Perforation

Installation Instructions for GRAFIX Linear Perforation System

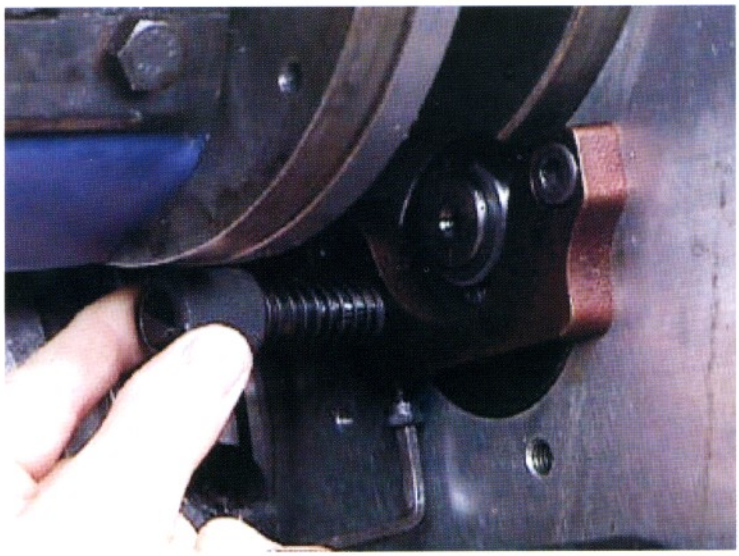

Fig. 1: Spring Loaded Retainer

To remove this, undo the socket head bolt underneath right hand side bracket.

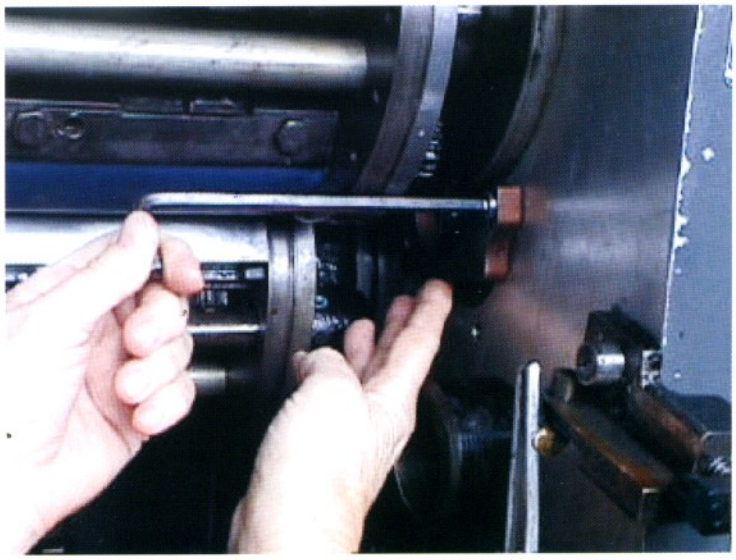

Fig 3: Remove Retaining Bolts

Undo the two socket head bolts holding brackets to side frame, making sure not to drop the spacer washers from behind brackets. TIP: A good idea is to put a rag over the delivery chains to catch the washers just in case they do fall

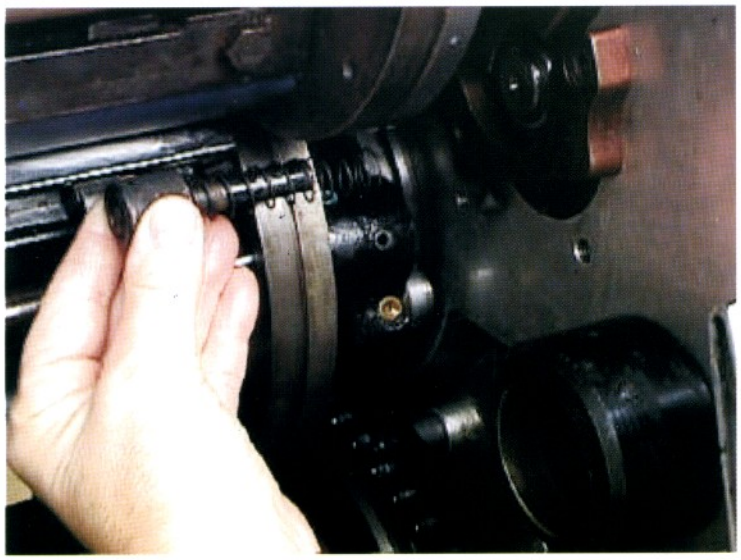

Fig 2: Remove Spring Loaded Retainer

This will now pull out, enabling you to reach the rear bracket bolt.

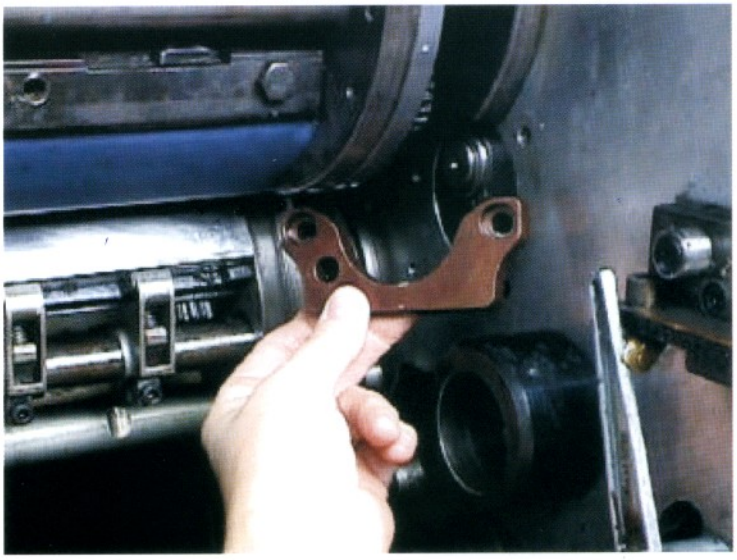

Fig 4: Remove Bracket

Remove original bracket. This is to be replaced by a new bracket. Repeat Fig. 3 & 4 on other side of press.

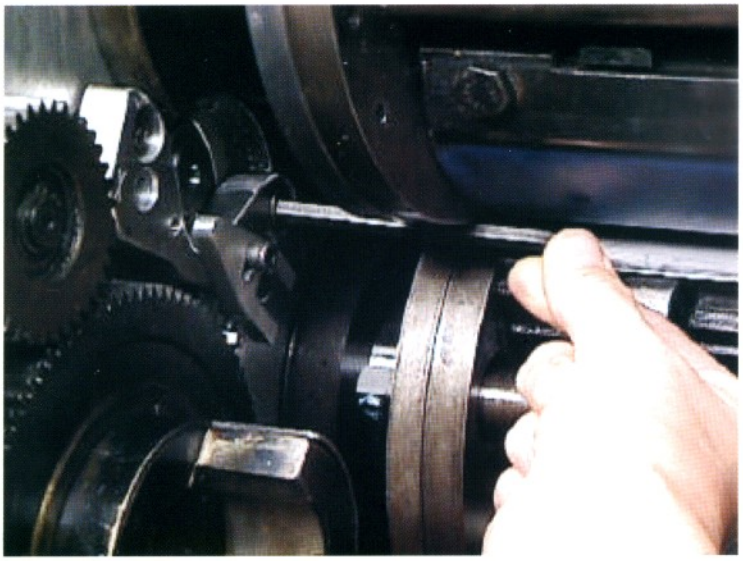

Fig 5: Installing New Brackets

The New Left hand side bracket is now installed. Note: At this stage the fork shaped lever should be hanging loose. Do not forget to put the spacer washers behind brackets. Repeat operation on right hand side. Note: Right hand side bracket does not have a lever attached to it.

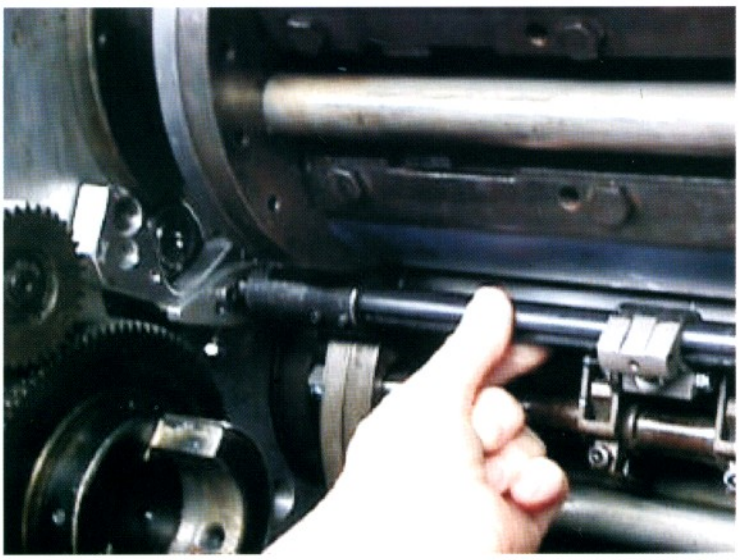

Fig 6 : Fit Carrier Bar

The perforation carrier bar is now installed. The left hand side is now pushed firmly into place making sure the flats on the adaptor fit into the fork shaped lever when the adaptor is pushed firmly in place. Hold the adaptor in place and slide the bar over to the right into the right hand side bracket. Both ends must be pushed all the way into the brackets.

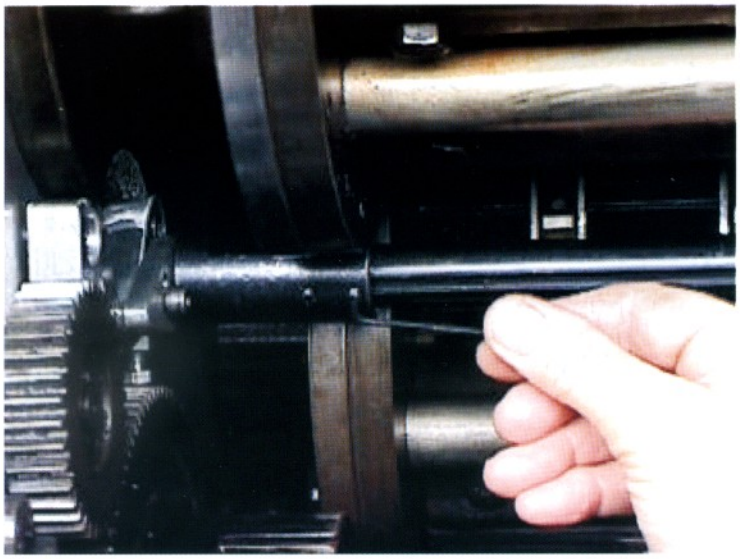

Fig 7: Lock in Carrier Bar

Now that the bar and adapter are fully extended into the brackets, lock the two grub screws in adapter onto the bar. This ensures that the bar will not slide into adapter during print run.

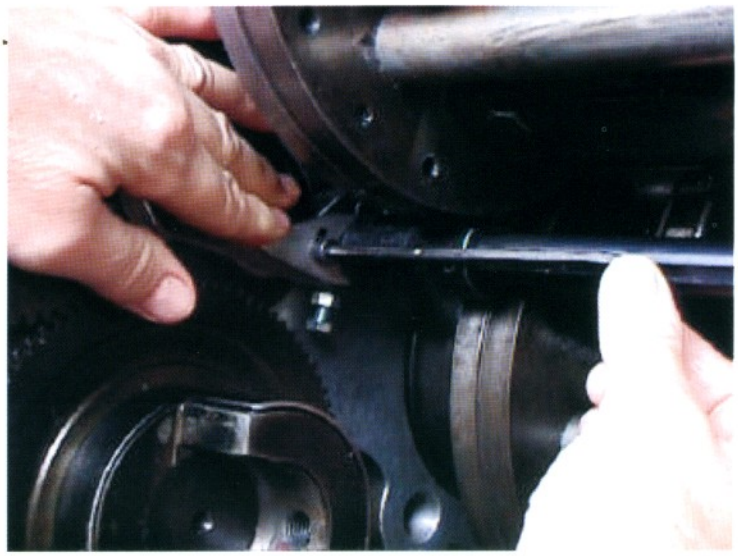

Fig 8: Setting Spring Tension

Rotate machine forward till the wheels are about 50mm past the grippers & resting on the jacket. Press down on lever on left hand side bracket. This will put pressure on springs and you will notice the gaps open up on the perforation heads. Press down until a 3.5 to 4mm gap appears. At this position lock the grub screw holding the lever to the bracket. This adjustment can also be used to increase pressure i.e.: thickcard (there are also heavy duty springs supplied for this purpose) Heavy duty springs and extra pressure should only be used when necessary. The light springs as originally fitted to the unit, plus the 3.5 to 4mm tension setting are usually all you need. It is this light spring tension in conjunction with our specially ground wheels that help to make the jacket last longer!

TIP: Keep wheels sharp. This lengthens jacket life i.e. less pressure required to cut stock.

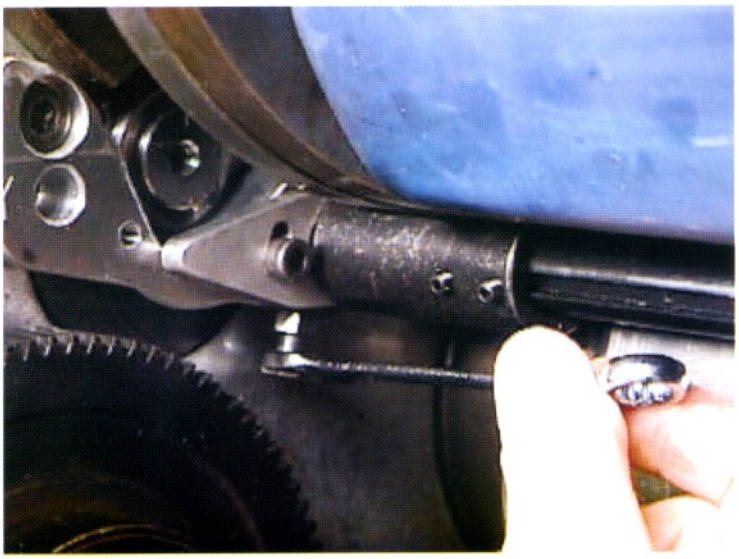

Fig 9: Lock Bar Into Brackets

Fig 9 & 10. Now that you have set the tension the bar must be locked in place. This is done by the bolts underneath each bracket. Tighten each bolt (Do not over tighten) then run up the locking nuts and just nip these up.

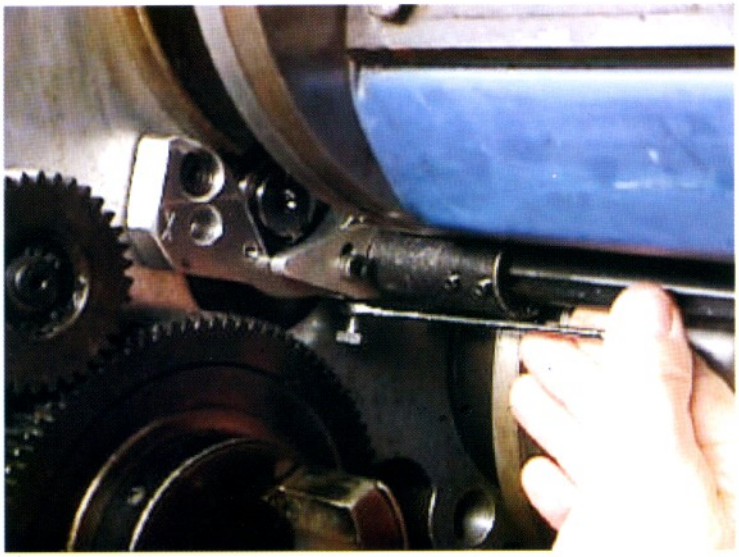

Fig 10: Tighten Locking Nuts

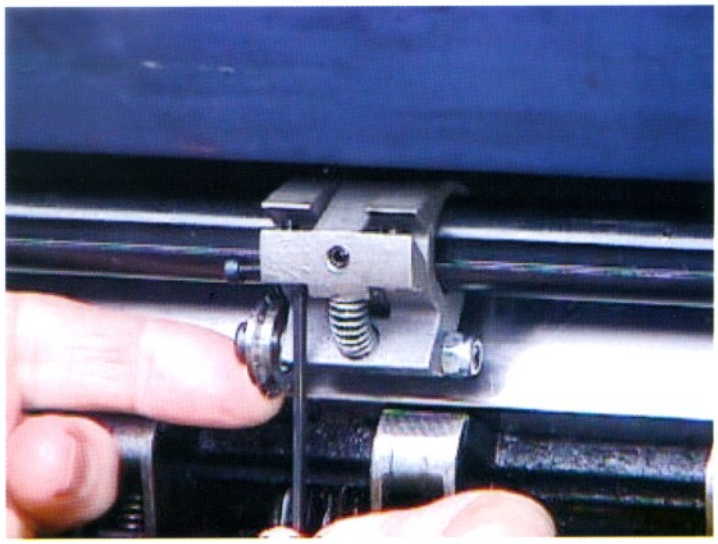

Fig 11: Set the Head Height

The grub screw on left (underneath) sets the head height. **Wind all perfs off before setting.** Lower each one down until you achieve the correct pressure to jacket turning wheel with finger as shown.

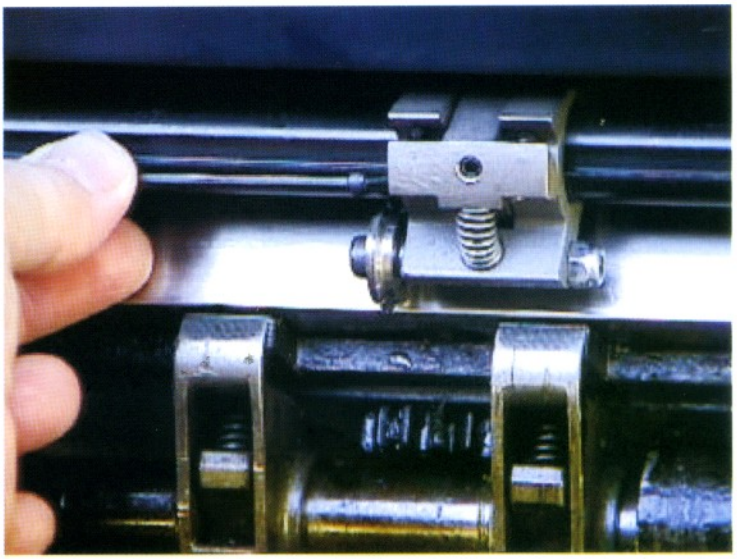

Fig 12: Lock Height Setting

When correct setting is achieved this small screw is locked onto the setting screw. **Do not over tighten.**

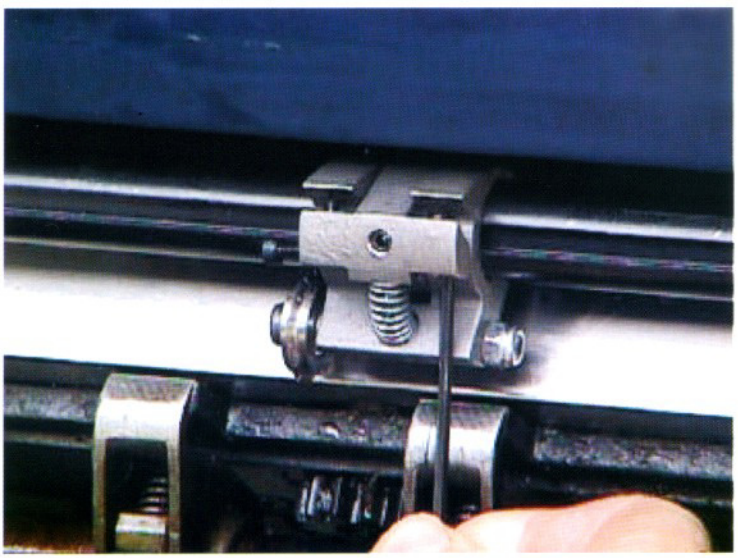

Fig 13: Wheel Lift Off Screw

At the end of the run use this screw to lift head as soon as wheel lifts off cylinder turn this screw (1 turn only). If you lift the wheel too far you will damage the springs!

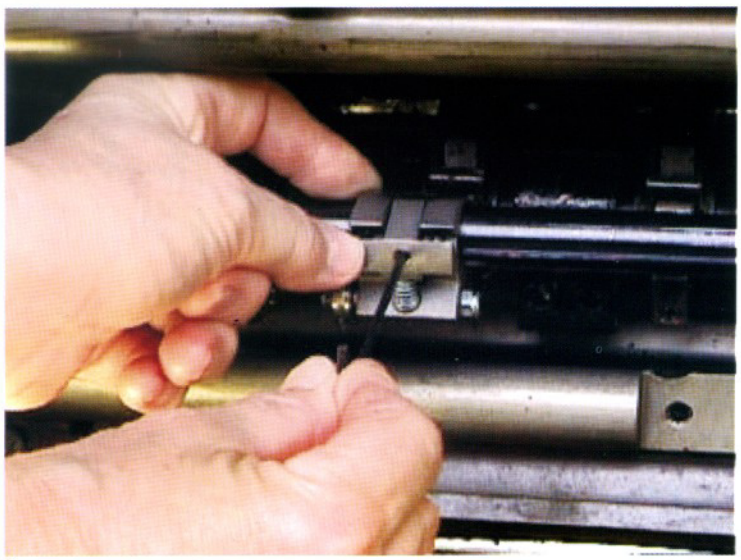

Fig 14: Moving Perforation Head

This operation is best done in the jaws of the cylinder. Undo center grub screw as shown. With an upwards downwards action on allen key, you will find slight side pressure will move unit accurately into new position.

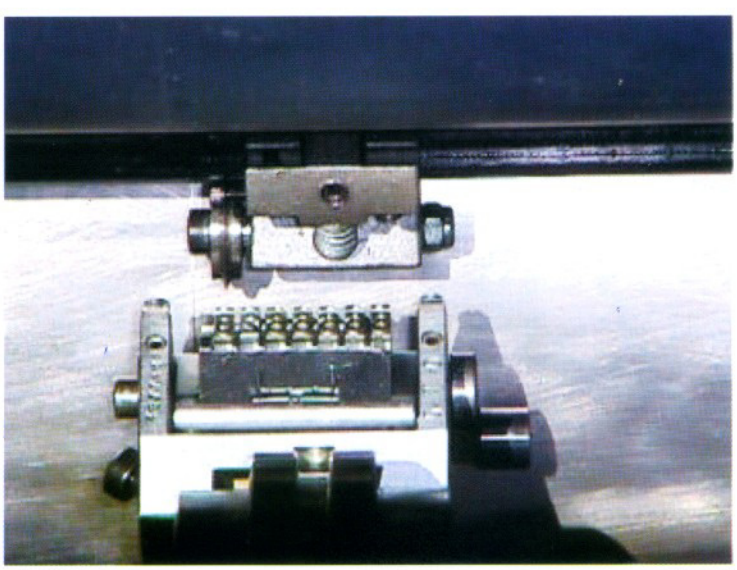

Fig 15: Check Numbering Box Clearance

As you will see the perforator does not restrict the positioning of the numbering box. Therefore the problems of repositioning numbers at the artwork stage do not occur.