

## TECNICAL BULLETIN 8

# Technical info

August 2015

Hi All

Here is a technical bulletin with information covering several different products. Please read carefully and translate for your tech service as needed.

### TECHNICAL BULLETIN NR 8

---

**Subject:** Light paper feeding kit for **Multi Air** top feeding machines

#### Background

The **Multi Air** will feed just about any kind of paper.

However due to the extra high amount of air blast lighter stocks can “dance around” in the tray and loose their register with a resulting erratic infeed skew. I have developed a European made kit to reduce this problem almost to 0.

The kit is available on all new units for 299€ supplement.

For older machine the kit can be retrofitted by a competent technician in about ±30 minutes.

#### What is involved in the kit:

- 1- A dual position cut out switch for fan nr 2 to reduce the air volume.
- 2- The movement of the tray limit switch upwards by ca 5 mm to reduce sheet buckling when sucked by the belt, this involves drilling 2 x M3,5 holes and tapping M4 to move the limit switch screws 5 mm above their current position.
- 3- The fitting of 3 magnetic guides to the machine.
  - A guide clipped to the register plate that stops the paper climbing up the register plate.
  - A long guide fitted to the suction box that holds the paper flat.
  - A guide fitted/clipped to the cross bar cover that stops the paper climbing up the moving side guides there are 2 variants, short for A4 and long for A3.
- 4- The use of a smaller back stop to let the air in the pile escape and not float the sheets too high.

5- Extra option: A paper cross curling plate to stop light papers rolling up in the tray (supplemental cost to kit)

## Setting the machine

### Prerequisites:

Paper has to be flat, cut at right angles and the sides of the pile straight and square, the skew correction should be set at neutral.

If the paper in the pile is not cut equally feeding errors will occur the paper should be de-reamed to enter air into the pile.

A lower than max pile height will allow for more accurate feeding.

- 1- Set the height switch so that the pile stops at about 1 cm lower than the suction belt.
- 2- Set the air blast gates nearly closed.
- 3- Set the sheet separators nearly closed.
- 4- Cut out fan nr 2.
- 5- Set the guides as per the pictures attached.
- 6- Set the feed speed on slow speed.
- 7- Set the side guides firmly against the paper pile (the latest generation of side guide is lightly sprung to lean in by about 3 degrees).
- 8- Set the back stop lightly against the pile.

Do a trial run of 10 sheets to check line accuracy.

You will find the accuracy is much better than before both on creasing and per-  
fing

***Have fun and remember Dumor machine are easier to repair!***

**Dumor Crew**



**[www.dumor.be](http://www.dumor.be)**

