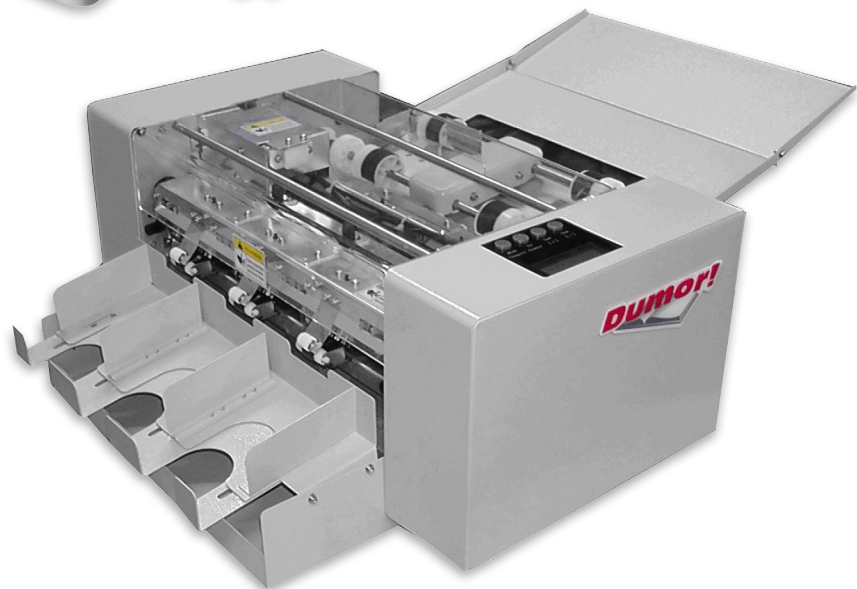




Dumor!

**Value !
Quality !
Innovation !**

EASYCARD A4+ EASYCARD SRA3+



USER MANUAL



Thank you for purchasing a Dumor machine

This is a short instructions for the A4 and A3 card cutters.

What the machine will do

- Cut regular uncoated card stock from a A4 or A3 sheet into various length visit cards in 1 pass.

Limitations (See diagram 1)

Paper is to be clean cut, no lip or hooking, square cut, even width and parallel sided, flat, no end curl. Uncoated, unlaminated stock up to 350 gsm (A4 machine) or 320 gsm (A3 machine).

Working principle

The sheets are stacked in the infeed tray up to the load line. **(1) see pictures at end of the manual**

They are pushed forward to the front stop.

The machine is started.

The feeding wheels will move from home position **(2)** and rotate one turn, the cam **(3)** will raise the tray and engage the sheet against the feeding rubber on the feed wheel **(4)** during the feeding part of the turn.

The single sheet will start to feed past the separator fingers **(6a)** (if the height is correctly set) and be engaged by the grey secondary roller. **(5)**

The infeeding rollers will return to home position and stop with the cut off **(6)** facing the sheet so as not to drag/hold back the sheet that is being fed in.

The lead edge of the paper passes over a IR cell **(7)** and sends a signal to the main-board that the sheet is on the way.

The machine then counts the start position of the sheet and calculates the stops at pre determined intervals to allow the cross cutting blade **(10)** to cut the sheet into cross strips as selected by the user program.

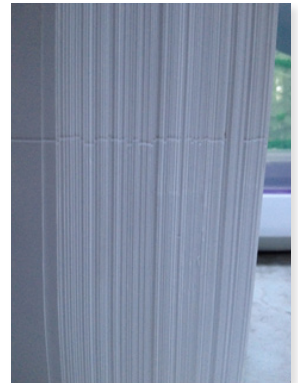
The sheet then advanced under the slitting cassette **(8)** where it is slit into individual cards.

The cut off waste is deflected into a lower waste bin. **(9)**

The cards fall into the reception tray.

The cross blade is a scissors type blade set **(10)** and is generally self sharpening and good for around 1.000.000 cuts.

The linear slitters **(11)** are also self sharpening and are generally good for 500.000 cards.



1- User set up

Mechanical set up

Setting the paper separation according to the caliper of the paper being run.

1 Set the separator finger gap **(6a)** to let only 1 sheet through at a time.

If the gap is too tight then the sheet will not feed.

If the gap is too large 2 or more sheets will feed in at one time and cause a blade jam.

To adjust this there are:

2 knobs **(12)** on the front side of the machine that lock the tray in position; loosen to free up the tray for adjustment.

They must be loose for next step to work or you will damage the levelling system.

Two Levelling screws **(13)** with red indicator needles to move the tray lower or higher; thus altering the finger gap to suit the card being used.

Turn anti clockwise to lower the tray and increase the gap

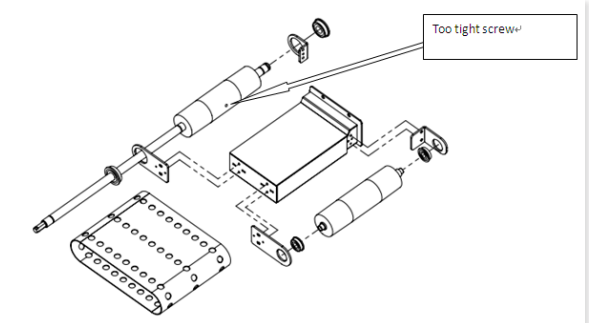
Turn clockwise to raise the tray and decrease the gap

Twelve O'clock on the dial is the zero setting for 220 gsm paper

The adjustments are minute.

The adjustments have to be done equally on both sides.

The adjustment is correct when only 1 sheet will feed through at one time.





Re- lock the knobs (12) when the adjustment is complete

2- Next step

Centre the paper in the tray

There are 2 side guides.

The left side guide has a pressure plate with spring preload and adjustment knob. (13)

There is a cut out in the tray in the form of an arrow head (14) that indicates the centre line.

The centre of the sheet must be defined and placed in front of the tip of the arrow head and then the side guides pushed in to lightly guide the paper.

The spring guide pressure can be adjusted (13) using the knob so that the paper doesn't shimmy on infeed.

3- Next step

Check that there is no waste paper in the cutting area. (15)

Lift the top cover and visually inspect the paper flow area, remove waste.

If scrap is in the paper path a jam will occur.

The cassette (16) is held to the machine with several knurled knobs (17), remove these to remove the cassette if there is paper jammed inside.

4- Next step

Correctly position the outfeed tray and extend it as needed (18) for longer cards to 110 mm

Note: that very long cards will not fit in the tray.

5- Next step

Pre set a job

Turn ON the machine, switch ON (19) the infeed side cover under the tray and wait 4 sec for the display to light up.

The machine will display some basic information:

- Cut width (determined by the cassette in use either 85 mm or optionally 90 mm)
- Cut length
- Number of cards to be cut
- Sheet size

There are 4 press buttons (Denominated from left to right 1 to 4)

What do they do?

1 MODE = cut length selection (20)

Selects the length of cut by increments according to the factory preset values as displayed on the screen.

Press sequentially to scroll through the menu, the value displayed is the value that will be used when you start.

If you overshoot a setting just scroll onwards till the correct value appears again.

The main handbook contains card print templates with the values memorized in the machine.

Note: that if using the standard presets and templates the cut length doesn't fit the printed image on the card (due to print stretch or shrink) the various cut positions can be over-written by increments of 1/10 mm to compensate the error you do not need to do a custom program. The limitation of the manual correction is ± 2 mm per line.

#2 PARAMETER (21)

Selects the adjustment mode

Press sequentially to scroll through the menu.

Depending on mode selected by button nr 2:

#3 + key (22)

Selects to start the machine / move the sheet forward / increase a value.



4 - key (23)

Selects to stop the machine / move the sheet back / decrease a value.

#2 Selectable menus available (the menu settings are switched /altered by using the + or - buttons)

- Language :**Attention! if you put it in chinese you will not be able to return to English!**
- Standard presets or * mode => custom cut length settings
- Mark reader ON or OFF (square in display present or not), if on then there must be a mark on the sheet.
- Mark position compensation + or - in 1/10 mm
- First line position compensation
- Card length compensation
- Gutter cut compensation
- Batch counter and reset
- Total cut counter, not adjustable
- Number of cards to be cut according to the multiple laid out on one sheet press + or - to increase/decrease
- Unjam forward generally not to be used as it will make the jam worse
- Unjam backwards to be used with a gentle pull on the jammed sheet to help it out
- Slit width of the cassette usually factory set at 85 mm. *Note it will not change the setting , its just a reminder*
- Inch to mm conversion => leave it in mm
- Specify number of slit rows. *its just a reminder*
- Return to standard factory settings

* Menu for custom cut lengths

To access

Press button # 2 for 4 full seconds (21)

The menu will now be in custom mode

Available data to enter:

- Selection of the first cut line length
- Selection of the card length
- Selection of the cross cut gutter width
- Selection of the nbr of rows of cards per sheet

All selections are in increments of $\pm 1/10$ mm

When you exit the menu the values are memorized until overwritten

Use of the mark reader

Digital printers are easy to use but are very inaccurate as they have no reference point and the print can drift up and down the sheet and shift from side to side and the image can stretch and shrink at random.

For a high accuracy job like card cutting the cut lines have to be very accurately positioned.

The mark reader will signal the machine to start cutting when the print is in view.

This may increase the apparent print position accuracy on the card as the total print deviates up and down the sheet at random.

Limitations of the mark reader

The mark reader will determine the correct position of the first cut and the relative positions of the follow on linear cuts.

It will not correct the following printer deviations

- Shrink
- Stretch
- Sideways shift
- Image skew

Possible apparent errors in image position when you run a job and ways to correct the cutting to suit.

- Always use a metal precision ruler to determine the error.
- First measure the card and the cross waste lengths.
- Usually they will be spot on if not reset the cut length fractionally using button nr 2.



Skew



Too high



Too low



Correct



If they are correct then its a print shift issue as is the case 95% of the time.

Print shift issues

Symptom

- 1- All the cards are equally too high
Increase the first cut length
Opposite if too low
- 2- The image is creeping up the sheet the further down the sheet you go (*remember the last card cut is at the top of the pile in the tray!!!*)
Increase the card length and / or the gutter cross cut length fractionally
- 3- The image is creeping down the sheet the further down you go
Decrease the card length and / or the gutter cross cut length fractionally
- 4- The image moved constantly to one side
Move the infeed side guides in the opposite direction
- 5- The card spacing is too short
Increase the gutter cut length
- 6- The card spacing is too long
Decrease the gutter cut length
- 7- The image on the cards is skewed
No adjustment possible => printer error

Tips to get a good result

- The machine doesn't need cut lines printed on the sheet to cut accurately!!
Do not print them, they just get in the way
- If you want to run the colour to the edge of the card do a 3 mm over print bleed so that if there is a minor print position error it will not be seen as a white edge.

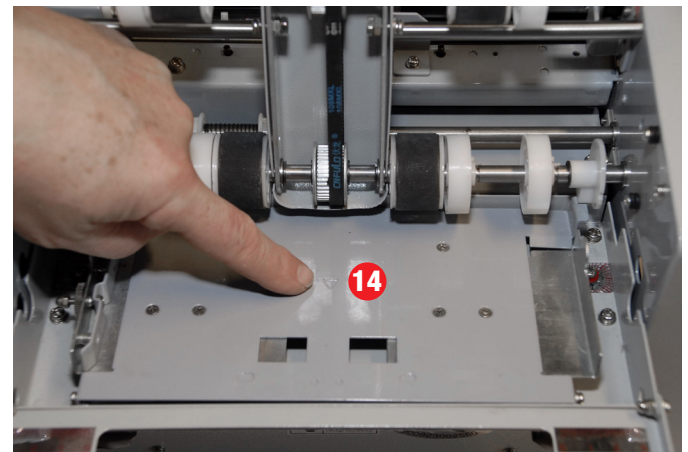
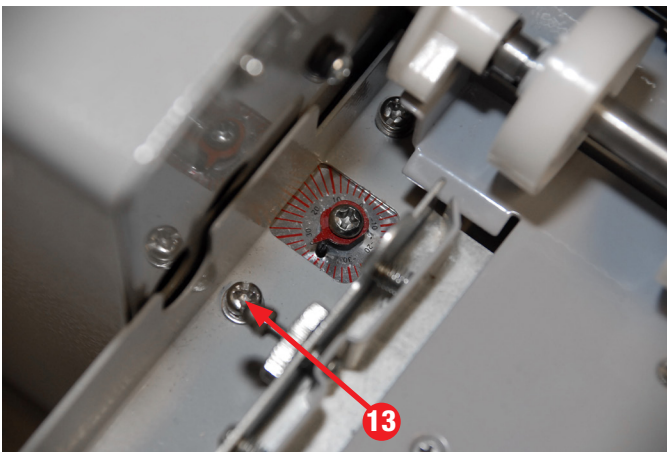
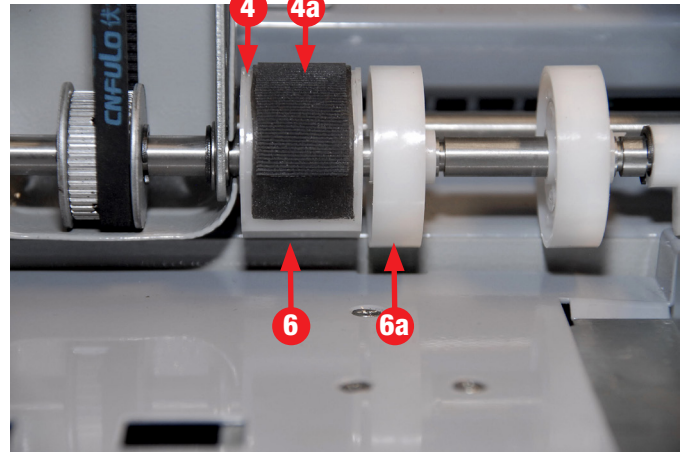
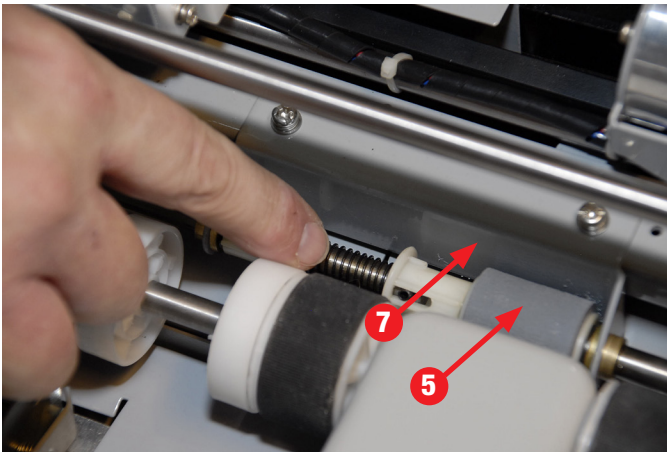
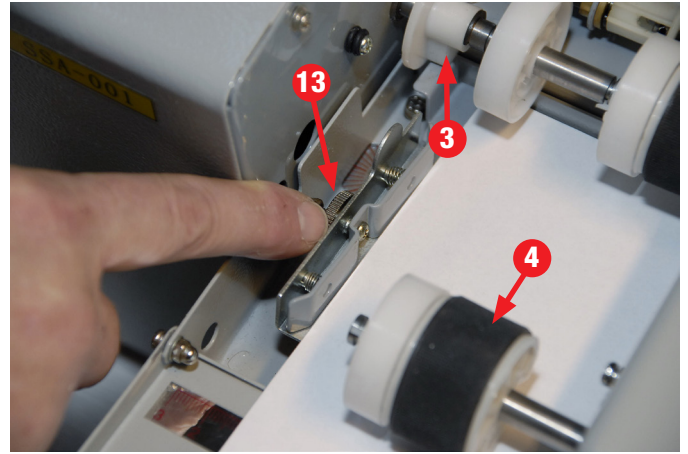
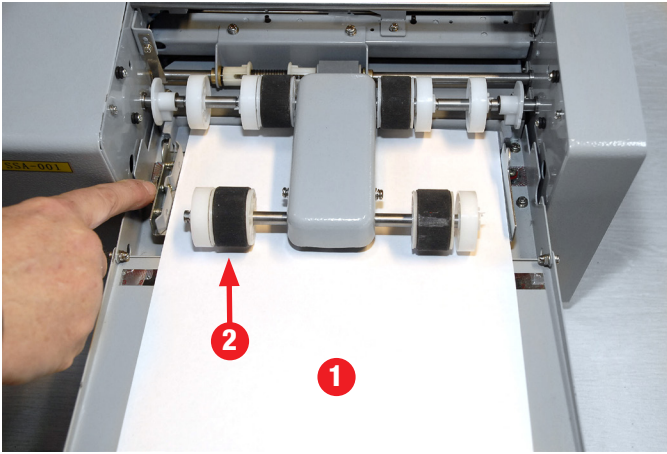
Unjamming

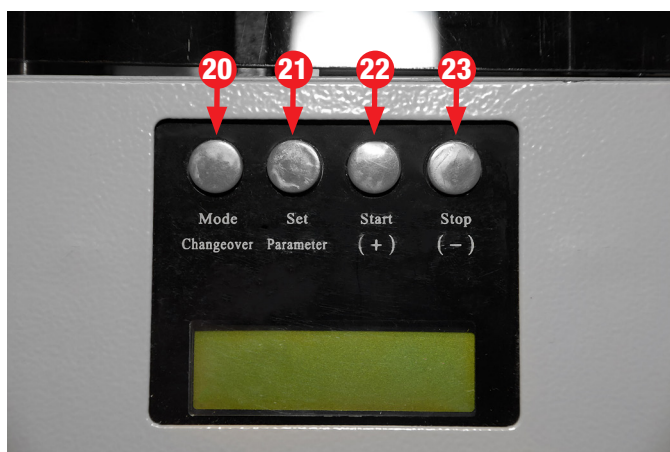
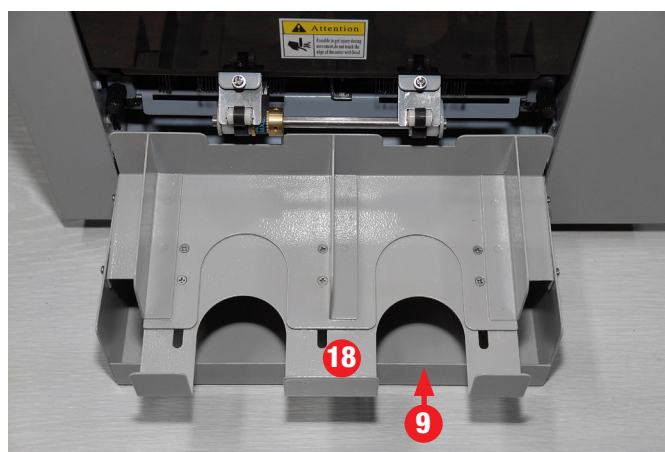
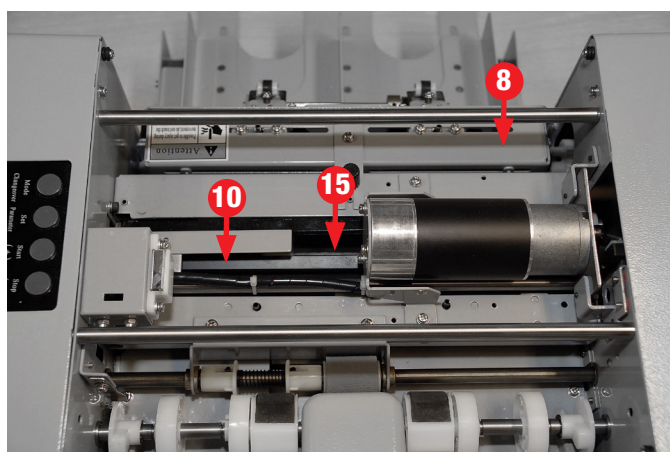
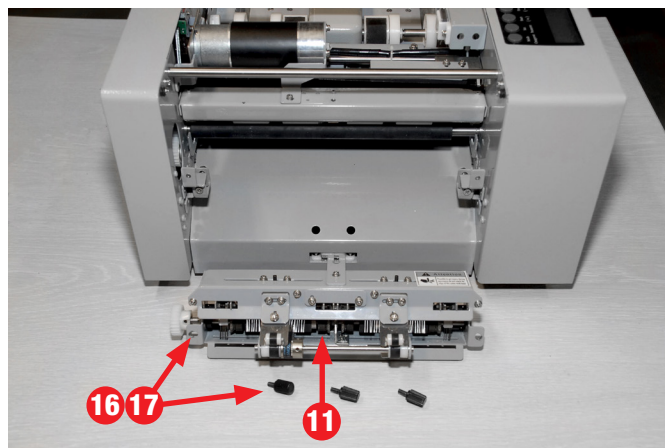
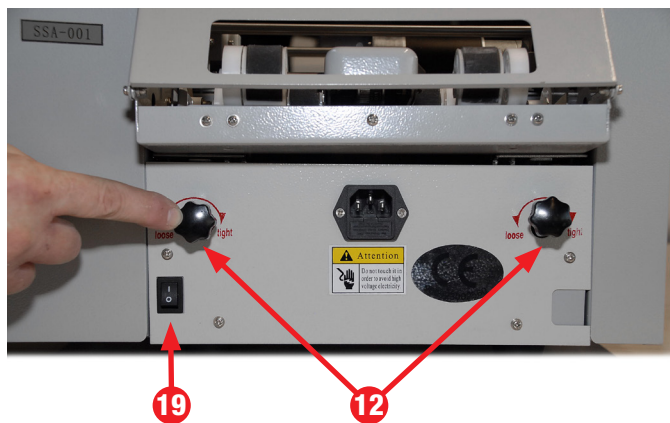
Generally the paper will jam in the infeed side of the blade.

A message jammed will appear along with arrows.

Use the right arrow only to pull the paper back out.

If you use the left arrow the jam will get worse and the drive belt may snap (*no warranty*).







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