



Dumor!

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Innovation !**



TECNICAL BULLETIN 14

Technical info

MULTI ACCESSORIES TB # 12 ADDITION

Use of the cross perforating tool

Permitted operation modes of the Dumor Lightning, Multi-Air and Hand fFeed Multi.

Due to several cases of users trying out - of - spec operation and making complaints we give you the allowable spec of operation of the Multi range of machines
Please read the spec carefully, if you have questions contact us

Paper sizes

Paper sizes from A5 to SRA3; longer formats may be used after user test but are not warranted.

Paper exterior cut accuracy prerequisites for stable feeding

On the sheet.

The lead edge has to be absolutely straight and square to the register edge or the infeed register position will vary.

The register edge has to be absolutely straight or the paper will not feed in accurately.

The paper has to be clean cut with no hooking

On the pile.

The sides of the pile have to be absolutely even or the guides will not grip the paper and skew will occur.

Paper quality

Light card only

Weights from caliper 0.1MM CA100 to caliper 0.35 MM CA 350 GSM lighter and heavier weights may be used after user test but are not warranted

Note that if paper over 250 GSM is used a wider bar (1,5 mm line; optional) may be required.

Exclusions

Super hard calendered paper => crease line may not be visible

Open grain blotting style paper may not feed or crease correctly



Synthetic papers like tyvec
Heavy film laminated card eg over 35 MICRON SINGLE SIDED note the film thickness counts as double for the caliper spec
Film or plastic sheets
Rough surface/ LEATHERETTE paper may feed double sheets due to grip and friction.

Infeeding direction

Only short edge first is allowed
Long edge first or square paper is not warranted as it will not feed in correctly and lead to skewing

Paper grain

Allowed crossways to infeed direction
Lengthways is not warranted as the crease line will not be so sharp

Creasing direction

Allowed :bottom up
Top down is not warranted as lead edge will catch on the crease bar pip

Paper curl at end

Allowed to +2 mm
Not allowed negative curl as will catch on the crease bar pip

Waviness

Not allowed due to infeed positioning accuracy issues

Static charge from the copier

The static charge must be fully removed before feeding

Hot paper direct from the copier

Not allowed due to feeding and static issues

Cross creasing

min crease step 0.5 mm
Note if the steps are set at less than 5 MM the standard tool will flatten the previous line; an optional narrow tools is available for this

Line positioning

1st line min from front edge 5 MM
Last line min from trailing edge 30 MM due to lack of main roller grip
Note shorter settings are possible but are not warranted

Line position accuracy +/- 0.2 MM ON LOW SPEED SETTING



Strike perfin spec on Lightning

min from lead or tail edge of sheet 0 mm
min on distance 10 mm
min off distance 10 mm
min separation of lines 45mm
min distance of line from edge 10 mm

Infeed skew accuracy ± 1 deg
note the skew knob at the back of the tray corrects in the opposite direction of the apparent skew error.

Toner flaking at crease line

Not warranted as paper grain related issue, to minimise it the bar should press the toner into the grain.

Limitations of tools

Cross perf bar
12tpi to approx 220 GSM
24tpi to approx 180 GSM
48 tpi to approx 120 GSM

Linear tools

Linear tools min separation of lines 35 mm
min setting from edge ca 10 mm

Slitting to approx 200 GSM

Kiss cutting to approx 0.15 MM STICKER

Rotary perfin or strike perfin to approx 220 GSM

Rotary scoring to approx 200 GSM

Tool kinds should not be mixed in the same run

Dumor Crew

www.dumor.be

