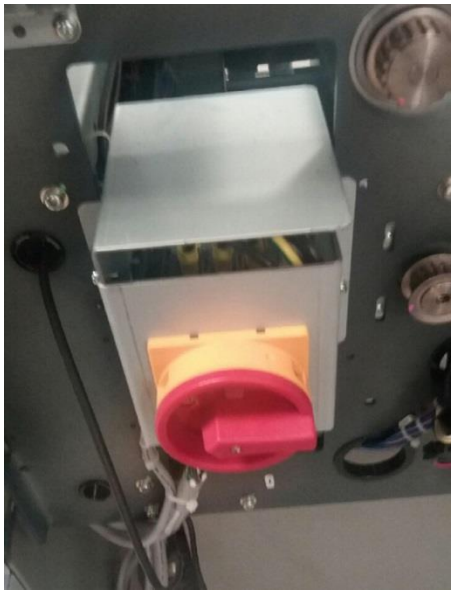
Instructions for Horizon BQ 470

Important

Before installation please check the motor that drives the creasing shafts uses the red labelled motor. The original black labelled motor is not strong enough to drive the shafts.

X old motor is not strong enough

New motor is OK

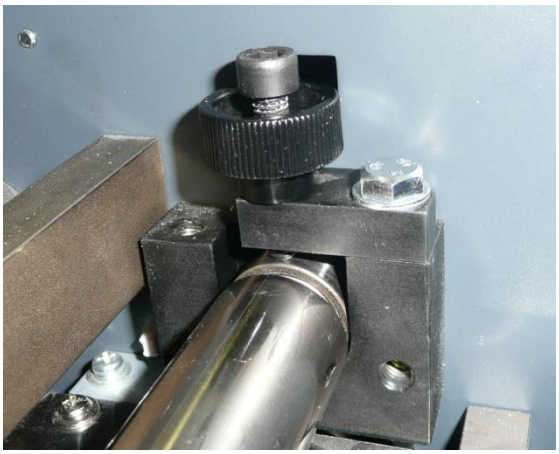


The servo motor is located behind the main switch. Please remove the main switch bracket to gain access to the servo motor.

Original Crease System

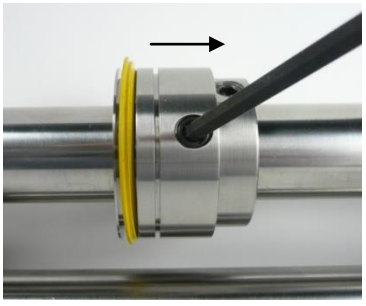
It is recommended to replace the original top shaft pressure screws as the grip knob is very close to the framework and is difficult to adjust.

Tech-ni-Fold Crease System

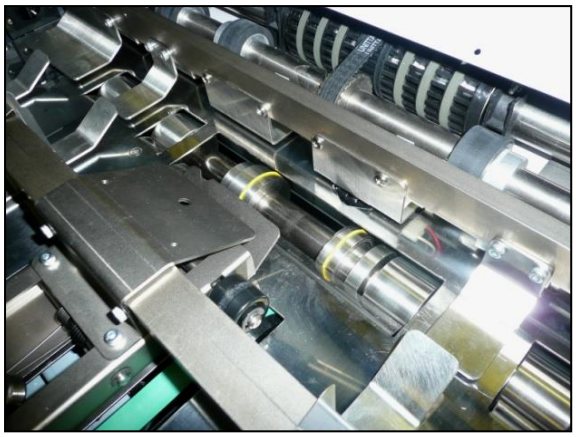


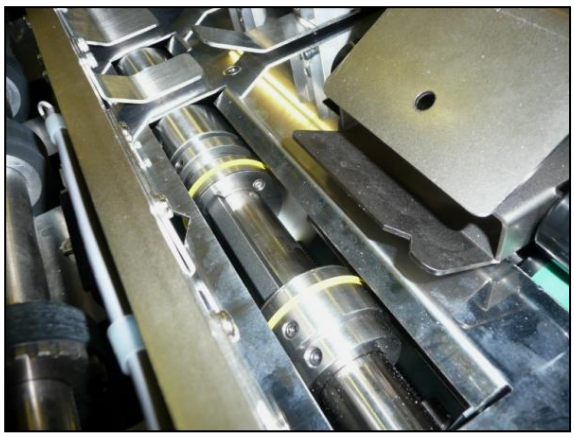
Hexagon cap head screws screws are included in the pack. Use a hexagon key to adjust the pressure screw.

Setting the Spine & Hinge Creaser

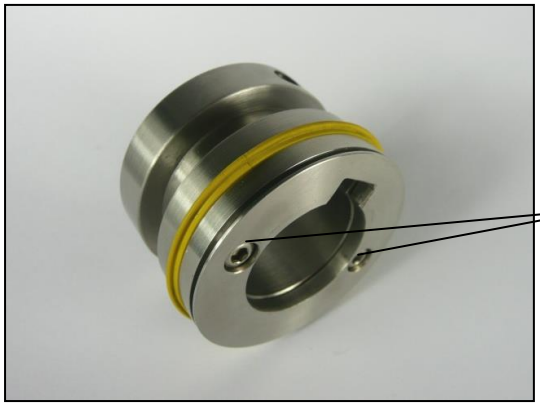


When changing from one stock weight to another you may need to change to another creasing rib. The split design of the rib makes it quick and easy.

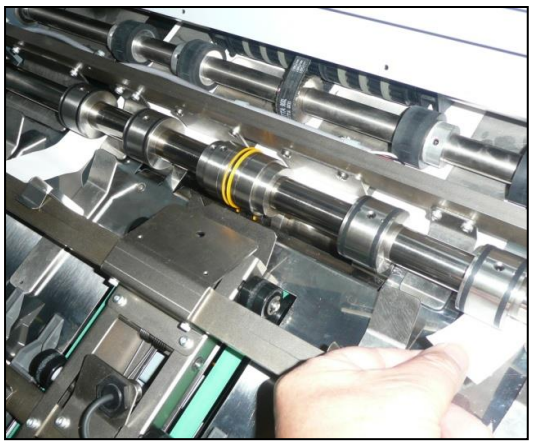


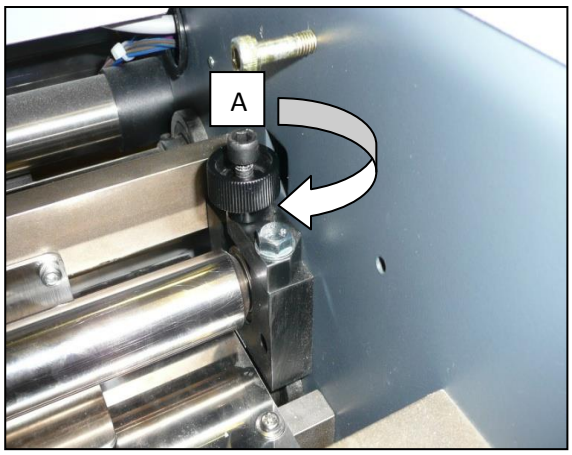


To release and change the crease rib on the bottom shaft driven crease unit, **instruct the machine to open the book spine width to 60mm.**



Using the supplied 3mm hexagon key, loosen the 2 crease rib fixing screws on side of the holder.

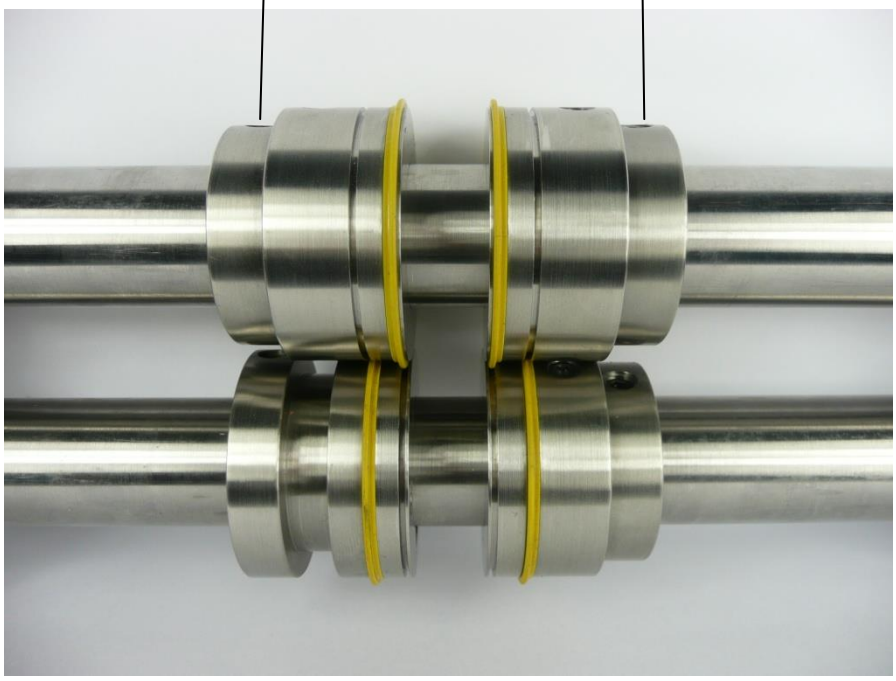




Important To set the depth of crease, screw down the shaft pressure screws A.
As a general guide place 2 sheets of 300gsm stock under the support collars on each side of the machine. Place your hand under the top crease shaft a gently lift. At the same time Increase the pressure on the adjustable screws (A) until a slight grip is achieved on the 300gsm cover stock. Remove the remove the cover stock strips.

There should be a small amount of movement between the top and bottom shafts. If the shafts are tightened too close together the top creasing shaft will stop rotating when the cover is fed through the machine

Leave the fixing screws loose until a sheet of cover stock is rotated in between the creasing units.



Tighten the shaft fixing screws in the desired position

Slowly run a sheet of cover stock between the crease units. As the cover stock rotates through the crease units the loose top crease units automatically centralise to the optimum crease position. Tighten down the fixings screws when the crease unit fixing screws come into view.

To achieve the optimum crease position the crease ribs must locate into the centre of the female channels.

Crease Rib Guide

Blue Split Creasing Ribs (M-90):
used to crease medium stock material 100-280gsm

Yellow Split Creasing Ribs (M-89):
used to crease heavy stock material 250-350gsm

Yellow Nylon Creasing Ribs (HO-ST/YE-PC):
used for creasing heavy and laminated stock material

Important

Creasing heavy covers

As the top creasing shaft is not driven by a motor the shaft can stop rotating when a heavy cover from 300 gsm upwards passes under the creasing parts. To overcome this problem place the same cover paper you are going to use on the book under the support collars and adjust the pressure setting so that a light grip is achieved, this procedure automatically sets the depth of crease to the right depth. It will then be necessary to slide away the top support collars so that the top and bottom support collars are not directly adjacent to each other.

By carrying out this simple operation you will now be able to crease up to 450gsm.