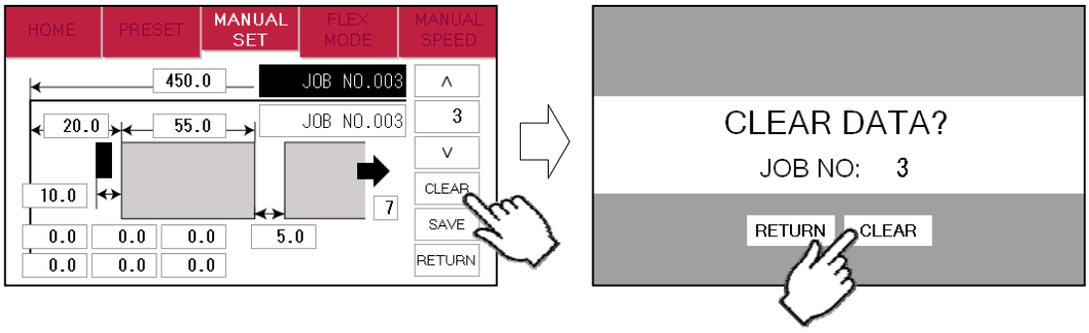
Currently registered name
Press and hold over 1 sec. to make a copy of input name.




④ This message will be shown if SAVE was pressed. Then press YES and save data.



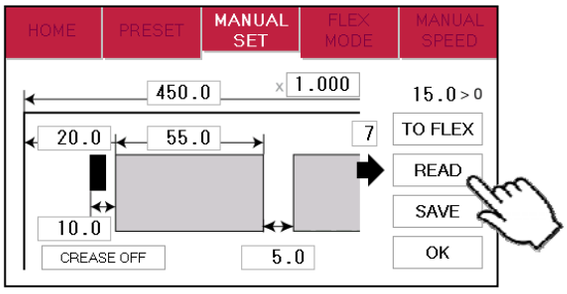
⑤ Saved user data can be deleted with a press of CLEAR.



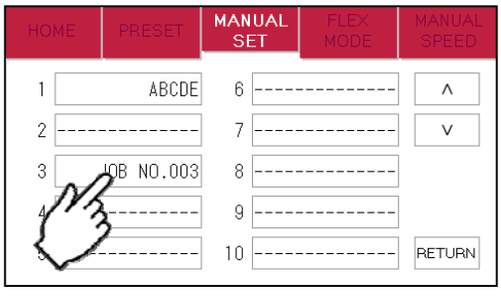

## READ

① Can store the contents of the MANUAL SET Press the READ.

Cutting Pattern Input Screen

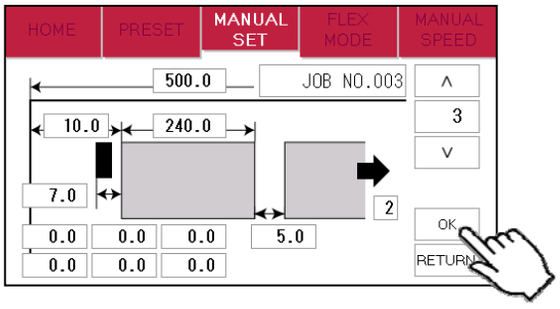



② Press the button of the name you wish to retrieve.




③ Confirm the details of the program for retrieval.

Data can be accessed with a press OK.

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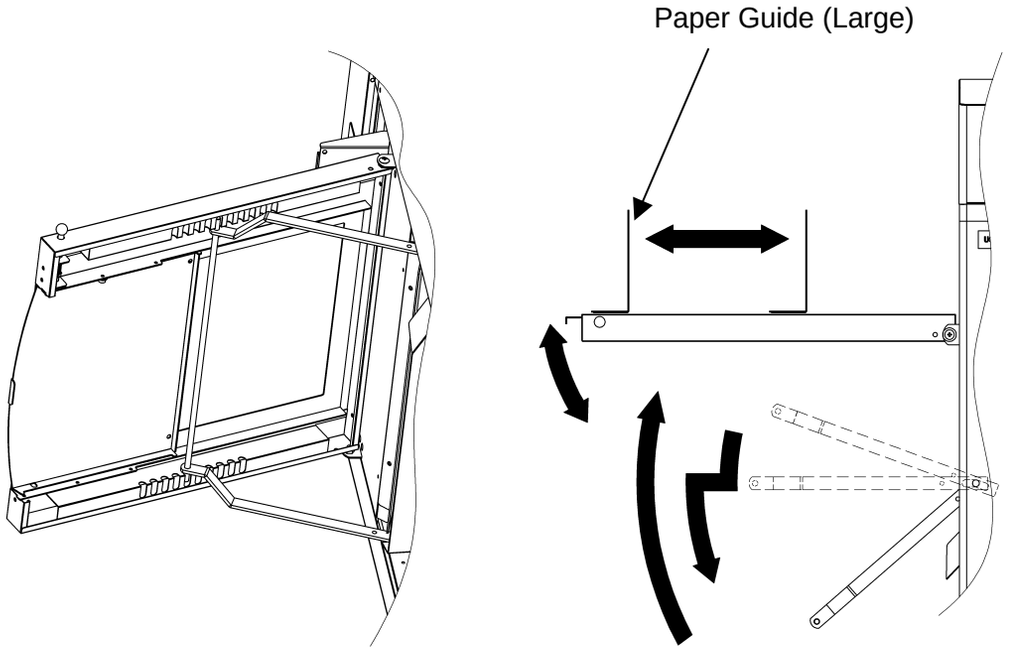
# 4 How to use options

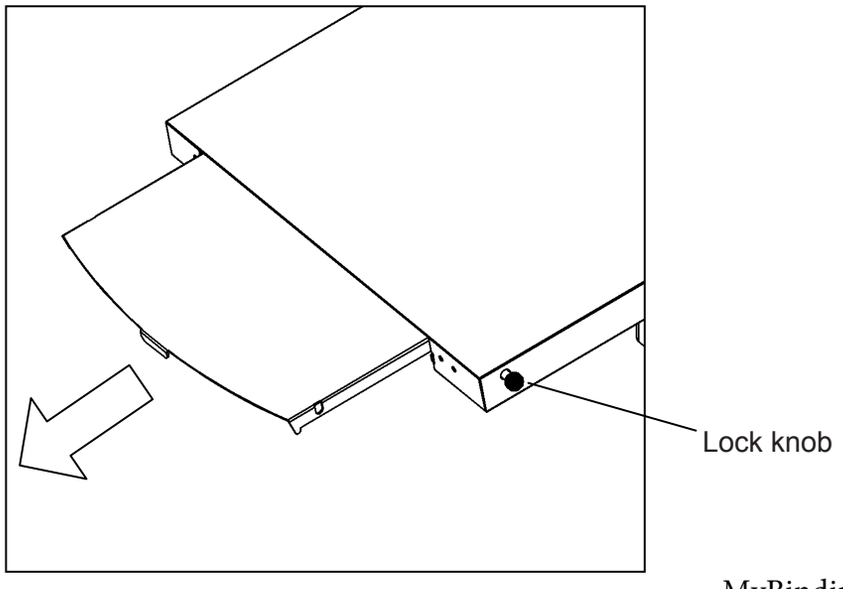
## 4.1 Long stacker




① Open the stacker and set the stays in the indentation of the back of the stacker at an appropriate angle to allow smooth paper ejection.

② Adjust the large paper guide according to the paper size.

③ Stacker can be extended by pulling out the extension while releasing the lock knob.

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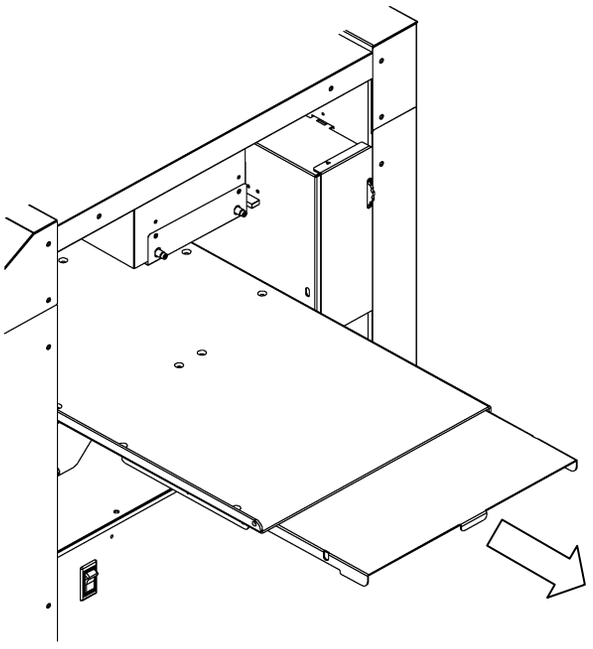
## 4.2 Long feed table

① Adjust the large paper guide according to the paper size.



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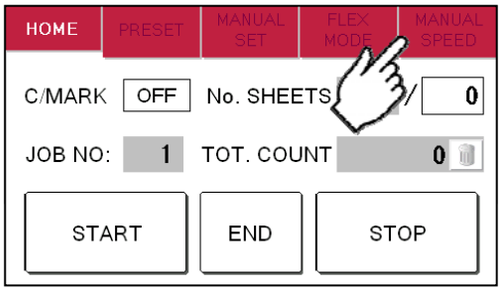
# 5 Adjustment

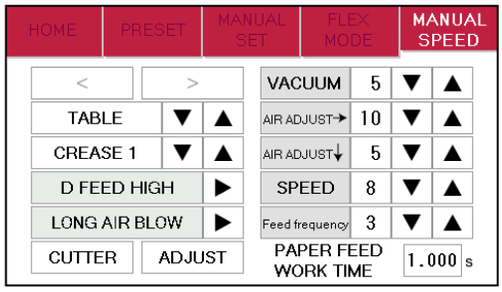
## 5.1 Adjustments on the paper feed section

・Adjustments are required when the machine is likely to feed double or skew.

Home screen

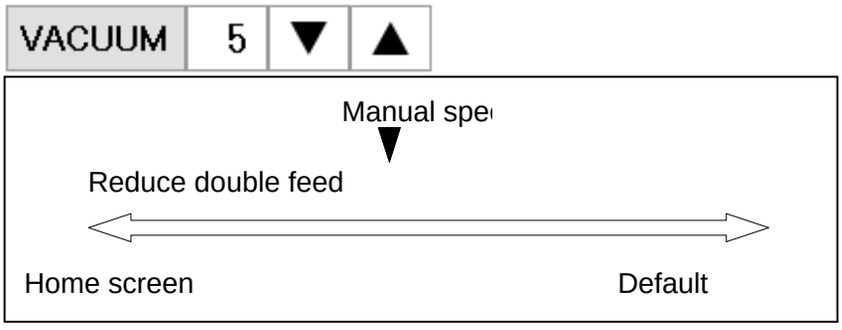



Manual speed screen




① Upper suction adjustment

「 VACUUM 」



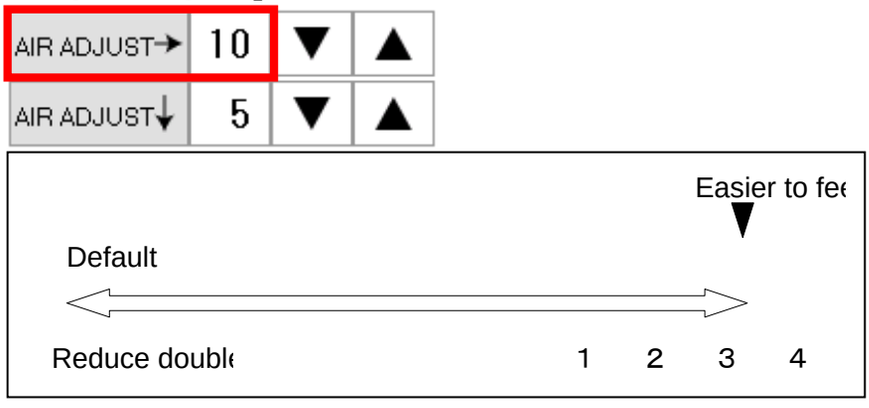

Double paper feeds may occur in case of feeding thin or low density papers. In such cases, turn down the VACUUM.

Empty feed may occur in case of feeding heavy paper. In such a case, turn up the VACUUM.

VACUUM will be turned off when the value is 0.

② Lower suction adjustment

「 BLOW - FRONT 」




BLOW – FRONT will be turned off when the value is 0.



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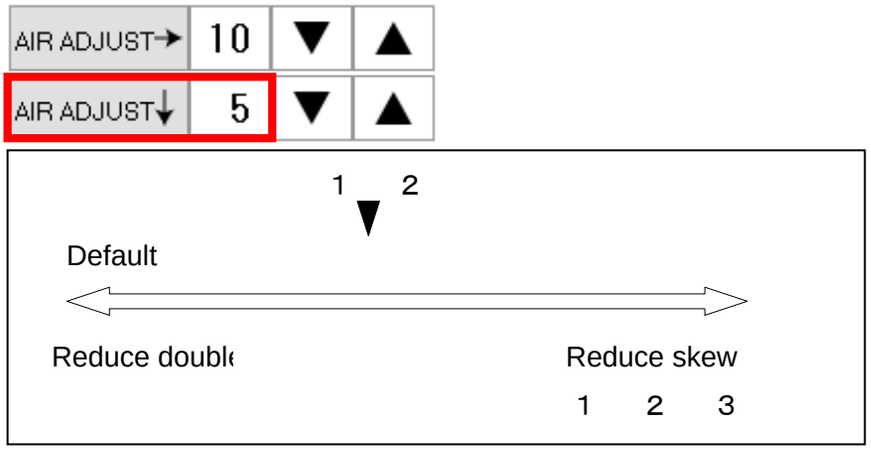
「 BLOW - SIDE 」



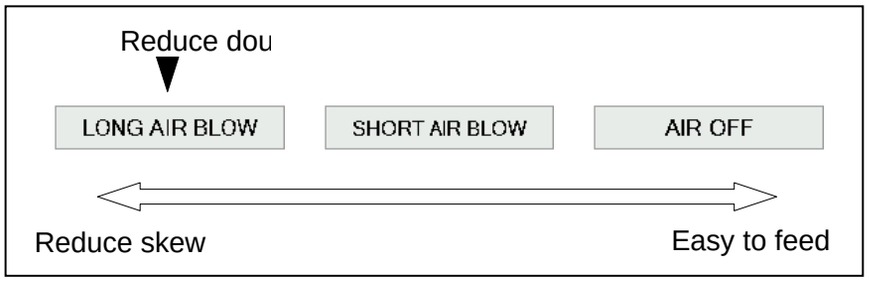

Thin paper might be bent and fed. In this case, turn down the side blower.

Empty feed may occur when paper is heavy. In such cases, turn up the blower.

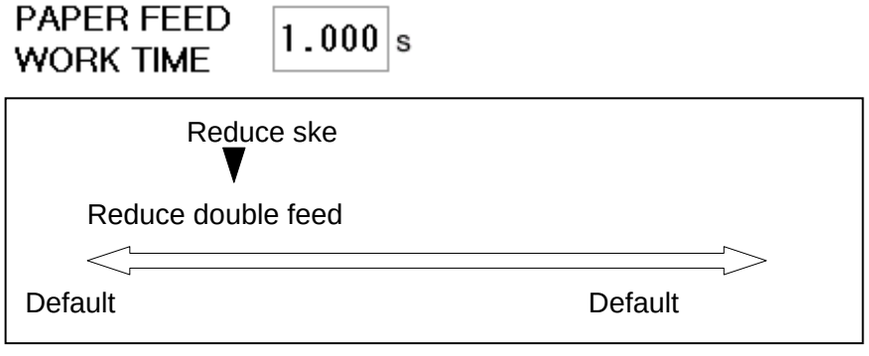
Papers with statics may cause double paper feed. In such cases, turn up the blower.

BLOW- SIDE will be turned off when the value is 0.

③ Air blow adjustment




④ PAPER FEED WORK TIME adjustment




1.0 sec. is the default setting. Paper fed work time can be adjusted with a fraction of 0.1s.



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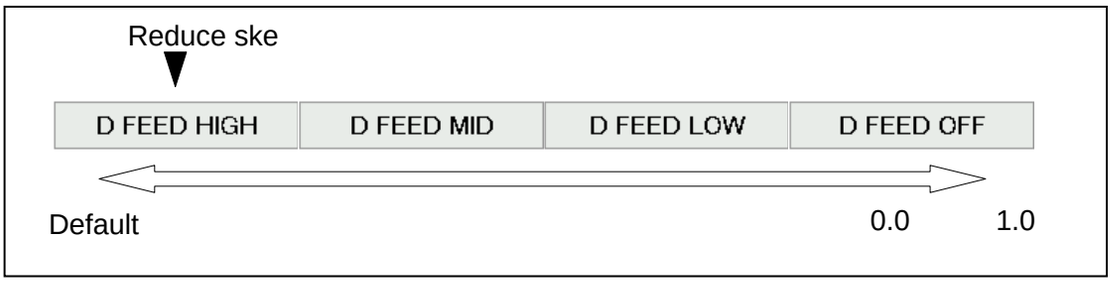
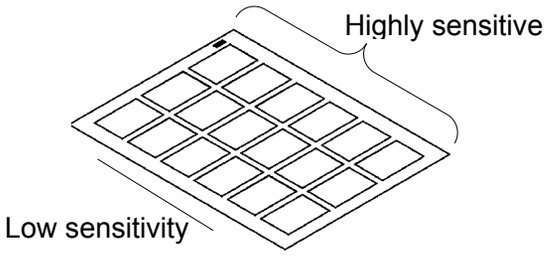
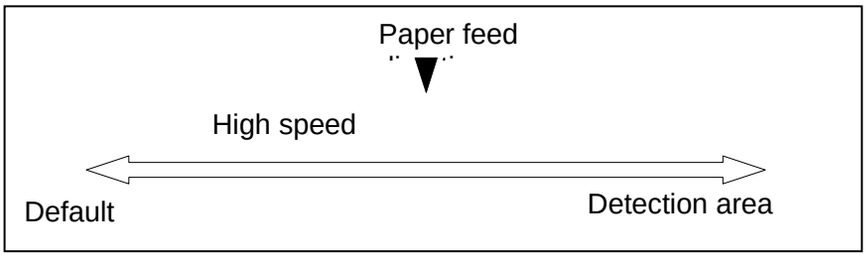
⑤ Sensitivity of Double feed sensor




- If the machine detects double feed even with a single sheet, lower the sensitivity of the detection sensor.
- The detection sensor detects double feed by checking the edge of sheets as shown on the drawing. It is recommended not to print on the sheet edge.




⑥ Feed frequency




Feed frequency is the function to alter intervals between paper feeds. As the number increases, feed frequency is increased and the interval is decreased. At level 5 the machine can feed papers at the highest speed, but the risk of double feed is also increased.

3 is the default setting.

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## 5.2 Speed change

| SPEED | 8 |
|---|---|

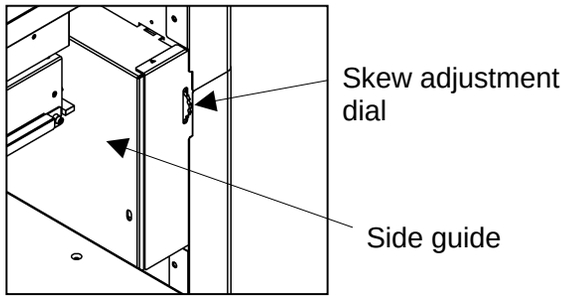
・There are eight feeding speed levels.

## 5.3 Skew adjustment

・If print is skew on the sheet, the angle of the side guide can be adjusted.

・The angle of the side guide changes as the skew adjustment dial is turned.

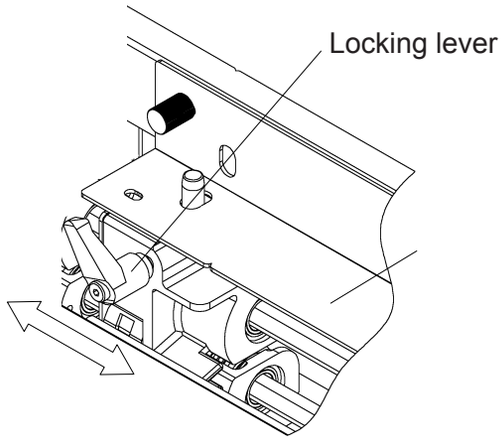
Set the sheets again. ☞ Page 16




## 5.4 Slit position adjustment

・Adjust the positions of the slitter heads by moving the gauge.

・The gaps between the slitter heads are not adjustable.

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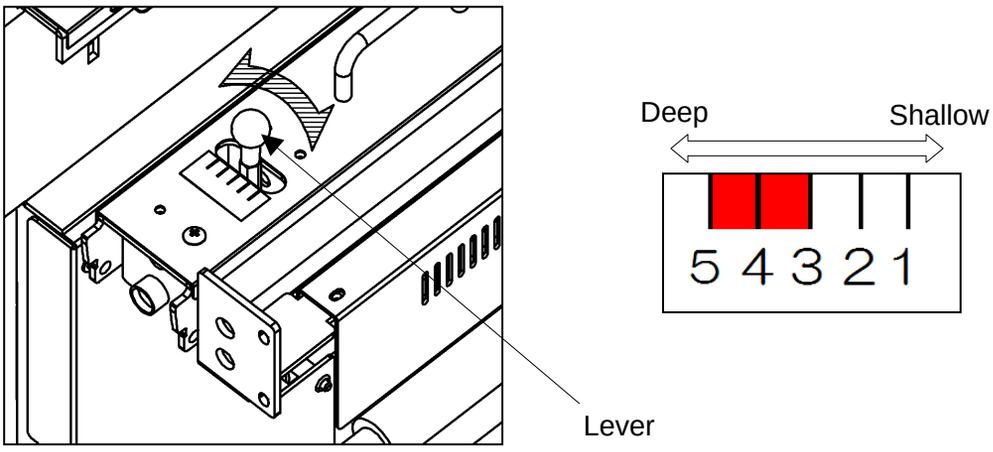
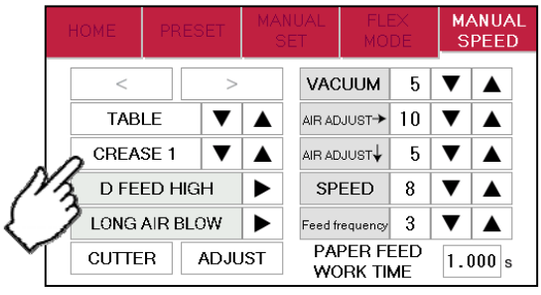
## 5.5 Creaser adjustment

・Turn the lever shown in the drawing below to adjust the crease depth.




・If creasing pressure is not enough even the lever is adjusted, pressing CREASE1 button on MANUAL/SPEED screen and changing creasing mode to CREASE2 may help. CREASE2 mode enables the machine to cycle the creaser twice at creasing positions, which results in deeper creases.

Manual speed screen




Note.

Use less than 3 in case of creasing on heavier paper than 300 gsm to avoid paper jam.

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.

## 5.6 Fine adjustments on processing positions

### 5.6.1 In case cutting positions don't match to image positions.

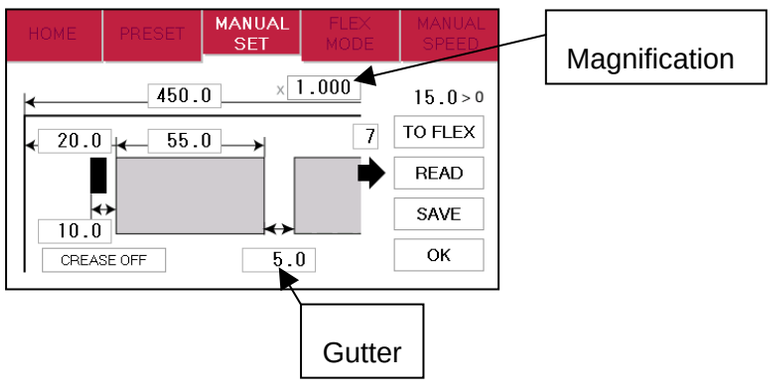
① Make sure the original sheets are printed correctly and consistently.

② Ensure that image positions correspond to input data.

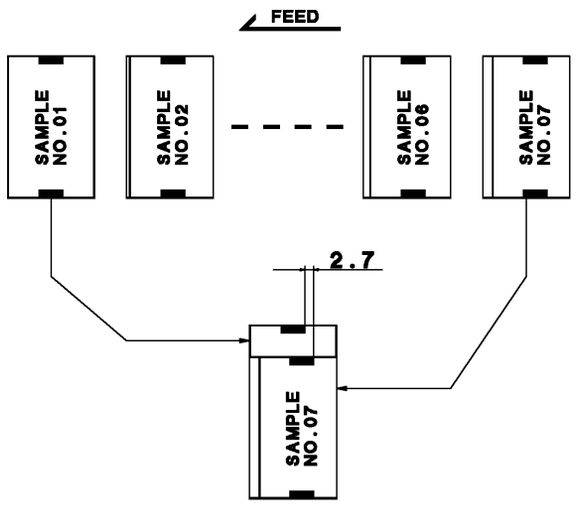
⇒If it does not, amend input values so that they correspond to image positions.

③ If the cutting position shifts along feeding direction, input a value on micro adjustment according to below picture.

MANUAL SET screen




In case cutting positions shifts toward the lead edge.




If the image position moves as the left drawing, increase the width of gutter.

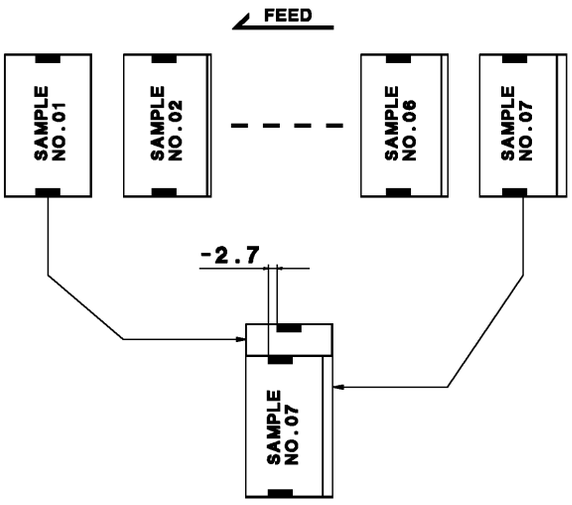
Measure the difference of images between first card and the last card.

Revised values can be calculated by dividing the difference by number of gutters.

EX：

In case the gap is 2.7mm and there are 6 gutters between cards, a gap per gutter is 2.7÷6=0.45mm. Since the machine allows to input 1/10mm, omit the figures below the second decimal place add 0.4 to the gutter size. To compensate 0.05mm difference and fine tune the cutting quality, input (card size 55 + gutter size 5.4 + Remained gap 0.05) / (card size 55 + gutter size 5.4) = 1.001 (*roundup the fifth decimal place) to Magnification setting.

In case cutting positions shift towards the trailing edge.




If the image position moves as the left drawing, decrease the width of gutter.

Measure the difference of image between first card and the last card.

Revised values can be calculated by dividing the difference by number of gutters.

EX :

In case the gap is -2.7mm and there are 6 gutters between cards, a gap per gutter is -2.7÷6=-0.45mm. Since the machine allows to input 1/10mm, omit the figures below the second decimal place subtract 0.4 from the gutter size. To compensate 0.05mm difference and fine tune the cutting quality, input (card size 55 + gutter size 4.6 + Remained gap -0.05) / (card size 55 + gutter size 4.6) = 0.999 (*roundup the fifth decimal place) to Magnification setting.

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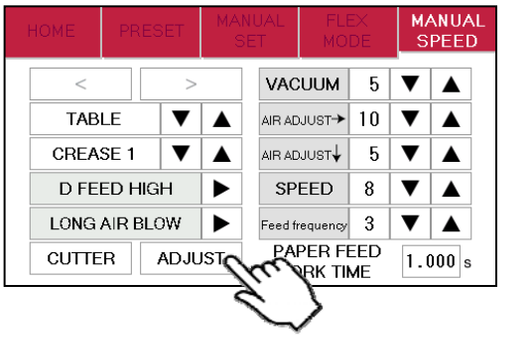
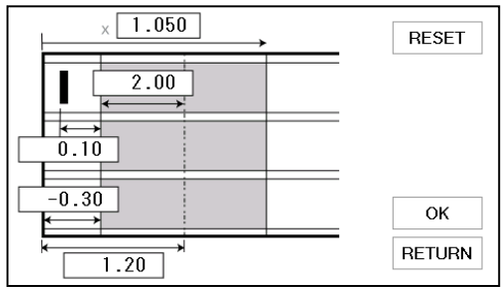
### 5.6.2 If the cut measurement does not match the input value

If the actual size and measurements of output differs from input values, calibrate the machine via ADJUST screen.

Manual speed screen




ADJUST screen




| | |
|---|---|
| RESET | Reset the machine to the factory setting, all the adjusted values will be 0. |
| OK | Save the adjusted values and go back to Manual speed Screen. |
| RETURN | Go back to manual speed Screen without making any changes. |

① In case the length of leading edge is wrong:

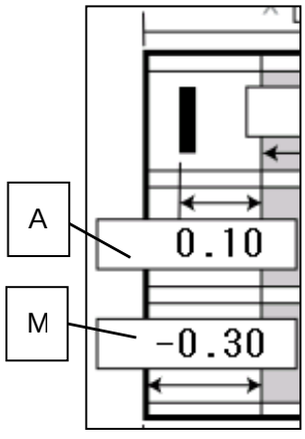
<u>With cut mark</u>

Input the difference between inputted value and actual measurement into A.

EX:

In case input value is 10mm and cut measurement is 9.9mm, input +0.1 to A.

（You can input ±10.00mm at the most）



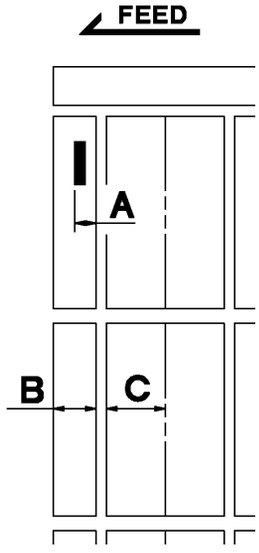

<u>Without cut mark</u>

Input the difference between inputted value and actual measurement into B.

EX:

In case input value is 20mm and cut measurement is 20.3mm, input -0.3 to B.

（You can input ±10.00mm at the most）

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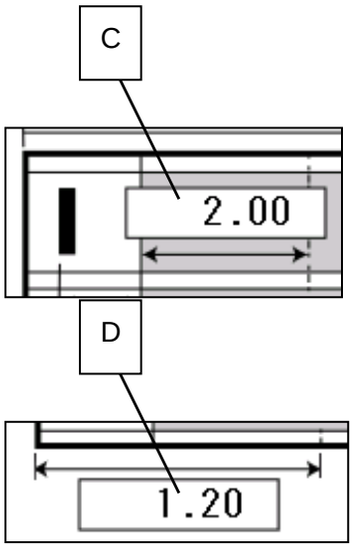
② In case creasing position is incorrect

Input the difference between inputted value and actual creasing position into C.

EX:

In case input value is 50mm and the actual creasing position is 48mm length, input +2.0 to C.

（You can input ±10.00mm at the most）



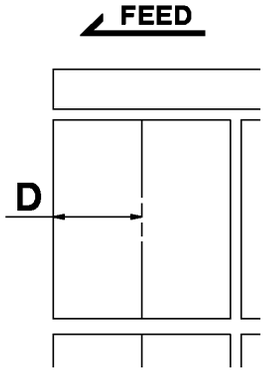

③ When the job has no cut prior to crease, and creasing position is incorrect.

Input the difference between inputted value and actual creasing position into D.

EX:

In case input value is 50mm and the actual creasing position is 48.8mm length, input +1.2 to D.

（You can input ±10.00mm at the most）




④ Others

<u>In case you amend the value according to expansion or contraction of printing.</u>

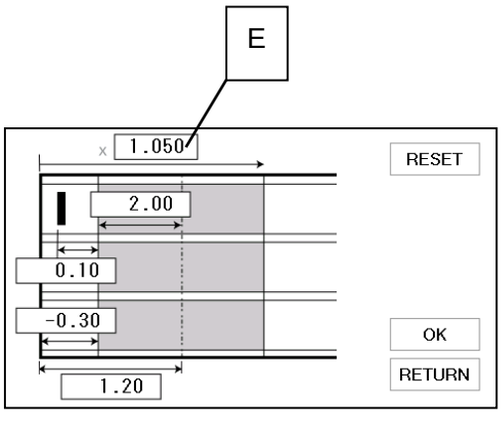
Input magnification into L if the printing is stretching to the feed direction.

Please note that changing magnifications results in changing actual measurements of outputs.

EX:

If printing should be 100mm width, but actual printing is 105mm, input 1.050 (105/100) into E.

（”E” must be from 0.500 times to 2.000 times.）



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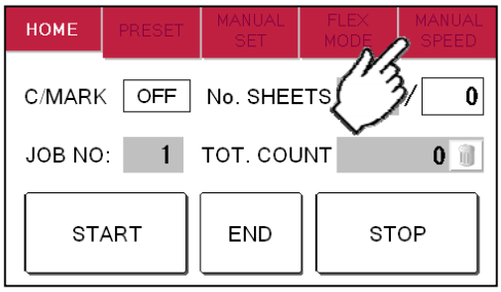
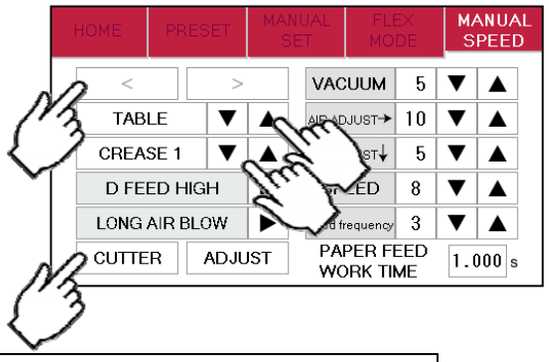
# 6 Manual control

## 6.1 Manual control screen

Home screen




Manual speed screen



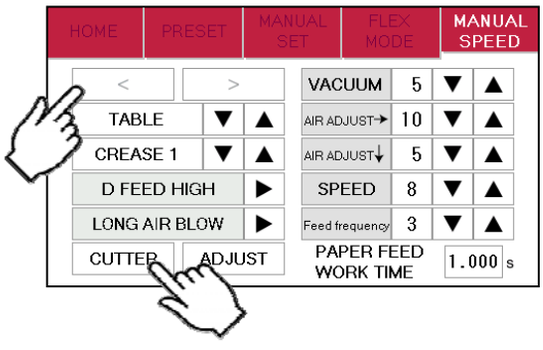

| | |
|---|---|
| < | Feed roller will rotate.<br>Inching. |
| > | Feed roller will rotate in reverse.<br>Inching. |
| CUTTER | Guillotine will move once. |
| CREASE 1 ▼ ▲ | Crease will move. |
| TABLE ▼ ▲ | Feed table will move. |

## 6.2 Paper jam

① Enter Manual speed screen, press [<] [>] buttons to inch the rollers forward / backward and remove the jammed paper.

② If paper is stuck around the guillotine section, press [CUTTER] to cycle the guillotine to chop jammed paper.

Manual speed screen

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# 7 Error messages

1.


Cover open error

Safety cover (☞ Page 8) might be open.

Make sure to close the Safety cover

2.


Time out error 1

Paper was not fed within a set time period.

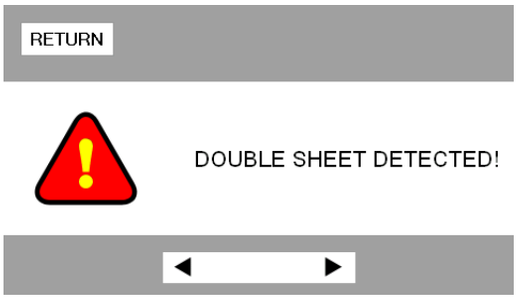
Check the paper feeder.

3.


Time out error 2

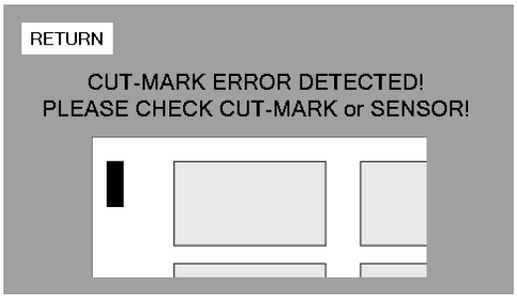
Paper did not pass through within a set time period.

Remove the paper remaining inside the machine.

4. 


Double sheet error

Check the paper or paper path.

5. 


Cut-mark error

Cut-mark was unable to be detected.

Check the cut mark.

Eject the paper inside the machine.



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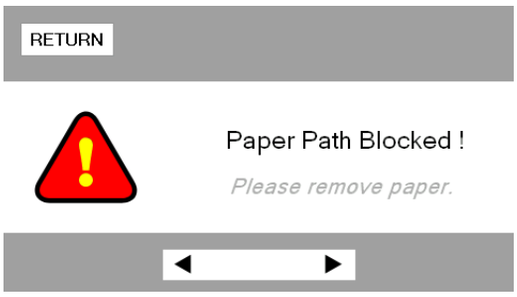
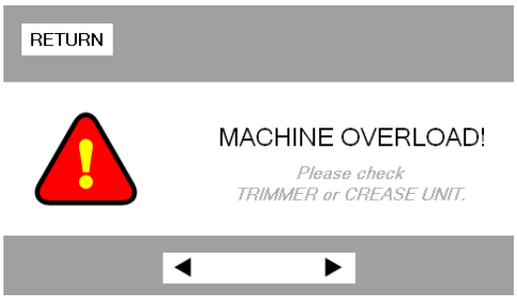
6.




Paper path blocked error

Paper remains inside the machine. Remove the paper.

7.




Machine overload error 1

Cutting or creasing did not complete within a set time period.

Remove the paper remaining inside the machine.

8.

Machine overload error 2

An overloading error occurred at the feed table.

Check the feed table.

9.

Update message

This error message appears as a warning when proceeding to another screen without saving the corrected dimensions in the MANUAL SET or FLEX MODE screen. Press OK if you want to proceed to the other screen; otherwise, press RETURN.

10.

Communications error

Communication with the touch screen is not possible.

Turn off the power, and turn it on again after 5 seconds or longer.



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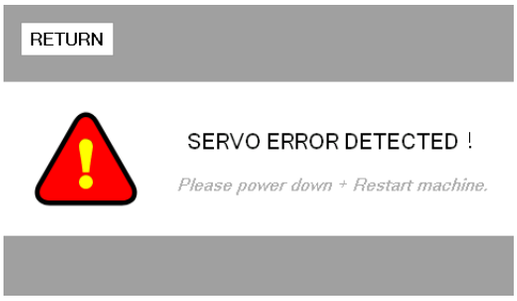
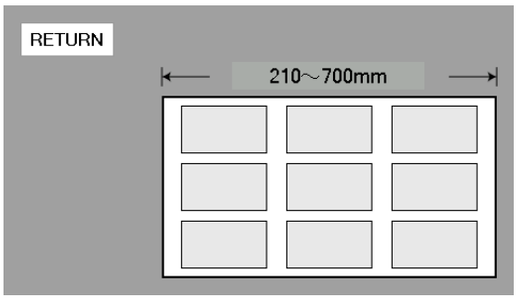
11.




Servo error

Servo error detected. Turn off the power, and turn it on again after 5 seconds or longer.

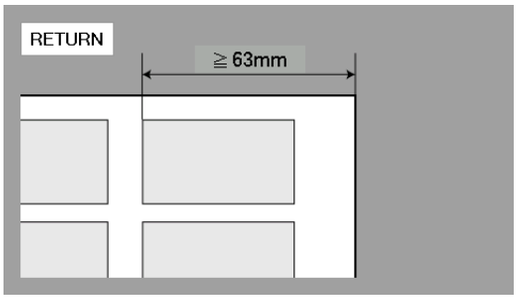
12.




Paper size error

Correct the paper size to fit in the value range below.

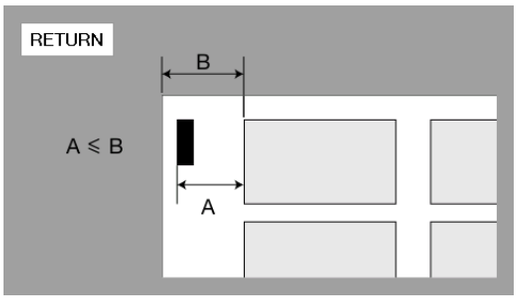
13.




Final cutting measurement error

Correct the final cutting measurement to exceed the value specified below.

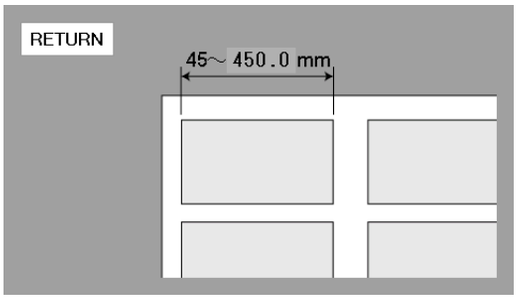
14.




Leading edge margin and cut mark margin warning

Correct the measurement so that the leading margin becomes larger than the cut mark margin.

15.




Cutting measurement error

Correct the cutting measurement to fit in the value range below.

The maximum value is subject to change depending on the entered paper size.



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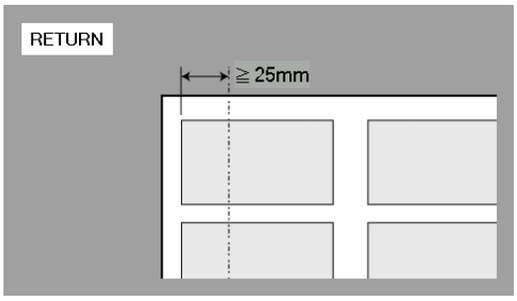
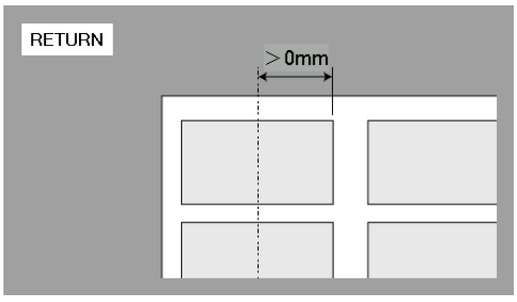
16.




Crease front margin error

Correct the crease front margin to exceed the value specified below.

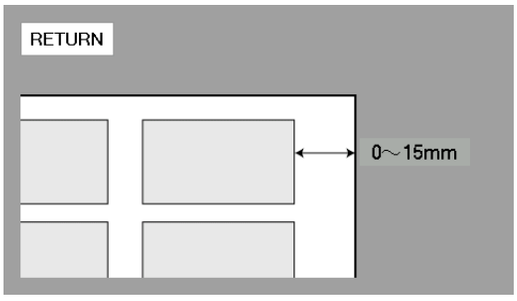
17.




Crease back margin error

Correct the crease back margin to exceed the value specified below.

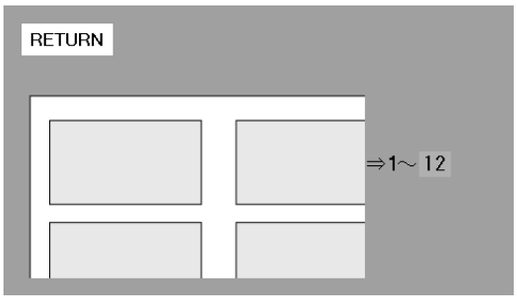
18.




Back margin error

Correct the back margin to fit in the value specified below.

19.

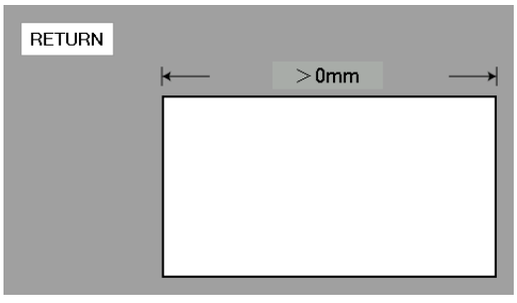



Cut piece number error

Correct the number of cut pieces to be in the value range below.

The maximum number of pieces is subject to change depending on the operation.

20.




FLEX MODE input error 1

This error results when the three input values shown in the following figure are “0” or lower at FLEX MODE time.



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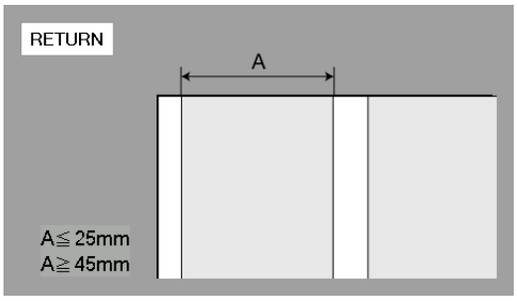
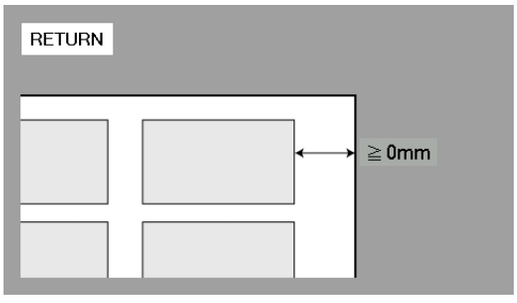
21.




FLEX MODE input error 2

Make sure for the first cut line must be 20.00mm or shorter from the edge of the paper. If you want to cut off 20.00 mm or more, please cut off 20.00mm or less at first and then cut off again and again. If you try to move the slitter cut line at 47.00 or more position, the slit will be ejected on Paper ejection table instead of waste box.

22.

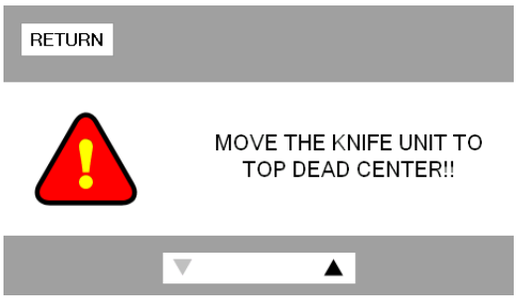



FLEX MODE input error 3

Back margin error.

Correct the back margin to fit in the value specified below.

23.

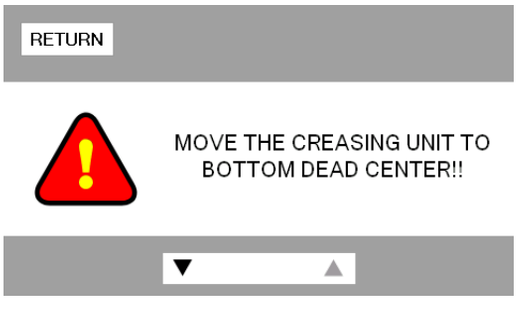



Guillotine error

The cutter blade has moved and is staying at lower position.

Move the cutter to top dead center.

24.

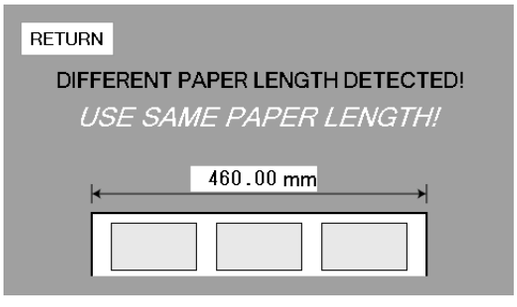



Crease error

The creaser has moved and staying at upper position.

Move the creaser to bottom dead center.

25.




Different paper length error

The machine detected longer paper than the first sheet. Please remove the paper inside machine.



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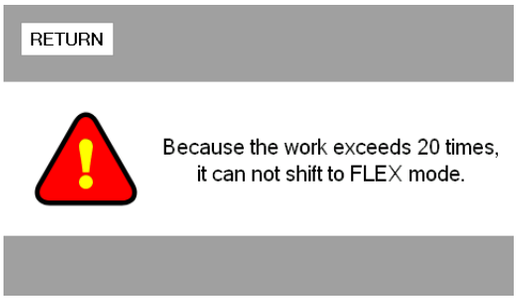
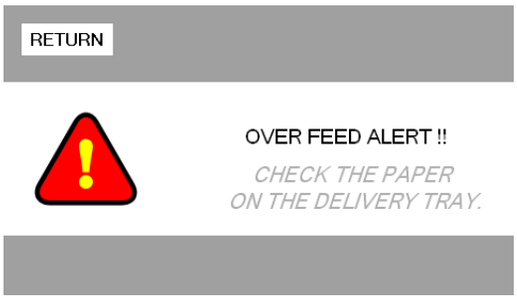
26.




FLEX MODE Shifting alert

Since there are over 20 steps, the job cannot be run at FLEX MODE.

27.




Over feed alert

More sheets than set number has been delivered. Please check the outputs on delivery tray.

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# 8 Troubleshooting

1. Papers are not fed well.
   - Turn up Upper suction (☞ Page 33)
   - Turn up Side blow (☞ Page 34)
   - Shorten the PAPER FEED WORK TIME. i.e. less than 1.0 (☞ Page 34)
   - Check if the paper guides on the feed table hold sheets too tight.
   - Make sure that the paper edges are not curled or waved.
   - Make sure that the papers are not heavily electric static charged.

2. The machine feeds double-sheets.
   - Turn down Upper suction (☞ Page 33)
   - Turn up Lower suction (☞ Page 33)
   - Turn up Side blow (☞ Page 34)
   - Make sure that the papers are not heavily electric static charged.
   - Lengthen the PAPER FEED WORK TIME. i.e. 2.0 (☞ Page 34)

3. The machine doesn't detect double-feed properly.
   - The machine detects the density of the first fed sheet and compares the density of the next sheet to the first one. Therefore, the machine cannot detect double-feed when it occurs with the first fed sheet.
   - Adjust the sensitivity of the double-feed detection sensor. (☞ Page 35)
   - The detection sensor detects double feed by checking the edge of sheets as shown on the drawing. It is recommended not to print on the sheet edge. (☞ Page 35)

4. The machine detects double-feed mistakenly.
   - Adjust the sensitivity of the double-feed detection sensor. (☞ Page 35)
   - The detection sensor detects double feed by checking the edge of sheets as shown on the drawing. It is recommended not to print on the sheet edge. (☞ Page 35)

5. Cut skewing

   ① Make sure that the stock is put on the feed table correctly. (☞ Page 16)

   ② Check whether the skewings are consistent or inconsistent.

   If skewings are consistent :

   + Make the skewing adjust via the skew adjustment dial. (☞ Page 36)
   + Set the paper guides without play.

   Do not set them too tight as the sheet may not be fed well.

If skewings are inconsistent :

+ Turn down Side blow. (☞ Page 34)
+ Shorten the PAPER FEED WORK TIME. i.e. less than 1.0 (☞ Page 34)
+ Make sure that the sheets are printed consistently and aligned well.

6. Paper jam often occurs.

- Make sure that papers, paper strips or paper dusts not remain inside of the machine.
- Check the conditions of the paper stock.(☞ Page 12)

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# 9 Product specifications

| Specifications | |
|---|---|
| Slitter | 4 sets (6 slitter blades) |
| Guillotine | 1 set |
| Creser | 1 set |
| Maximum paper size | 330mm x 490mm(Option 700mm) |
| Minimum paper size | 210mm x 210mm |
| Minimum work size | 85mm x 50mm |
| Paper weight | 120-350g/㎡ (Depending on paper) |
| Maximum paper curl size | ±3mm |
| Paper type | Offset, Coat, UVcoat, Glossy, Laminate<br>(Depending on paper) |
| Paper feeding method | Upper belt air suction feeding mechanism |
| Input tray capacity | MAX100mm |
| Speed | 5,000 sheets per hour (Depending on paper)<br>(1 Crease from A4SEF) |
| Machine dimensions [mm] | W850xD754xH1082 (Depends on configuration) |
| Net weight | 200kg (Depends on configuration) |
| Power supply | Single phase 200- 240VAC, 50/60Hz, |
| Power consumption | 400W |

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