1. Control section
1) This section consists of control panel, digital screen, key of “confirm”, “+”, “-”, etc.
2) “Txx” on the digital screen indicates the environmental temperature before heating.

2. Setting of temperature controller
1) Press the key of “ok”, video indicates setting temperature, then adjust the temperature to around 150 by pressing “+”, “-”.
2) Seconds after finishing setting, the showing temperature
will back to current temperature and show “HXX” . In the meantime , relay pick-up and glue box start heating , the showing temperature rise gradually and up to the setting 150° during 15-20 minutes. The relay close at this moment . Showing temperature continue to rise then go down gradually till 1-3° under the setting , the relay pick-up and heating again. Time after time , the temperature of melting glue can be maintained . The key “ok ” should be pressed if temperature need remain the

<table>
<thead>
<tr>
<th></th>
<th>Phenomena</th>
<th>Reason</th>
<th>Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Indicate:ER-01</td>
<td>Thermal Tube Malfunction</td>
<td>Replace thermal tube</td>
</tr>
<tr>
<td>2</td>
<td>Indicate:er-02</td>
<td>Thermal couple malfunction</td>
<td>Replace thermal couple</td>
</tr>
</tbody>
</table>

3. Turn on the machine after setting same.
Thanks for choosing binding machine. For operation easily and better binding result, now promote new model of 4 machine, it is binding, creasing, cutting perfect all in one. Please read operation manual carefully before operate. If any problem else, please contact supplier.

<table>
<thead>
<tr>
<th>Model</th>
<th>Milling cutter</th>
<th>Temperature controller</th>
<th>Hardback setting</th>
<th>Creasing setting</th>
</tr>
</thead>
<tbody>
<tr>
<td>RD-JB-2</td>
<td>✓</td>
<td>✓</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RD-JB-3</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
<td></td>
</tr>
<tr>
<td>RD-JB-4</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>RD-JB-5</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
</tbody>
</table>

List

- List ................................................................. 1
- Packing list and installation ................................. 2
- Precautious ...................................................... 2
- Operate parts ..................................................... 3
- Operation manual(soft cover) ................................. 4
- Operation manual(hard cover) ................................. 8
- Adjustment of gluing roller ................................. 11
- Adjustment of milling blade ................................. 12
- Using of creasing setting ................................. 13
- Using of hard back setting ................................. 14
- Malfunctions, causations and solution ...... 16
Binding Machine Packing list Installation and Precautions

Packing list

1. 1 unit of machine
2. 1 set of soft cover template
3. 1 pcs of cable
4. 1 pcs of cross screw-driver
5. 1 pcs of M5 hexagonal socket spanner
6. 1 operate manual
7. 1 bag of glue

Installation

Please put this machine onto a stable worktop, avoid approaching any humidity. Certain space should be kept to operate the machine.

Precaution

1. Connect to the specified power supply (220V/50Hz or 110V/60Hz). Open glue box cover, put in the solid glue. Note: A. The glue should be clean and without any sundries. B. Regularly add the glue particles into the glue box according to glue slurry consumption. Thus a proper amount of glue slurry can be continuously supplied.

2. Turn on the switch, the glue to be heated under 170 degree about 15-20 minutes. During heating, don’t move the glue box to avoid damage. Pay special attention to avoid the glue box touching hard thing during operating.

3. Make sure the template on the machine is accordant to the cover of binding file. (e.g. soft cover matches soft cover template and hard cover file matches hard cover template)

4. Put the paddle on “N” position.

5. During the installation, if the gluing roller on the glue box is not parallel to the spine of the binding book, please adjust it according to “Adjustment of the gluing roller” section in this manual. (page 11)

6. Milling cutter’s position can be adjusted by adjusting four screws. (page 12)
1. Press the handle and draw out the paper Pressurer

2. Put the cover in-between the paper pressurer and platform, and keep it close to the localizer. The platform could be raised so that the cover could be easily placed.

3. Put the paper in-between the cover and paper pressurer, piling it up neatly.
4. Push the paper pressurer down against the paper and rotate the handle up, locking the paper in as the picture shows.

5. Press paddle down to “DN” position, so that a crease can be made on the bottom cover. And then push paddle back to “N” position.

6. Push paddle to “UP” position, rotate the platform upwards and make sure the bottom side of files is flat.
7. Push the milling cutter back and forth on the bottom side of files

8. Gelatinize by moving glue box

9. After gelatinizing, immediately draught the back cover slightly by left hand, press the paddledown to “N” position by right hand, and then to “DN” position, sustaining for around 6--8 seconds.
10. Push the paper pressurer down against the paper and rotate the handle up, turn the book to back face and put in again, sustain about 3 seconds

11. Press the handle down, draw the paper pressurer open, and take out the made-book. Cut the untidy edges of the book to neatly by the paper cutter
Before operation:
① Prepare the hard cover
② Replace the paper pressurer complied for hard cover and allocation shaft.
③ Allocate the operation handle to “N” position

1. Press the handle and draw out the paper pressurer.
2. Put the hard cover in-between the platform and paper pressurer. Adjust allocation shaft to press the hard cover against the front baffle tightly
3. Put two pieces of self-adhibit mount separately on two sides of the files, tidy them neatly, and then put them inside the hard cover. Keep them close to the allocation shaft, then push the handle
4. Push the paddle to “UP” position, rotate the platform upwards.

5. Push the milling cutter back and forth movement on the bottom side of files.

6. Press the back cover of hard cover close to platform document, gelatinize by moving glue box.
7. Draw the paddle back to “N” position and then press it to “DN” position for 2 seconds.

8. Draw out the paper pressurer, turn the book to back face and put in again, press the paddle down again to “DN” position for about 3 seconds.

9. Take out the made-files and tear the seal paper, back up the mount of the inside cover, and then make it smooth.
Adjustment of the gluing roller

Step 1

1. Place a piece of sheet (thickness: 0.8 mm, 320 mm x 60 mm) on the platform
2. Place pile of 25 mm—thickness paper on the right position of the binder.
3. Push clamp plate and lock it.
4. Upturn the rotating unit (Platform), until spine of book is upward.
5. Move the glue box after the glue is heated
6. Watch whether the glue roller is parallel to the spine of book
7. If not parallel, please adjust bolt (4) until they are parallel.

Step 2

8. Loosen the bolt (1) in picture B
9. Adjust bolt (3), until the roller touches the back surface of paper
10. Tighten the bolt (1)
11. Push the glue box to the other side
12. Loosen the bolt (2) in picture B
13. Adjust bolt (5), until the roller touches the back surface of paper
14. Tighten the bolt (2) in the picture B
15. Complete the steps as showed in picture 2 (as showed in the attached picture)
16. After finishing the adjustment, tack back the sheet, and place another pile of paper, glue it, and watch whether the glue is evened, otherwise more adjustment will be needed, following the same steps as above.
1. The milling depth can be adjusted by adjusting the depth adjusting bolt. Loose the adjusting bolts on milling blade, move the blade to suitable place, then tighten the bolt.

2. The milling range can be adjusted by adjusting the range adjusting bolt. Loose the adjusting bolt on blade, move the blade to suitable place, then tighten the bolt.
Using of marking setting

1. Creasing setting is one accessory of 4 there are four kinds of different blades, creasing blade, undeep blade, beeline blade and breakpoint blade.

2. As user demand, choosing blade for different paper binding effect.

3. Blade replacing, twist the blade knob, install right blade, then twist the blade knob back.

4. Adjusting paper position, press forcibly the blade cover and slip along the slide rail.
Using of hardback setting

1. Ready for hardback operation, take down the pressure plate A. (Image one)
2. Put the cover in between the pressure plate and platform, fix up it by the localizer. (Image two)
3. Put two sheets self adhesive head page as the first page and end page. (Image two)
4. Put the paper in between the cover and the plate against teh localizer. (Image two)
5. Piling the paper up neatly and overturn the platform, gelatinize two or three times by moving glue box, and the time is not more than six second. (Image three)
6. Put the fibrillar webbing on the gelatinized spine of a book, and put the cloth on the both book ends. (Image three)
7. Overturn the platform, press out the cover and the paper by the pressure plate, take out the book and press out the inverse side.
8. Take out the gelatinized book, rip off the release paper and put the self anhesive head page on the hardback cover smoothly. (Image four)
9. If there is tectorial cover, heating pressure for tighten binding, the operation as below:
   ① Install the heating pressure plate and switch on power
   ② Waiting for the red light on the plate is ok (Image five)
   ③ Press the gelatinized book 4 second by the heating plate.
   ④ Release the plate, take out the book and press out the inverse side. (Image six)
10. After heating pressure, the hardback book is OK.
## 1. Malfunctions, causations and solution

<table>
<thead>
<tr>
<th>Malfunctions</th>
<th>Possible causations</th>
<th>Solutions</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>I</strong></td>
<td>The glue box can’t be heated</td>
<td>1. the fuse of power source is burned</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2. <strong>The melting fuse tube is burnt</strong></td>
</tr>
<tr>
<td></td>
<td></td>
<td>3. the thermostat doesn’t work</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4. the electro heat tube is broken</td>
</tr>
<tr>
<td></td>
<td>1. the glue in the box is insufficient</td>
<td>Add glue</td>
</tr>
<tr>
<td></td>
<td>2. <strong>The gluing roller doesn’t rotate</strong></td>
<td>Fit the roller and tighten the bolt, don’t move the glue box until the temperature reaches to the point</td>
</tr>
<tr>
<td></td>
<td>3. the gluing roller doesn’t average distance to the spine of book</td>
<td>Adjustable the gluing roller</td>
</tr>
<tr>
<td></td>
<td>4. the pressure of gluing roller is insufficient</td>
<td>Adjust the gluing roller</td>
</tr>
<tr>
<td><strong>II</strong></td>
<td>The glue is not layed on evenly or insufficient</td>
<td>1. the glue in the box is insufficient</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2. <strong>The gluing roller doesn’t rotate</strong></td>
</tr>
<tr>
<td></td>
<td></td>
<td>3. the gluing roller doesn’t average distance to the spine of book</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4. the pressure of gluing roller is insufficient</td>
</tr>
<tr>
<td><strong>III</strong></td>
<td>It’s hard to move the glue box</td>
<td>1. the glue isn’t heated well</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2. some sundries is in the box</td>
</tr>
<tr>
<td></td>
<td></td>
<td>3. the glue slurry goes bad due to long idleness</td>
</tr>
<tr>
<td><strong>IV</strong></td>
<td>The spine of book is not well formed</td>
<td>1. <strong>The paper not neatly placed</strong></td>
</tr>
<tr>
<td></td>
<td></td>
<td>2. Too short time to push and press the cover template</td>
</tr>
<tr>
<td></td>
<td></td>
<td>3. Misuse the cover template</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4. The pressure of two ends of the cover template isn’t balanced</td>
</tr>
<tr>
<td><strong>V</strong></td>
<td>Poor fastness of binding</td>
<td>1. too slow gluing</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2. too slow or too short of pushing and pressing the cover template</td>
</tr>
<tr>
<td></td>
<td></td>
<td>3. poor quality of the glue</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4. wrong grain direction of paper</td>
</tr>
</tbody>
</table>