

User manual

BLM 500 / Bookletmaker 50

Operating information

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Chapter 1

Introduction to the Booklet maker

Introduction

Introduction

Thank you for choosing the Booklet maker.

Your Manual

The User Manual for the Booklet maker describes how to perform these tasks:

- Operate the Booklet maker
- Find and correct error conditions
- Perform normal maintenance tasks

Operator training is given when the Booklet maker is installed. To make sure you use your Booklet maker correctly, read your manual.

The User Manual for the Booklet maker does not describe the operation of the printer. If needed, refer to your printer user manual.

Safety Information

Safety information is included in the separate “Safety Information Manual.” Read the safety information before you use your Booklet maker.



Caution: A CAUTION message tells you that a procedure or operation can be dangerous. To prevent injury, you must follow the instructions.



Attention: An ATTENTION message tells you that a procedure or operation can damage the machine or the product. To prevent damage, you must follow the instructions.

Installation

Your Booklet maker must be installed by a service engineer. Special knowledge is needed to install the machine.

Attention:

Connect the machine only to a power supply of the correct voltage with a good ground connection. The correct machine voltage is shown on the label at the power supply input on the rear of the machine. If the machine is connected to the wrong supply, the warranty is voided.

How to Get Help

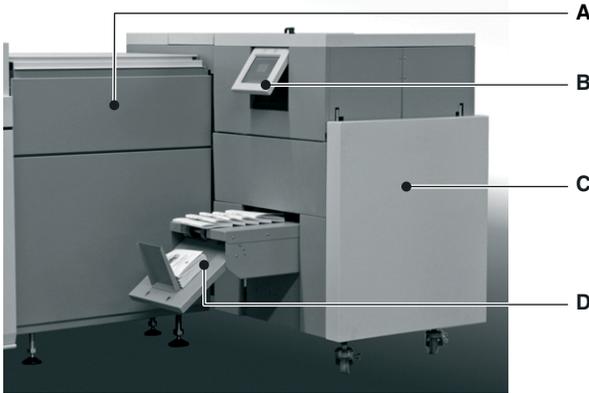
If you have any questions or problems, refer to the problem-solving section in this manual (see the chapter “Error Conditions, Problems, and Solutions”). Contact your Booklet maker supplier for further help.

Description of the Booklet maker

Introduction

The Booklet maker operates online with digital printers to process sets of printed pages into stitched books. The main parts are shown below.

Illustration



[1] Operator Side of the Booklet maker

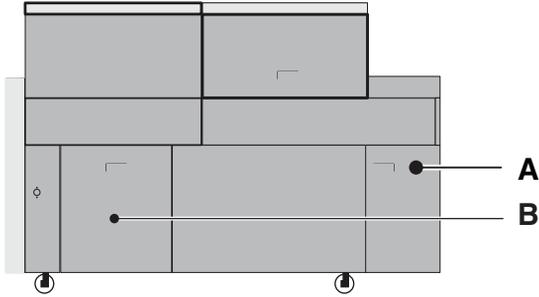
Component - function table

[1] Operator Side of the Booklet maker

	Component	Function
A	The connecting bridge	The connecting bridge moves the printed sheets from the printer to the Booklet maker. If needed, the sheets are rotated into the correct direction. Rotation lets the printer operate at optimum print speed. Adjustment for the size of the paper and sheet rotation is automatic, according to the settings entered on the touch screen.
B	The user interface	The user interface has a color touch screen, a start button, and a stop button.
C	The Booklet maker	The Booklet maker stitches, folds, spine-forms, and trims the sheets to make a finished book.
D	The stacker	The stacker collects the finished books.

Right-Hand Side of the Booklet maker

Illustration



[2] Right-hand side of the Booklet maker

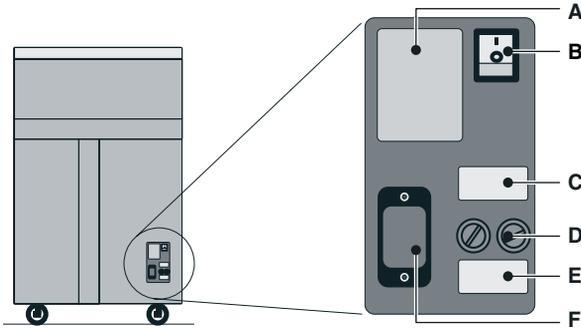
Component - function table

[2] Right-hand side of the Booklet maker

	Component	Function
A	The stitch-wire cabinet	The stitch-wire cabinet holds the spool of stitch-wire.
B	Trim Bin	The trim bin collects the paper that is trimmed from the edge of the book

The Rear Panel of the Booklet maker

Illustration



[3] The Rear Panel of the Booklet maker

Component - function table

[3] The Rear Panel of the Booklet maker

	Component	Function
A	Rating and serial label	The rating label displays the type of machine, serial number, power use, and fuse information.
B	Power ON/OFF switch	The power ON/OFF switch turns the Booklet maker ON or OFF. When you turn OFF the Booklet maker, the current settings are stored.
C	Voltage advisory label	The voltage advisory label tells the installer to refer to the installation instructions before the Booklet maker is connected to the electrical power supply. The Booklet maker can be adjusted for one of several different input voltages.
D	Fuses	The fuses make sure the operator and the machine are protected if there is an electrical problem or short circuit.
E	Voltage label	The voltage label is fitted to the Booklet maker during the installation procedure. The voltage label displays the selected voltage.
F	Power input connector	The power input connector is used to connect the Booklet maker to the electrical power supply.

Chapter 2

How to run the Booklet maker

This chapter gives information on how to run a job on the Booklet maker. For information on how to operate the printer, refer to the printer documentation. Information about the user interface is included in the chapter “The User Interface.”

Information about standard procedures, for example opening covers to clear a paper jam, is included in the chapter “Standard Tasks.”

Before You Begin

Paper and Book Quality Instructions

- The size of paper and the thickness of the set must be measured. These measurements are entered via the touch screen before you begin a print job.
- Measure the size of the printed paper. The paper dimension changes when the paper is printed.
- Measure the set thickness as accurately as possible. Use the measuring tool supplied with the machine.
- Enter accurate dimensions via the touch screen.
- If the book is made from several different types of paper, make sure the different paper types are all the same size.

See [Book Quality on page 63](#) for further information.

Turn ON the Booklet maker

Procedure

1. Connect the Booklet maker to the power supply.
2. Use the ON/OFF switch to turn ON the Booklet maker.

Result

The machine makes this sequence of beeps:
'beep__beep beep beep beep_____ beep beep'.

The touch screen illuminates and the machine is ready for use.

Enter the Job Settings

Introduction

Enter the settings for a new job in the BASIC window on the touch screen. See the chapter “The User Interface” for more information.

The PAPER SIZE and PAGE DIRECTION settings are entered on the touch screen. These dimensions refer to the format of the paper when it enters the Booklet maker.



Attention: Do not operate the touch screen with a sharp object or with too much force. These actions can damage the touch screen.

Before You Begin

Step	Action	Information
1	Print a set to the stacker.	
2	Measure the sheet size and the set thickness.	Measure the set accurately. To make an accurate book you must enter accurate paper dimensions via the touch screen.
3	Use these dimensions for the job setting.	



Note: *This set can be made into a book (see [Operate the Booklet maker offline on page 47](#)).*

Procedure for a New Job

Step	Action	Information
1	Touch BASIC	
2	Enter the paper size	Touch PAPER SIZE. Enter the dimensions of the paper. The job setting is easier if you first select a preset paper size, then adjust the settings as necessary Touch PAPER SIZE > PRESETS > A3 or A4. (USA: 11x17, 8.5x11 or 8.5x14)
3	Enter the page direction	Touch PAGE DIRECTION > LANDSCAPE or PORTRAIT. If the PAGE DIRECTION option is not available, the PAGE DIRECTION cannot be changed.
4	Enter the page rotation setting	For A4 paper size, the normal setting for ROTATE is ON. Rotation lets the printer operate at optimum speed. Touch ROTATE to turn the sheet rotation ON or OFF. Always select the page direction before you change the rotate setting.
5	Enter the set thickness.	Touch SET THICKNESS. Enter the measured value.
6	Enter the number of stitches.	Touch STITCHES and enter the number of stitches. If needed, the stitch pitch can be changed. See "STITCH PITCH," table 9 on page 25
7	Enter the spine form setting	The spine form setting is automatic, according to the SET THICKNESS setting. If needed, the setting can be changed. See "FORM" in table 9 on page 25
8	Enter the trim setting.	The trim setting is automatic, according to the PAGE SIZE and SET THICKNESS settings. To change the setting, touch TRIM. See "TRIM" in table 10 on page 27
9	Touch CLOSE	
	If needed, save the job settings to memory.	If the same job settings are used frequently, then save the job settings to memory. See "Save a job." Load and Save the Job Settings on page 34

Procedure for a Saved Job

1. Touch LOAD & SAVE

Enter the Job Settings

2. Touch the job name or use the Up arrow or the Down arrow to select the job.
3. Touch LOAD.
4. Wait until the Booklet maker is ready

Stacker adjustment

Adjust the Stacker

Adjust the stacker according to the size and thickness of the finished book [Adjust the Stacker on page 45](#).

Run the Job

1. Make sure the adjustments on the Booklet maker are complete before you release the print job from the print queue.
2. Start the print job. The Booklet maker starts automatically.
3. Check the quality of the first book.
4. If the quality is not acceptable, make adjustments (see [‘Book Quality’ on page 63](#)).

Result

During the job

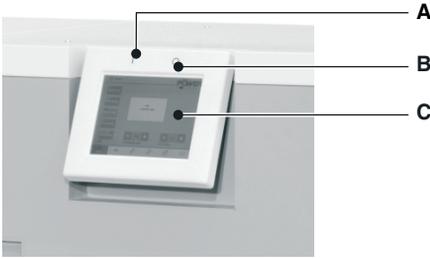
- Unload books from the stacker before the stacker is full. The Booklet maker stops and displays a message if the stacker is full.
- Empty the trim bin from time to time. The Booklet maker displays a message if the trim bin is full (see [‘Empty the Trim Bin’ on page 43](#)).

Chapter 3

The User Interface

The Touch Screen

Introduction



[4] The User Interface

A	START Button
B	STOP Button
C	Touch Screen

The user interface includes a color touch screen and START/STOP buttons.

Operate the touch screen with your fingertip. You can touch the screen with a blunt item, for example a palm-top 'wand' or the blunt end of a pen. Do not use too much force. A light touch is all that is needed.

Power save

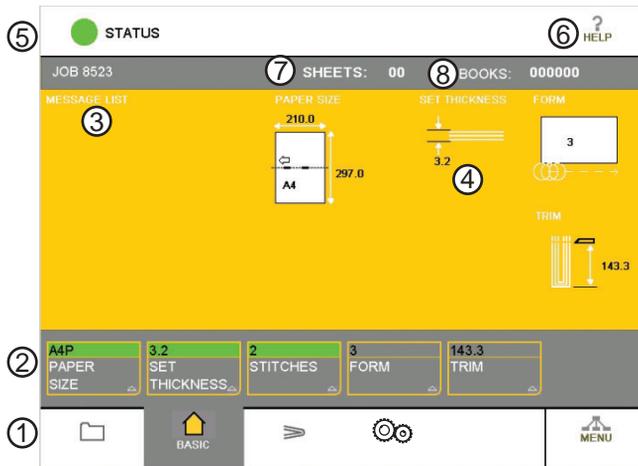
The touch screen has a power-save function. After several minutes without use, the brightness of the touch screen decreases. After several hours, the touch screen turns off. Touch the screen to restore the normal brightness. The touch screen takes two or three minutes to reach full brightness.

If you hear a 'beep' when you operate the touch screen, the selected function is not available. Some functions are not available when the machine is in operation. Some functions and buttons are only available at certain access levels. See "ACCESS LEVEL" [The MENU Window on page 31](#).



Attention: Do not operate the touch screen with a sharp object or with too much force. These actions can damage the touch screen.

Illustration



[5] The Touch Screen

Component - function table

No.	Component	Function
1	Window Tabs	The touch screen buttons are divided into groups that have related functions. Each group of buttons has a separate window. Touch the correct tab to select the window. LOAD & SAVE BASIC ADVANCED CONFIGURE MENU
2	Window Buttons	Each window contains a group of buttons. Touch the button to select the function.
3	Message List	Information and error messages are shown in the MESSAGE LIST . To display the information about a message, touch HELP then touch the message list.
4	Job Mimic	The job mimic shows the current machine settings.

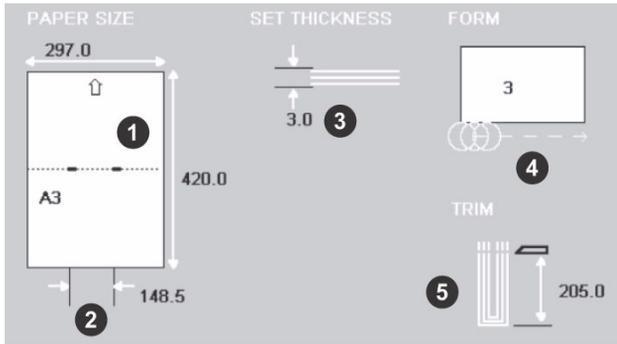
No.	Component	Function
5	Status	The STATUS line shows the machine status.
	- GREEN	The Booklet maker is READY or RUNNING .
	- ORANGE	PLEASE WAIT - wait until the Booklet maker is ready. ATTENTION - the Booklet maker needs intervention by the operator.
	- RED	The Booklet maker is in an ERROR condition.
6	Help	Help text is available on the touch screen. <ul style="list-style-type: none">■ Touch HELP then touch any button or tab on the screen. Information about that button or tab is displayed.■ Use the Up arrow and the Down arrow to scroll up and down the screen.■ Some text has more than one screen. Use the right arrow and left arrow to see the other screens. To leave the help text, touch HELP or touch X .
7	Sheet Counter	The sheet counter shows the number of sheets in the gathering area. The counter starts again with each book.
8	Book Counter	The book counter shows the number of books made. The counter is reset to zero when the Booklet maker is turned off.

The Job Mimic

Introduction

The job mimic shows the current machine status.

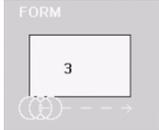
Illustration



[6] The Job Mimic

Component - function table

No.	Icon	Information
1		<p>The following items are shown</p> <ul style="list-style-type: none"> ■ the size of paper ■ the format of the paper in the gathering area ■ the broken line shows the fold line ■ the small thick lines show the stitches ■ the arrow shows the original feed edge in the printer
2	<p>Stitch Pitch</p>	<p>The stitch pitch is shown only when a non-standard setting is selected.</p>
3		<p>The set thickness, in mm, is shown.</p>

No.	Icon	Information
4	 The icon for the FORM function is displayed on a grey background. It features the word "FORM" at the top. Below it is a white rectangular box containing the number "3". At the bottom left of the box are two overlapping circles, and at the bottom right is a dashed line with an arrow pointing right. A red "X" is superimposed over the entire icon.	The number of forms is shown. If the pressure is adjusted, the setting is shown in brackets. A red X shows that the form function is not active.
5	 The icon for the TRIM function is displayed on a grey background. It features the word "TRIM" at the top. Below it is a white rectangular box containing a vertical scale with a horizontal bar at the top. To the right of the scale is the value "205.0". A red "X" is superimposed over the entire icon.	The trim setting is displayed. A red X shows that the trim function is not active.

The BASIC Window

Introduction

The **BASIC**  window gives you access to frequently-changed machine settings.

Button overview

[9] The BASIC Window Buttons

(1 – 2)

Button	Information
PAPER SIZE	Measure the accurate size of the paper before you make a book. Touch PAPER SIZE to enter the paper size. When the machine is in operation, you can adjust the PAPER SIZE by a maximum of +/- 1 mm.
- PAGE DIRECTION	Touch PAGE DIRECTION to change the direction of the paper to Landscape or Portrait.
- ROTATE	Touch ROTATE to set the sheet rotation ON or OFF. If you select A4 portrait (USA: 8.5x11), ROTATE is set to ON automatically.
- PRESETS	Touch PRESET to select a standard paper size.
SET THICKNESS	Use the SET THICKNESS window to define the thickness of the set. Measure the thickness of the set before you make a book. Touch SET THICKNESS and enter the value.
STITCHES	Touch STITCHES to select the number of stitches. Available options are 1 - 6 . The machine automatically calculates the position of the stitches according to the size of the paper. Select 0 to turn off the stitch function.
- STITCH PITCH	The stitch pitch is the space between the stitches. The machine automatically calculates the stitch pitch according to the size of the paper. If a non-standard stitch pitch is needed, use STITCH PITCH to make the adjustment.
- AUTO	Touch AUTO to select the default stitch pitch.

Button	Information
FORM	<p>To make the square spine of the book, pressure is applied to the spine. This process is called forming. Touch FORM to specify the amount of spine form. To make a good spine on different paper types, the amount of spine form can be changed.</p> <p>To change the amount of spine form</p> <ul style="list-style-type: none"> ■ Touch NUMBER to change how many times the spine is processed ■ Touch PRESSURE to change the pressure
- AUTO	Touch AUTO to select the optimum amount of spine form, according to the set thickness.
- NUMBER	Touch NUMBER to select how many times the form roller processes the spine. The available options are 1, 2, 3, or 4. The form function can be turned off. An increase in NUMBER increases the time taken to form the spine and can decrease the production rate for thin books. Alternatively, increase the PRESSURE .
- PRESSURE	Touch PRESSURE to increase or decrease the pressure used to form the spine. Touch + to increase the amount of spine form. Touch - to decrease the amount of spine form. The range is -9 to +9. The default setting is 0.
- THRESHOLD	The square spine is formed only on sets thicker than 0.8 mm. To change this value, touch THRESHOLD and enter the value you need. The maximum value is 1.5 mm.
TRIM	The trim dimension is calculated automatically according to the PAPER SIZE and SET THICKNESS . If needed, the trim dimension can be changed. Touch TRIM to adjust the size of the finished book after the fore-edge is trimmed. The maximum trim is 28 mm. The trim function can be turned off.
- AUTO	Touch AUTO to select the default trim position.

The LOAD & SAVE Window

Introduction

The **LOAD & SAVE**  window lets you save and reload job settings. Each job is given a name. The jobs are displayed in a list on the screen. Touch the job name or use the Up arrow or Down arrow to make the selection.

Button overview

[10] The LOAD & SAVE Window Buttons

(1 – 2)

Button	Information
SAVE	Touch SAVE to save the current settings. An on-screen keyboard is displayed. Enter the job name. Touch OK or CLOSE . The new job appears in the list of saved jobs. You can reload a saved job to decrease set-up time in the future.
- REPLACE	If you change the settings of a saved job, touch REPLACE to save the new settings.
- CANCEL	Touch CANCEL if you do not need to save a job that you have changed.
- SAVE NEW	If you change the settings of a saved job, touch SAVE NEW to save the new settings as a new job. An on-screen keyboard is displayed. Enter the new job name. Touch OK or CLOSE . The original job is not changed. If the job name is not changed before OK or CLOSE is touched, the job will be saved with the current name followed by an asterisk *.
JOB DETAILS	JOB DETAILS shows the settings for each saved job. Select the job that you need to view from the job list. Touch JOB DETAILS to see a summary of the job settings.
LOAD	Touch the job name or use the Up arrow or the Down arrow to make the selection. Touch the LOAD button

Button	Information
PADLOCK SYMBOL	<p>The padlock symbol shows when a saved job is locked or unlocked. There is a small padlock symbol next to each locked job. To lock or unlock a job.</p> <ol style="list-style-type: none"> 1. select the job from the job list 2. touch the large key symbol. <p>A padlock symbol displayed in light grey shows that a job has been locked by a supervisor to prevent changes to the settings</p>
DELETE	<p>To delete a particular job it must be unlocked. Touch the job name or use the Up arrow or Down arrow to make the selection from the job list. Touch and hold DELETE. A red line appears. The red line fills from left to right. Hold DELETE until the red line reaches the right-hand side.</p>
VIEW OF JOB LIST	<p>VIEW OF JOB LIST changes the order that saved jobs are listed. There is a line between Factory Template jobs and jobs saved by the operator. The Factory Template jobs are at the top of the list</p>
- A->Z	<p>Touch A->Z to list the jobs in alphabetical order.</p>
- BY USE	<p>Touch BY USE to list jobs in the order they were last used. The most recently-run job is at the top of the list.</p>
- BY INDEX	<p>Touch BY INDEX to list jobs in numerical order. the machine gives a number to all jobs that are saved.</p>

The ADVANCED Window

Introduction

The **ADVANCED** ➤ window gives you access to special machine functions.

[11] Button overview

Button	Information
RE-REF	If the machine calibration appears incorrect or if an 'axis moving' error message remains on the screen, touch RE-REF to re-reference the adjustment axes. The adjustment axes return to the current settings. At intervals, the machine will re-reference the axes during the set-up procedure.
STITCHER UP	Touch STITCHER UP before you lubricate the stitch head. This action moves the stitch head to the correct position for lubrication.
PURGE SET	When an error occurs, a set or part of a set can remain in the gathering area. Touch START , then touch PURGE SET to clear the set from the machine. The book is not stitched or trimmed According to the type of error that occurred, there can be a pause of 7 seconds before the PURGE SET button will operate.
- MAKE BOOK	When an error occurs, a set or part of a set can remain in the gathering area. Touch START then touch MAKE BOOK to clear the set from the machine. The book is not stitched or trimmed. According to the type of error that occurred, there can be a pause of 7 seconds before the MAKE BOOK button will operate.

The CONFIGURE Window

Introduction

The CONFIGURE  window lets you make changes to the configuration of the machine.

Some functions and buttons are only available at certain access levels, see 'ACCESS LEVEL' [table 13 on page 31](#).

CONFIGURE Window Buttons

[12] Button overview

Button	Information	Supervisor Access
MACHINE OPTIONS	Touch MACHINE OPTIONS to view the general machine setup. Some of the settings can be changed, depending on the current access level.	Yes
- MEASUREMENT	Select 'mm' or 'inch' as the unit of measurement.	Yes
- STITCH SENSOR	There is a sensor that checks for stitches. Touch STITCH SENSOR to turn the stitch sensor on or off. The default setting is ON.	Yes
- PRESET PAPERSIZES	The preset paper sizes can be either ISO A sizes or US paper sizes. To select which preset paper sizes are available, touch the relevant button.	Yes
NETWORK SETTINGS	This button is used by the service engineer.	No
SHUTTLE	Touch SHUTTLE to make adjustments to the tamper.	Yes
-TAMPER DELAY	This button is used by the service engineer.	View only
- TAMPER TIME	TAMPER TIME adjusts the time that the tamper touches the set. An increase in TAMPER TIME causes a decrease in the production rate for thin books.	Yes
FORM SETUP	This button is used by the service engineer.	View only

The MENU Window

Introduction

MENU  shows the settings that are not changed during day-to-day operation.

These settings include

- Change the Access Level
- Change the display language
- Advanced machine settings that are accessed by a person who has the correct access-code.

Button overview

[13] The MENU Window Buttons

(1 – 2)

Button	Information
ACCESS LEVEL	<p>The Touch Screen has five different access levels</p> <ul style="list-style-type: none"> ■ Operator ■ Supervisor ■ Service ■ Distributor ■ Factory <p>Touch ACCESS LEVEL and select the correct level from the list. The last three levels are protected by access codes. To protect job settings, the supervisor level allows jobs to be locked.</p>
CURRENT LANGUAGE	Touch one of the flags to select the language you need.
AXES	Touch AXES to re-reference individual axes. Supervisor access level is needed for this function. Other functions on this button are used by the service engineer.
BRIDGE	Touch BRIDGE to re-reference the bridge axes. Supervisor access level is needed for this function. Other functions on this button are used by the service engineer.
SERVICE OPTIONS	This button is used by the service engineer.
TEST	This button is used by the service engineer.

Button	Information
COUNTERS	The counters display the <ul style="list-style-type: none">■ number of books that have been made■ number of sheets that have been processed■ number of stitches that have been used
-RESET	Touch RESET to reset the book, sheet counter, and stitch counter. Touch and hold RESET . A red line appears. The red line fills from left to right. Hold RESET until the red line reaches the right-hand side.

Chapter 4

Standard Tasks

This chapter describes the standard tasks that are needed in the day-to-day operation of your Booklet maker.

Load and Save the Job Settings

Introduction

The current job settings can be saved to memory and reloaded for use again at a later date. Load the 'Default Job Template' to reset the Booklet maker to normal settings.

Save a job

1. Touch **LOAD & SAVE**  **> SAVE**.
2. If these options appear, select one.
 - **REPLACE** to over-write the previous job with the current job settings.
 - **SAVE NEW** to save the current job with a new name.
 - **CANCEL** to cancel the job save.
3. Enter the name for the job on the keyboard
4. Touch **OK** or **CLOSE**.

Load a job

1. Touch **LOAD & SAVE** .
2. Touch the job name or use the Up arrow or the Down arrow to select the job.
3. Touch **LOAD**.
4. Wait until the Booklet maker has made the adjustments.

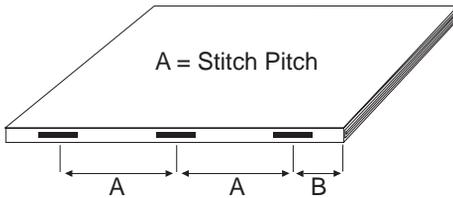
Reset the Booklet maker to default settings

1. Touch **LOAD & SAVE** .
2. Select the **Default Job Template** from the list of jobs.
3. Touch **LOAD**.
4. Touch **YES**.

Adjust the Stitch Pitch

Introduction

The stitch pitch is the space between the stitches. The machine automatically calculates the stitch pitch according to the size of the paper and the number of stitches. The stitches are inserted symmetrically on the spine of the book. If a non-standard stitch pitch is needed, use STITCH PITCH to make the adjustment.



[12] Stitch Pitch

Limitations:

- The minimum stitch pitch 'A' is 25 mm.
- The minimum distance from the center of the stitch to the edge of sheet 'B' is 15 mm.

When to do

If you need the Booklet maker to insert the stitches in a non-standard position. For example, to keep the stitches away from the text on the spine of the book.

Select a non-standard stitch pitch

1. Touch BASIC > STITCHES
 2. Touch AUTO. The STITCH PITCH value becomes green.
 3. Change the stitch pitch value. Either use the "+" and "-" or touch the green stitch pitch value to open a numeric keypad.
 4. Touch STITCHES to close the window.
- The stitch pitch value is displayed in the job mimic and on the STITCHES button.

Select a standard stitch pitch

1. Touch BASIC > STITCHES.
 2. Touch AUTO to select ON.
 3. Touch STITCHES to close the window.
- The stitch pitch value is not displayed in the job mimic or on the STITCHES button.

Open the Connecting Bridge Cover

Introduction

The Booklet maker will not stop if you open the connecting bridge cover.



[13] Connecting Bridge Cover in the open position.

A	Connecting Bridge Cover
---	-------------------------

When to do

If a machine error occurs, or for maintenance.

- To clear a paper jam
- To clean the static elimination bar



Caution: Keep your hands, clothing and hair away from the belts.

Procedure

Lift the connecting bridge cover.

Open and Close the Folder Cover

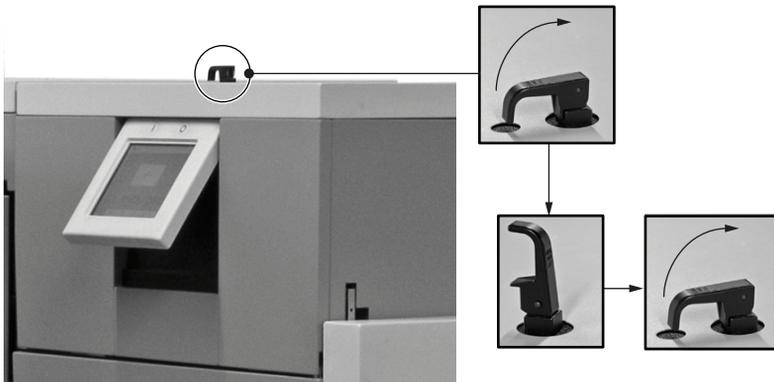
Introduction

If a machine error occurs, or for maintenance.

- To access the stitch area
- To access the folder area



Note: *The folder cover has an interlock switch. The Booklet maker stops if you open the folder cover.*



[14] Unlock and lock the Folder Cover.

Open the Folder Cover

1. Lift the black locking handle against the spring pressure.
2. Turn the handle through 90° to unlock.
3. Lift the folder cover carefully to the vertical position.

Close the Folder Cover

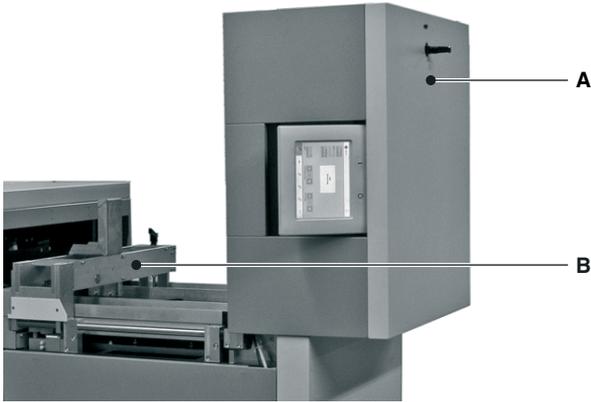


Caution: Check that the folder cover will not hit the clincher frame locking handle when you close the folder cover. If necessary, lift and rotate the clincher frame locking handle to a new position [figure 16 on page 38](#).

1. Lower the folder cover.
2. Turn the handle through 90° to lock.
3. Close the locking handle to lock the folder cover.

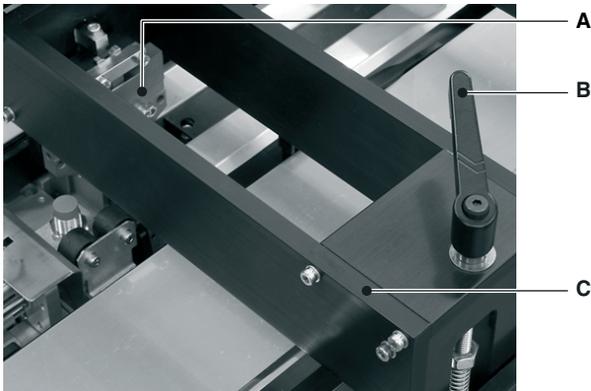
Lift and Lower the Clincher Frame

Introduction



[15] Folder Cover in the vertical position.

A	Folder Cover
B	Clincher Frame



[16] Clincher Frame Components

A	Clincher
B	Locking Handle
C	Clincher Frame

When to do

If a machine error occurs, or for maintenance.

- To clear a paper jam in the stitch area
- To unlock the Booklet maker main deck

Lift the Clincher Frame

1. Open the folder cover.
2. Turn the locking handle to the left  until the thread is disengaged.
3. Lift the clincher frame to the vertical position.

Lower the Clincher Frame

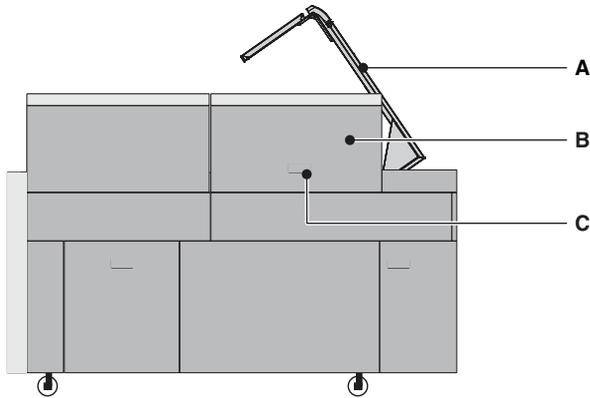


Attention: You must hold the weight of the clincher frame. Do not let the clincher frame fall on your hand.

1. Lower the clincher frame.
2. Turn the locking handle to the right  until the handle is tight.
3. Check that the locking handle will not be hit by the folder cover when you close the folder cover. The locking handle should point towards the middle of the machine. If necessary, lift and rotate the locking handle to a new position.

Open the Gathering Area Cover

Introduction



[17] Gathering Area Cover.

A	Connecting Bridge Cover open
B	Gathering Area Cover
C	Gathering Area Cover Handle

When to do

If a machine error occurs, or for maintenance.

- To access the gathering area
- To access the static elimination bar in the gathering area

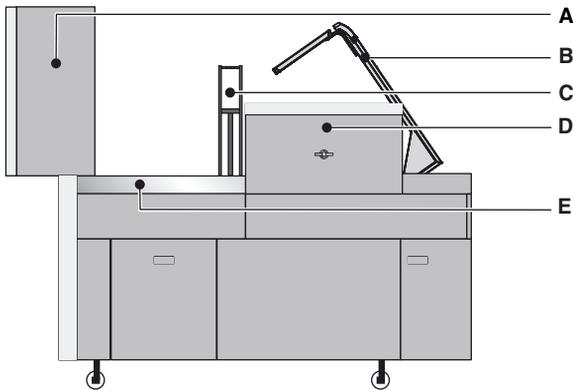
The Booklet maker will stop if you open the gathering area cover.

Procedure

1. Open the connecting bridge cover.
2. Use the gathering area cover handle to lift the gathering area cover.

Lift the Booklet maker Main Deck

Introduction



[18] Lift the Booklet maker Main Deck

A	Folder Cover open
B	Connecting Bridge Cover open
C	Clincher Frame lifted
D	Gathering Area Cover
E	Main Deck

When to do

If a machine error occurs, or for maintenance.

- To access the stitch head
- To access the former area
- To access the trim area

Procedure



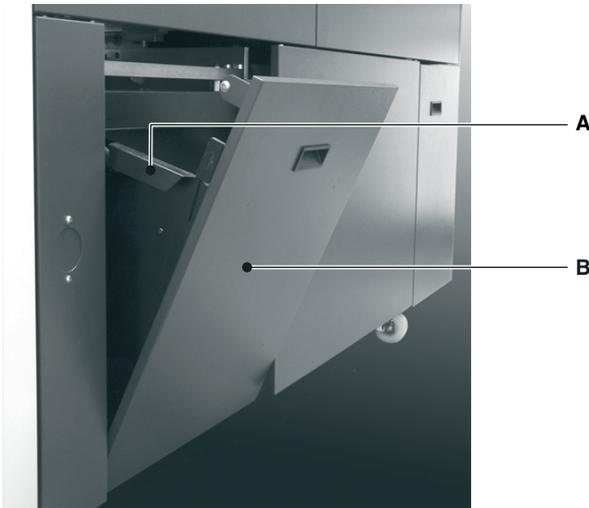
Caution: Keep your hands and fingers clear when you lift the main deck.

Lift the Booklet maker Main Deck

Step	Action	Information
1	Open the connecting bridge cover.	(see ' <i>Open the Connecting Bridge Cover</i> ' on page 36)
2	Open the folder cover.	(see ' <i>Open the Connecting Bridge Cover</i> ' on page 36)
3	Lift the clincher frame.	(see ' <i>Lift the Clincher Frame</i> ' on page 39)
4	Open the gathering area cover.	(see ' <i>Lower the Clincher Frame</i> ' on page 39)
5	Lift the Booklet maker main deck.	The main deck lifts to approximately 60°. The weight of the main deck is supported by a gas strut. Let the gas strut control the movement of the main deck.

Empty the Trim Bin

Introduction



[19] Trim Bin Open.

A	Trim Bin Side Handle
B	Trim Bin open



Note: *The Booklet maker operates with the trim bin removed for a short period of time. The printer waits while the trim bin is removed, then continues when the trim bin is replaced. To prevent lost production, you must remove, empty, and return the trim bin to the Booklet maker as quickly as possible.*

When to do

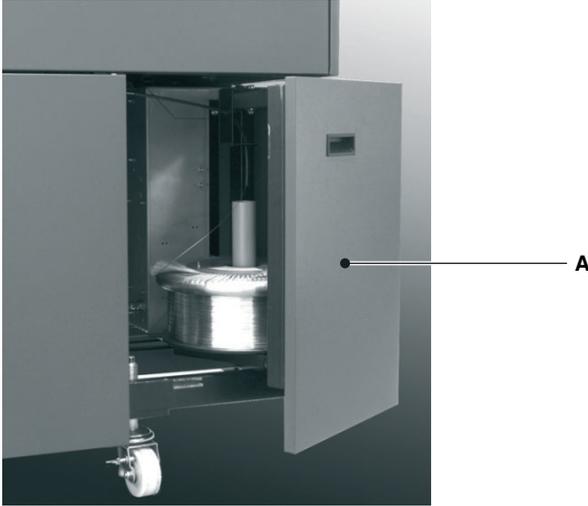
- An error message is displayed on the touch screen when the trim bin is full.
- You can empty the trim bin when you choose. For example, before you start a print job.

Procedure

1. Use the handle to open the trim bin.
2. Use the side handles to lift and remove the trim bin.
3. Empty the trim bin
4. Fit the bottom of the trim bin over the mounting rail.
5. Push the trim bin closed at the top.

Open the Stitch Wire Cabinet

Introduction



[20] Stitch Wire Cabinet.

A	Stitch wire cabinet open
---	--------------------------

When to do

- To see if the stitch wire is jammed or finished. An error message is displayed on the touch screen when the stitch wire is jammed or finished.
- To install a new stitch wire spool. (see [‘Install New Stitch Wire’ on page 107](#)).

Procedure

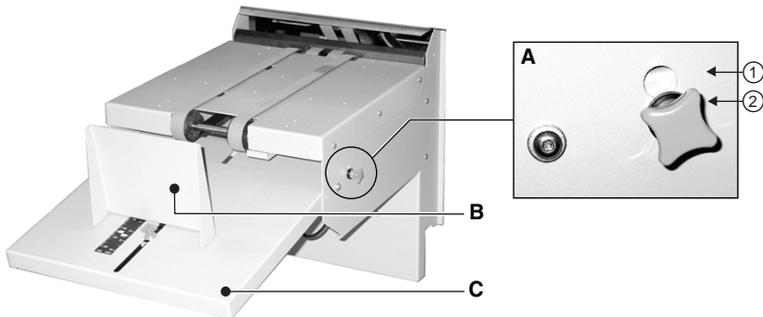
Open the stitch wire cabinet cover. The cover is held closed by a magnetic catch.

Adjust the Stacker

Introduction

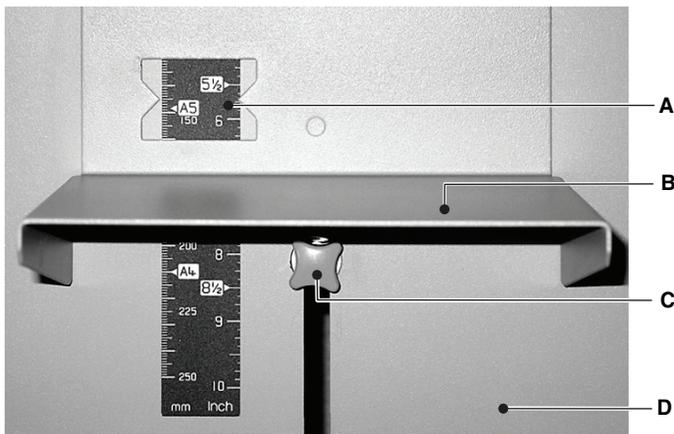
The collection table must be in the correct position for the stacker to operate. The position of the collection table depends on the finished size of the job.

- When you start a new job
- If the books do not stack correctly



[21] The Stacker

A	Catch tray adjustment
B	Collection table
C	Catch tray



[22] Collection table position

Adjust the Stacker

A	Book size in window
B	Collection table
C	Orange plastic hand screw
D	Catch tray

Procedure

Step	Action	Information
1	Set the catch tray angle according to the thickness of the book.	For books that are 1.5 mm thick or less, use position 1. For books that are 1.5 mm thick or less, use position 2. figure 21 on page 45
2	Set the collection table position according to the size of the book.	Read the settings through the window. figure 22 on page 45

These settings are recommendations. The settings can change with the size, thickness, and material of book. Make further adjustments if necessary.

Operate the Booklet maker offline

Introduction

You can hand feed sets into the Booklet maker if offline operation is needed. The machine operates when you push the two buttons.

When to do

- To check the settings are correct
- To make a small number of books offline



Attention: Do not put your hands in the gathering area when the machine operates. Use two hands to push the buttons. For safety reasons, this task is for a single operator. Do not let another person help you.

Procedure

1. Enter the correct settings on the touch screen, according to the size and thickness of the job.
2. Touch START ⓘ
3. Open the connecting bridge cover.
4. Open the gathering area cover.
5. Put the set in the gathering area with the middle pages of the book face up.
6. Press the two buttons and hold for 9 seconds, or until you hear the folder operate. The time interval changes according to the number of stitches.

Chapter 5

Error Conditions, Problems, and Solutions

*This chapter describes how to correct problems that can occur with your Booklet maker.
If a problem persists, contact your service engineer.*

Clear a Printer Error

Introduction

If a paper jam or other error occurs in the printer, the printer and the Booklet maker stop.

Procedure

1. Clear the printer error.
2. Follow the instructions on the printer. If the printer tells you to remove paper from the Booklet maker, touch **START** to start the machine.
3. Then touch **ADVANCED > PURGE SET > PURGE SET**.
4. The partial book is delivered to the stacker.
5. Discard the book.

Clear a Booklet maker error

Introduction

If a paper jam or other error occurs in the Booklet maker, the printer and the Booklet maker stop. The type of error is displayed on the touch screen (see *'Error Messages'* on page 54).

Procedure

1. Clear the error. The error message on the touch screen tells you about the error.
2. Remove all sheets from the Booklet maker.
3. Follow the instructions on the printer.

General Problems

Problem	Cause	Solution
The Booklet maker does not start	The Booklet maker is not turned on.	Turn ON the Booklet maker (see <i>'Turn ON the Booklet maker'</i> on page 13).
	The printer has not sent a job to the Booklet maker.	Correct the problem at the printer.
	The Booklet maker is not connected to the power supply.	Connect to the power supply of the correct type and voltage (see <i>'Turn ON the Booklet maker'</i> on page 13)
	A safety cover is open.	Close all safety covers.
	The trim bin is not installed or the trim bin is not installed correctly.	Install the trim bin.
	The Booklet maker is not connected to the printer interface.	Check the interface cables. Connect the cables.
	A fuse has blown on the power input.	Replace the fuse(s) as needed (see <i>'Change the Fuses'</i> on page 85)
	The stitch head is jammed.	Clear the stitch head jam and start the Booklet maker again. <i>Clear a Stitch Head Jam</i> on page 80
	An error condition exists on the Booklet maker.	Check the error message on the touch screen. Correct the fault (see <i>'Error Messages'</i> on page 54)
The START and STOP buttons do not work	The touch screen is in power-save mode	Touch the touch screen to restore normal function <i>The Touch Screen</i> on page 20.

Problem	Cause	Solution
The operation of the touch screen is incorrect	The touch screen is in power-save mode	Touch the touch screen to restore normal function <i>The Touch Screen on page 20.</i>
	The touch screen calibration is incorrect	Calibrate the touch screen (see ' <i>Calibrate the Touch Screen</i> ' on page 84).

Error Messages

Problem	Cause	Solution
AXES MOVING	Some of the machine axes are moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF	
BOOK CYCLE TIME TOO LONG	The printer has delivered the sets faster than the books can be made. To decrease the book cycle time, adjust the machine settings: <ul style="list-style-type: none">■ decrease the number of FORMS■ decrease the number of STITCHES■ decrease the TAMPER TIME■ touch STOP to clear the message from the screen	
Bridge axis moving	The bridge axis is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
BRIDGE INFEED COVER OPEN	The bridge infeed cover is open. The machine will not operate until the cover is closed.	(see <i>'Clear Paper Jams'</i> on page 68)

Problem	Cause	Solution
BRIDGE MOTOR STALL	<p>Check for a paper jam in the connecting bridge.</p> <ul style="list-style-type: none"> ■ Touch STOP to stop the Booklet maker. ■ Clear the paper jam. ■ Touch STOP to clear the message from the screen. ■ Continue the print job. 	(see ' Clear Paper Jams ' on page 68)
CHECK THE TRIM BIN	The trim bin is either open or full. Check the trim bin. Empty the trim bin if necessary.	
COVER OPEN	A safety cover is open. The machine will not operate until the cover is closed.	
DRIVE MOTOR STALL	There is a paper jam. Check the machine and correct the error. Touch STOP to clear the message from the screen.	
Endlay axis moving	The endlay axis (size adjustment) is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
ERROR IN TRIM AREA	There is an error at the trimmer. Check the trimmer for a paper or book jam. Touch STOP to clear the message from the screen.	
FLOW ERROR - BRIDGE	There is an error at the connecting bridge. Open the connecting bridge cover and check for a paper jam.	(see ' Clear Paper Jams ' on page 68)

Problem	Cause	Solution
FLOW ERROR - FORMER	There is an error at the former. Open the folder cover and remove the book(s). If necessary, open the main deck to remove the book(s). If there is paper in the gathering area, touch START , then touch ADVANCED > PURGE SET > PURGE SET to clear the set from the machine.	<i>Jam in the Folder or Former Area on page 72</i>
FLOW ERROR - OUTFEED	There is an error at the outfeed. Check the outfeed. If necessary, remove the trim bin and open the trim stop guard to remove the book(s). Touch STOP to clear the message from the screen. If there is paper in the gathering area, touch START , then touch ADVANCED > PURGE SET > PURGE SET to clear the set from the machine.	<i>Jam in the Trim Area on page 74</i>
Fold blade axis moving	The fold blade axis (book thickness adjustment) is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF	
FOLD BLADE NOT PARKED	The fold blade is in the wrong position. Touch START to reset the position. Follow the instructions on the screen.	

Problem	Cause	Solution
FORM CLAMP CLOSED	The form clamp is in the wrong position. Touch START to reset the position. Follow the instructions on the screen.	
FORM ROLLER ERROR	The form roller is jammed. Clear the jam and continue.	(see ' <i>Jam in the Trim Area</i> ' on page 74)
FORM ROLLER NOT PARKED	The form roller is in the wrong position. Touch START to reset the position. Follow the instructions on the screen.	
GATHERING AREA COVER OPEN	Close the gathering area cover if you need to operate the machine online.	
INVERTER ERROR	Check for a paper jam and clear if necessary. Touch STOP to clear the message from the screen. If the problem continues, contact your service engineer.	
JAM AT BRIDGE INFEED	There is a paper jam at the infeed to the connecting bridge. Clear the jam and continue.	(see ' <i>Clear Paper Jams</i> ' on page 68)
JAM AT FORM ROLLER	The form roller is jammed. Open the folder cover and remove the jam.	(see ' <i>Jam in the Trim Area</i> ' on page 74).
JAM BEFORE TRIMMER	There is a book jammed before the trimmer. Clear the jam and continue.	(see '' on page 73).
JAM IN CONNECTING BRIDGE	There is a paper jam in the connecting bridge. Clear the jam and continue.	(see ' <i>Jam in the Connecting Bridge</i> ' on page 70)

Problem	Cause	Solution
JAM IN GATHERING AREA	There is a paper jam in the gathering area. Open the connecting bridge cover, lift the connecting bridge and remove the paper jam.	(see ' <i>Jam in the Gathering Area</i> ' on page 71)
JAM IN STACKER AREA	There is a paper jam at the outfeed of the machine. Remove the jammed books and continue.	
JAM IN STITCHER AREA	There is a paper jam in the stitch area. Open the folder cover, remove the paper jam and continue.	(see ' <i>Jam in the Stitch Area</i> ' on page 72)
JAM IN STITCH HEAD	There is a jam in the stitch head.	<i>Clear a Stitch Head Jam</i> on page 80
JAM IN TRIMMER	There is a book jammed in the trimmer. Clear the jam and continue.	(see ' <i>Jam in the Trim Area</i> ' on page 74)
MANUALLY PARK SHUTTLE	The shuttle is not parked correctly. Open the folder cover and move the shuttle to the park position. Close the folder cover. The shuttle will reset. When the message list is clear, continue operation.	<i>Manually park the Shuttle</i> on page 86
MISSING STITCHES	The machine has detected missed stitches. Check to see whether the stitch-wire is jammed or whether the stitch-wire spool is empty.	(see ' <i>Clear a Stitch Wire Jam</i> ' on page 77) (see ' <i>Install New Stitch Wire</i> ' on page 107)
MOTOR CONTROLLER NOT READY	The drive motor controller is not ready. If the problem continues, contact your service engineer.	

Problem	Cause	Solution
REMOVE SET FROM FOLD AREA	Open the folder cover and remove the set.	
REMOVE SET - GATHERING AREA	Open the gathering area and remove the sheets. Or touch START , then touch ADVANCED > PURGE SET > PURGE SET to clear the set from the machine.	
Rotate axis moving	The rotate axis is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
SET IN GATHERING AREA	There is a set or partial set in the gathering area. If the print job has been canceled, open the gathering area and remove the sheets. Or touch START , then touch ADVANCED > PURGE SET > PURGE SET to clear the set from the machine.	
Shuttle axis moving	The shuttle axis is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
SHUTTLE MOTOR COMMS FAIL	Use the ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, call your service engineer.	

Problem	Cause	Solution
SHUTTLE MOTOR ERROR	Use the ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, call your service engineer.	
SHUTTLE NOT PARKED	The shuttle is in the wrong position. Touch START to reset the position. Then touch STOP to clear the message from the screen.	
Sidelay axis moving	The sidelay axis (size adjustment) is adjusting. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
STACKER FULL	The stacker is full. Unload the books from the stacker.	
Stitch axis moving	The stitch axis is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
Stitch position adjusting	The stitch position is adjusting. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	

Problem	Cause	Solution
STITCH TIMEOUT	There is an error at the stitcher. If the problem continues, call your service engineer.	<i>Stitch Timeout Error on page 75</i>
TOO MANY PAGES	The printer has delivered more than 55 sheets into the gathering area. Remove the incorrect set. Correct the printer setting. Touch STOP to clear the message from the screen.	<i>(see 'Open the Gathering Area Cover' on page 40)</i>
TOUCH PAD ERROR	There is a fault with the START and STOP touch pads. If the problem continues, call your service engineer.	
Touch START to clear machine	There may be some paper in the machine. Touch START to clear the machine before you start a new job.	
Trim axis moving	The trim axis (size adjustment) is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
TRIM BIN OPEN	The trim bin is not installed or is not in contact with the safety switch. Install the trim bin.	

Problem	Cause	Solution
TRIM BLADE NOT PARKED	The trim blade is in the wrong position. Touch START to reset the position. Follow the instructions on the screen.	
USER STOP	The user has touched the STOP button while the machine is in operation. Touch START to restart the machine.	

Book Quality

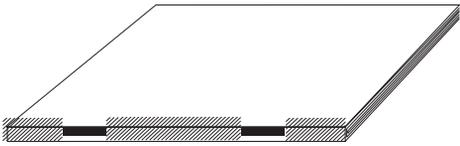
Paper Size and Book Quality Instructions

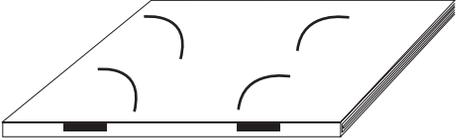
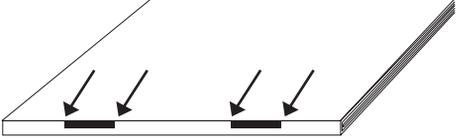
- Careful measurement of the paper size and set thickness is important.
- To make an accurate book you must enter accurate paper dimensions into the touch screen.
- Measure the size of the printed paper. The paper dimension changes when the paper is printed.
- If the book is made from several different types of paper, make sure the different paper types are all the same size. If the size of the paper is different, an accurate book cannot be made.
- The paper must be cut accurately. If the sheets are not cut squarely, an accurate book cannot be made.
- Adjustments to the **FORM** settings can be necessary for some types of paper.

Machine Adjustments

Machine adjustments can be made while the machine is in operation. The **PAPER SIZE** adjustment is limited to a maximum of +/- 1 mm when the machine is in operation.

Book Quality Problem	Cause	Solution
<p>The finished book is not neat and tidy</p> <p>The sheets are not aligned</p>	<p>The wrong paper size was entered on the touch screen.</p>	<p>Measure the paper and enter the correct dimensions (see ‘Enter the Job Settings’ on page 14).</p>
	<p>The book is made from paper that is different sizes.</p>	<p>Only use paper of the same size (see ‘Paper Size and Book Quality Instructions’ on page 63).</p>
	<p>The Booklet maker adjustment system is not calibrated correctly.</p>	<p>Touch RE-REF in the ADVANCED window to calibrate the Booklet maker adjustment axes. (see table 11 on page 29)</p>
	<p>The static elimination bars are dirty.</p>	<p>Clean the static elimination bars (see ‘Clean the Static Elimination Bars’ on page 92).</p>
	<p>Incorrect function of the static elimination bars.</p>	<p>Call your service engineer.</p>
<p>The spine is not formed correctly</p>	<p>Incorrect settings.</p>	<p>(see ‘Spine Form Problems’ on page 66)</p>
<p>The book is not trimmed</p>	<p>The TRIM function is not selected.</p>	<p>Turn on the TRIM function. See "TRIM" in table 9 on page 25</p>
	<p>The trim position is set larger than the book.</p>	<p>Reset the trim position. See "TRIM" in (see table 9 on page 25)</p>
<p>The book is not trimmed square</p>	<p>Trimmed paper has collected on the trim stop.</p>	<p>Clear the trimmed paper from the trim stop. (see ‘Jam in the Trim Area’ on page 74)</p>
<p>The trimmed edge is of bad quality</p>	<p>The trimmer blade is blunt or damaged.</p>	<p>Call your service engineer.</p>

Book Quality Problem	Cause	Solution
The stitch is not on the center-line of the spine	The wrong paper size was entered on the touch screen.	Measure the paper and enter the correct dimensions.
	The Booklet maker adjustment system is not calibrated correctly.	Touch RE-REF in the ADVANCED window to calibrate the Booklet maker adjustment axes. (see table 11 on page 29)
The books do not stack on the stacker	The collection table is in the wrong position.	Adjust the position of the collection table to fit the size of the finished book. <i>Adjust the Stacker on page 45</i>
The book cover is dirty or marked	The former roller is dirty.	Clean the former roller (see 'Clean the Former Roller' on page 94).
	 <p>Marks on the spine</p>	
	The former clamp is dirty.	<i>Clean the Polyurethane Strips in the Form Clamp on page 96</i>
 <p>Marks beside the spine</p>		

Book Quality Problem	Cause	Solution
The book cover is dirty or marked	The trimmings-removal fingers are dirty.	<i>Clean the Trimmings Removal Fingers on page 98</i>
		
	Curved marks on the book	
	There are grease marks around the stitches.	<i>Clean excess grease from the Stitch Head on page 101</i>
		
Grease marks near the stitches		

Spine Form Problems

To make the square spine of the book, pressure is applied to the spine. This process is called forming. The Booklet maker automatically applies the optimum amount of form according to the book thickness.

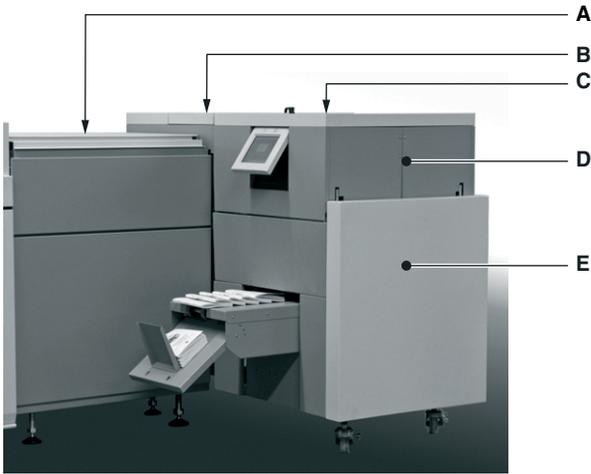
Some types of paper may need further adjustment.

Spine Form	Condition
	<p>Correct</p> <p>The spine is square at each end and the paper is not damaged.</p> <p>The Booklet maker setting is correct. Adjustment is not needed.</p>

Spine Form	Condition	
	Incorrect - The spine needs more form. Check these settings:	
	The SET THICKNESS setting is incorrect	Measure the set thickness and enter the correct dimension. <i>Enter the Job Settings on page 14</i>
	The folder cover is not securely closed?	Close the folder cover. <i>Close the Folder Cover on page 37</i>
	The FORM function is not turned on?	Turn on the FORM function. See "FORM" in <i>table 9 on page 25</i>
	The THRESHOLD THICKNESS? value is less than the SET THICKNESS?	Decrease the THRESHOLD value. See <i>THRESHOLD table 9 on page 25</i>
	Does the spine need more form at one end?	Change NUMBER to 2 or 4. See "FORM" in <i>table 9 on page 25</i>
	Does the spine need more form at each end?	Increase PRESSURE . Then, if the spine still needs more form, increase NUMBER . See "FORM" in <i>table 9 on page 25</i>
	Incorrect - The spine is damaged or there are creases near the spine. Check these settings:	
	The SET THICKNESS setting is incorrect?	Measure the set thickness and enter the correct dimension. <i>Enter the Job Settings on page 14</i>
	The spine of the book needs less forming.	Decrease PRESSURE . Then, if the spine is still over formed, decrease NUMBER . See "FORM" in <i>table 9 on page 25</i>

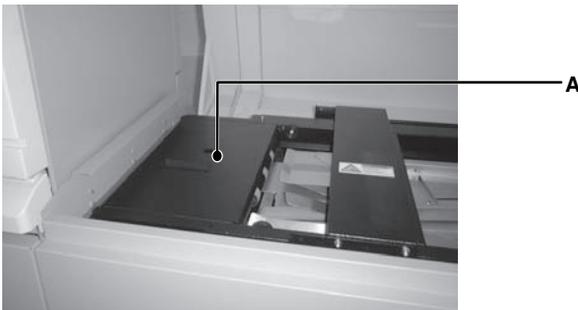
Clear Paper Jams

Introduction



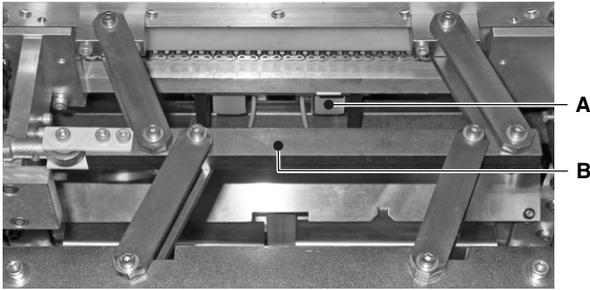
[30] Paper Jam Locations

A	Connecting Bridge
B	Gathering Area
C	Stitch Area
D	Fold and Forming Areas
E	Trim Area



[31] Paper Jam Location - Bridge Infeed

A	Bridge Infeed Cover
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[32] Trimmer Infeed Conveyor viewed from above.

Jam before the Trimmer on page 72

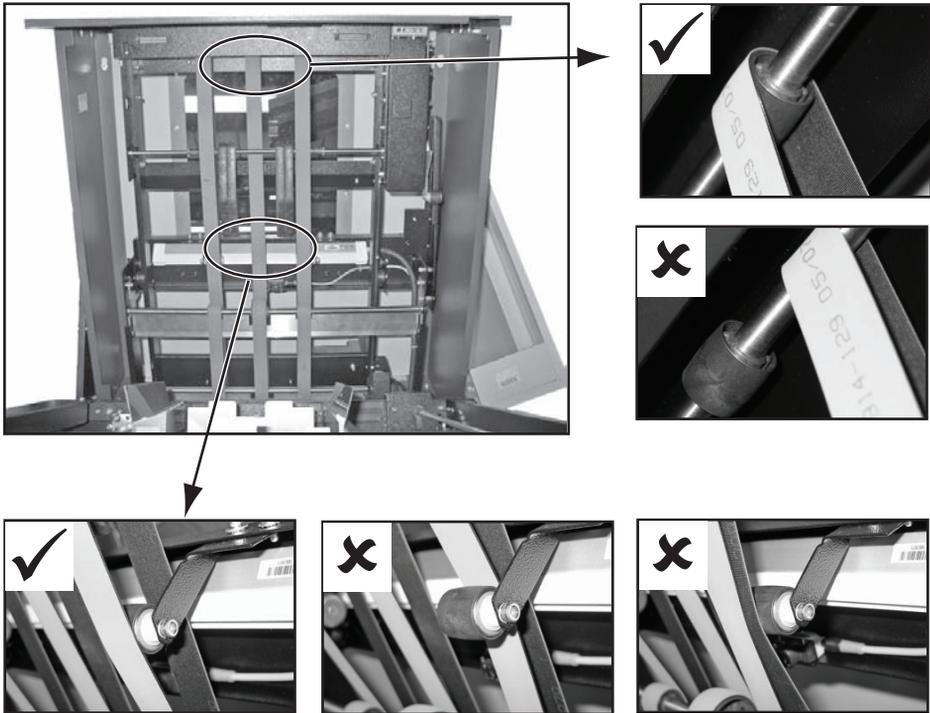
A	Trimmer Infeed Conveyor
B	Former-clamp mechanism



[33] Trim Stop Assembly

Jam in the Trim Area on page 74

A	Orange Plastic Hand Screw
B	Locking Plate
C	Trim Stop Guard



[34] Gathering Area Belt Positions

Jam in the Bridge Infeed

1. Open the bridge infeed cover.
2. Remove the jammed paper.
3. Close the bridge infeed cover.
4. Touch STOP (0) to clear the message from the screen.
5. If there is paper in the gathering area, touch START (1), then touch **ADVANCED** > **PURGE SET** > **PURGE SET** to clear the set from the machine.
6. Continue the print job.

Jam in the Connecting Bridge

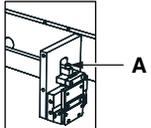
1. Open the connecting bridge cover.
2. Remove the jammed paper. Do not damage or move the belts.
3. Close the connecting bridge cover.
4. Touch STOP (0) to clear the message from the screen.

5. If there is paper in the gathering area, touch **START** (⏪) , then touch **ADVANCED > PURGE SET > PURGE SET** to clear the set from the machine.
6. Continue the print job.

Jam in the Gathering Area

1. Open the connecting bridge cover.
2. Lift the gathering area cover.
3. Remove the jammed paper.
4. Check the belts are in the correct position. Adjust the position of the belts if necessary. [figure 34 on page 70](#)
5. Close the gathering area cover.
6. Close the connecting bridge cover.
7. Touch **STOP** (⏹) to clear the message from the screen.
8. Continue the print job.

Jam in the Stitch Area

Step	Action	Information
1	Open the folder cover.	(see <i>'Open and Close the Folder Cover'</i> on page 37)
2	Lift the clincher frame.	(see <i>'Lift and Lower the Clincher Frame'</i> on page 38).
3	Remove the jammed paper.	
4	Check for broken or damaged stitches in the clincher area. Manually operate the clincher to clear any stitches that are jammed.	 <p>Press to manually operate the clincher.</p>
5	Lower the clincher frame.	(see <i>'Lift and Lower the Clincher Frame'</i> on page 38)
6	Close the folder cover.	
7	If there is paper in the gathering area, touch START , then touch ADVANCED > PURGE SET > PURGE SET .	This action clears paper from the BLM 500 / Bookletmaker 50.
8	Continue the print job.	

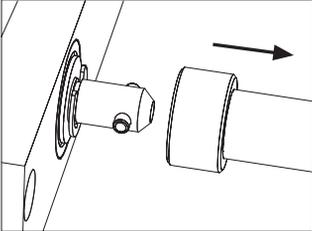
Jam in the Folder or Former Area

1. Open the folder cover.
2. Remove the jammed paper. If you cannot see the paper in the former area. (see *'Jam in the Trim Area'* on page 74)
3. Close the folder cover.
4. If there is paper in the gathering area, touch **START** (ⓘ), then touch **ADVANCED > PURGE SET > PURGE SET** to clear the set from the machine.
5. Continue the print job.

Jam before the Trimmer

The error message **JAM BEFORE TRIMMER** is displayed. This error can be

1. a book jammed before the trimmer
2. a piece of paper trimming has covered the jam sensor

Step	Action	Information
1	Open the Booklet maker main deck	
2	Remove the trim bin.	
3	Loosen the trimmer infeed conveyor.	<p>The procedure can be seen from the top of the machine. Access to the parts is through the former-clamp mechanism. Hold the shaft and push to the right, against the spring pressure. Hold the shaft and push to the right, against the spring pressure to disengage the shaft from the drive pin.</p>  <p>Lift the left-hand end clear.</p>
4	Remove the book, if one is found.	
5	Remove any paper offcuts from the trimmer infeed conveyor.	A small piece of paper can cover the jam sensor and cause an error message.
6	Install the trimmer infeed conveyor.	Insert the right-hand end of the shaft into the bearing, against the spring pressure. Insert the left-hand end.
7	Install the trim bin.	
8	Close the Booklet maker main deck and covers.	
9	If there is paper in the gathering area, touch START , then touch ADVANCED > PURGE SET > PURGE SET .	This action clears paper from the Booklet maker.
10	Continue the print job.	

Jam in the Trim Area

Step	Action	Information
1	Remove the trim bin.	
2	Loosen the 2 orange plastic hand screws to release the locking plates.	The locking plates can rotate to release the trim stop guard.
3	Pull the trim stop guard towards you.	
4	Remove the jammed book.	Check the trim stop and remove any pieces of trimmed paper.
5	Push the trim stop guard into position.	
6	Hold the locking plates in position and tighten the orange hand screws.	
7	Attach the trim bin.	
8	Touch START , then touch ADVANCED > PURGE SET > PURGE SET.	This action clears any other paper from the Booklet maker.
9	Continue the print job.	

Stitch Timeout Error

Introduction

Step	Action	Information
1	Open the folder cover.	<i>Open and Close the Folder Cover on page 37</i>
2	Lift the clincher frame.	<i>Lift and Lower the Clincher Frame on page 38</i>
3	Remove the paper.	
4	Lower the clincher frame.	<i>Lift and Lower the Clincher Frame on page 38</i>
5	Close the folder cover.	
6	If the error message SHUTTLE NOT PARKED is displayed, touch START ①	This action moves the shuttle to the correct position.
7	Touch STOP ② and then continue the print job.	

Stitch Head Problems

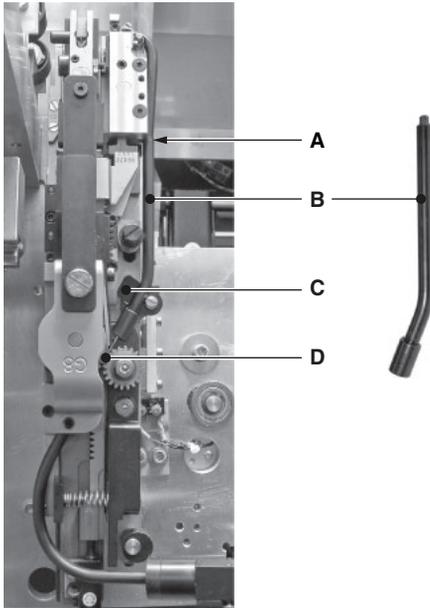
Problem	Cause	Solution
The stitch head does not operate	The STITCH function is not selected.	Make sure STITCH is set to 1 or more (see <i>'The BASIC Window'</i> on page 25).
	The stitch wire is finished.	Load a new spool of stitch-wire (see <i>'Install New Stitch Wire'</i> on page 107).
	The stitch wire is jammed.	Clear the jammed stitch wire (see <i>'Clear a Stitch Wire Jam'</i> on page 77).
The stitches are broken	There is stitch wire jammed in the stitch head.	Inspect and remove the jammed stitch wire (see <i>'Clear a Stitch Wire Jam'</i> on page 77).
The stitch wire is jammed on the spool	The stitch wire spool is not installed correctly.	Check and correct (see <i>'Fit a New Stitch Wire Spool'</i> on page 108).

Clear a Stitch Wire Jam

Introduction

Before you begin:

Lift the Booklet maker main deck. See [Lift the Booklet maker Main Deck](#) on page 41



[37] Stitch Head.

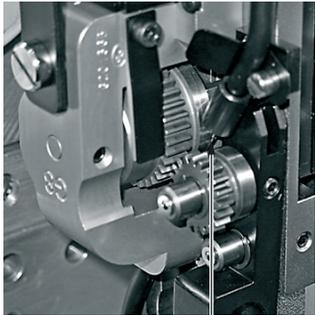
Clear a Stitch Wire Jam

A	Top location of Middle Wire Tube
B	Middle Wire Tube
C	Metal Spring Clip
D	Feed Gears

Before You Begin

Step	Action	Information
1	Turn off the Booklet maker	Use the ON/OFF switch.
2	Disconnect the Booklet maker from the power supply.	
3	Lift the Booklet maker main deck	(see ' <i>Lift the Booklet maker Main Deck</i> ' on page 41)

Clear the Jammed Wire

Step	Action	Information
1	Cut the stitch wire at position 'A' approximately 50mm (2 inches) from where the stitch wire leaves the stitch wire guide.	 <p>A</p> <p><i>Detail A: Cut stitch wire here.</i></p>
2	Cut the stitch wire at position 'B' between the feed gears and the middle wire tube.	 <p>B</p> <p><i>Detail B: Cut stitch wire here.</i></p>
3	Pull the stitch wire from the stitch wire guide block.	 <p>Pull stitch wire in direction of arrow</p>

Step	Action	Information
	Remove the middle wire tube.	figure 37 on page 77
	Pull the wire from the stitch head.	
5	Install the stitch wire into the stitch head.	(see 'Install the Stitch Wire into the Stitch Head' on page 110)

Clear a Stitch Head Jam

Introduction

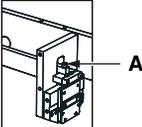
The error message **JAM IN STITCH HEAD** is displayed.

This may be caused by

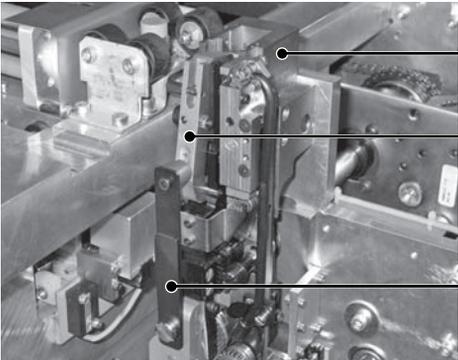
- the **SET THICKNESS** setting is incorrect
- the stitch head is jammed by broken wire
- the stitch head needs lubrication

Do Procedure 1. If the error message continues, do Procedure 2.

Procedure 1

Step	Action	Information
1	Stop the Booklet maker.	Touch the STOP button
2	Open the folder cover.	<i>Open and Close the Folder Cover on page 37</i>
3	Lift the clincher frame.	<i>Lift and Lower the Clincher Frame on page 38.</i>
4	Remove the jammed paper.	
5	Check for broken or damaged stitches in the clincher area. Manually operate the clincher to clear any stitches that are jammed.	 <p>Press to manually operate the clincher.</p>
6	Lower the clincher frame.	<i>Lift and Lower the Clincher Frame on page 38</i>
7	Close the folder cover.	
8	If there is paper in the gathering area, touch START, then touch ADVANCED > PURGE SET > MAKE BOOK.	This action clears paper from the BLM 500 / Bookletmaker 50 and resets the stitch head.
9	Continue the print job.	

Procedure 2



[42] Remove the stitch head wire holder

A	Stitch head
---	-------------

Clear a Stitch Head Jam

B	Wire holder
C	Wire holder retaining spring

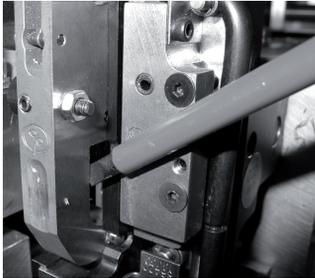


[43] Inspect for stitch wire

A	Inspect this area for pieces of stitch wire
---	---

Tools and Materials:

1. Klüber Isoflex NBU 15 Grease, 50g.
2. Air duster. Supplied with the machine
3. Wire cutters. Supplied with the machine.
4. Flat blade screwdriver.

Step	Action	Information
1	Lift the Booklet maker main deck.	See Lift the Booklet maker Main Deck on page 41
2	Remove the wire-holder from the stitch head.	<ul style="list-style-type: none"> ■ Move the wire-holder retaining spring to the right. figure 42 on page 81 ■ Remove the wire-holder <p>If the wire-holder is held in position, use a screwdriver to help remove the wire-holder from the stitch head.</p> 
3	Inspect the area behind the wire-holder for stitch-wire.	figure 43 on page 82
4	Remove any stitches or pieces of stitch-wire and clean the area with the air duster.	Use wire cutters to remove any jammed stitches or pieces of stitch-wire.
5	Lubricate the stitch-head.	Lubricate the Stitch Head on page 102
6	Fit the wire-holder.	Remember to put the wire-holder retaining spring in position.
7	Close the Booklet maker.	
8	Start the Booklet maker.	<p>If the head operates normally and returns to the parked position, then further action is not needed.</p> <p>If the stitch-head remains jammed, then repeat the procedure again.</p> <p>If the problem continues, contact your service engineer.</p>

Calibrate the Touch Screen

When to do

Calibrate the touch screen if the buttons do not operate or the buttons do not operate correctly.



Attention: Use a pencil, the blunt end of a pen or a palm top wand for this procedure. Do not use a sharp object. Sharp objects damage the screen.

Procedure

1. Touch the STOP button  5 times.
2. Follow the instructions on the touch screen.
3. Touch **DONE** in the centre of the screen.

Change the Fuses

Introduction

The Booklet maker has two fuses at the power input. If either fuse is blown, the Booklet maker will not operate.

Required tool

Fuse description: 7A, HRC Quick Acting, F



Attention: Turn OFF the machine and remove the power supply cable before you change the fuses. This machine uses two fuses in parallel. To avoid the risk of fire, replace fuses only with the same type and rating.

Procedure

1. Turn OFF the Booklet maker.
2. Disconnect the Booklet maker from the power supply.
3. Turn one fuse-holder to the left and remove the fuse-holder from the Booklet maker.
4. Check the fuse.
5. If the fuse is blown, then replace with a fuse of the correct specification.
6. Repeat the procedure for the other fuse.



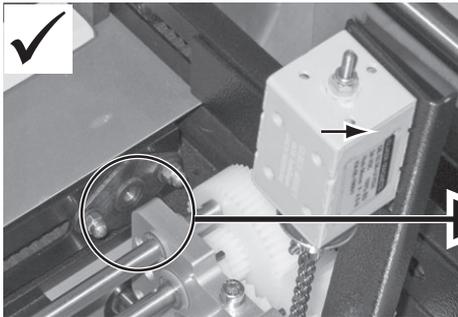
Note: *If the fuse blows again, call your service engineer.*

Manually park the Shuttle

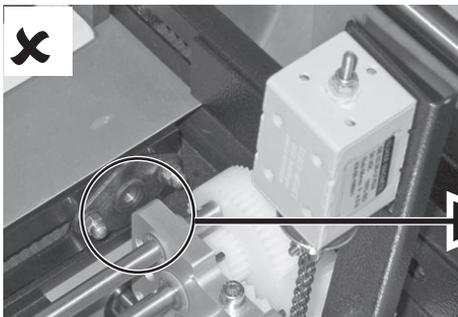
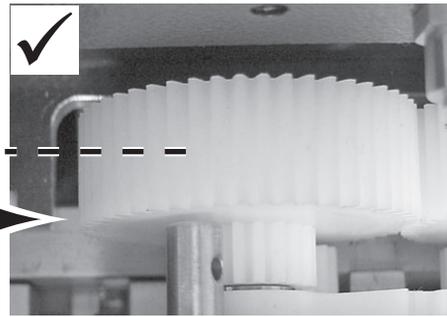
When to do

The error messages 'MANUALLY PARK SHUTTLE' and 'SHUTTLE NOT PARKED' are displayed.

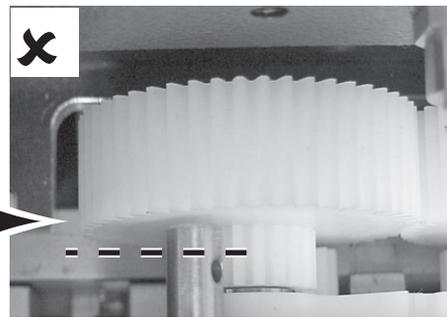
Illustration



[45] Shuttle Assembly Position - CORRECT



[46] Shuttle Assembly Position - NOT CORRECT



[47] Detail A: Pick-up fingers

Step		
1	Open the folder cover.	<i>Open and Close the Folder Cover on page 37</i>
2	Push the shuttle-assembly to the right.	<p><i>figure 45 on page 86</i> shows the correct position for the shuttle assembly.</p> <p>If the shuttle assembly does not move to the correct position, push the pick-up fingers away from each other by 2-3mm and try again. Repeat if necessary.</p>
3	Wait until the error message 'SHUTTLE NOT PARKED' is cleared from the screen.	If the message does not clear, check that the shuttle assembly is in the correct position. Repeat Step 2 if necessary.
4	Close the folder cover.	

Result

The error message **'MANUALLY PARK SHUTTLE'** is cleared from the screen. The shuttle axis re-references and the message 'Shuttle axis moving' is displayed. When the message list is clear, you can continue operation

Chapter 6

Maintenance

About Maintenance

Service Interval

- The Booklet maker needs service every four months.
- After every one million stitches, the stitch head needs service. This interval is every third spool of stitch-wire.

Only a service engineer can service the Booklet maker. Contact your supplier for further information.

Operator Maintenance

Correct maintenance by the operator makes sure that

- The machine operates correctly
- The machine makes high-quality books
- The machine is safe to use
- Small problems can be identified early

Operator Maintenance Plan

Interval	Task	Reference
■ Every week	Clean the machine.	(see ' <i>Booklet maker cleaning</i> ' on page 91)
	Clean the static elimination bars.	(see ' <i>Clean the Static Elimination Bars</i> ' on page 92)
■ Every month, or ■ When a new stitch wire is installed if this interval is shorter.	Lubricate the stitch head.	(see ' <i>Lubricate the Stitch Head</i> ' on page 102)

Booklet maker cleaning

Introduction

Clean the Booklet maker every week to remove surface dust.



Attention: Only clean the machine with materials that are recommended in this manual. Do not use other chemicals or abrasive material.

Outside of the Booklet maker

Use a moist cloth to clean the outside of the Booklet maker.

Touch screen

Clean the touch screen with a clean, dry cloth. Never use an abrasive material or chemical to clean the touch screen. Light pressure with a clean, dry cloth is enough to remove fingerprints. Do not use too much force.

Clean the Static Elimination Bars

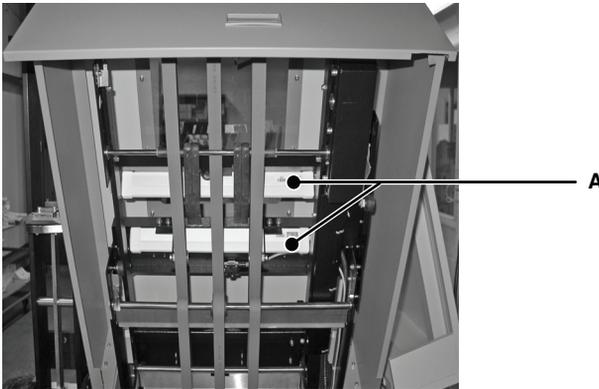
Introduction

Clean the static elimination bars every week. This action extends the performance and service life of the static elimination bars.

The Booklet maker is supplied with a small brush. Use the brush to clean the static elimination bars.

There are three static elimination bars.

- One in the connecting bridge
- Two in the gathering area



[48] The Static Elimination Bars in the Gathering Area



[49] The Static Elimination Bar in the Connecting Bridge

A	Static Elimination Bars
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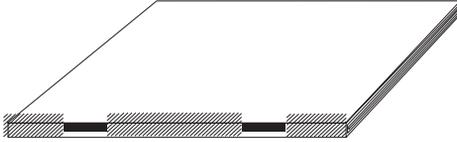
Note: *On the bottom of the static elimination bar there is a row of sharp pins. The pins are not dangerous, but if you touch the pins accidentally, this action can alarm you.*

Step	Action	Information
1	Clean the static elimination bar in the connecting bridge.	<ul style="list-style-type: none">■ Open the connecting bridge cover.■ Clean the pins on the bottom of the static elimination bar with a small brush
2	Clean the static elimination bars in the gathering area.	<ul style="list-style-type: none">■ Open the gathering area cover.■ Clean the pins on the bottom of the static elimination bars with a small brush
3	Close the Booklet maker.	<ul style="list-style-type: none">■ Close the gathering area cover■ Close the connecting bridge cover.

Clean the Former Roller

Introduction

Clean the former roller if the spines of the books are dirty. Ink and toner can collect on the former roller.



[50] Dirty marks on the spine

Required tool

Clean, plain paper that is not printed. A3 size (USA: 11 x 17") is recommended. 4mm thickness is needed for each cycle. More than one cycle can be needed

Procedure

Step	Action	Information
1	Enter the correct settings on the touch screen.	<ul style="list-style-type: none"> ■ Set the touch screen to the correct PAPER SIZE ■ Set the SET THICKNESS to 4.0 ■ Set the number of STITCHES to 0. ■ Set the number of FORMS to 4.
2	Touch START ①	
3	Open the connecting bridge cover.	
4	Lift the gathering area cover.	
5	Put 4mm of clean paper in the gathering area.	
6	Press the two orange buttons and hold for 9 seconds, or until you hear the folder operate.	

Result

The book is delivered to the stacker. Check the book. Repeat the procedure until the book spine is clean.

Clean the Polyurethane Strips in the Form Clamp

Introduction

Follow this procedure if there are dirty marks near the spine on the front and back cover of the book. Ink and toner can collect on these parts, especially when you make thin books.



[51] Dirty marks beside the spine

Required tools

Alcohol wipe or
A lint free cloth and alcohol (isopropanol)

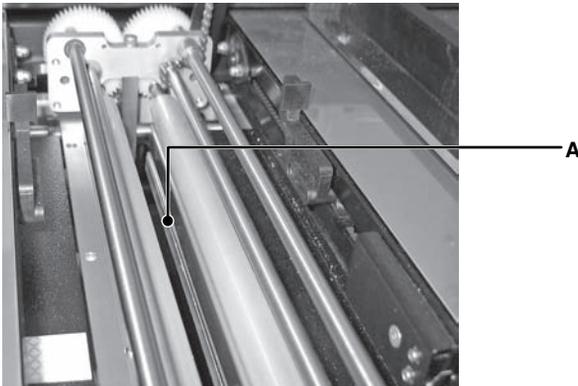


Caution: Only use alcohol to clean this part of the machine. Other chemicals can damage the machine.



Note: *If you push the eject rollers, the rollers can move together against your hand. This movement can alarm you, but is not dangerous.*

Illustration



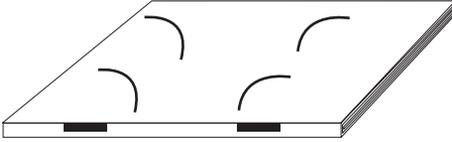
[52] Detail A: Polyurethane strips

Step	Action	Information
1	Open the folder cover	
2	Use an alcohol wipe, or apply a small amount of alcohol to a lint free cloth.	
3	Reach into the form clamp and clean each of the polyurethane strips.	There is a polyurethane strip on the face of each side of the clamp. Repeat this step until the polyurethane strips are clean.
4	Close the folder cover	

Clean the Trimmings Removal Fingers

Introduction

Follow this procedure if there are small, dirty marks on the book. Ink and toner can collect on the trimmings removal fingers and cause marks on the book.

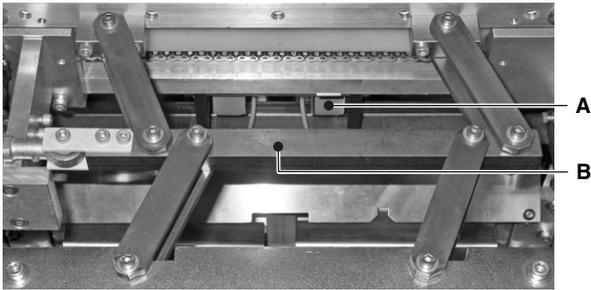


[53] Curved marks on the book

Required tool

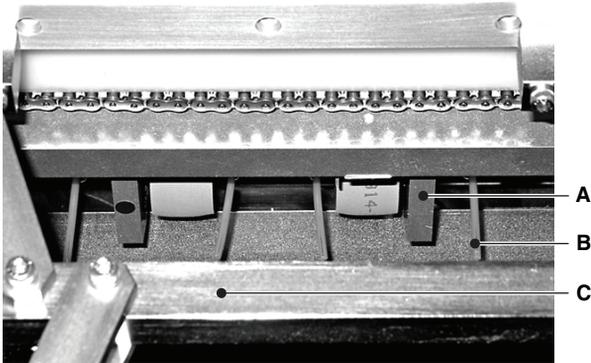
Alcohol wipe

Illustration



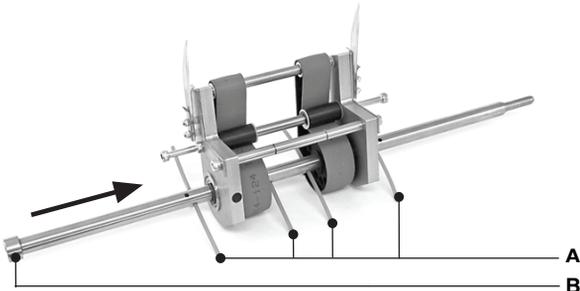
A	Trimmer infeed conveyor
B	Former clamp mechanism

Illustration



A	Trimmer infeed conveyor
B	Trimmings removal fingers
C	Former clamp mechanism

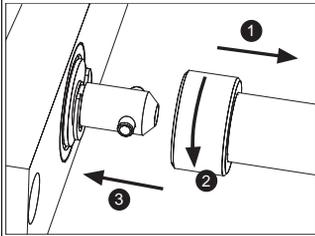
Illustration



Clean the Trimmings Removal Fingers

A	Trimmings removal fingers
B	Drive end of the conveyor shaft

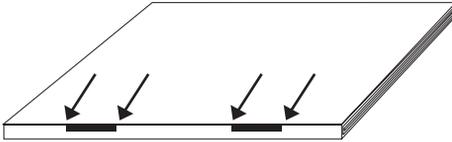
Procedure

Step	Action	Information
1	Turn off the Booklet maker	
2	Lift the Booklet maker main deck.	The procedure can be seen from the top of the machine. Access to the parts is through the former-clamp mechanism.
3	Remove the trim bin.	
4	Clean the visible trimmings-removal fingers with an alcohol wipe.	
5	Rotate the conveyor shaft by half a turn.	<p>1. Hold the shaft and push to the right, against the spring pressure to disengage the shaft from the drive pin.</p>  <p>2. Rotate the shaft by half a turn. 3. Align the shaft with the drive pin and release.</p>
6	Clean the visible trimmings-removal fingers with an alcohol wipe.	
7	Install the trim bin.	
8	Close the Booklet maker.	

Clean excess grease from the Stitch Head

Introduction

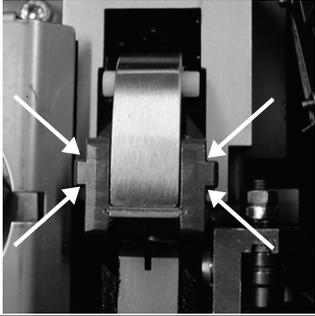
Follow this procedure if there are grease marks around the stitches on the book.



Required tool

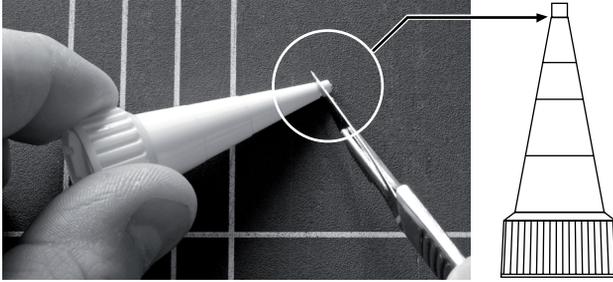
Lint free cloth

Procedure

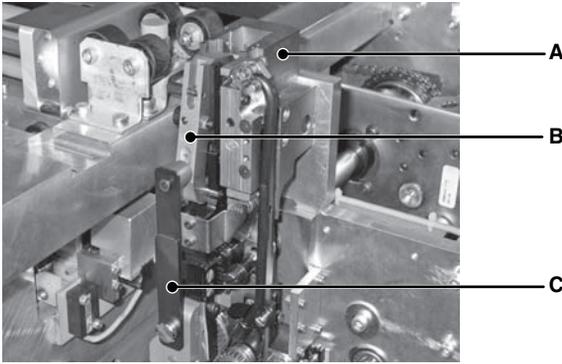
Step	Action	Information
1	On the user interface, touch ADVANCED > STITCHER UP > STITCHER UP	The folder cover must be closed. This action moves the stitch head to the correct position for lubrication.
2	Open the folder cover.	<i>Open and Close the Folder Cover on page 37</i>
3	Lift the clincher frame.	<i>Lift and Lower the Clincher Frame on page 38</i>
4	Clean grease from the sides of the stitch head.	
5	Lower the clincher frame.	
6	Close the folder cover.	

Lubricate the Stitch Head

Introduction

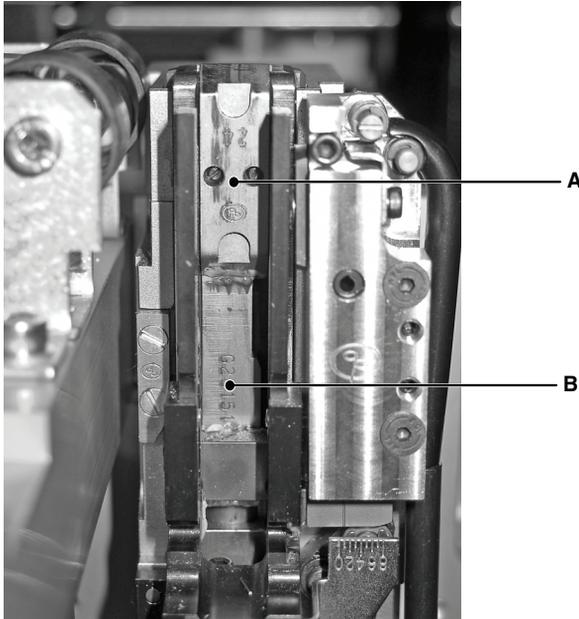


[60] Trim the nozzle of the tube of grease



[61] Stitch Head Wire Holder

A	Stitch Head
B	Wire Holder
C	Wire Holder Retaining Spring



[62] Driver Bar

A	Driver, in upper position
B	Driver Bar

Required tools

- Klüber Isoflex NBU15 Grease, 50g
- Air duster - is supplied with the machine



Attention: - Only use the grease shown in this manual. Correct lubrication extends the performance and service life of the stitch head. Other types of grease do not protect the stitch head

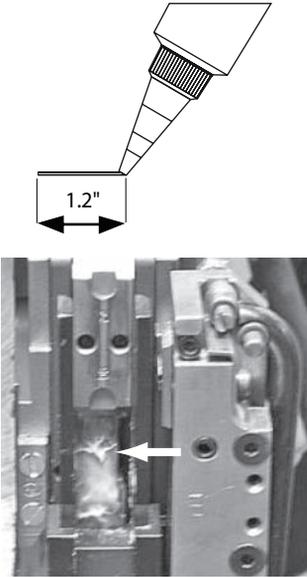
- Only apply the grease as shown. If you apply additional grease, the paper gets marked.

Before You Begin

Step	Action	Information
1.	Trim the first part from the nozzle.	figure 60 on page 102
2.	Remove the cap from the tube of grease.	
3.	Fit the nozzle to the tube of grease.	
4.	On the user interface, touch ADVANCED > STITCHER UP > STITCHER UP	The folder cover must be closed. This action moves the stitch head to the correct position for lubrication.
5.	Lift the Booklet maker main deck	See Lift the Booklet maker Main Deck on page 41

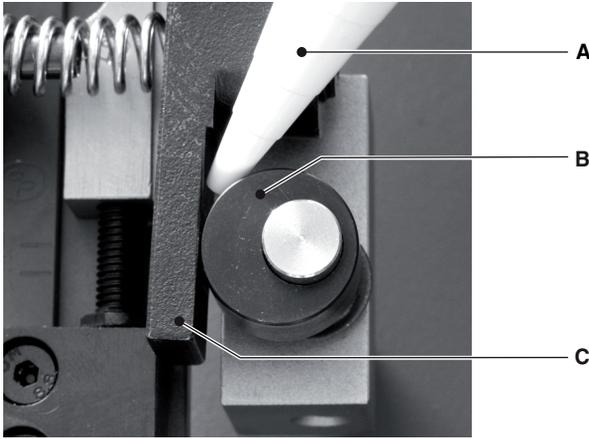
Apply Grease to the Driver Bar

Step	Action	Information
1	Use the supplied air duster to remove dust from the stitch head.	
2	Remove the wire-holder from the stitch head.	Move the wire-holder retaining spring to the right. Then remove the wire-holder (see Introduction on page 102)

Step	Action	Information
3	Apply 30 mm of grease to the visible surface of the driver bar	<p data-bbox="753 178 1000 207">figure 62 on page 103</p> 
4	Re-fit the wire-holder.	
5	Lower the Booklet maker main deck.	
6	Lower the clincher frame.	(see ' <i>Lower the Clincher Frame</i> ' on page 39).
7	Close all of the covers.	

Lubricate the Wire-feed Cam

Introduction



[65] Lubricate the wire-feed cam

A	Nozzle for the tube of grease
B	Wire-feed cam
C	Feed lever

Lubricate the wire-feed cam

Step	Action	Information
1.	Lift the PSQ main deck.	
2.	Apply 10 mm of grease from the tube between the bearing surface of the wire-feed cam and the feed lever.	<p>figure 65</p>
3.	Lower the Booklet maker main deck	
4.	Lower the clincher frame.	Lower the Clincher Frame on page 39
5.	Close all of the covers	

Install New Stitch Wire

Introduction

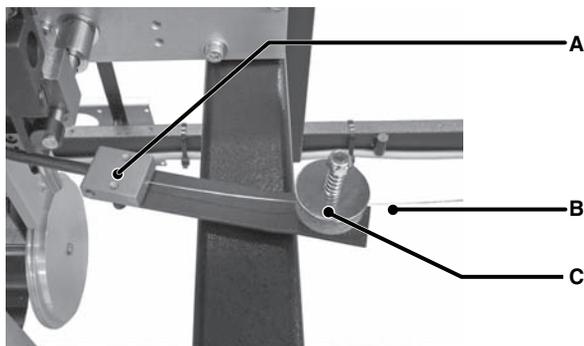
Only use stitch-wire that is approved by your supplier. Stitch-wire that is not approved by your supplier can cause poor performance and voids the warranty. Stitch-wire Description: Sticher wire S33.

Before you begin

Lift the Booklet maker main deck.

See (see [‘Lift the Booklet maker Main Deck’ on page 41](#))

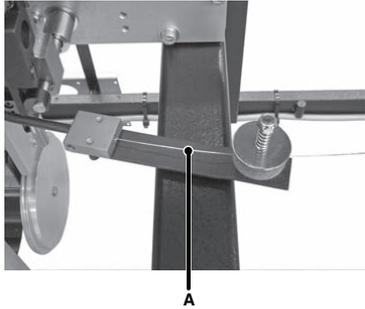
Illustration



[67] Stitch Wire Guide Block

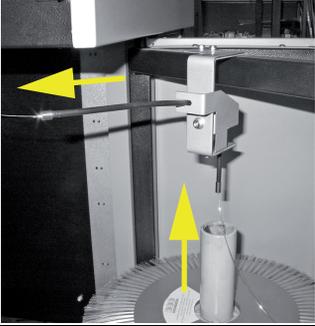
A	Stitch Wire Guide Block
B	Stitch wire
C	Felt wire-cleaning pads

Remove the Stitch Wire from the Stitch Head

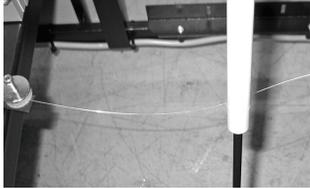
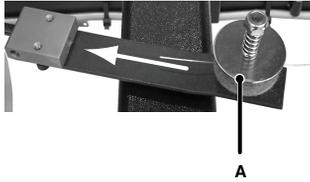
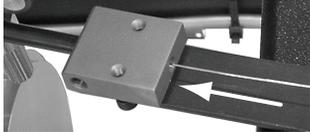
Step	Action	Information
1	Cut the stitch wire to the right of the stitch wire guide block.	 <p>Detail A: Cut here</p>
2	Pull the stitch wire from the stitch wire guide block.	
3	Fit a new stitch wire spool.	<i>(see 'Fit a New Stitch Wire Spool')</i>

Fit a New Stitch Wire Spool

Step	Action	Information
1	Open the stitch wire cabinet	
2	Remove the stitch wire cap and finished stitch wire spool.	
3	Fit a new stitch wire spool.	
4	Fit the stitch wire cap	
5	Loosen the end of the stitch wire from the edge of the stitch wire spool.	

Step	Action	Information
6	Use wire cutters to remove the damaged end of the stitch wire.	Remove enough stitch wire to leave the end of the stitch wire clean and straight.
7	Feed the stitch wire through the stitch wire guide.	
8	Install the stitch wire.	(see <i>'Install the Stitch Wire into the Stitch Head'</i> on page 110)

Install the Stitch Wire into the Stitch Head

Step	Action	Information
1	Pull the stitch wire from the end of the stitch wire guide.	
2	Make sure the stitch wire runs behind the gas-strut.	
3	Feed the end of the stitch wire between the felt wire-cleaning pads.	 <p data-bbox="677 697 1116 735"><i>Detail A: Felt Wire-Cleaning Pads</i></p>
4	Push the stitch wire into the stitch wire guide block.	 <p data-bbox="677 880 1116 920">Push stitch wire in direction of arrow</p>
5	Push the stitch wire as far as possible.	 <p data-bbox="677 1115 1116 1217"><i>Detail A: Make sure the stitch wire runs between the wire feed rollers and into the middle wire tube.</i></p>

Close the Booklet maker

Step	Action	Information
1	Close the stitch-wire cabinet.	
2	Lower the Booklet maker main deck.	<i>(see 'Lower the Clincher Frame' on page 39).</i>
3	Lower the clincher frame.	

Step	Action	Information
4	Close the folder cover.	
5	Close the connecting bridge cover.	

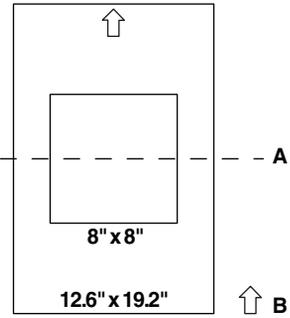
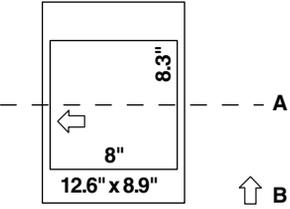
Feed the Stitch-wire

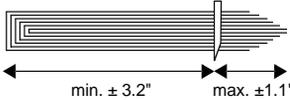
Step	Action	Information
1	Touch START.	
3	Set the number of stitches to 6	Touch BASIC > STITCHES .
4	Hand-feed or print an A4 or larger size test job.	The stitch-wire loads automatically during the stitch head cycle.
5	Check that the stitch-wire is loaded.	Check that a stitch is made. If needed, repeat the previous step. If a stitch is still not made, repeat the procedure. Install the stitch-wire into the stitch head <i>Install the Stitch Wire into the Stitch Head on page 110</i> .
6	Reset the number of stitches on the touch screen.	

Appendix A

Specifications

Specifications

<p>Operating Conditions</p>	<p>10-35°C at 35-85% relative humidity</p>
<p>Production</p>	<p>Cycle time: Printer dependent Interset gap: 2 seconds (if printer has DFD2, then 1.5 or 2 seconds, depending on job settings) Minimum set time: 7.5 seconds (if printer has DFD2, then 5.5 or 7.8 seconds, depending on job settings) Maximum set time: 12.5 seconds</p>
<p>Stock Sizes</p>	<p>Minimum input size: 203 x 203 mm Maximum input size: 320 x 488 mm</p>  <p>A = Stitch & fold line B = indicates original lead edge from the printer</p>
<p>Sheet Rotation</p>	<p>Integrated rotator ensures maximum printer productivity. Maximum rotation sheet size: 320 x 227 mm Minimum rotation sheet size: 210 x 203 mm The cross-track dimension of the sheet (before rotation) must be at least 7 mm greater than the in-track dimension.</p>  <p>A = Stitch & fold line B = indicates original lead edge from the printer</p>
<p>Stock Range</p>	<p>80 - 160gsm normal paper types 70 - 250gsm dependant on paper type and quality</p>

Book Thickness	Maximum finished book thickness: 10 mm (approximately 200 pages 80gsm) Maximum set thickness: 5 mm (approximately 50 sheets 80gsm)
Stitching	1 - 6 stitches, evenly spaced on the spine of the book Stitches/spool: up to 291,500 Books*/spool: approximately 127,000
Trimming	Maximum fore-edge trim: 28 mm Minimum trimmed book size: 80 mm  † Serial no. 22 onwards
Stacker Capacity	35 books*
Paper Input Requirements	Input sheets must be of consistent size and cut square. Machine setting must match paper size at the input to the Booklet maker Book quality is dependent upon the quality of the input sheets.
Dimensions	Footprint: 1870 x 1675 mm Height - 1330 mm maximum
Weight	Booklet maker including stitching wire: 542kg As per above, plus bridge and bridge covers: 702kg
Power Supply	Adjustable to 200, 208, 220, 230 and 240V 50/60Hz, single phase
Power Consumption	stand-by: 92VA (75W) in operation: 700VA (500W)
Noise Emission	stand-by: ambient in operation: 66 dB (A), peak 87 dB (A)
Approvals	Complies with CE and UL. Conforms to FCC rules Part 15 Class A.
* Standard book is made from 20 sheets of 80gsm paper, with 2 stitches.	
Production may vary according to operating conditions. In line with a policy of continual product improvement, the manufacturer reserves the right to alter the materials or specifications of this product at any time without notice.	

Appendix B
Declaration of Conformity

Declaration of Conformity

Name of Manufacturer:	Watkiss Automation Limited
Address of Manufacturer:	Watkiss House Blaydon Road Sandy, Bedfordshire SG19 1RZ United Kingdom
Declares that the product:	
Name of Product:	BLM 500 / Bookletmaker 50
serial Number:	WA/PSQ/---/010 onwards
Conforms to the following Directives:	
Safety:	290/95/EEC Council Directive 'on the approximation of laws of Member States relating to electrical equipment designed for use within certain voltage limits'. BS EN 60950 : 2002
EMC:	89/336/EEC Council Directive 'on the approximation of laws of Member States relating to electromagnetic compatibility'. EN55022:1998 Class A EN55024:1998 EN61000-3-2:2000 + A2:2005 EN61000-3-3:1995 + A1:2001
	M C Watkiss Technical Director Watkiss Automation Ltd. January 2, 2007