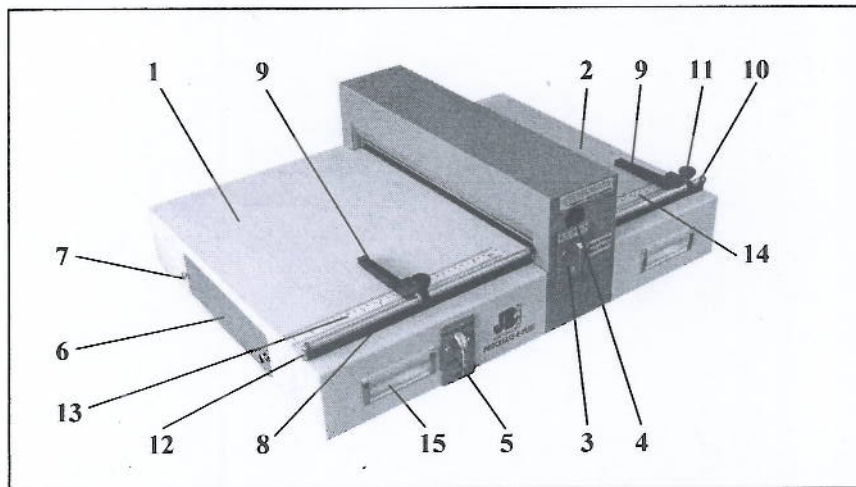


1. Product Introduction

Procrease-E-Plus Automatic Creasing-Perforating Machine is a new concept multi-function professional equipment combined with many creasing/perforating functions. It can deal with most daily creasing/perforating operations on papers and films. It's using highly reliable energy-saving motor, which can fulfill high load works. It can keep working continuously. It has professional patent design on special clutch drivers mode. Its maintenance-free transmission system is highly reliable and has many different standard quick changing independence blade systems, which will make your operation easier. This machine is easy to handle, very reliable, high quality and durable.

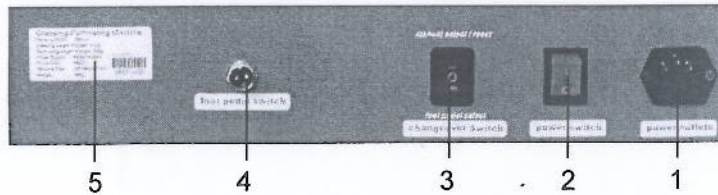
2. Components Names

Machine Structure



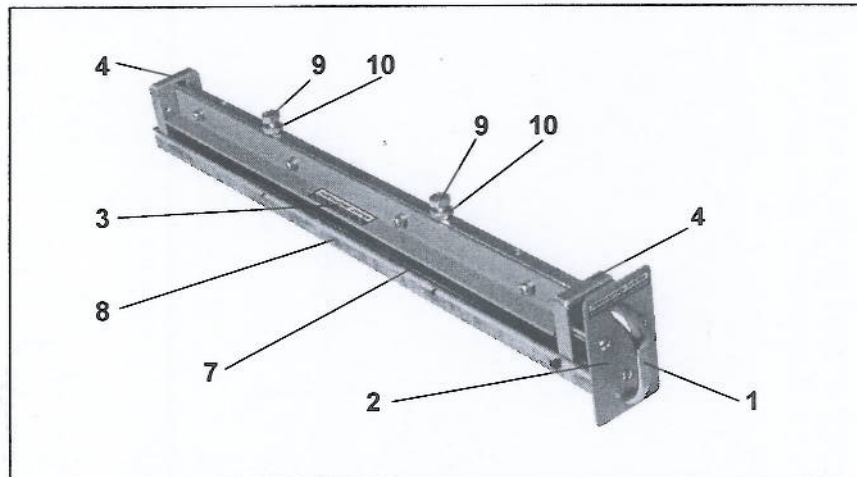
- | | | |
|-------------------------------------|----------------------------|----------------------------|
| 1. Left Operation Panel | 2. Right Operation Panel | 3. Blade Installation Slot |
| 4. Jammed Reversing System | 5. Blade Storage Slot | |
| 6. Attached Tools Storage Box Cover | 7. Storage Box Fix Screw | |
| 8. Fixed Position Vernier | 9. Moving Position Vernier | |
| 10. Vernier Rail | 11. Vernier Lock | 12. Vernier Bracket |
| 13. Left Position Ruler | 14. Right Position Ruler | 15. Lift Handle |

Operation Panel



- | | |
|-----------------------------------|----------------------------|
| 1. Power Jack with Fuse | 2. Power Switch with Light |
| 3. Operation Mode Changing Switch | 4. Step Switch Jack |
| 5. Machine Data Board | |

Blade System



- | | |
|-----------------------------|-------------------------------|
| 1. Blade Handle | 2. Blade Cover |
| 3. Blade Standard Label | 4. Blade Support System |
| 5. Pressing Spring | 6. Creasing/Perforating Blade |
| 7. Creasing/Perforating Pad | 8. Blade System Bracket Pad |
| 9. Press Adjust Screw | 10. Press Adjust Lock Screw |

3. Components List

| No. | Name | Qty. | Notes |
|-----|----------------------------|------|---------------------------------------|
| 1 | Procrease-E-Plus Machine | 1 | |
| 2 | Creasing Blade System | 1 | Installed |
| 3 | Perforating Blade System | 1 | Installed in the Storage Slot |
| 4 | 10mm Hexagon Sleeve | 1 | Inside Machine's Tools Storage Box |
| 5 | 10mm Hexagon Wrench | 1 | |
| 6 | 5mm T-shape Hexagon Wrench | 1 | |
| 7 | Cross Screw Driver | 1 | |
| 8 | Power Line | 1 | |
| 9 | Step Switch | 1 | |
| 10 | User Manual | 1 | |


4. Installation Instructions

Installation Location

- ★ Before the installation, please make sure the machine will be installed on an appropriate operation table and have enough space for operation.
- ★ Please avoid the following situation when choosing the installation location:
 - Avoid direct sunshine
 - Bad for ventilating
 - High temperature and humidity
 - Close to the AC's cool or heat
 - Dusty or strong vibration
 - Uneven or unstable

Installation Method

- Open the package, pull the bands to take out the machine from the box and put the machine stably.
- Take off all the transportation fix.
- Take out the step switch attached in the box and plug it into the jack on the machine, then lock it with the nut. Put the step switch on the floor.

When plug the step switch into the jack on the machine, please  **Caution:** make the plug aim to the jack then plug it inside, to avoid any damage to the plug

- Take out the power line attached in the box and plug it into the jack on the right of the machine, then confirm whether the power voltage is suitable for the machine.

5. Safety Notes



Danger!

- Please DONNOT put your hand or body into machine's paper entrance after connected to power.
- During the operation, please DONNOT put your side items like tie, hair or necklace into the machine's paper entrance to avoid any harm.
- Please avoid children close up the machine to avoid any harm.



Caution!

According to the different blade system, our creasing/perforating machine's normal running range for creasing is between 0.09-0.65mm and for perforating is lower than 0.5mm. Please DONNOT operate with the machine beyond the running range to avoid any damage to the creasing knife or transmission system. Please maintain and clean the machine frequently to make the machine be long time serviceable.

If any damage was appeared by any beyond running range operation, we are sorry that will not be our repair guarantee.



Please stop all the works before move the machine or open the machine up to repair.

The connector plug MUST be pull out.

6. Operation Instructions



Please read the user manual carefully before you start to use this creasing machine



Please plug the machine's power line in the socket



Please make sure the operator is beside when machine is working

6.1 Creasing Operation Instructions

 Important Note:

Using the suitable creasing blade system according to the thickness of the paper to make the perfect creasing effect. If the creasing blade system is not suitable for the paper may cause bad creasing effect or even damage the creasing blade system.

Recommended Creasing Operation Data:

| Blade Sys No. | Paper Thickness | Blade Thickness | Creasing Width | Creasing Depth |
|---------------|-----------------|-----------------|----------------|----------------|
| C46-A | <0.36mm | 0.71mm | 1.3mm | 0.4mm |
| C46-B | 0.30-0.45mm | 0.71mm | 1.6mm | 0.5mm |
| C46-C | 0.40-0.50mm | 1.07mm | 1.7mm | 0.6mm |
| C46-D | 0.45-0.55mm | 1.07mm | 2.3mm | 0.7mm |
| C46-E | 0.50-0.65mm | 1.42mm | 2.7mm | 0.8mm |

Note: The Creasing Blade System attached with the machine is C46-B.

- Plug in, turn on the machine, make sure the red power indication light on.



Caution: Before the operation, please confirm the blade system you are using is the best choice for the paper first, otherwise, please choose another system.



- Turn the switch to "1", the machine is under manual mode, the machine will finish one punch by a single touch on the switch, then the machine will reset automatically.
- Turn the switch to "0", the machine is standby.
- Turn the switch to "2", the machine is under automatic mode, the machine will finish one punch by a single step on the step switch.



Suggestion: We suggest you to turn the switch to "2" for automatic mode.

- Make sure the position and size of the creasing first, if only one piece of creasing is needed, fix the position of left-side Slide Positioning Model according to the creasing size.
- If two piece of creasing is needed, i.e. book spine creasing and reading creasing make sure the position of book spine creasing first, move the right-side Slide Positioning Model to that position and fix, then move the left-side Slide Position model to correct position and fix according to the reading creasing size and position.



When moving the Slide Positioning Model, please hold its head up and move the model parallelly. Please don't move when its head on the vernire, in case any damage occurred to the model suit or vernire.



When moving the Slide Positioning Model to the needed position, please push its head there, and fixed the screws manually, then the model is fixed there, in case the creasing position is not exact.

- When the Slide Positioning Model is fixed in the need position, put down the creasing papers from Mechanism core protection cover and rely it on the fixed Slide Positioning Model back side
- If only one piece of creasing is needed, move the paper rightward, and rely it on the fixed right-side Slide Positioning Model right side. Step onto the step switch, wait until the machine stops and take out of creasing paper. Creasing is ready
- If two piece of creasing is needed, move the paper rightward first, and rely it on the fixed right-side Slide Positioning Model right side. Step onto the step switch, wait until the machine stops and then move the paper leftward, rely it on the left-side Slide Positioning Model left side. Step onto the step switch again, wait until the machine stops and take out of creasing paper. Creasing is ready

6.2 Perforating Operation Instructions



Important Note:

Using the suitable perforating blade system according to the thickness of the paper to make the perfect perforating effect. If the perforating blade system is not suitable for the paper may cause bad perforating effect or even damage the perforating blade system.

Recommended Perforating Operation Data:

| Blade Sys No. | Paper Thickness | Teeth Per inch | Teech Width | Teech Disdance |
|---------------|-----------------|----------------|-------------|----------------|
| P46-A | <0.30mm | 16:1 | 0.8mm | 0.8mm |
| P46-B | <0.35mm | 12:1 | 1.4mm | 0.7mm |
| P46-C | <0.40mm | 10:1 | 1.2mm | 1.2mm |
| P46-D | <0.45mm | 8:1 | 2.0mm | 1.0mm |
| P46-E | <0.50mm | 6:1 | 3.0mm | 1.0mm |

Note: The Perforating Blade System attached with the machine is C46-B.

- Plug in, turn on the machine, make sure the red power indication light on.



Caution: Before the operation, please confirm the blade system you are using is the best choice for the paper first, otherwise, please choose another system.



- Turn the switch to "1", the machine is under manual mode, the machine will finish one punch by a single touch on the switch, then the machine will reset automatically.
- Turn the switch to "0", the machine is standby.
- Turn the switch to "2", the machine is under automatic mode, the machine will finish one punch by a single step on the step switch.



Suggestion: We suggest you to turn the switch to "2" for automatic mode.

- Make sure the position and size of the perforating first, if only one piece of perforating is needed, fix the position of left-side Slide Positioning Model according to the perforating size.
- If two dotted lines are needed, make sure the position of the first dotted line, move the right-side slide positioning model to that position and fix, then move the left-side slide position model to the second dotted line position and fix.




When moving the Slide Positioning Model, please hold its head up and move the model parallelly. Please don't move when its head on the vernire, in case any damage occurred to the model suit or vernire.








When moving the Slide Positioning Model to the needed position, please push its head there, and fixed the screws manually, then the model is fixed there, in case the creasing position is not exact.

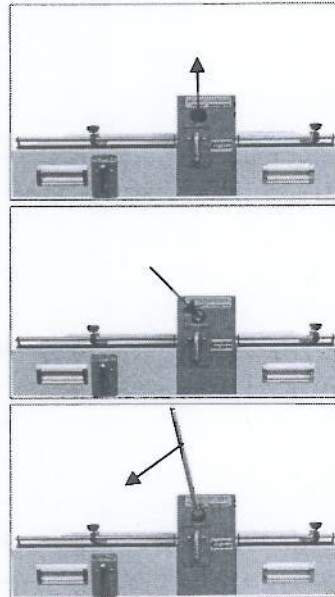
- When the Slide Positioning Model is fixed in the need position, put down the creasing papers from Mechanism core protection cover and rely it on the fixed Slide Positioning Model back side.
- If only one piece of perforating is needed, move the paper rightward, and rely it on the fixed right-side Slide Positioning Model right side. Step onto the step switch, wait until the machine stops and take out of perforating paper. perforating is ready.
- If two piece of perforating is needed, move the paper rightward first, and rely it on the fixed right-side Slide Positioning Model right side. Step onto the step switch, wait until the machine stops and then move the paper leftward, rely it on the left-side Slide Positioning Model left side. Step onto the step switch again, wait until the machine stops and take out of perforating paper. Perforating is ready.

7. Troubleshooting


 If the following glitches appeared during your operation, please stay calm and follow the following instructions to fix the glitches. If the glitches remain or other glitches appear, please find a professional maintenance person.

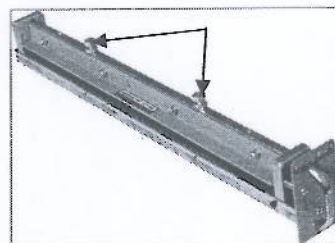
7.1 Paper jammed during the operation:

-  Please turn off the machine immediately. This may be caused by putting thick paper which beyond the max working thickness of the machine.
-  Take the Jammed Reversing System cover (on the blade system cover) off.
-  Put the Hexagon Sleeve (inside the tools storage box, on the left side of the machine) onto the transmission pole (with the square side).
-  And then put the Hexagon Wrench into the Hexagon Sleeve.
-  Turn counterclockwise by about 90 degrees, the jammed paper can be taken out. Take the Hexagon Sleeve and Wrench off, put the transmission system cover back, turn on the machine and continue the operation.



7.2 Unbalanced creasing/perforating effect:

-  Take the blade system out, unlock the press adjust lock screw on the shallow side of the creased/perforated paper, adjust the press adjust screw counterclockwise, then lock the press adjust lock screw and put the blade system in and try the creasing/perforating again. If the effect is still unbalanced, please repeat the steps above and adjust the blade system again until the effect of the creasing/perforating is perfect.

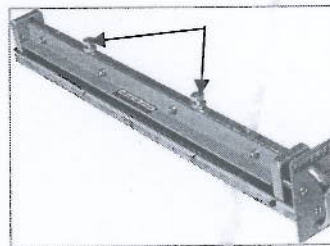




Caution: The pressing effect of the blade system has been adjusted to the best. There is no need to adjust it under normal operating. If the unbalanced effect is appeared, every time's adjustment cannot turn the press adjust screw over 90 degrees. Otherwise, it may cause the machine jammed. If the machine is jammed, please repeat the troubleshooting step 7.1, then readjust the blade again.

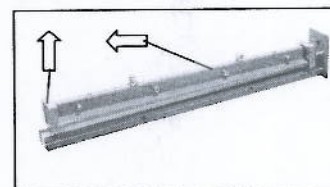
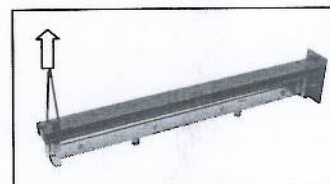
7.3 Perforating effect makes paper break:

- ★ Take the blade system out, unlock the press adjust lock screw on the shallow side of the creased/perforated paper, adjust the press adjust screw counterclockwise, then lock the press adjust lock screw and put the blade system in and try the creasing/perforating again. If the effect is still unbalanced, please repeat the steps above and adjust the blade system again until the effect of the creasing/perforating is perfect.



7.4 Uneven perforating effect:

- ★ Changing perforating pad is necessary. Take the blade system out, loose the 2 hexagon screws on the bottom of the blade system back by the Hexagon Wrench.
- ★ Take the Blade Support System on the back off, then take the blade shelf off. Loose the 2 hexagon screws on the left side of the blade system support pad.
- ★ Take the perforating pad off from the blade system support pad, then turn the bottom side of the perforating pad over and put it back into the blade system support pad on the same place.
- ★ Reinstall the blade system and put it back to the machine and the machine is ready for operation.





- Caution:**
1. When turn the bottom side of the perforating pad over, please keep the surface of the perforating pad and blade system support pad flat, then screw the 2 hexagon screws on the left side of the blade system support pad tight.
 2. The perforating pad is consumables and not included in the warranty.
 3. Screw the 2 hexagon screws on the bottom of the blade system back tight, but not too hard. That can avoid the possible damage to the blade system support pad.

8. Maintenance Notes

- If the next operation will be operated after a long time, please shut down the machine to save power and make the machine be long time serviceable.
- After every operation finished and shut down the machine, please clean the surface of the machine up. Especially clean the operation panel up to avoid any granule inside the machine, which may cause any damage to the machine.
- Drop some lubricating oil onto the two mandrils and axletree connecting position to ensure the smooth running of the mechanism every week.

9. Technical Parameter

| Function/Model | PROCREASE-E-PLUS |
|-----------------------|--|
| Max Working Width | 460mm |
| Max Working Thickness | 0.09-0.65mm(Creasing)/0.5mm(Perforating) |
| Working Speed | 1800 times/hour |
| Working Noise | 50-55Db(A) |
| Power Supply | AC220V/50Hz |
| Power | 150W |
| Machine Size | 700×560×230mm |
| Machine Weight | 38.8kg (including two blade systems) |