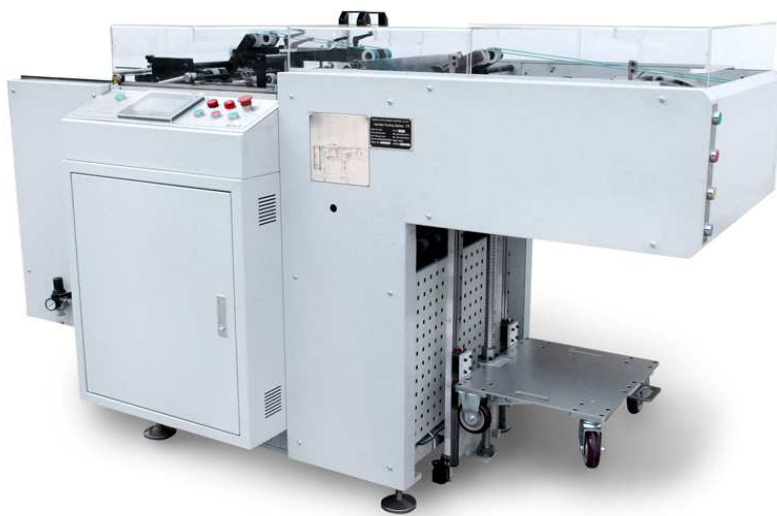


AP400 Automatic Punching Machine Manual



AP-400A Automatic Punching Machine



AP-400C Automatic Punching Machine

1、 Brief Introduction:

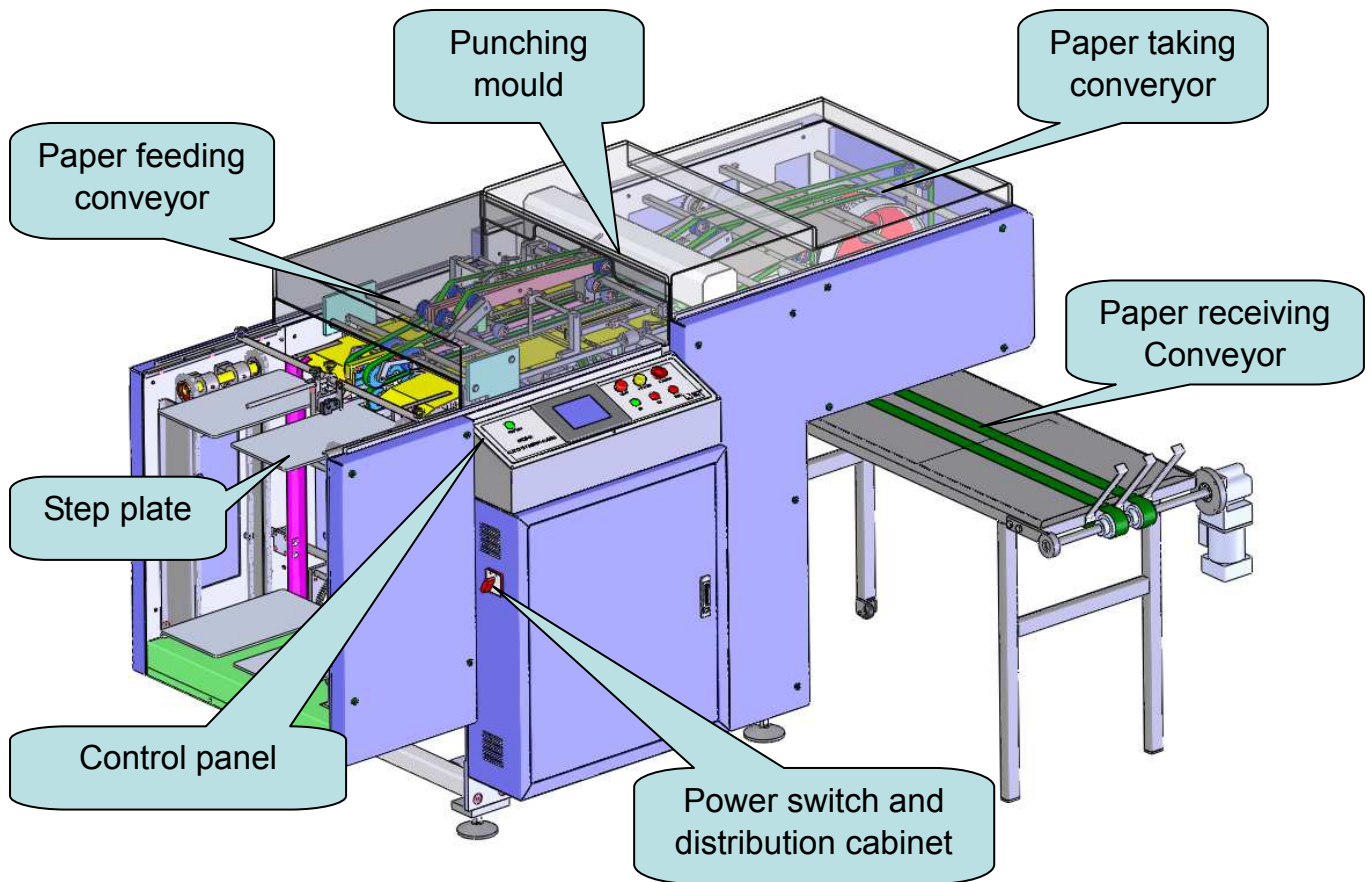
AP400 punching machine is specially used for punching papers of table and wall calendars, notebooks, exercise books etc.

The paper feed table moves up each cycle driven by a stepping motor which accurately controls the amount of sheets fed into the machine. The amount of sheets is adjusted using a touch screen. The paper is taken into the punching die by conveyers and then be aligned from three sides at the same time ready for punching. After punched, the paper is taken into the paper collector in order automatically. Both the paper size and paper margin can be adjusted. Various punching dies can be offered to punch different holes.

2、 Technical Data:

Max. paper size	420x420mm
Min. paper size	140x120mm
Max. Punching thickness	1.5mm
Suitable paper	60-200g/m ²
Max. Speed	100times/minute
Paper taking method	High pile reception and conveyor optional
Power	AC380V/3ph /50Hz/ 3kw
Machine dimension (L×W×H)	2200×1000×1300mm
Weight	720KG
Air compressor	0.37kw
Air compressor	3-6bar

3、 Basic structure



4、 Key features:

- 1、 High-speed automatic punching machine will cycle up to 100 strokes per minute.
Reach the production efficiency of German machines
- 2、 Can punch a variety of hole patterns. Different punching dies can be offered to meet customer's requirements.
- 3、 Will also punch perforated holes for easy tear off
- 4、 Paper margins are easily adjustable by operators
- 5、 There are two delivery options: High pile reception or conveyor (optional)
- 6、 Central lubrication system for easy maintenance

5 Punching mould installation, punching pins pulling out and paper margin adjusting.

5.1 Punching Mould:

One punching mould is already on the machine, if you need to change to different mould, please follow the steps as following:

First: Loosen the 4 screws and take off the cover.

Second: Loosen 2 pieces M8 screws and 2 pieces M16 screws, take off the upper mould, we can pull out punching pins at this time.

Upper mould

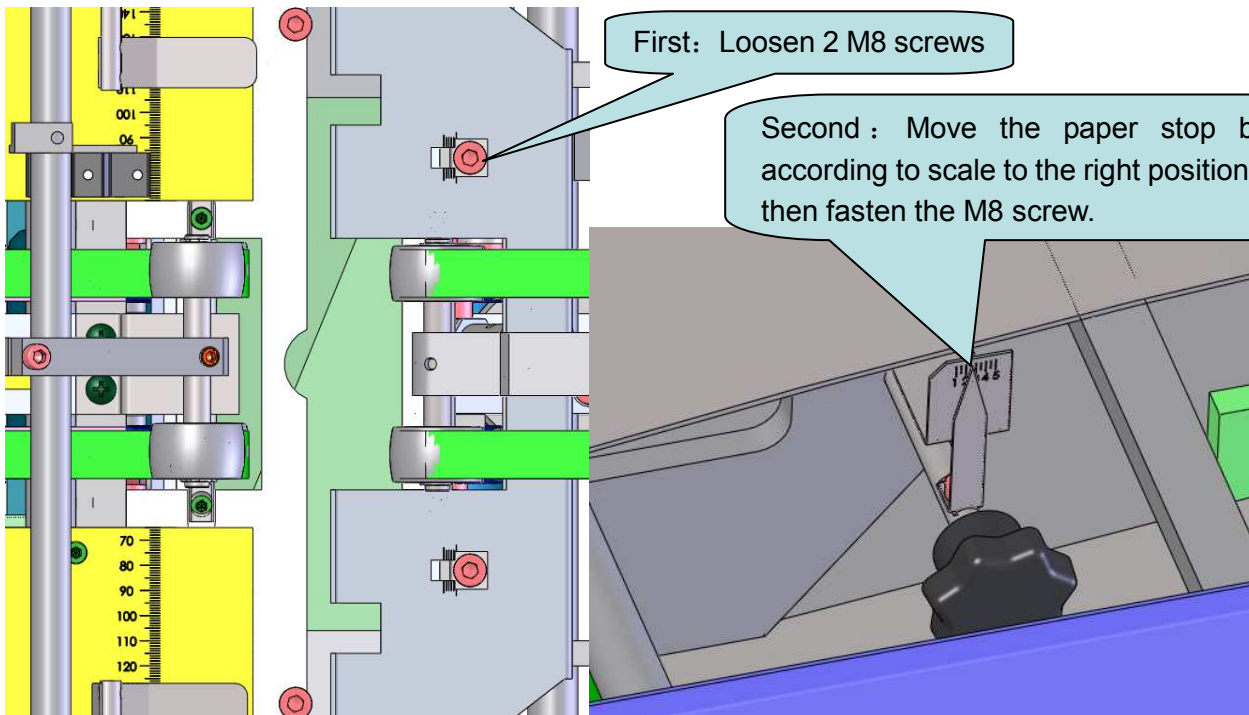
Third. Take off 4 pieces M8 screws and then we can take off the whole punching mould

M8 and M16 spanner is needed for the above procedures, we have all these spanners together with the machine.

Note: After Installation, all the screws have to be fastened to avoid loose while machine is running.

5.2. Paper margin adjusting

After Punching mould's installation, finish one punch by using manual switch, check the paper margin, if it is not up to our requirement, we can adjust it according to the following steps:



After the paper margin is adjusted well, we can adjust the paper arranging board in all sides more precisely until the punching quality meet our requirement.

The Min. paper margin that can set is 2mm and the Max. margin is 5mm. the factory setting is the Min. one.

5.3. Attention point during running

- Do not put your hand near the running parts area such as punching mould;
- Check whether the belts loose;
- If the waste paper drawer is too full, the paper may flow out and the outlet will be jammed.
- Make sure that all the protection switch is well.
- Do not work too long with over thick paper which can lead to quick damage of punching pins and punching mould.

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