

SWIFT Multi



AUTO CREASER OPERATION MANUAL

INDEX

Chapter 1 INTRODUCTION.....	3
1.1 Preface	3
1.2 Specification	1
Chapter 2 SAFETY	2
2.1 Environment.....	2
2.2 Do's and Don'ts.....	2
2.3 Caution	3
Chapter 3 MAIN PARTS AND ASSIES.....	4
Chapter 4 FIRST INSTALLATION	5
4.1 Output tray, stops and guides	5
4.2 Feeding extension	5
4.3 Power socket and switch	6
Chapter 5 QUICK START	7
Chapter 6 OPERATION	9
6.1 Control panel	9
6.1.1 Keys and Screen	9
6.1.2 Function and operation	10
6.2 Hardware Setting	13
6.2.1 Skew adjustment	13
6.2.2 Crease depth	14
Chapter 7 OPTIONAL PARTS.....	16
6.1 Slid-in Tools	16
6.2 Linear blade	17
6.2.1 Installation	17
6.2.2 Notice	18
Chapter 8 TROUBLE SHOOTING	19

Chapter 1 INTRODUCTION

1.1 Preface

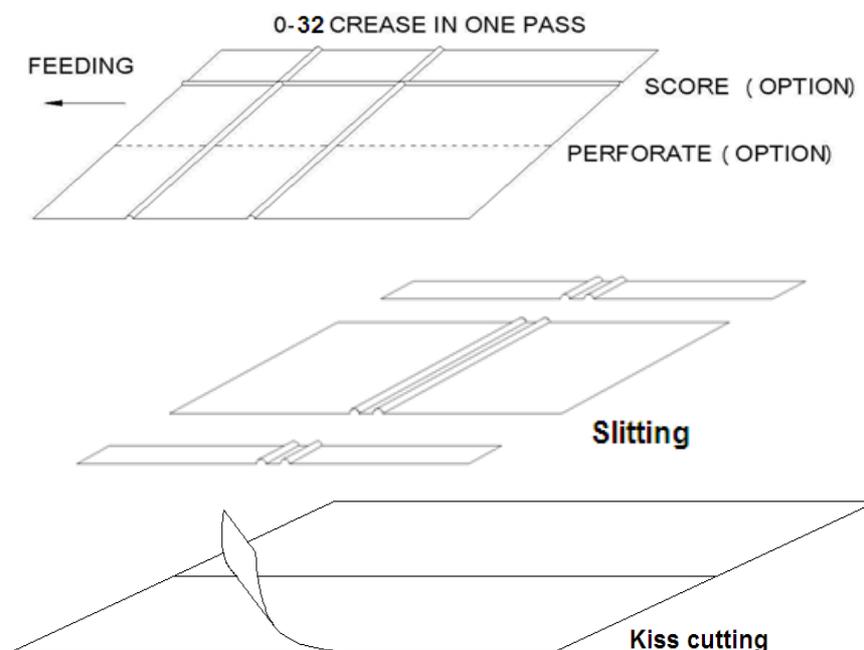
SWIFT Multi, Auto creaser 335 is a super cost effective machine that created by. It is with vast functions that you can ever seen in same line

The operation system is controlled by high speed MCU, crease speed and frequency are much more improved than last generation, especially for that more than one crease on one sheet. Professional designed steel structure guarantee the durability, accurate motor and circuit system guarantee the crease accuracy and performance.

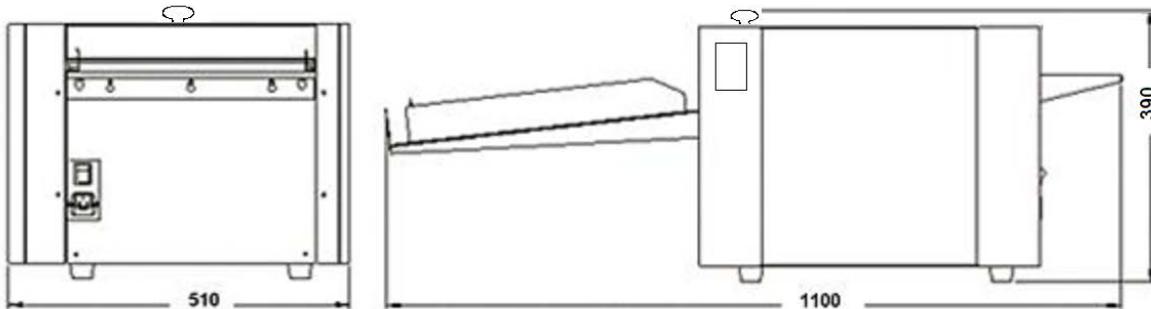
Appearance is cute and pretty, with membrane keyboard control panel, LCD display, bi-language and friendly interface, even untrained staff is able to operate once touching it. Meanwhile, the software is embedded with technical code for electrical parts checking. Each chip is written into a unique serial number, which facilitate the market management and after-sale service tracking.

The designed has taken all possible situation of crease process in the field into account. Meanwhile, there are functions of depth and skew adjustment reserved in hardware.

Besides crease, it is optional for user to mount cross perforating bar, linear perforate blade, scoring tools, Slit blade and half cutters on the exit rollers.



1.2 Specification



Paper thickness	about 100-400 gsm
Paper length	90-900mm
Paper width	50-330mm
Speed(One crease on A4):	45 pcs/min(high)or 35pcs/min(low)
Min crease gap	1mm
Min gap from leading edge to first crease	0.2mm
Crease qty in one pass	0 - 32
Max program qty	30
Crease Counting	reversible counter
Total counter	for crease qty and paper qty
Skew adjustment	Standard
Crease depth adjustment	Standard
Feeding extension table	Standard
Output tray	Standard
Language	CN/EN
Linear perforating max 8 set,min gap between 2 is 30mm	Option
Linear scoring max 8 set,min gap between 2 is 30mm	Option
Linear half cutter max 8 set,min gap between 2 is 30mm	Option
Linear Slitter max 8 set,min gap between 2 is 40mm	Option
Stand	Option
Power	220V/50HZ/150W
Fuse rating	3.15A
Weight	42kg(NG) 47kg(GW)

Note: The machine is keep upgrading, specification and information in this manual is updated as per the change without notice.

Chapter 2 SAFETY

Before or while operating this machine, you should pay great attention to the safety.

2.1 Environment

Temperature: 10°C to 35°C

Humidity: 30% to 70%

Altitude: Below elevation 1000m

There is no corrosiveness gas, flammable gas, oil mist and so on in room

2.2 Do's and Don'ts



Do-Read this manual and fully understand before the operation.



Do-Check the *plug and machine voltage and frequency* to your main supply, and that the socket has a correct working earth lead for this single insulated machine.



Do-Use at least a 10 amp power source at 220 V.



Do-Make sure all *safety covers* are in place. The top covers have an interlock switch which will disable the unit if removed.



Do-Open or close the cover slowly.



Do-Contact the local maintenance center before you are about to move the machine.



Do-disconnect the power before clean the inner side.



Do-unplug the cord if you won't use the machine for a long while,



Do-Be careful of the blade edge.



Don't install the machine on an unstable ground.



Don't-operating with wet hand, especially plug or unplug the cord.



Don't- wear long hair, loose fitting clothes or put your fingers into the creasing unit nip, while the operation.



Don't- place any receptacles with any liquid on any surface of machine.



Don't- put other pieces, especially tiny pieces on loading table.



Don't- alter or uninstall the machine, unless by authorized engineer.



Don't- touch any running parts while running



Don't- shut down the machine while running.



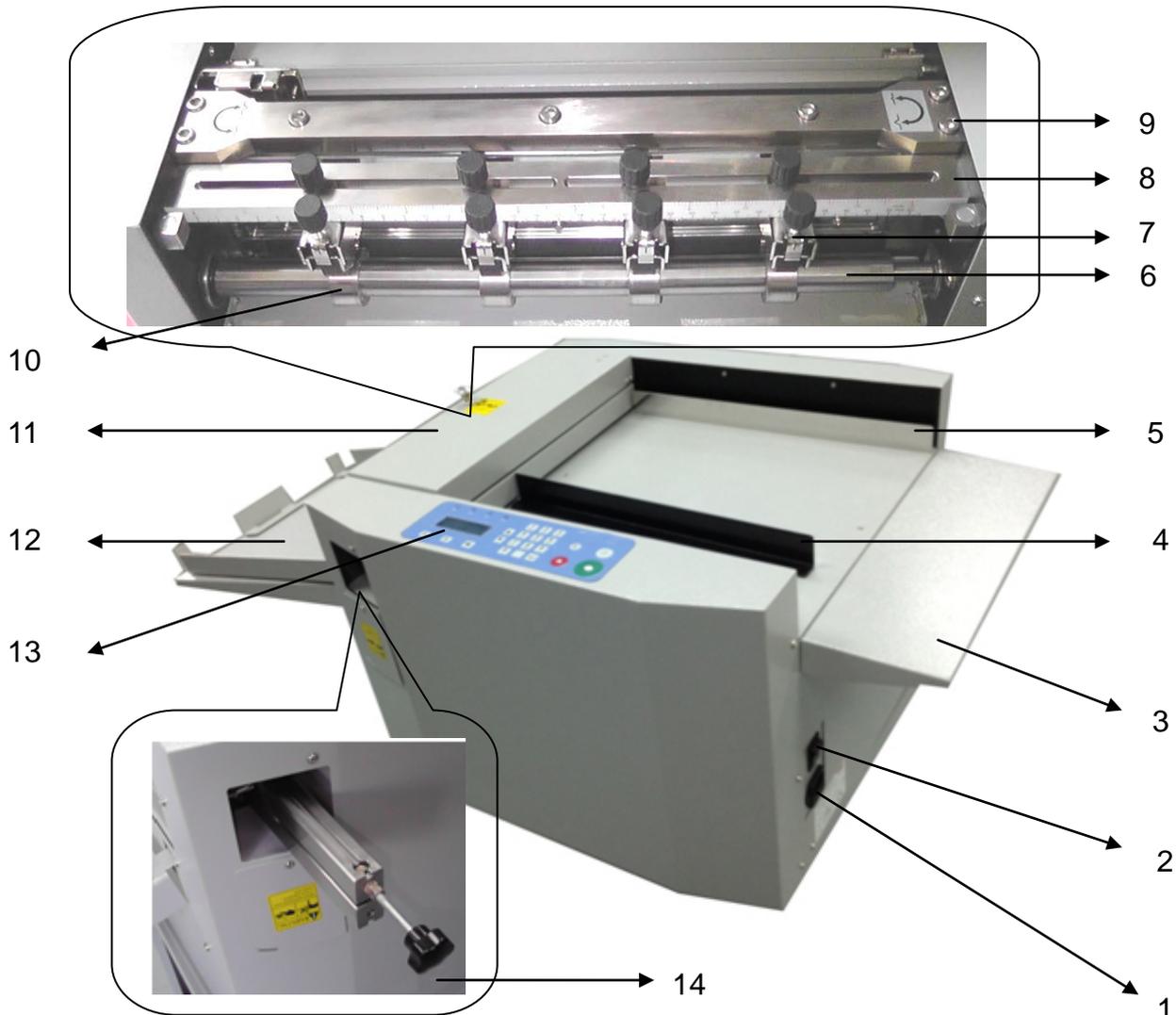
Don't- put heavy matter on machine or shock it.

2.3 Caution

Be careful of any metal or flammable thing in internal machine, or it may cause fire or electronic shock. if it happens, first shut down the power, disconnect the cord, then contact the technician .

If the machine becomes heat, smoke, or smelly, Shutdown at once, disconnect the cord, and contact the maintenance staff.

Chapter 3 MAIN PARTS AND ASSIES



No.	Parts	Description
1	Power socket	For system power
2	Power switch	On/off
3	Extension table	For longer sheet
4	Magnetic side guide	Flexible guide for the paper infeeding
5	Fixed Side guide	For skew adjustment
6	Outfeed shaft	Easy-uninstalled, to mount outfeed tools
7	Upper Outfeed roller	
8	Tools mounter	
9	Depth setting Screw	For crease depth adjustment
10	Lower Outfeed roller	
11	Safety cover	Covering turning parts with interlock switch
12	Output tray	To stack the finished products
13	Control panel	Input the data
14	Slid-in tool	Crease tool, easy to exchange

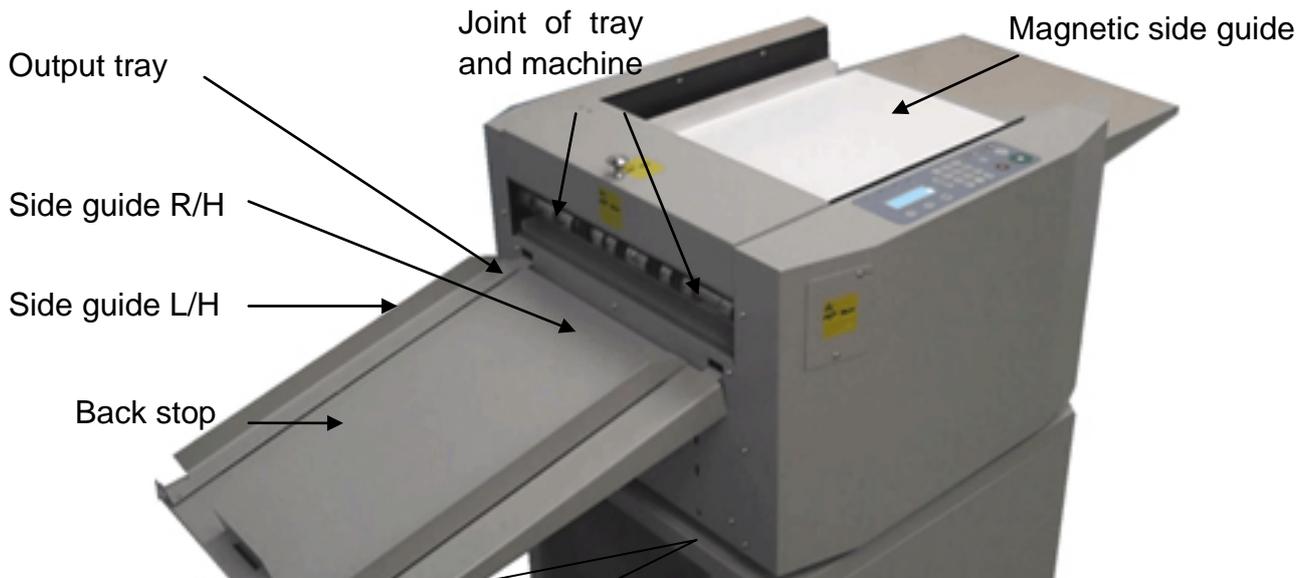
Chapter 4 FIRST INSTALLATION

4.1 Output tray, stops and guides

Unpack it , install the parts as per above illustration.

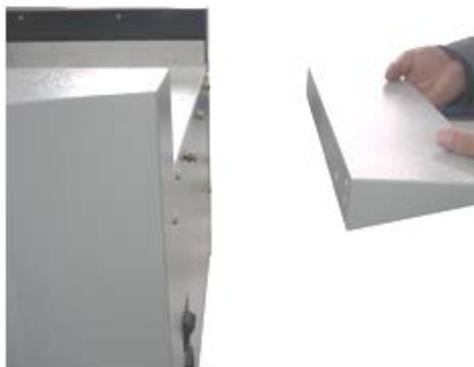
Note: Set guide and stops according to the paper format.

The capacity of the tray should always less than 30mm(A3) to keep machine balance.



Note: Please be careful of the bracket from your hand when you are moving it to the stand.

4.2 Feeding extension

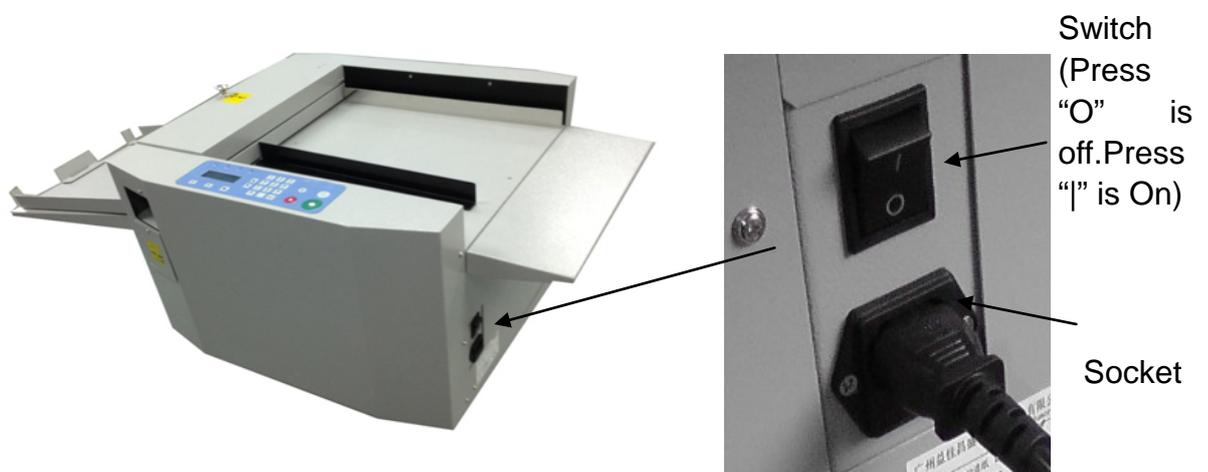


We can see there are 3 screws on trail of feeding table, and there are 3 holes on side of extension table.

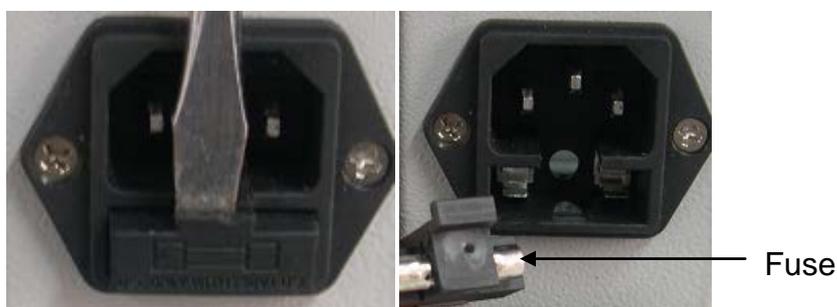
Install them as per following steps:

- 1: Loosen 3 screws, but don't remove
- 2: Connect extension table, with each screw head through a hole, clip the extension table on.
- 3: Tighten 3 screws.

4.3 Power socket and switch



The power socket and switch are both on right side of operator.
Before the operation, please connect the socket to the electricity with attached cord, press the switch (when the red point is down, the machine is power on.)
Fuse under the socket is protect the system in case the current is over 3.15A, to replace the Fuse, we firstly clip the cartridge with a straight screw driver.
Secondly remove the broken fuse from the cartridge and load a new one back.
At last, we reload the cartridge.

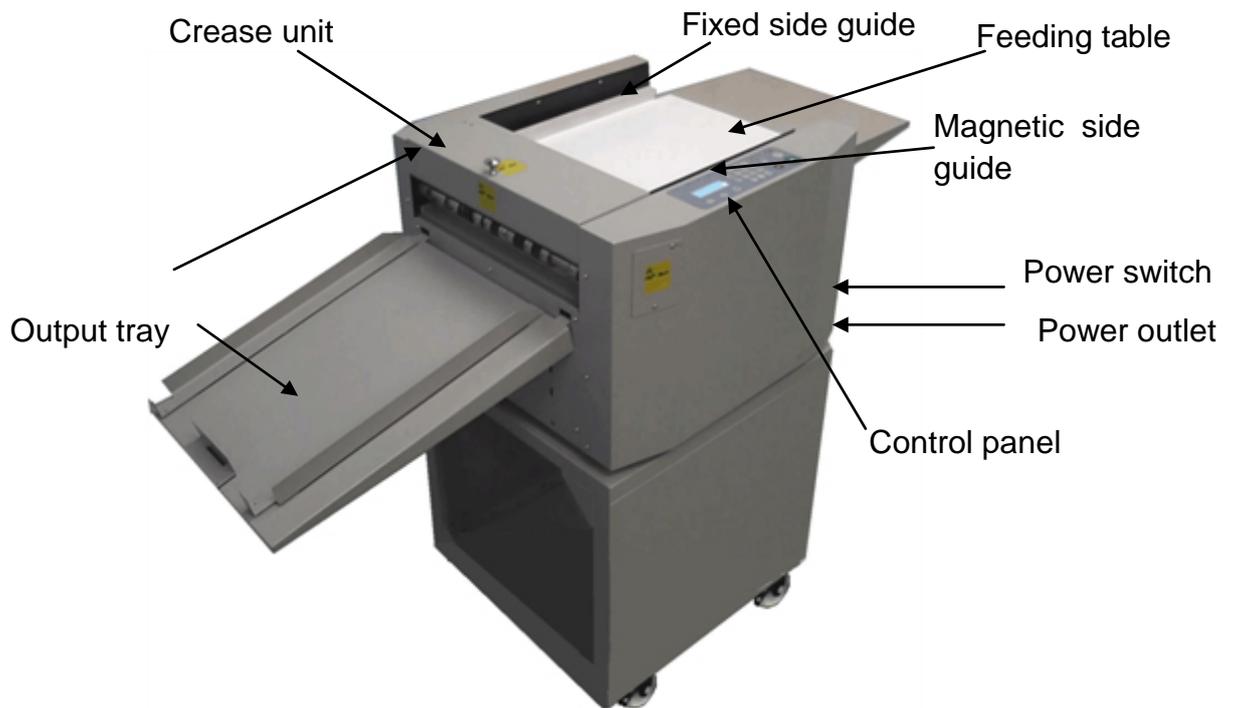


Chapter 5 QUICK START

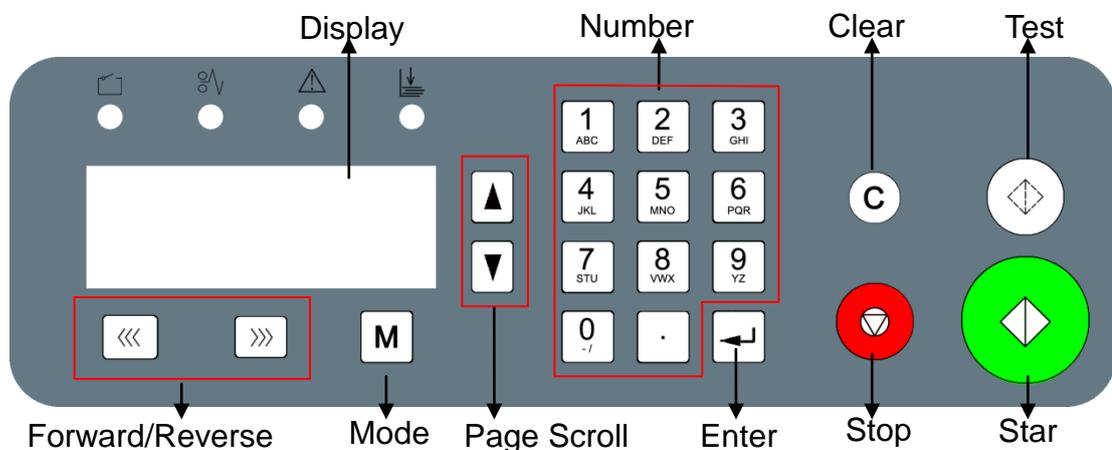
The auto creaser SWIFT MULTI makes 0-32 crease lines in one pass, paper with thickness from 0.1 mm to 0.4mm, size from 50*90 to 330*900mm.

The 330 creaser is single insulated, pay attention to the feed nip and do not wear loose hair or clothes, do not let any foreign object enter the inside.

Main part of the swift multi is as follows.



Control panel



To access to crease job

(a job that crease on 10mm,20mm and 30 mm)

1. Turn on machine, screen 1 will appear after welcome page.

Ready	0/0
[1]0.0	[2]0.0

screen 1

Input CR Data	
[1]0.0	[2]0.0

screen2

2. Press M 1 time, screen jump to Screen 2, line [1] will flash.
3. Enter line [1] value, 1 and 0 .Press Enter, line [2] will flash.
4. Enter line [2] value, 2 and 0 .Press Enter, screen jump to screen 3.

Ready	0/0
[1]10.0	[2]20.0

screen3

[3]0.0	[4]0.0
[5]0.0	[6]0.0

screen 4

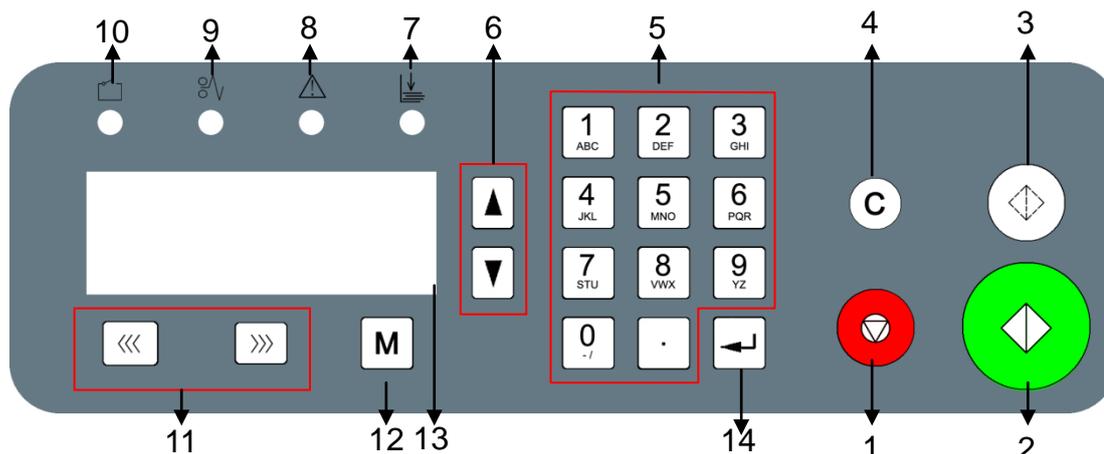
5. Line [3] will flash, Enter line [3] value 3 and 0, press Enter, line [4] will flash
6. Press Enter when line [4] is 0, screen will jump to screen 4
7. Press RUN, feed a sheet. paper is creased at 10mm, 20mm, 30 mm (crease line distance from the leading edge).
8. Press STOP if you want the job stopped

Chapter 6 OPERATION

6.1 Control panel

6.1.1 Keys and Screen

The control panel consist of keys and screen, as per following picture.



No	Key	Description
1	STOP	Stop the machine.
2	START	Run the machine.
3	TEST	Machine will stop after one sheet
4	CLEAR	Clear the data or clear the error display
5	NUMBERS	Input data
6	SCROLL	Turn the page
7	INDICATOR-NO PAPER	If the machine didn't find a paper for ca. 20s while it is running, it lit and return a error report. "C-4 No paper pr Jam"
8	INDICATOR-BLADE JAM	If the crease motor locks, it lighten and return a error report "E-1 CR Motor Error"
9	INDICATOR-PAPER JAMMED	If the paper is jammed inside the machine, it lightens and returns error. "C-2 Jam at infeed" or "C-3 Jam at outfeed"
10	INDICATOR-SAFETY COVER	If the safety cover is not well setting, it lighten and returned a error report. "C-1 CR cover open"
11	UNJAM FORWARD/REVERSE BUTTON	When paper jams, press them to move rollers, so that the paper can be easily cleared.
12	MODE	Change the modes
13	SCREEN	Display information.
14	ENTER	After the data input, press it to confirm.

6.1.2 Function and operation

All system screens are divided into 5 MODES as per different functions, we can scroll the mode by press the key **M**.

In each MODE, there may be over 1 page to display different info, we can scroll the page by press **↓** or **↑**.

MODE 1 Main operation

Page 1:

Display the *machine states*:

Ready: Not run, screen editable.

Running: Feed paper and crease

Note: In "Ready" state, press RUN or TEST button will shift to "Running" state; In "Running" state, press STOP will shift to "Ready" state.

Display *Fed qty/ Preset qty*,

Preset qty: Your wanted qty of sheets. You can input it through keyboard, and Enter to confirm.

Fed qty: It is not editable, but in "Running" state, while sheets passing. It counts up from 0.

Note: If Preset qty is not 0, when Fed qty counts up to Preset qty, machine will stop automatically. If Preset qty is 0, machine will never stop after "Running", until STOP is pressed.

Ready	0/0
[1]10.0	[2]20.0
Running	12/20
[1]10.0	[2]20.0

Display *First 2 crease data* of 6

Note: Crease data can't be input in this mode.

Press **↓**, goes to page 2

Page 2:

[3]30.0	[4]40.0
[5]50.0	[6]60.0
.	.
[31]0.0	[32]0.0

Display *Last 4 crease data* in 6.

Note: Crease data can't be input in this mode.

Press **↓**, goes to page 3.....9.

Page 10:

Sheet:1
Crease:1

Total counter of sheet
Total counter of crease

Press ↓, goes to page 4

Page11:

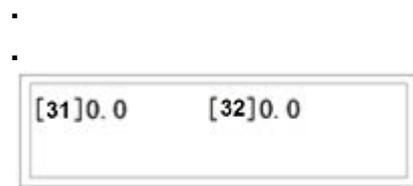
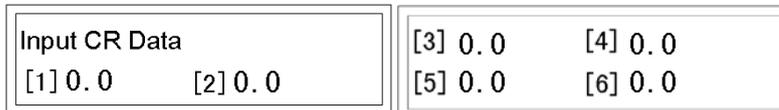


Ver: Software version Nr,
S/N: Serial Nr, factory setting, it can not be overwritten unless main board is changed
Note: User should offer them to the dealer or supplier to facilitate the after service.

Press ↓, return to page 1

Press **M**, goes to MODE 2

MODE 2 Crease data Input



Initially in Mode 2, Line [1] flashes, (which means can be input), input the data , from 0-900.0, accurate to one decimal place.

Press ENTER,[1] stop flash, [2] flashes.

Input a data, press ENTER.

[2] Stop flashing, screen automatically jumps to 2nd page.

[3] Flashes.....

Input all 32 likewise.

Note: Each value has to be greater than last value.

If all 32 lines are needed, after we Enter the 32nd data, screen will automatically jump to MODE 1, page 1. Input finished.

If less than 6 line is needed, after we finish the last data (say, the 3rd line), Enter, Line[4] flash, press ENTER again when line[4] is 0, screen will jump to main operation mode, input finished.

Press **M**, goes to MODE 3.Press **M** again, goes to MODE 4

MODE 3 Recall job and MODE 4 Save job

Frequently used crease data can be saved and recalled, so that user don't have to input data each time. The system at most saves 30 jobs.

```
Save Job
Code:1
```

1. How to save a job

- a. See MODE 2, Let's input a job, say, 10, 20, 30, 0, 0, 0.

```
Ready      0/0
[1]10.0    [2]20.0    [3]30.0    [4] 0.0
[5] 0.0    [6] 0.0
```

- b. Press **M** 2 times, We go to **Save job** Mode.

- c. Input a number between 1-30, say 10. It changes into

```
Save Job
Code:10
```

- d. Press Enter, save success.

```
Save Job
Success
```

2. How to recall a job

- a. See above steps about **How to save a job**, we take the saved job as a example.

- b. Press **M** until we go to recall job mode, seeing following screen.

```
Recall Job
Code:1
```

- c. Input a number between 1-30 (10 according to above example).

```
Recall Job
Code:10
```

- d. Press Enter, Recall success.

```
Recall Job
Success
```

- e. Screen jump to main operation MODE, and the data become 10 20 30.

```
Ready      0/0
[1]10.0    [2]20.0    [3]30.0    [4] 0.0
[5] 0.0    [6] 0.0
```

Note: It is quite advisable for users to remember jobs of each number, because job will be overwritten without any notice.

Press **M** at Recall Job mode, It goes to MODE 5

MODE 5 Speed

Speed 1=Low 2=High*

Speed 1=Low* 2=High

1. If you want low speed, Press 1, "*" become besides "Low", Press Enter, screen jump to main operation MODE, low speed is chosen.
2. If you want high speed, Press 2, "*" become besides "High", Press Enter, screen jump to main operation MODE, high speed is chosen.

MODE 6 Recalibrate

If the Crease line gap is stretched, the crease tolerance will be accumulated as crease line increased. For a quick calibrate, we operate on Recalibrate mode.

1. Measure the real length of a paper
2. Input the real length of the paper as following (say 420mm)

Recalibrate Length: 420

2. Press **↵**, machine runs.

Testing Length: 420

4. Pass the paper. And the Recalibrate is done automatically.

Note: If the input date is more than 3% tolerant to the real length, it fails

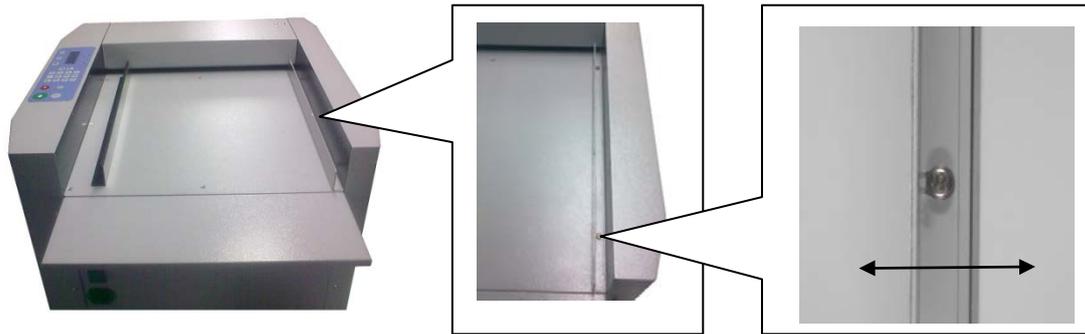
Failure Length:

OK Length:

6.2 Hardware Setting

6.2.1 Skew adjustment

If it is found the crease is skewed (not vertical to the paper side), You need to adjust the feeding angle to get a satisfied performance.



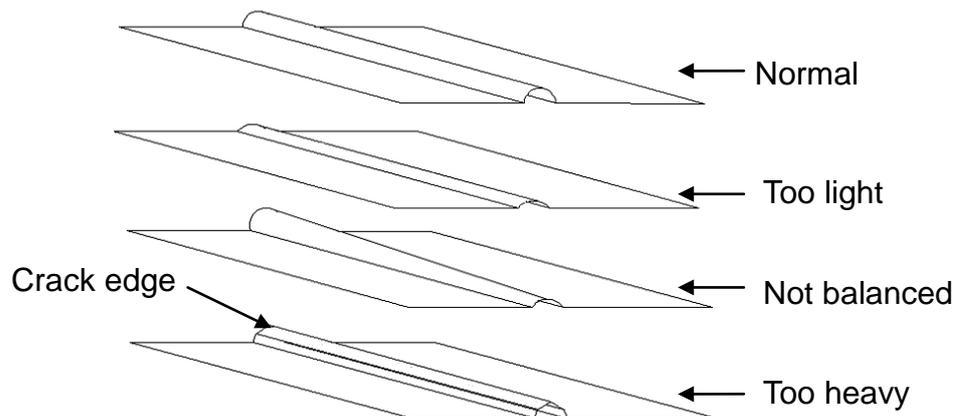
Fixed side guide is the hardware where we adjust the skew.

As per above picture, the guide is fixed by 2 screw, rear one is through a slot hole. We can loosen the screw, and move the side guide a bit, so that the feeding direction is micro adjusted to compensate the skew issues

6.2.2 Crease depth

Crease depth is important to crease quality. It just depends on the gap between male die and female die. Depth should be adjusted according to the paper thickness. Low Depth will perform a not clear crease. but a high Depth may cause cracking, cause system take it as a double feed.

The adjustment is also needed if the crease depth are not balance on both sides.

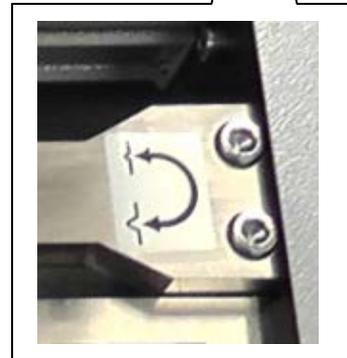


To adjust the Depth:

Open the safety cover and you will see following picture



Find 4 screws on both side, turn the Allen screw according to the label beside to make the crease line deeper or light



Chapter 7 OPTIONAL PARTS

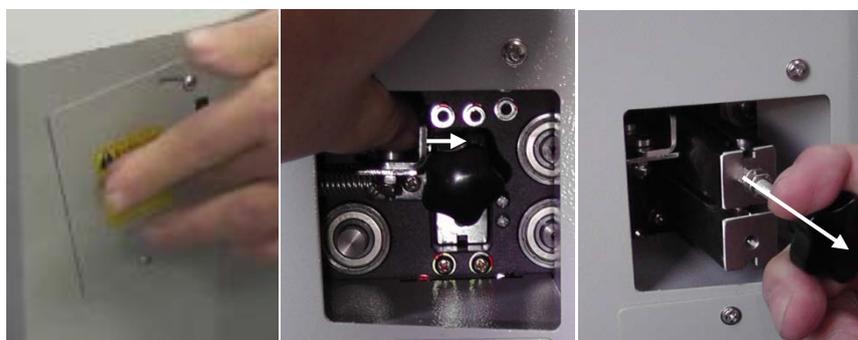
6.1 Slid-in Tools



There are 2 kinds of cross bar, Crease tool and Perforate tool.
To make the sliding easy, we install the screw on the bar.
To insert the tool, please do as per following.

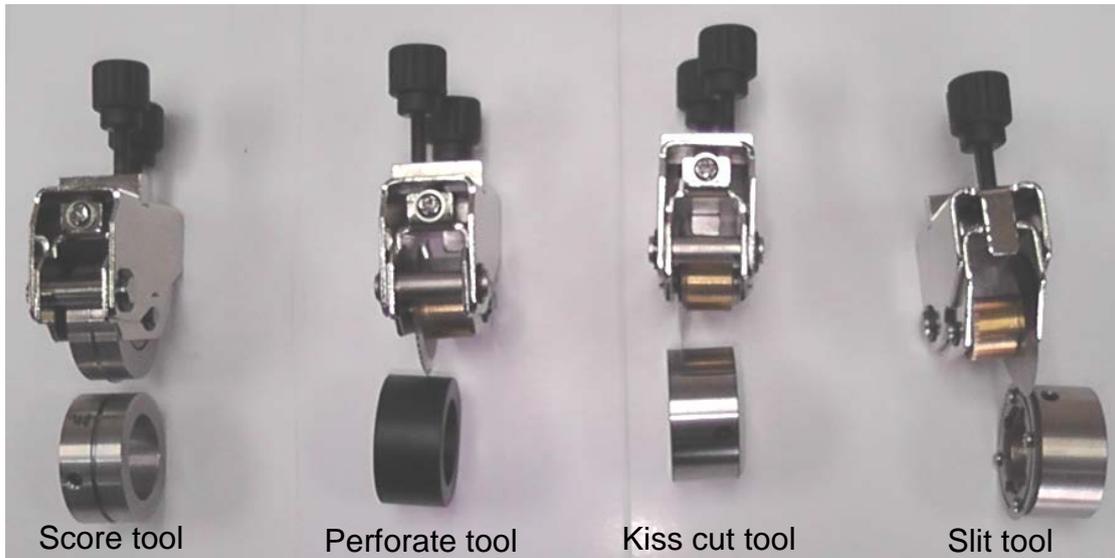


To slid out the tool, please do as per following.



For Crease tools, 1.0mm version is standard, Optional version is 0.6mm, 1.2mm, 1.5mm
For perforate tools, there are 12 TPI and 24TPI, both are for option.

6.2 Linear blade



There are 4 kinds of linear optional blades, Scorer, Perforator, Kiss cutter and Slitter. Each tool consists of blade and anvil.

6.2.1 Installation

Install the Blades on the tools mouter as follow.

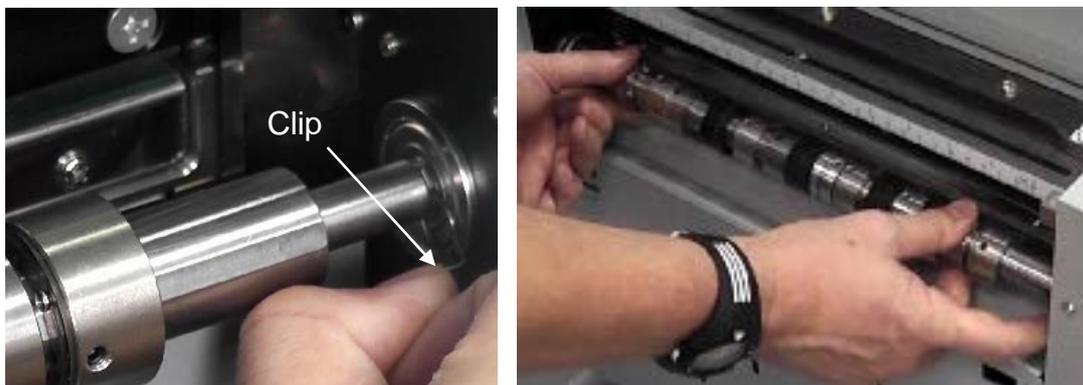


Screw 1 to fix the blade with the machine.

Screw 2 to adjust the tool depth of the blade, like crease depth, perforate depth, Kiss cutter depth etc. This screw is very important to kiss cutter.

mount the anvil on the outfeed shaft after it is uninstalled from the machine.

1. Remove the clip at the operate side of the roller



2. Grab the shaft, slid right to loosen it and remove it from the machine.

3. Loosen the set screw of anvils and install the new anvils in order. Mind the flat part of the shaft, all set screw should touch this flat surface.



4. After all anvil is mounted again, install the shaft back, so to the clip.

6.2.2 Notice

1. For scorer tool, the male line should fit the female line in anvil.
2. For perforate tools, the perforating blade should cut against the plastic black anvil, turn the screw 2 according to the paper thickness, the thicker the paper is , the lower the perforating blade should be.
3. For Slit tool, upper blade touch lower blade at face.
4. For the kiss cutter, the blade should not touch the anvil, with a very tiny gap according to the sheet layer thickness.
5. For the screw 2, if you turn a whole cycle, the depth change 0.8mm.



Chapter 8 TROUBLE SHOOTING

1. Paper jam



Solution: Firstly, use the scroll icon to control the roller manually to drive the jammed paper out of mechanical system



do not pull hard on the paper, or you may damage the infeed rollers !

This occurs :

A. if the paper is too thin (if out of spec, the paper will crumple) or too thick

Solution: you have to choose paper in 100-400 gsm.

B. if there is some waste present in the paper path.

Solution: Clean the waste in the path.

C. if there is too much ambient light shining on the IR sensor (especially direct sunlight or neon light which will send fake paper jam signal)

Solution: Avoid the ambient light.

D. if the papers are curled or the blade is set too low

Solution: Choose right paper, set Adjust the depth, according to 6.2.2

2. Bubbling in laminated stock

This occurs if you try to crease laminated stock, the curve of the crease will not adhere to the film

Solution: make a less deep crease or use a better film.

3. Not a deep crease

This occurs :

-1) If the card is too thick

Solution: The paper is out of standard spec, then you have to customize crease dies, with deeper female die.

-2) The upper blade is set too high

Solution: Adjust the depth, according to 6.2.2

4. Crease cracking or Motor error



Auto creaser

This occurs:

-1) If the card is too thick (over 400gsm)

Solution: The paper is out of standard spec, then you have to customize crease dies, with deeper female die.

-2) The upper blade is set too low

Solution: Adjust the depth, according to 6.2.2

5. Crease not balanced

Solution: Adjust the depth, according to 6.2.2

6. Infeed skew

Check if the paper is square,

No-Solution: Use standard paper or adjust the side guide to get a satisfied performance.

Yes- Solution: Adjust the fix side guide according to 6.2.1

! More trouble shootings refer to *Service Manual*