

Perfect Binder Problem Solving Tips-n-Hints		
Problem	What to look for...	What should you do...
Nail heading	<ul style="list-style-type: none"> <li>a. Glue pot too high.</li> <li>b. Nipper too high.</li> <li>c. Nipper plates not adjusted properly.</li> </ul>	<ul style="list-style-type: none"> <li>a. Lower glue pot.</li> <li>b. Readjust nipper.</li> <li>c. Reset nipper plates.</li> </ul>
Cover loose from book	<ul style="list-style-type: none"> <li>a. Nipper not coming up high enough.</li> <li>b. Insufficient glue.</li> <li>c. Glue in pot too cold.</li> <li>d. Nipper plates not set properly.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust nipper.</li> <li>b. Increase amount of glue on glue rolls.</li> <li>c. Reset gluepot temperature control.</li> <li>d. Reset nipper plates.</li> </ul>
Cover does not register with book	<ul style="list-style-type: none"> <li>a. Cover stops set wrong.</li> <li>b. Clamp stops in wrong position.</li> <li>c. Cover moved before being applied to book.</li> <li>d. Operator not feeding book against the clamp stops.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust cover stops for cover.</li> <li>b. Reset clamp stops to center book in clamp.</li> <li>c. Cover may not lay flat. Roll cover to lay flat.</li> <li>d. Pay more attention to keep book against stop.</li> </ul>
Glue applied to only small portion of book	<ul style="list-style-type: none"> <li>a. Book moving in clamp.</li> <li>b. Glue level low in gluepot.</li> <li>c. Glue rolls not turning.</li> </ul>	<ul style="list-style-type: none"> <li>a. Increase clamp pressure.</li> <li>b. Add more glue to pot.</li> <li>c. Turn on glue pot drive.</li> </ul>
Book not being cut clean (pages toward stationary clamp fold over)	<ul style="list-style-type: none"> <li>a. Saw blade gate worn.</li> <li>b. Cutters dull.</li> <li>c. Gate not set correctly.</li> </ul>	<ul style="list-style-type: none"> <li>a. Replace.</li> <li>b. Re-sharpen or replace.</li> <li>c. Reset saw gate.</li> </ul>
Books stick or stay on delivery chute	<ul style="list-style-type: none"> <li>a. Glue on delivery chute.</li> <li>b. Too much glue on book.</li> </ul>	<ul style="list-style-type: none"> <li>a. Remove glue and spray with silicone.</li> <li>b. Adjust amount of glue on rollers.</li> </ul>
Build up of glue on one end of book	<ul style="list-style-type: none"> <li>a. Speed of glue roll is wrong.</li> </ul>	<ul style="list-style-type: none"> <li>a. If glue build-up is on leading edge, increase the glue roll speed. If glue build-up is on trailing edge, lower the glue roll speed.</li> </ul>
Excessive glue strings forming	<ul style="list-style-type: none"> <li>a. Glue pot too low.</li> <li>b. Glue temp not hot enough.</li> <li>c. Damaged music wire.</li> </ul>	<ul style="list-style-type: none"> <li>a. Raise glue pot.</li> <li>b. Increase glue temp.</li> <li>c. <a href="#">Replace if damaged.</a></li> </ul>
Book is distorted when it gets into delivery	<ul style="list-style-type: none"> <li>a. Running glue too hot.</li> <li>b. Nipper improperly set.</li> </ul>	<ul style="list-style-type: none"> <li>a. Reduce glue temperature.</li> <li>b. Readjust nipper setting.</li> </ul>
Clamp stops about 3" too far right at nipper	<ul style="list-style-type: none"> <li>a. 1 ohm resister is not working.</li> <li>b. 1 ohm potentiometer is not working.</li> </ul>	<ul style="list-style-type: none"> <li>a. Replace resister.</li> <li>b. Replace potentiometer.</li> </ul>
Clamp fails to stop at nipper, delivery or end of cycle	<ul style="list-style-type: none"> <li>a. Clamp is not activating switch properly at these positions.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust switches position or replace if defective.</li> </ul>
Book does not drop from clamp and jams on clamp return	<ul style="list-style-type: none"> <li>a. Not enough time is being allowed for book to drop.</li> <li>b. Clamp is not properly adjusted for book thickness.</li> <li>c. Clamp appears to have glue present.</li> </ul>	<ul style="list-style-type: none"> <li>a. Increase time delay.</li> <li>b. Readjust clamp.</li> <li>c. Clean all clamping surfaces.</li> </ul>
Glue pot will not heat properly	<ul style="list-style-type: none"> <li>a. Heaters not working properly or low voltage.</li> <li>b. Fuse blown on temperature controller.</li> </ul>	<ul style="list-style-type: none"> <li>a. Check for burned out heaters and replace if necessary.</li> <li>b. Replace fuse.</li> </ul>
Cutter motor will not start	<ul style="list-style-type: none"> <li>a. Safety switch is not properly set or cover is off.</li> <li>b. Heater elements have shut off.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust safety switch.</li> <li>b. Reset starter or timer.</li> </ul>
Glue rollers do not turn	<ul style="list-style-type: none"> <li>a. Drive may not be engaged.</li> <li>b. Check switch or timer.</li> <li>c. Check for blown fuse.</li> </ul>	<ul style="list-style-type: none"> <li>a. Open front glue pot door and lifting glue pot with handle.</li> <li>b. Switch may not be on or timer might have shut the glue rollers down.</li> <li>c. Replace fuse.</li> </ul>
Nipper will not run	<ul style="list-style-type: none"> <li>a. Switch may be in jog position.</li> <li>b. Check for blown fuse.</li> </ul>	<ul style="list-style-type: none"> <li>a. Place switch in run position.</li> <li>b. Replace fuse.</li> </ul>
Machine will not cycle	<ul style="list-style-type: none"> <li>a. Cutter motor must be on.</li> <li>b. Glue pot must be up to temperature.</li> </ul>	<ul style="list-style-type: none"> <li>a. Turn on cutter motor.</li> <li>b. Preset gluepot before production. Glue must be molten before cycling.</li> </ul>