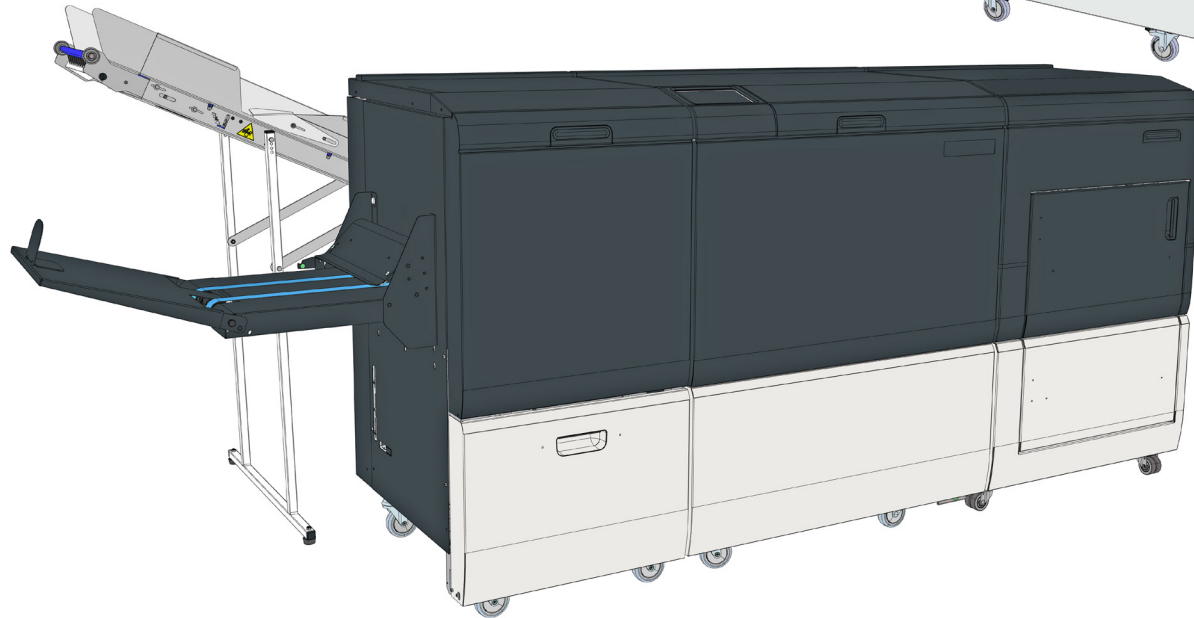
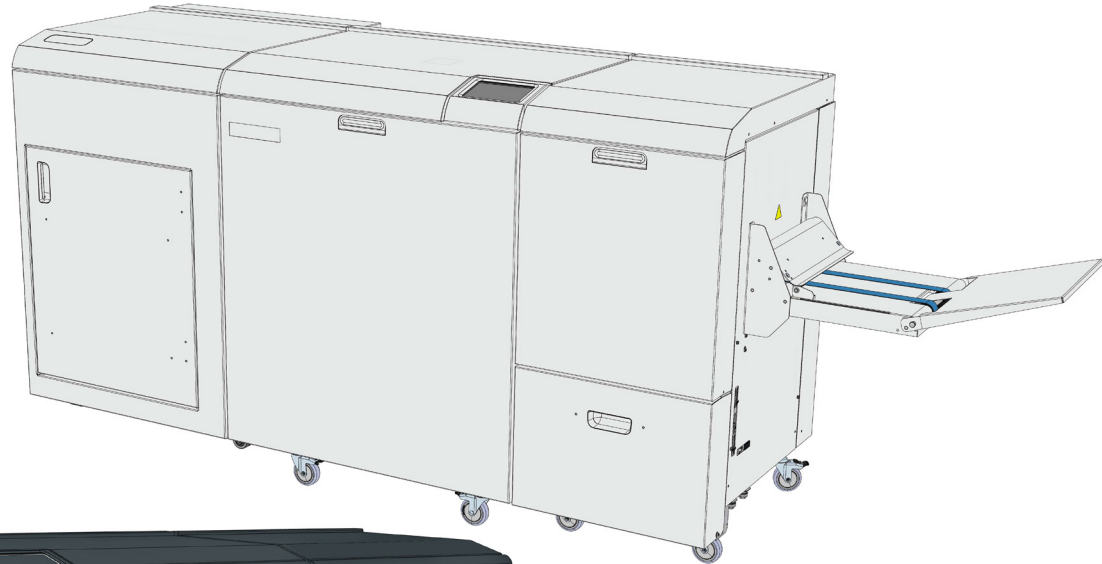

Plockmatic Booklet Maker System Unpack and Installation manual

***Plockmatic
Pro450e/435e***



***Plockmatic
Pro450e^I/435e^I***

Introduction

Please read the Safety Information before using this machine. It contains information related to USER SAFETY and PREVENTING EQUIPMENT PROBLEMS.

How to read this manual

Notation conventions

Whenever necessary, the following points of attention are indicated in the documentation for this product.

 **WARNING:**

Indicates a potentially hazardous situation which, if instructions are not followed, could result in death or serious injury.

 **CAUTION:**

Indicates a potentiality hazardous situation which, if instructions are not followed, may result in minor or moderate injury or damage to machine or property.

 **NOTE:**

This sign refers to:

- Remarks for making the operation much easier. You get practical hints or knowledge to assist you in the machine operation such as:
 - Preparations required before operating
 - How to prevent papers from being misfed or damaged
 - Precautions required or actions to take after misoperation
 - Limitations like numerical limits, functions that cannot be used together or conditions, under which a particular function cannot be used or obtained.
 - Information.
- [] Keys that appear on the machine's User Interface.

Safety Information

When using this machine, safety precautions should always be followed.

General Safety

WARNING

- This equipment is not suitable for use in locations where children are likely to be present.
- Only connect the machine to a mains power supply of the correct voltage with a good earth-connection; as advised by your service engineer at the time of installation. Improper Earthing of the equipment can result in electrical shock. The correct machine voltage is shown on the label at the mains power supply input on the rear of the machine. If the machine is connected to the wrong supply, the warranty is cancelled. This machine is destined for specific purpose only. Any use going beyond this specific purpose is regarded as beyond the determination. The manufacturer will not be liable for damages resulting from any use beyond the determination, unallowed operation, respectively. The user alone bears the risk.
- Do not make arbitrary changes or modifications to the machine. The manufacturer will not be liable for modifications made to the machine on your own and damages resulting thereof. The EU/UK Declaration of Conformity and the CE/UKCA mark will be invalidated if you make changes to the machine or to the individual components.
- Operators are never allowed to override or bypass electrical or mechanical interlock devices. Trained technicians are allowed to use interlock cheaters only when instructed to do so. Do not expose fingers or other parts of the body to moving, rotating, or cutting devices when running the machine with the interlock cheater installed. Do not wear ties, lanyards or other things that might get trapped into the rollers and cause injuries. Do not change, adjust, or tamper with the safety interlock devices fitted to the machine. Machine including UV-Light should never be bypassed by operator or trained technicians. Permanent eye damage could occur.
- The machine is to be used only by authorized and instructed persons. The responsibility on operating the machine must be strictly laid down and observed so that there are no unclear competences regarding safety aspects.
- Vent holes serve for air circulation to protect the machine from overheating. Make sure that the holes are not covered.
- Always locate the equipment on a solid support surface with adequate strength for the weight of the machine. Make sure the machine is located on a level floor and that there is enough work area around it.
- To protect against fire hazard, replace fuses with those of the same type and rating. Do not change fuses before the machine is disconnected from the main power supply. Refer to the product's documentation for the correct procedure.
- Do not expose the equipment to sudden temperature variations that can cause condensation.
- Operators and technicians must be familiar with the safety information detailed in this safety pamphlet and in the product's documentation.
- To avoid hazardous situations, like for instance electric shock or danger while exposed to moving, rotating or cutting devices, do not remove any covers, guards or screws other than those specified in the product's documentation and before the machine is disconnected from the main power supply.
- Always use only the power cord intended for the machine.
- Never connect plugs unless instructed so. Never connect plugs that have a different shape / number of pins.

continued on next page

Safety Information, continued

Safety during operation

WARNING

- Do not expose body parts, loose hanging hair or clothing to moving, rotating or cutting parts.
- If any adjustment or operation check has to be made with exterior covers off or open while the main switch is turned on, keep hands away from electrical or mechanically driven components.
- Note that components of the system and peripherals can be supplied with electric voltage even if the main power switch is turned off and the power cord is disconnected.
- Turn off the power and disconnect the power plug (by pulling the plug, not the cable) if any of the following conditions exists:
 - Objects are dropped into the equipment.
 - Liquids are spilled inside the equipment.
 - You suspect that your equipment needs service or repair.
 - Covers are damaged, loose or missing.
 - You notice unusual noises or odors when operating the equipment.
 - If the power cable or plug is worn out or otherwise damaged.
 - Before cleaning and care (unless otherwise specifically instructed).
- Do not remove covers or guards that are fastened with screws.
- Machines with open (non-covered) automatic sheet feeders pose a crush/pinch hazard. Keep away from these areas when the machines are operating.
- Machines with exposed cutting carriages and heads pose a crush/pinch hazard. Keep away from the moving carriages and ensure that these machines are inaccessible to children during operation. Never leave these units switched on without supervision.
- If an emergency stop button is on the machine – do not use the button for regular operation. It is designed for immediate stop solely for emergency situations to ensure the safety of all individuals involved.

CAUTION

- The product must be installed, relocated and maintained by a customer service representative who has been properly trained on the product.
- Remove paper from inside the machine and close all covers before undocking or relocating the product.
Use caution: the product is heavy, could be subject to a tilt hazard and tip over.
- Always follow all warnings marked on, or supplied with, the product.
- When you disconnect the power plug from the wall outlet, always pull the plug (not the cable).
- Disconnect the power cord before you move the machine. While moving the machine, always exercise care and make sure that the power cord will not be damaged under the machine.
- Do not move the machine while the machine is running.
- Do not open covers while the machine is running.
- Do not switch off the power while the machine is running. Make sure the machine cycle has ended.
- Lay the power cord in a way that nobody will stumble over it. Do not place things on the cord.
- Never attempt any maintenance function that is not specifically described in the product's documentation.
- Always keep magnets and all devices with strong magnetic fields away from the machine.
- If the place of installation is air-conditioned or heated, do not place the machine where it will be:
 - Subject to sudden temperature changes.
 - Directly exposed to cool air from an air-conditioner.
 - Directly exposed to heat from a heater.
- If the machine is not used over an extended period of time, it should be unplugged to prevent damage in case of overvoltage.
- Do not operate the equipment if you notice unusual noises or odors. Disconnect the power cord from the power source and call your authorized technician to correct the problem.

continued on next page

Safety Information, continued

Electromagnetic compliance

This device complies with Part 15 of the FCC rules.

Operation of this equipment in a residential environment could cause radio interference.

Notes for handling Lithium and Lead batteries

CAUTION













- *Danger of explosion if batteries are incorrectly replaced.*
- *Replace only with the same or equivalent type recommended by the manufacturer.*
- *Dispose of used batteries according to the manufacturer's instructions.*

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Safety Information, continued

Description of Safety/Warning labels in the product

<p>1</p>  <p>Crushing Hazard Risk for crushing or squeezing body parts.</p>	<p>2</p>  <p>Cutting Hazard Sharp objects inside machine.</p>	<p>3</p>  <p>Entanglement Hazard Risk for loose hanging hair, jewelry, or clothes to get caught.</p>		
<p>4</p>  <p>Hazardous Voltage High voltage inside machine.</p>	<p>5</p>  <p>Do Not Step A surface of the machine not to step/stand upon.</p>	<p>6</p>  <p>Hot Surface Do not touch with bare hands.</p>	<p>7</p>  <p>Protective gloves Protective gloves must be worn.</p>	<p>8</p>  <p>Hearing Protection Hearing Protection must be worn.</p>
<p>9</p>  <p>Tight clothes Tight clothes must be worn.</p>	<p>10</p>  <p>Earth / Ground Always ground the equipment.</p>	<p>11</p>  <p>Warning / Caution Indicates a generic warning or caution.</p>	<p>12</p>  <p>Laser Hazard Laser beam: do not stare into beam.</p>	<p>13</p>  <p>Tropical conditions Use only in non-tropical conditions.</p>

continued on next page

Safety Information, continued

Description of Safety/Warning labels in the product, continued













<p>14</p>   <p>Pinch Point Hazard Risk for pinching or squeezing body parts.</p>	<p>15</p>  <p>Respirator mask Respirator mask, suitable for removing used glue, must be worn.</p>	<p>16</p>  <p>Earth continuity Shows earth connection point. A separate earth connection needs to be fitted during installation.</p>	<p>17</p>  <p>Read user or service manual Do not operate unless you have read and understood the user manual. Refer to service manual for more information.</p>
<p>18</p>  <p>Altitude Do not use at altitudes over 2000m above sea level.</p>	<p>19</p>  <p>High touch current Follow specific instructions in install manual.</p>	<p>20</p>  <p>Tilt hazard The equipment might tip over under certain circumstances.</p>	
<p>21</p>   <p>UV Light Hazard UV lights can cause skin burns, eye damage, including permanent blindness and skin cancer.</p>	<p>22</p>  <p>EN: Only connect this equipment to an earthed socket outlet. DK: Apparatets stikprop skal tilsluttes en stikkontakt med jord, som giver forbindelse til stikkorens jord. FI: Laite on liitettävä suojakosketinilla varustettuun pistokanseen. NO: Apparatet må tilkoples jordet stikkontakt. SE: Apparatet skall anslutas till jordat uttag. 25601</p> <p>Scandinavian Earthing Label Connect equipment only to an earthed (grounded) outlet.</p>	<p>23</p>  <p>Eye protection Eye protection, against possible splashes of glue, must be worn.</p>	

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8 Installation Procedure - Inkjet based

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2.1 Unpacking Instruction

2.1.1 Unpacking the Rotate Crease Trim Module

 **NOTE!**

If you do not have the optional Rotate Crease Trim Module, please skip this section and proceed with the next one.



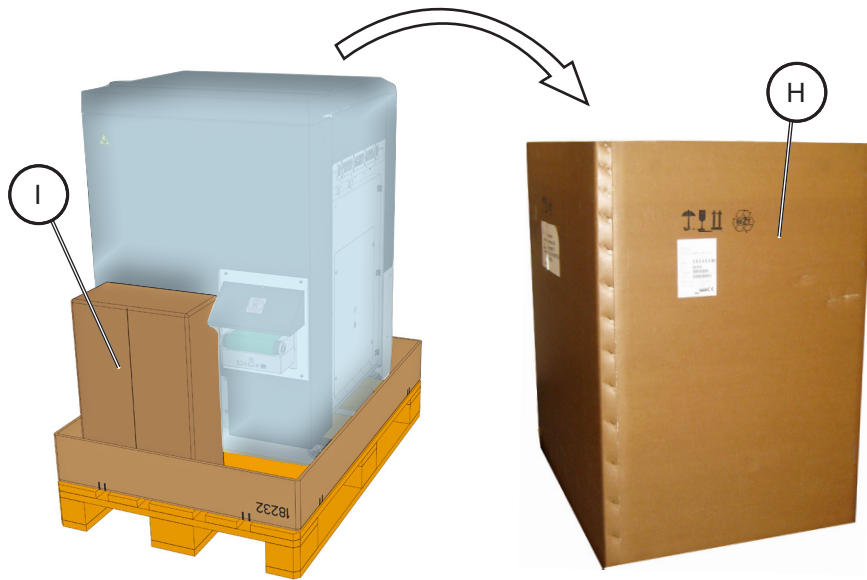
1. Remove the straps [A].
2. Remove the Top Cover [B].

3. Remove the Waste Box [C] and ensure it is saved.
4. Remove the plywood Ramp [D].

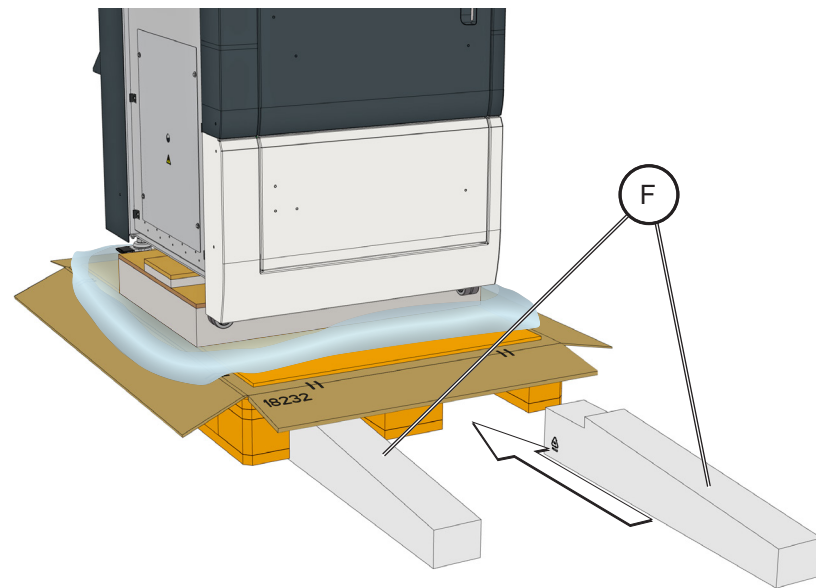


5. Remove the Top Protection Foam Blocks (x2) [E].
6. Remove Ramp Support Foam (x2) [F] and save it.

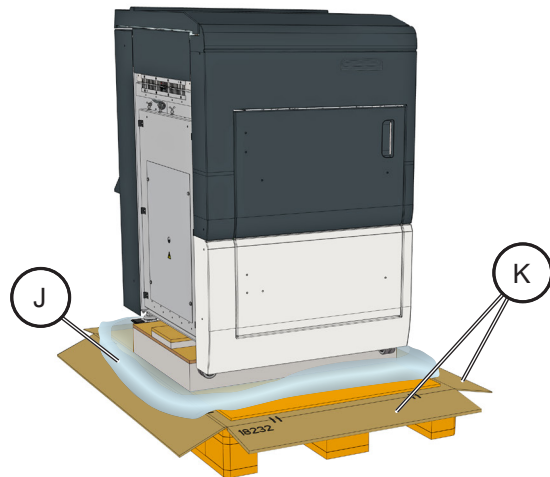
7. Remove the Corner Protection Foam Blocks (x4) [G].



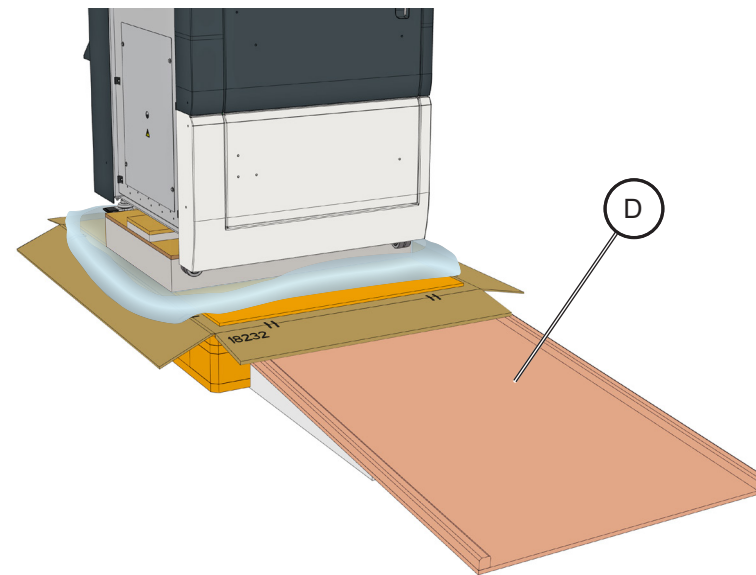
- 8. Remove the Sleeve [H].
- 9. Remove Accessories Box [I].



- 12. Mount Ramp Support Foam according to picture [F].

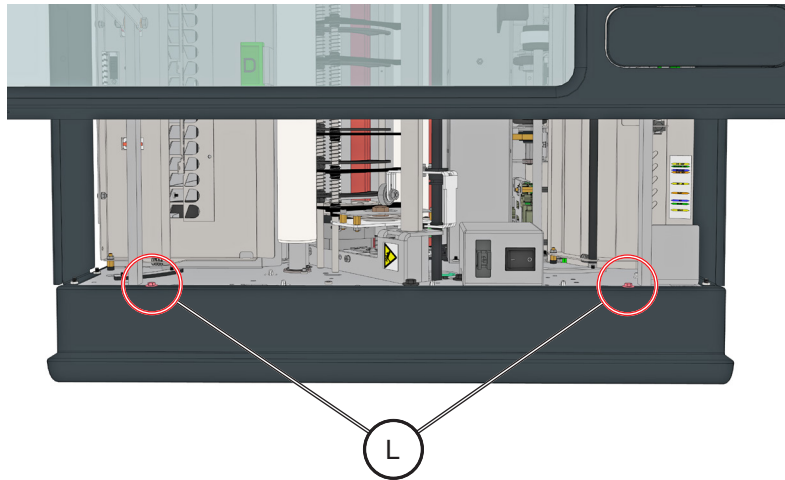


- 10. Roll down plastic wrap from RCT [J].
- 11. Fold out the sides of the cardboard box [K].

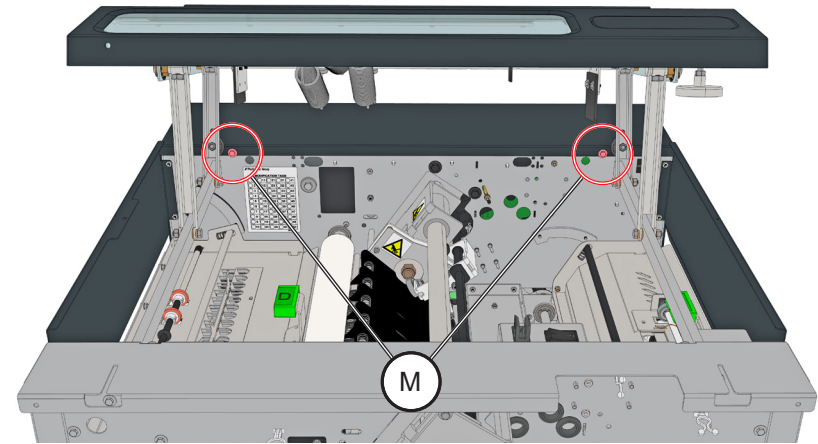


- 13. Place Ramp [D] as illustrated and carefully roll RCT off the pallet.

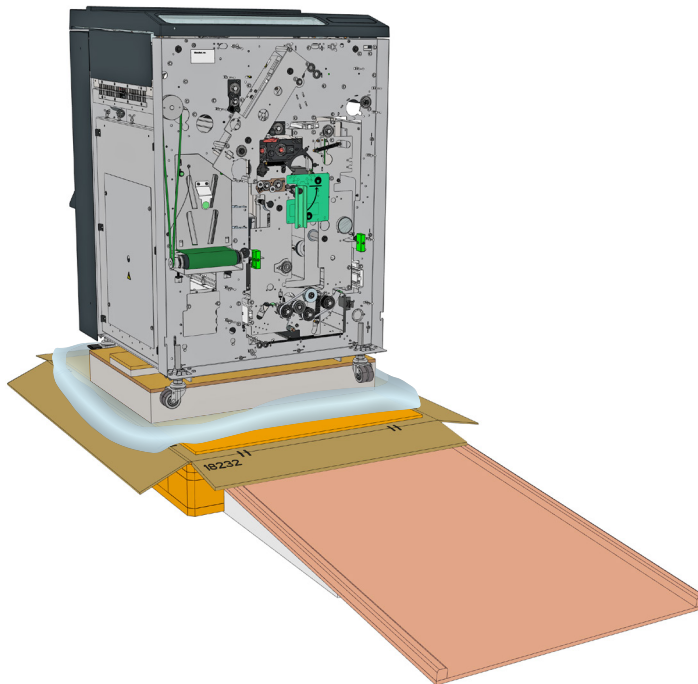
NOTE: RCT Module valid until Serial Number L122Y00__



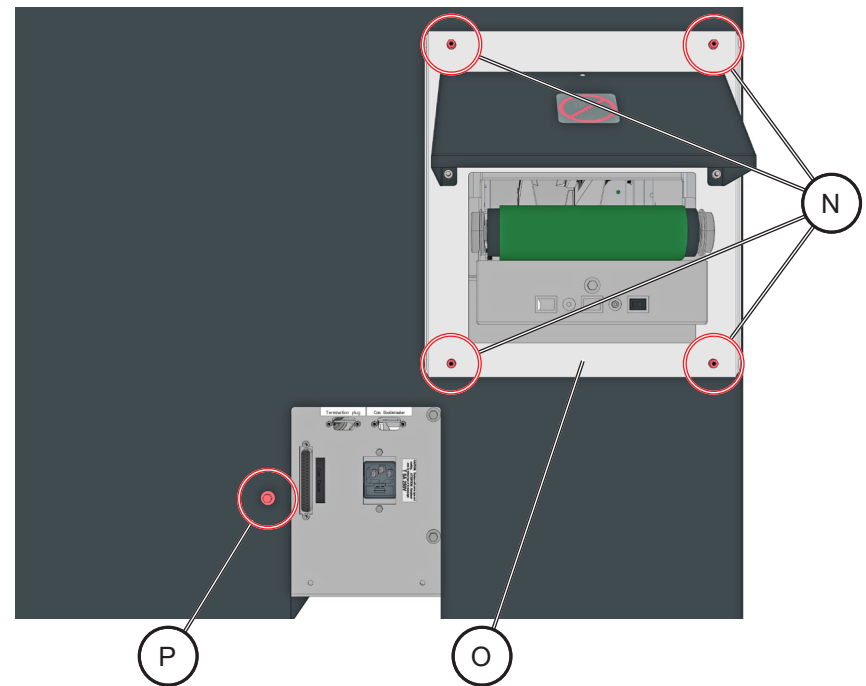
14. Open Top Cover and loosen two screws securing Front Cover [L].



16. Loosen screws [M] (2x).

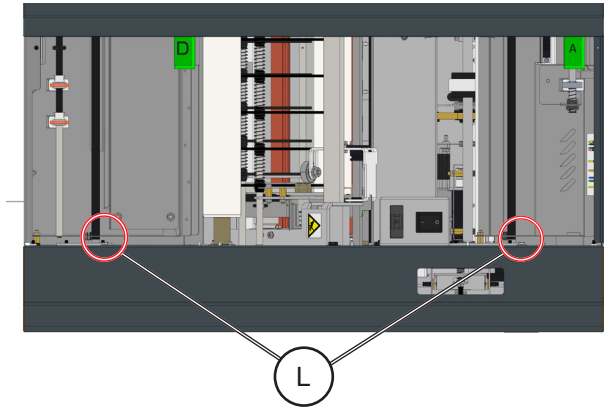


15. Lift and remove the Front Cover.

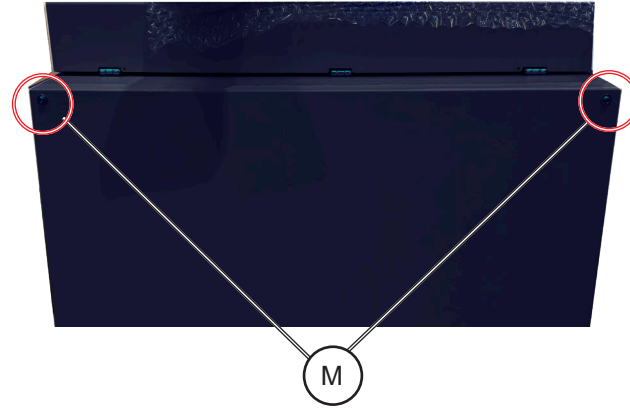


17. On rear side of RCT Remove screws [N] (4x) and Rear Waste frame [O]. Remove screw [P].

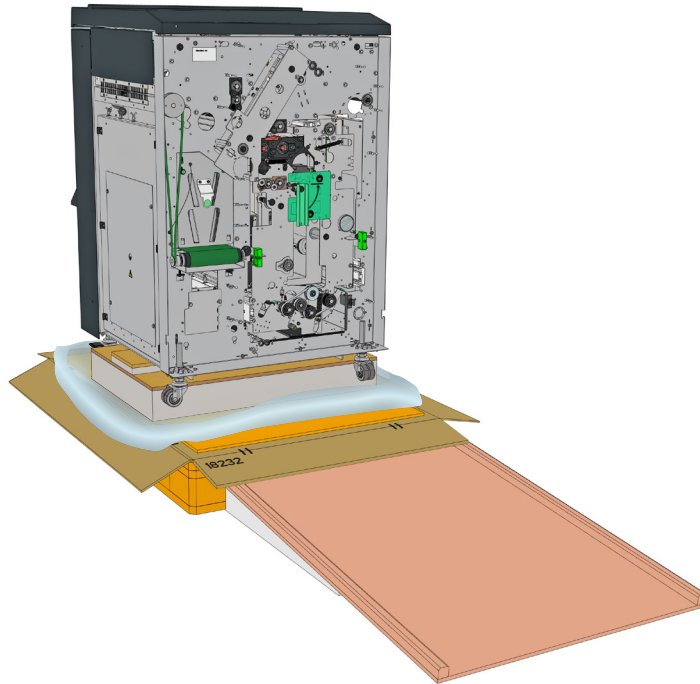
NOTE: RCT Module valid from Serial Number L122Y00___ (valid from TAG 43 Serial Number)



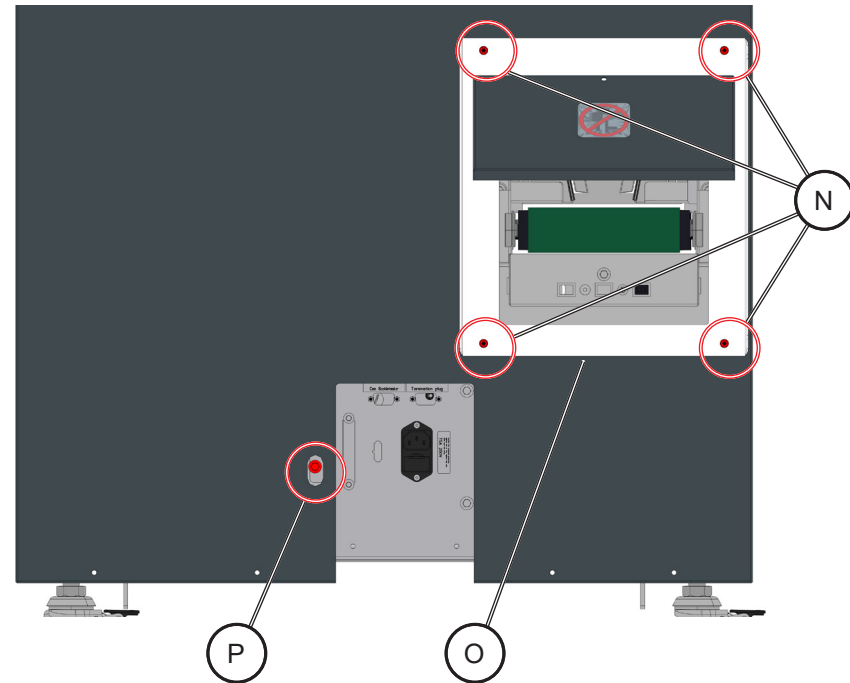
14. Open Top Cover and loosen two screws securing Front Cover [L].



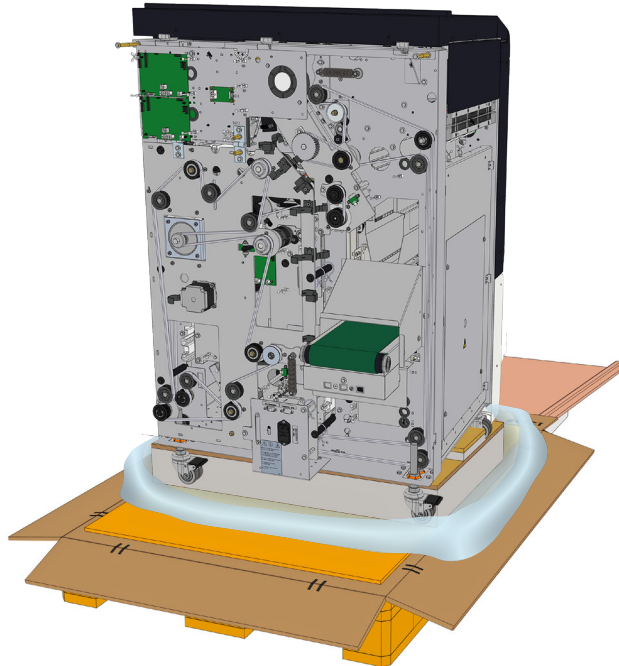
16. Loosen two screws securing the Rear Cover [M].



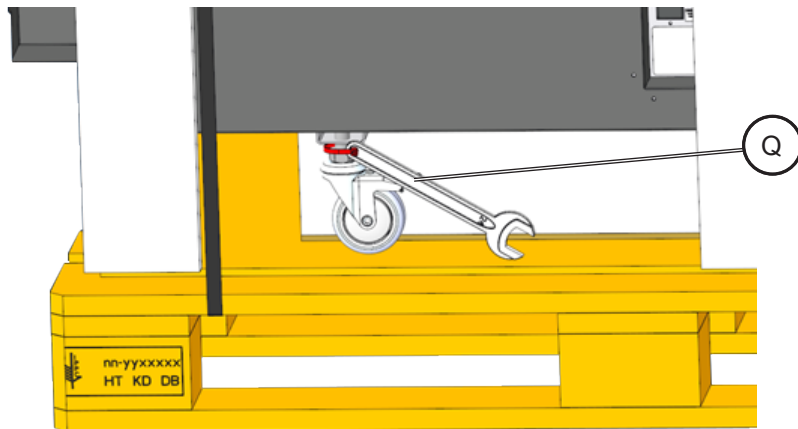
15. Lift and remove the Front Cover.



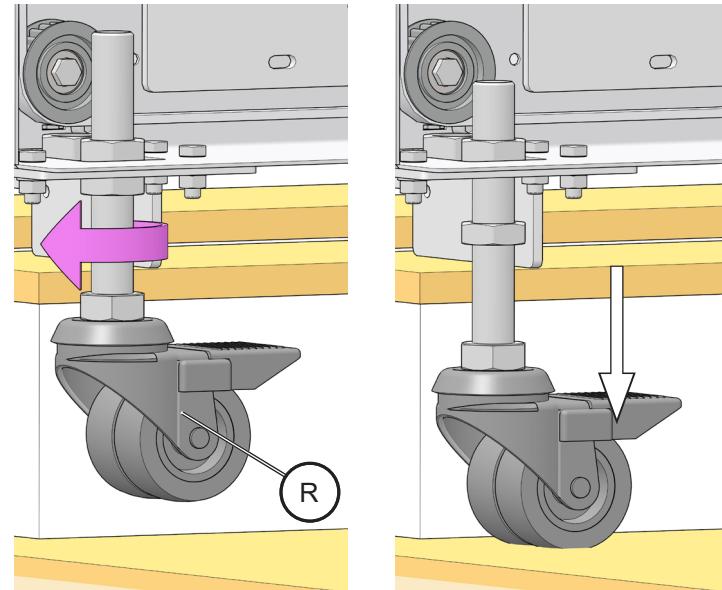
17. On rear side of RCT Remove screws [N] (4x) and Rear Waste frame [O]. Remove screw [P].



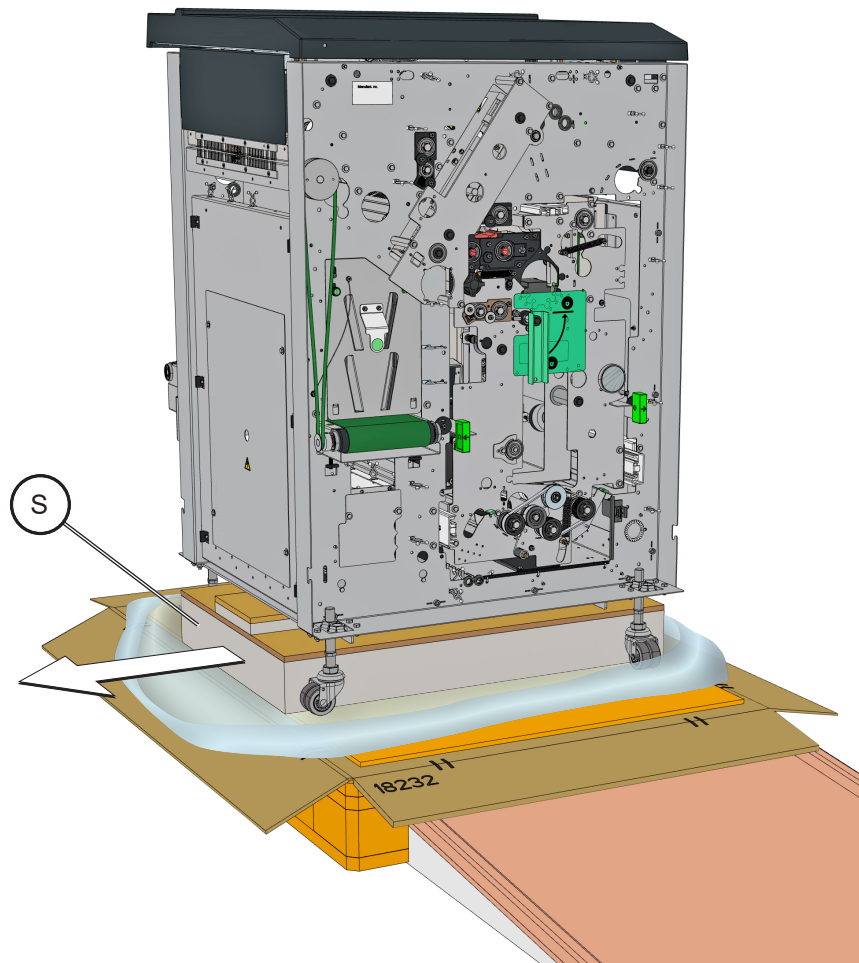
18. Lift and remove the Rear Cover.



19. If you do not have a 24 mm open wrench, you can use the one [Q] supplied with the Booklet Maker, non operator side.

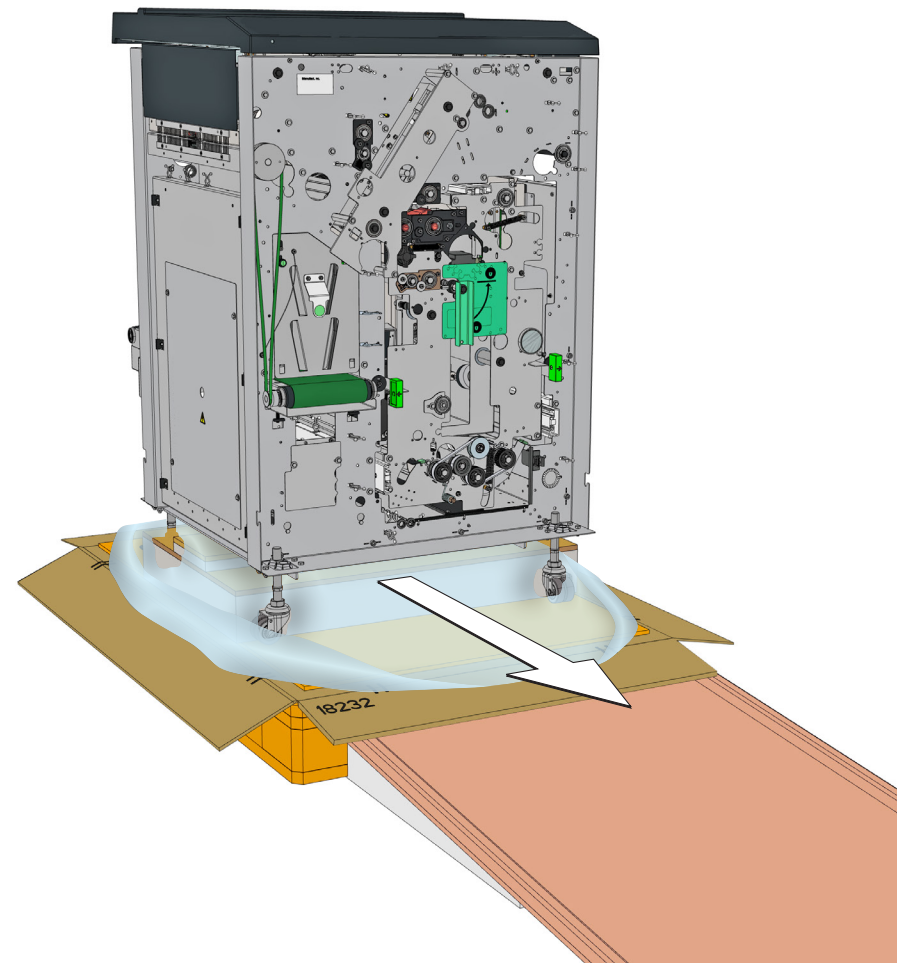


20. The Casters [R] (4x) are adjusted upwards at factory for transport reasons. By turning the lower nut clockwise, adjust the casters high enough to allow for pulling out the foam block as described in the next step of this procedure. Do not turn each wheel more than two full revolutions before adjusting the other wheels, otherwise the module might become unstable and tilt over.



21. While making sure the RCT does not move, pull out the foam block [S] underneath the RCT. Do not lift the module.

NOTE!
be careful when removing this piece of foam as it prevents the unit from rolling!

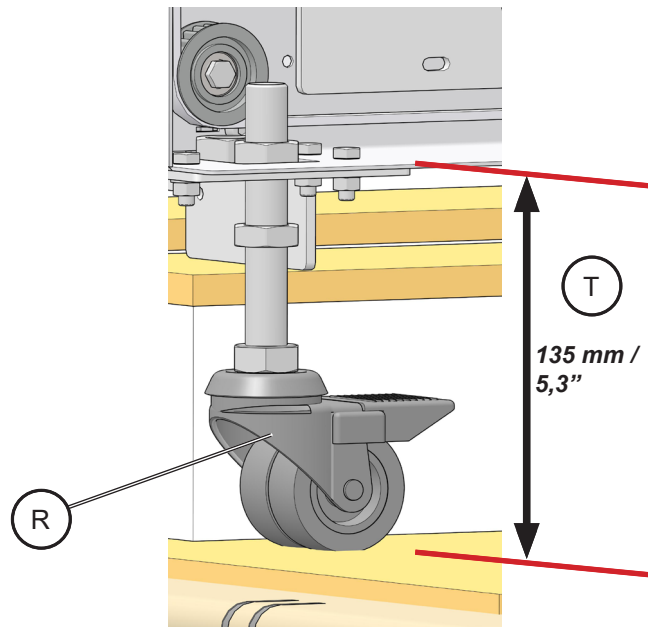


22. Carefully roll the RCT off the pallet.

! WARNING:
Two people are required to carefully roll the RCT off the pallet.



23. For contents of Installation Kit box, see Accessory check 2.4.1.



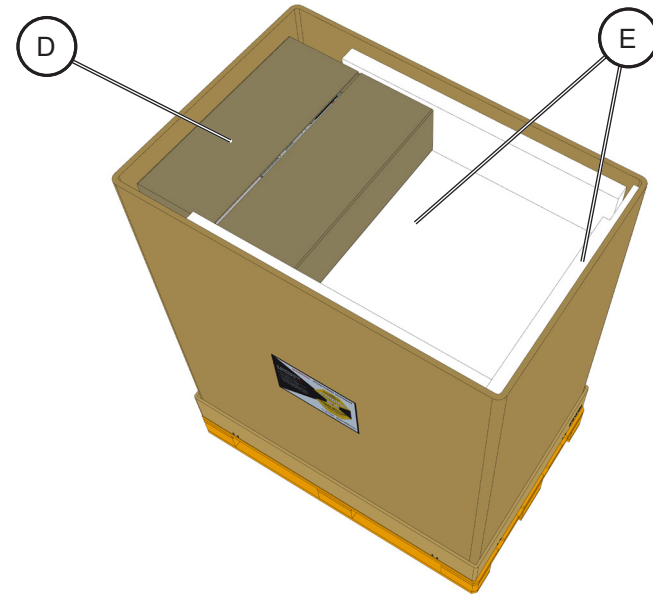
24. Adjust the casters [R] so that the distance between the floor and the frame of the machine (**NOTE! The frame of the machine, not its cover!**) is equal to 135 mm / 5,3" [T]. Do not turn each wheel more than two full revolutions before adjusting the other wheels, otherwise the module might become unstable and tilt over. No need to tighten the Counter Nut at this point. Final adjustment will be done later.
25. Do not reinstall front and rear cover on the module yet.

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2.1.2 Unpacking the Booklet Maker Module Pro435e^U



1. Remove the straps [A].
2. Remove the Top Cover [B].



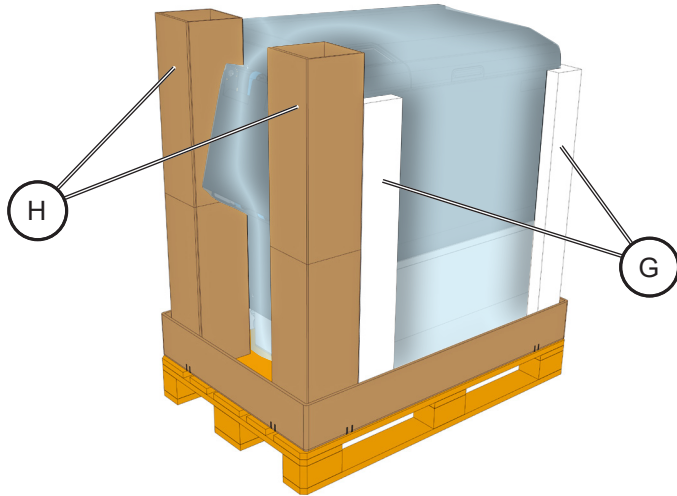
4. Remove accessories box [D].
5. Remove packaging foam [E] (2x).



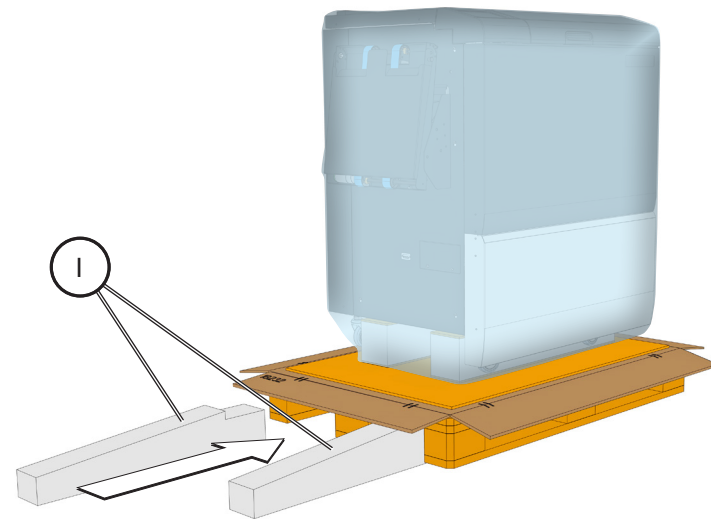
3. Remove ramp [C] from top of packaging and save it.



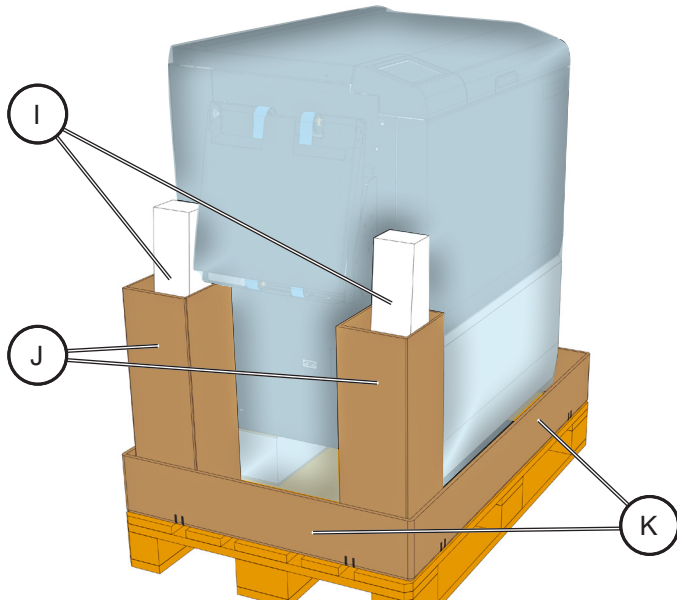
6. Remove the Sleeve [F].



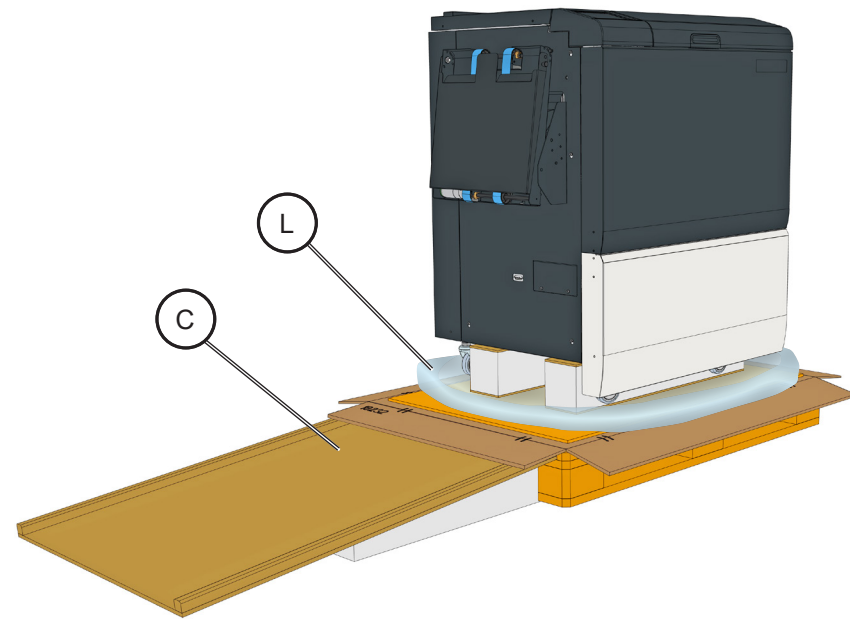
- 7. Remove packaging foam [G] (4x front and rear).
- 8. Remove upper cardboard boxes [H] (2x).



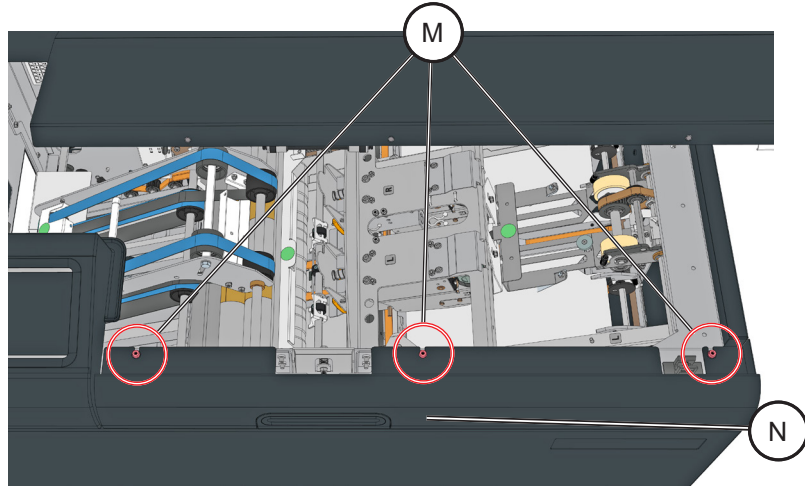
- 12. Mount Ramp Supports [I] (2x) according to picture.



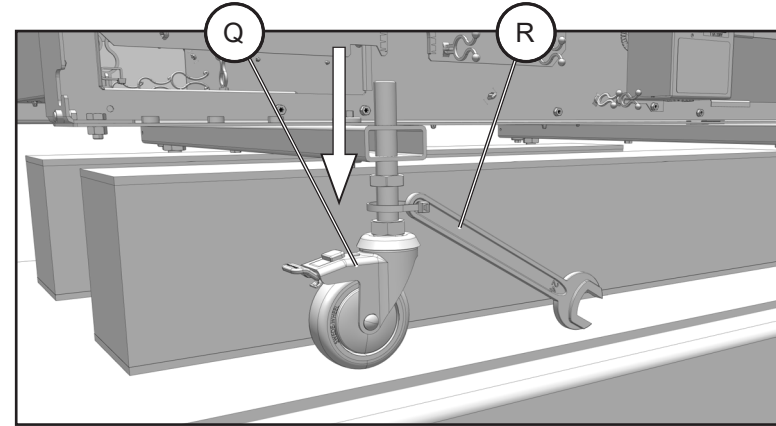
- 9. Remove ramp supports [I] (2x) and save them.
- 10. Remove lower cardboard boxes [J] (2x).
- 11. Fold out the sides of the cardboard box [K].



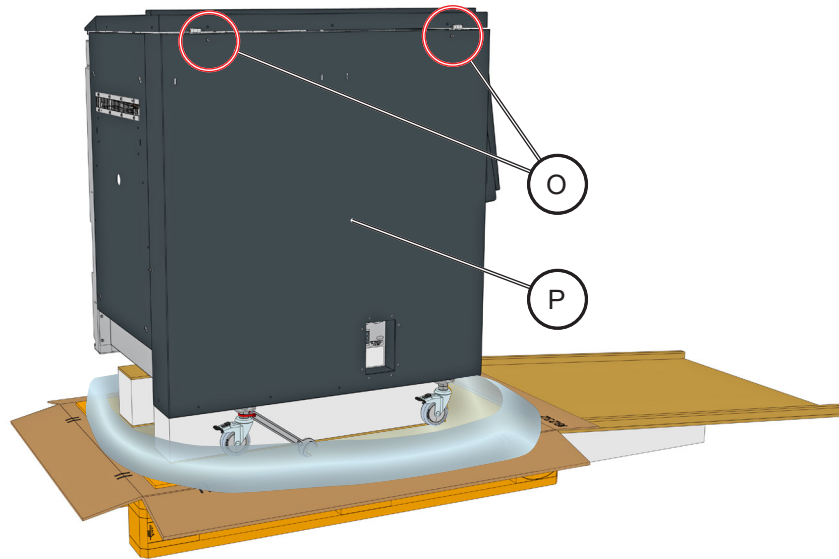
- 13. Place Ramp [C] on supports.
- 14. Roll down plastic wrap [L] from BM.



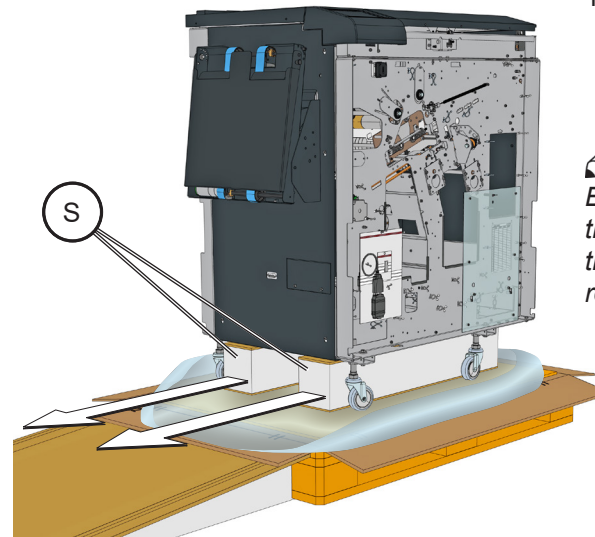
15. Open the Top Cover of Booklet Maker, loosen screws [M] (3x) and remove the Front Cover [N].



17. The Casters [Q] (4x) are adjusted to their uppermost position for transport reasons. By turning nut clockwise, adjust the casters high enough to allow for pulling out the foam blocks [S] (2x) as described later in this procedure. Do not turn each wheel more than two full revolutions before adjusting the other wheels, otherwise the module might become unstable and tilt over. Use wrench [R] attached with a cable tie to one of the rear casters of the machine.



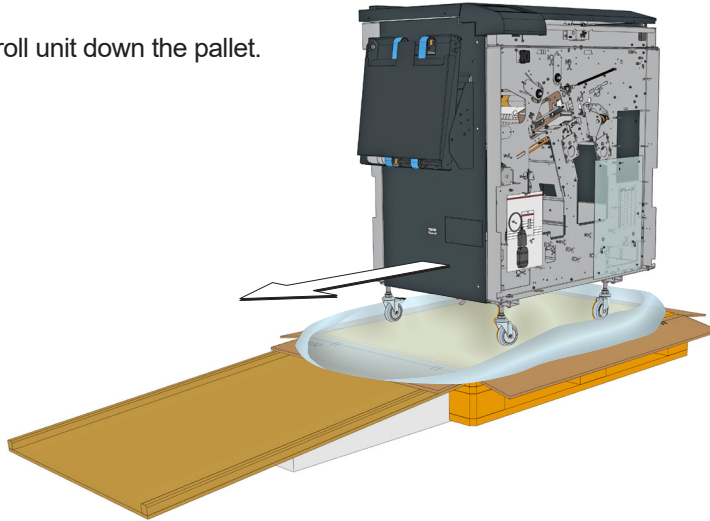
16. Remove screws [O] (x2) and remove the Rear Cover [P] from the Booklet Maker.



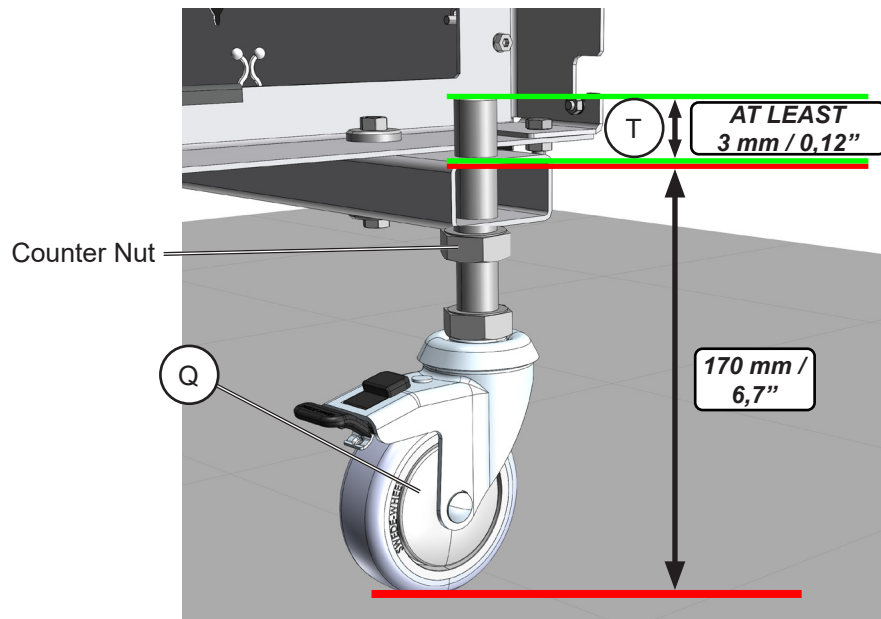
18. While making sure the module does not move, pull foam blocks [S] (2x) from Booklet Maker's base.

NOTE!
Be careful when removing these pieces of foam as they prevent the unit from rolling!

19. Carefully roll unit down the pallet.



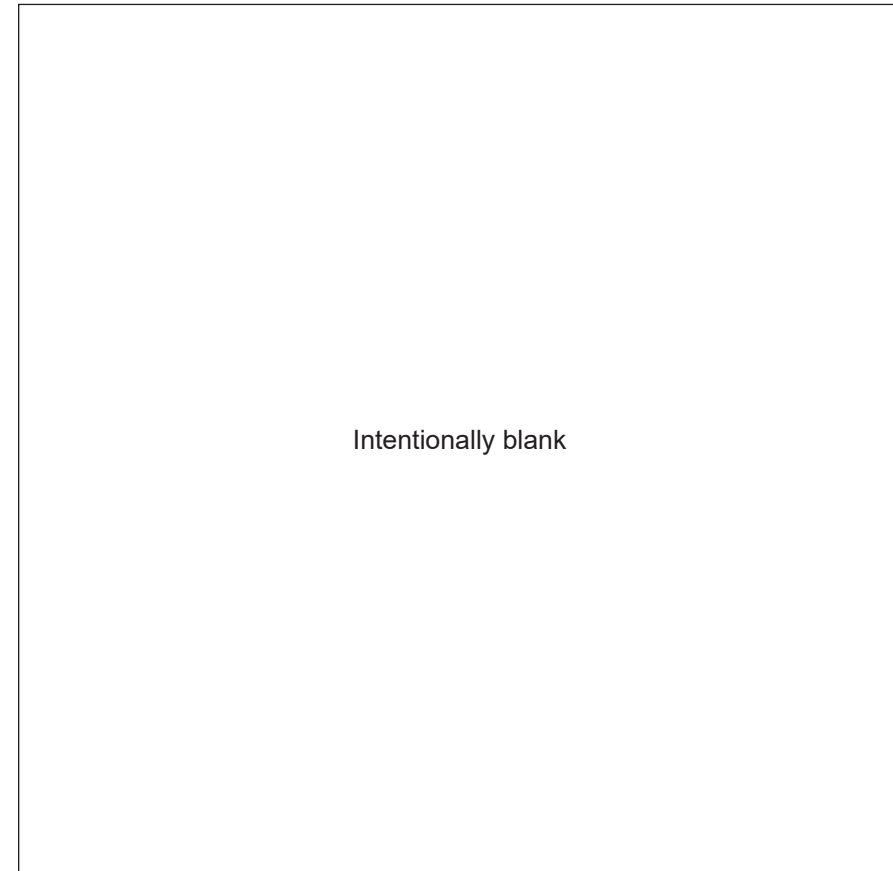
⚠ WARNING:
Two people are required to carefully roll the Booklet Maker off the pallet.



20. Adjust all casters [Q] so that the distance between the floor and the frame of the machine (⚠ *NOTE! The frame of the machine, not its cover!*) is equal to 170 mm / 6,7". Do not turn each wheel more than two full revolutions before adjusting the other wheels, otherwise the module might become unstable and tilt over. No need to tighten the Counter Nut at this point. Final adjustment will be done later.

⚠ NOTE!
If installation will not be completed concurrently reinstall the Rear and Front Cover.

⚠ CAUTION: Distance [T] has to be AT LEAST 3 mm / 0.12".

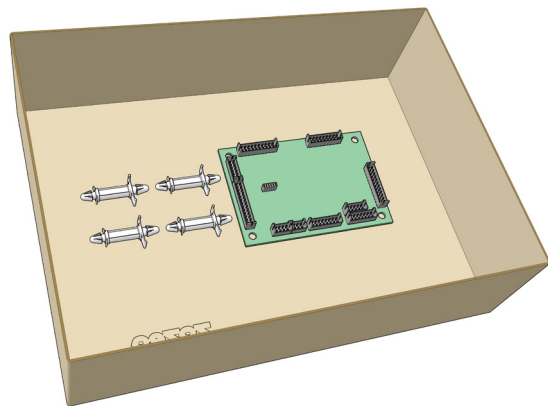


2.1.3 Unpacking the optional 50 sheet performance upgrade kit

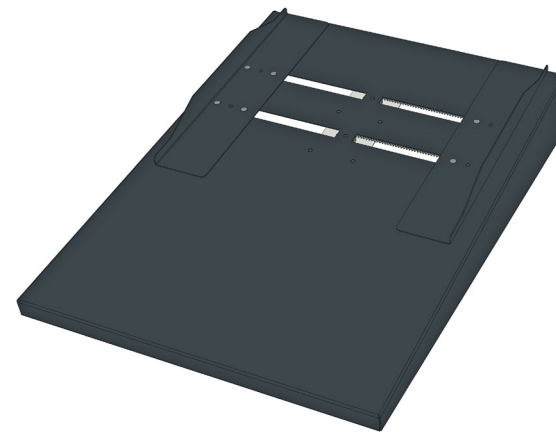
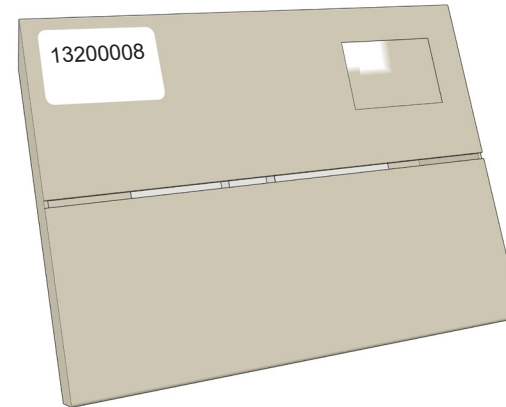


NOTE!

If you do not have the optional 50 sheet performance upgrade kit, please skip this section and proceed with the next one.



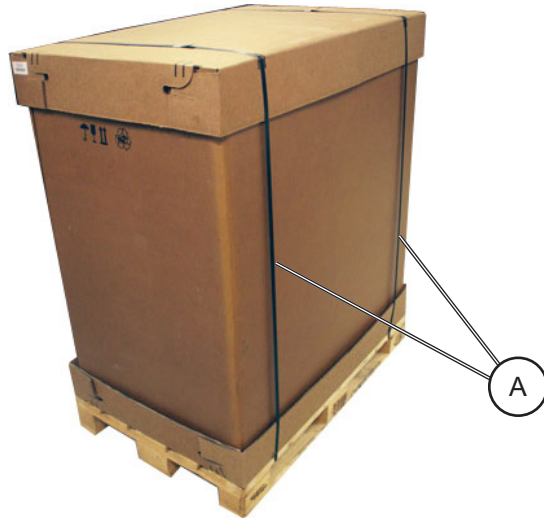
2.1.4 Unpacking the Hand Feed Tray



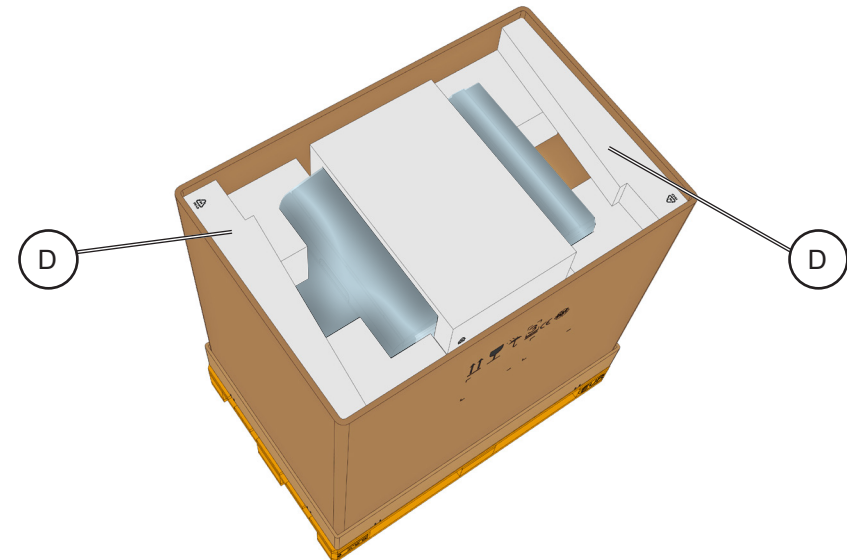
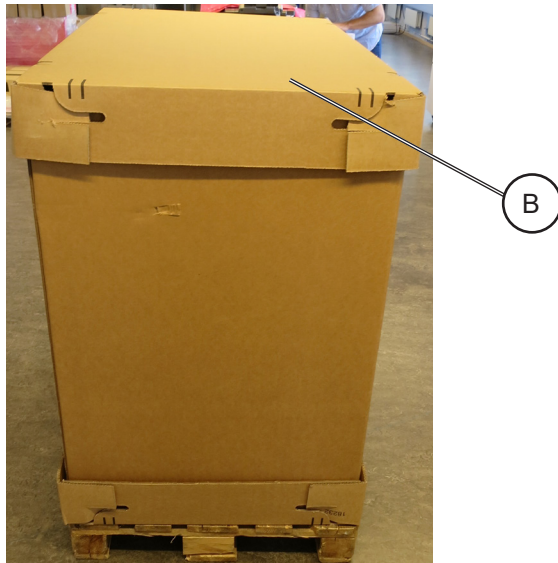
2.1.5 Unpacking the Finishing Module Pro435

NOTE!

If you do not have the optional Finishing Module, please skip this section and proceed with the next one.



2. Remove ramp [C] and save it.

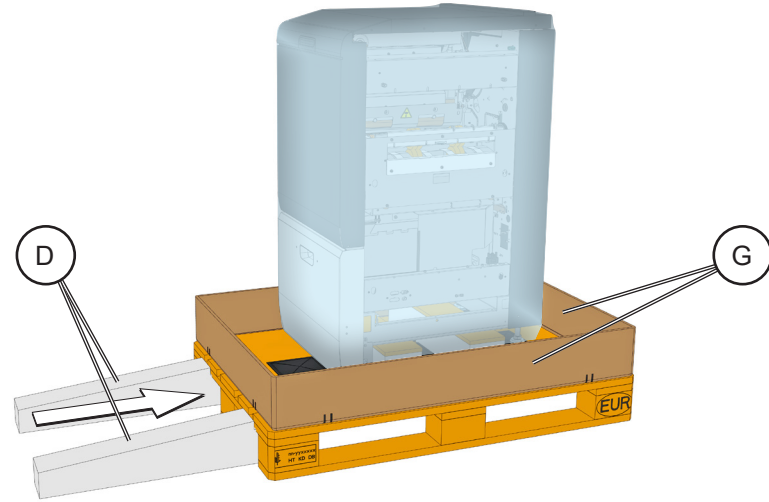


3. Remove Ramp supports [D] (2x) and save them.

1. Remove the Straps [A] and remove the Top Cover [B].

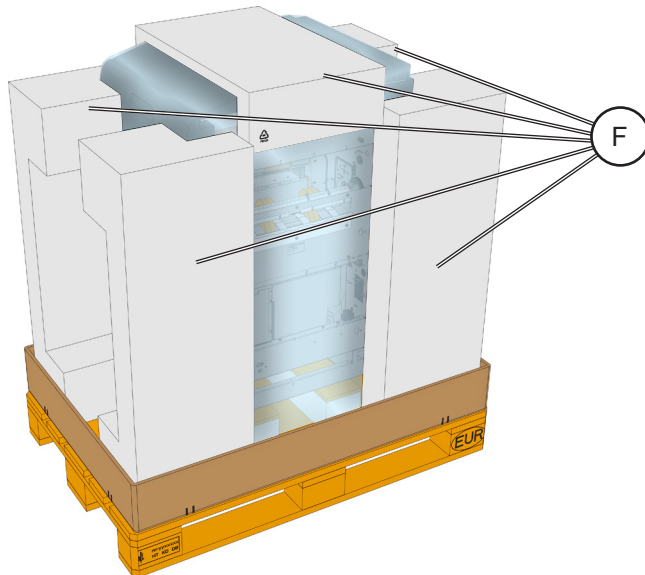


4. Remove Corrugated Sleeve [E].

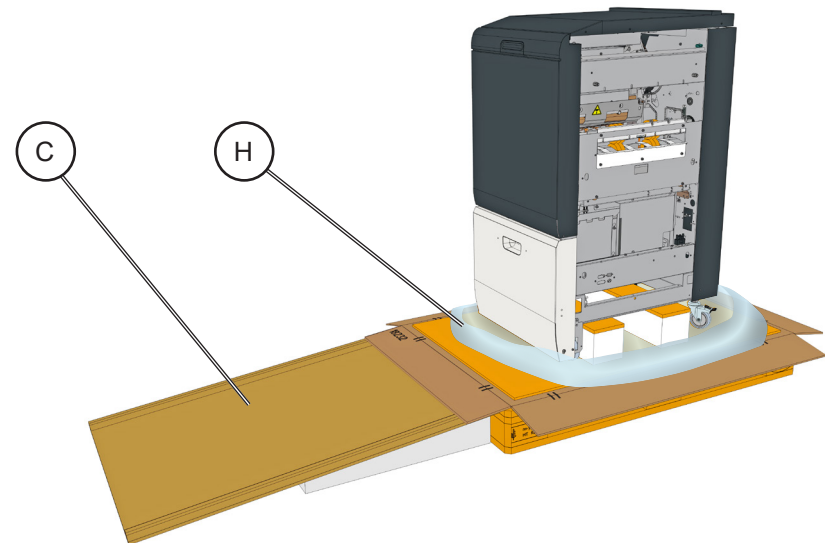


6. Insert ramp supports [D] (2x) .

7. Fold out the sides of the cardboard box [G]

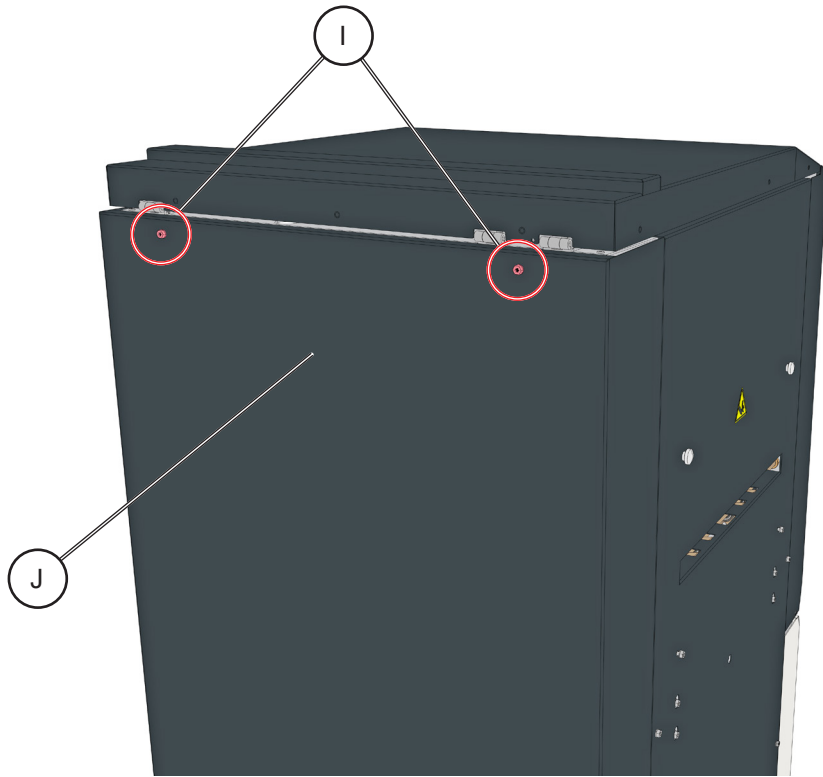


5. Remove protective foam [F] (5x).

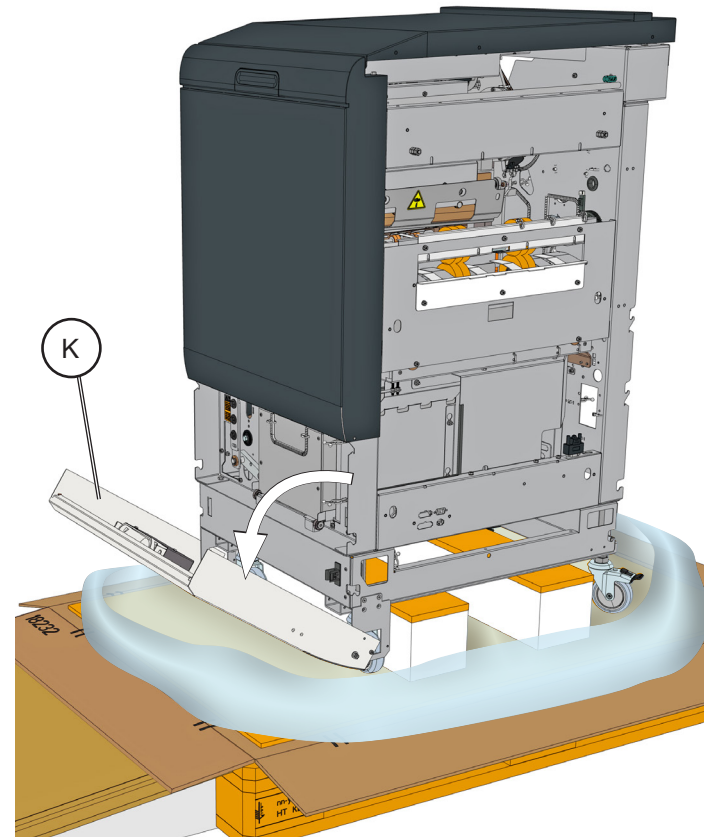


8. Place ramp [C] on supports [D].

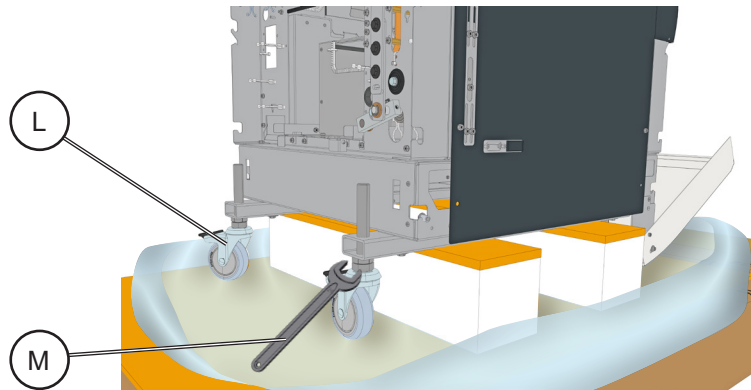
9. Pull down the plastic wrap [H].



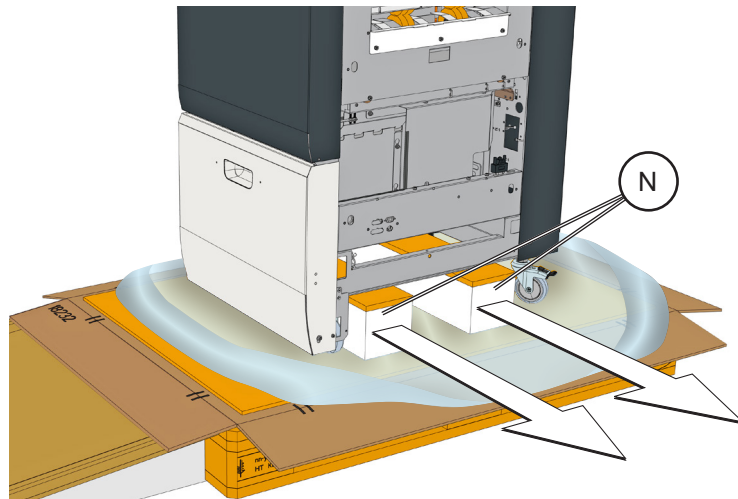
10. Remove screws [I] (2x) to remove rear cover [J].



11. Open waste cover [K].



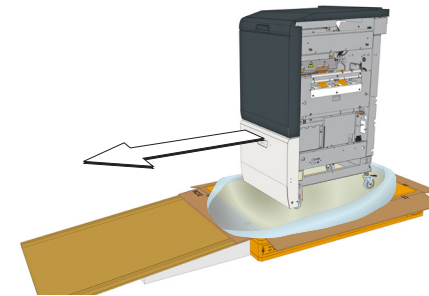
12. The Casters [L] (4x) are adjusted to their uppermost position for transport reasons. By turning nut clockwise, adjust the casters high enough to allow for pulling out the foam blocks as described later in this procedure. Do not turn each wheel more than two full revolutions before adjusting the other wheels, otherwise the module might become unstable and tilt over. If you don't have a 24 mm wrench [M], use the wrench supplied with the Booklet Maker.



13. While making sure the module does not move, remove the Foam Blocks [N] (2x).

NOTE!

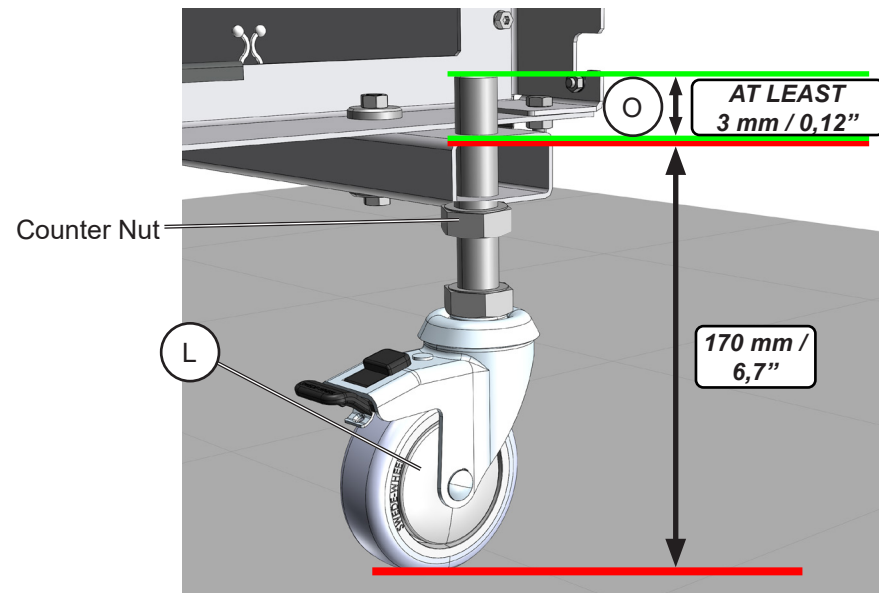
Be careful when removing these pieces of foam as they prevent the unit from rolling!



14. Close the front cover and carefully roll the Finishing Module off the pallet.

WARNING:

Two people are required to roll the Finishing Module off the pallet.



15. Adjust all casters [L] so that the distance between the floor and the frame of the machine (NOTE! The frame of the machine, not its cover!) is equal to 170 mm / 6,7". Do not turn each wheel more than two full revolutions before adjusting the other wheels, otherwise the module might become unstable and tilt over. No need to tighten the Counter Nut at this point. Final adjustment will be done later.

CAUTION: distance [O] has to be AT LEAST 3 mm / 0.12".

16. Reinstall rear cover if not installing the system after unpack.

2.1.6 Unpacking the BST 4000-1 Belt Stacker Module

 **NOTE!**

If you do not have the optional BST 4000-1 Belt Stacker Module, please skip this section and proceed with the next one.



1.



3.



2.



4.



5.



7.



6.



8.

2.2 Installation Requirements

2.2.1 Minimum Space Requirements

Approximate floor space requirements / configuration

Ensure that the minimum required floor space is available for the system that you are about to install.

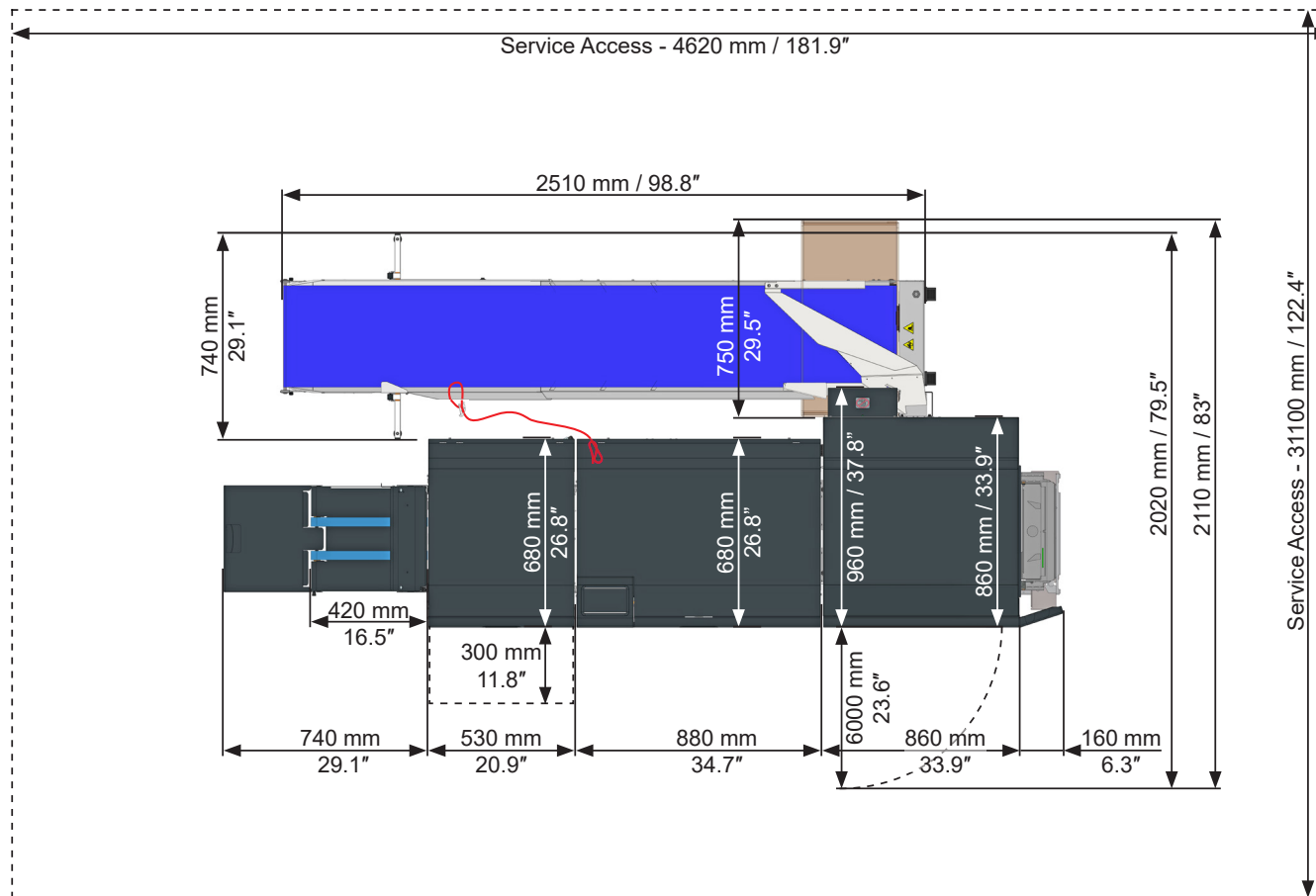
 **NOTE!**

The optional 50 sheet performance upgrade kit does not impact floor space requirements.

The optional high capacity Belt Stacker BST4000-1 (not shown) connects to the included belt stacker with the extender folded away and can be placed either in-line or angled to the Booklet Making system. The BST4000-1 measures 1730x440 mm / 68x17".

 **NOTE!**

Ensure at least 800 mm / 31.5" clearance around the system for servicing.



Plockmatic Pro450e^U/435e^U Production Booklet Maker floor plan

2.2.2 Power Requirements

1. Ensure that a power outlet is available nearby the system, fused to withstand the system's combined rated current.
The current consumption can be seen on the machine labels. For example: if the machine label says "100-240 V, 4-2 A" then the rated current is 4 A at 100 V and 2 A at 230 V.
2. Make sure to route power cords to avoid people from tripping on them.
3. Avoid using excessively long extension cords.
4. Make sure the wall outlet is grounded.

2.2.3 Pre Installation Information

You are about to install one or more of the following modules:

- Rotate Crease Trim Module
- Booklet Maker
- Finishing Module
- BST4000-1 Belt Stacker Module

There are also possible options available to install:

- Optional 50 sheet performance upgrade kit
- Hand Feed Tray

This installation instruction covers all of the above in the following order:

- Rotate Crease Trim Module
- Booklet Maker and any options
- Finishing Module
- BST4000-1 Belt Stacker Module

If you do not install a certain module or option, just skip to the next section. If you were not present during unpacking, check the unpacking instruction to make sure all boxes and parts supplied with each modules and options are present and ensure that all packaging material, stretch film etc. is removed from the modules.

2.2.4 Tools

To complete installation, the following tools are needed:

Supplied with the Booklet Maker:

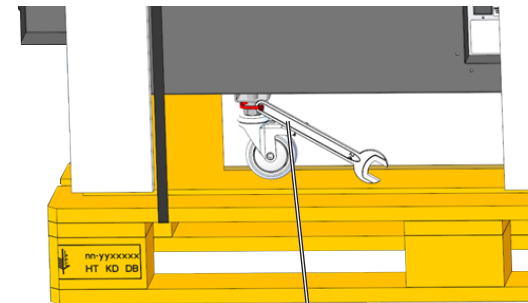
- 24 mm spanner/box or open end wrench.
- USB to RS-232 adapter, Software download cable and USB stick.

Not supplied:

- 7mm spanner/box or open end wrench
- 10mm spanner/box or open end wrench or hex nut driver
- T20 torx driver
- 10 mm socket, 100 mm long (if installing optional RCT module).

NOTE!

Other tools are also supplied, however they are not supposed to be used during the installation procedure.



Wrench



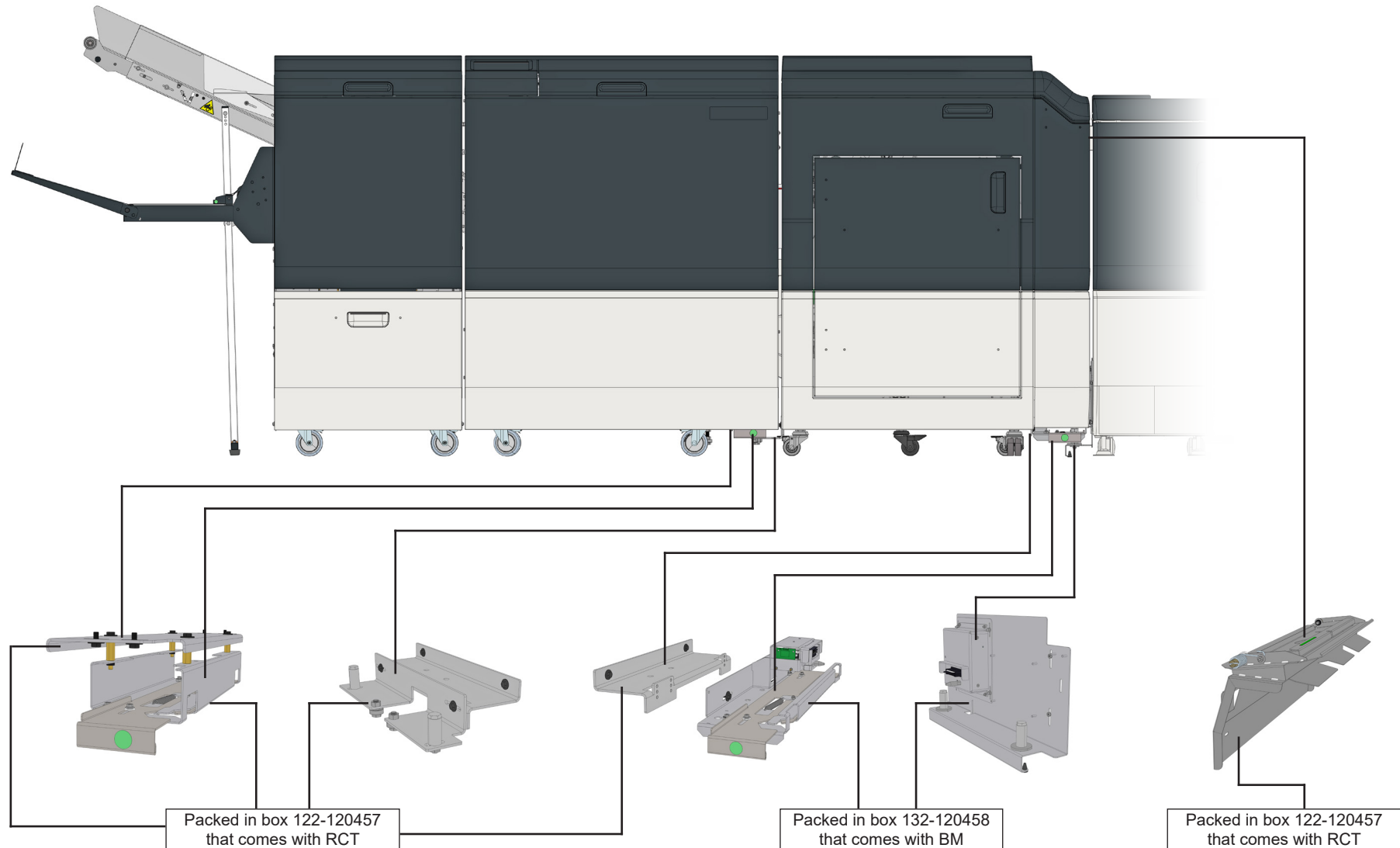
SW download cable
Stored behind the front cover



USB Drive
Stored behind the front cover

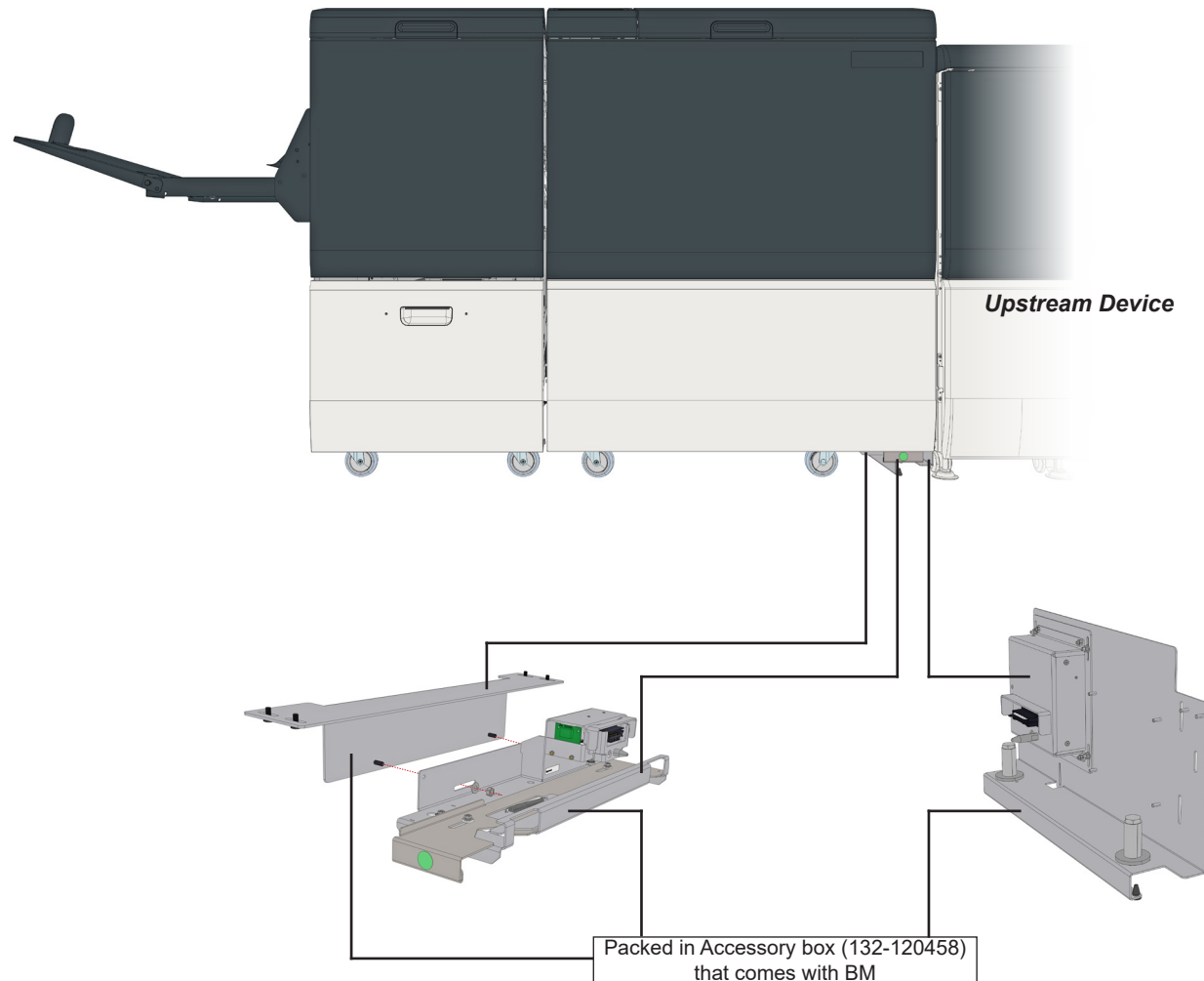
2.2.5 Dockings Overview BM + RCT + Upstream Device

The picture below shows how the dockings are to be installed on the system if the optional Rotate Crease Trim module (RCT) is going to be installed to the system. If the optional Rotate Crease Trim module is not going to be installed to the system, please refer to the description on the next page instead. Note that some docking brackets are shipped in the Accessories kit of the Booklet Maker, while some docking brackets are shipped with the RCT. A detailed description of how to install the brackets is provided later in this manual.



2.2.6 Dockings Overview BM + Upstream Device

The picture below shows how the dockings are to be installed on the system if the optional Rotate Crease Trim module (RCT) is not going to be installed to the system. If the optional Rotate Crease Trim module is going to be installed to the system, please refer to the description on the previous page instead. Note that the docking brackets are shipped in the Accessories kit of the Booklet Maker. A detailed description of how to install the brackets is provided later in this manual.



2.3 Installation Precautions

⚠ CAUTION:

ESD Hazard! ESD (Electrostatic Discharge) can cause hardware crashes, data and/or communications problems. Failure to use proper ESD procedures will cause damage to electronic components (example: PCBs). ESD problems can be minimized by maintaining all machine ground connections, ensuring the proper handling of circuit boards/ sensors. Use ESD protection when working near PCBs. Failure to use ESD protection is likely to result in a PCB failure.

⚠ WARNING:

If installation/s to be performed are additions to an existing, already installed system, turn off the Main Power Switch/es and disconnect the Main Power Cord/s before disconnecting, removing or replacing any electrical components. Do not connect power cord/s unless instructed.

⚠ WARNING:

To avoid hazardous situations like for instance electric shock or danger while exposed to moving, rotating or cutting devices, exercise extreme care when operating modules with covers, guards or protection removed or when electrical or mechanical interlock devices are overridden or bypassed.

⚠ WARNING:

The procedures described in this manual must be carried out by trained personnel only.

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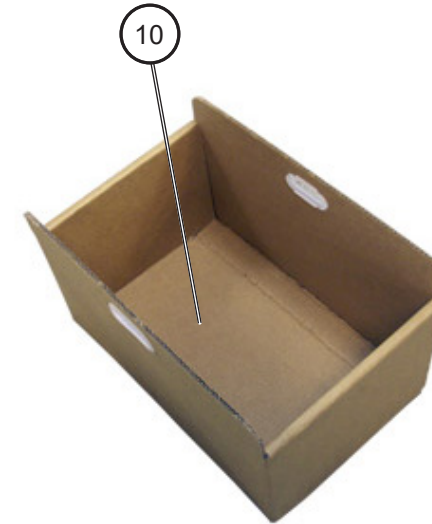
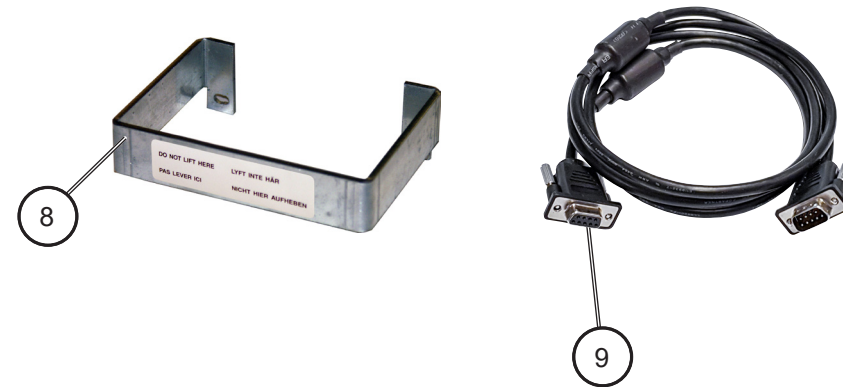
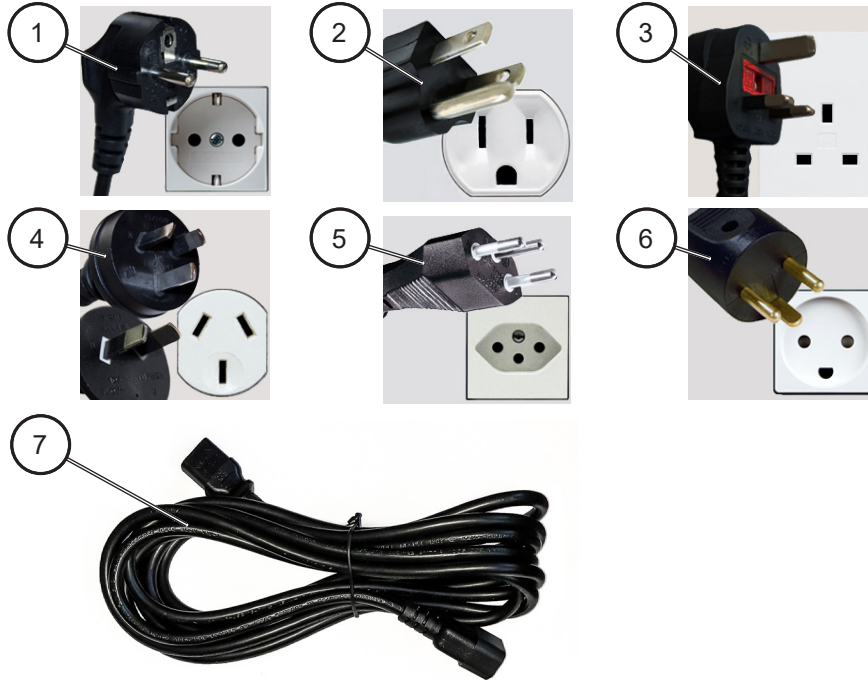
2.4 Installing the Rotate Crease Trim Module (RCT)

This section describes how to install the Rotate Crease Trim Module - RCT.

NOTE!

If you do not have the optional Rotate Crease Trim Module, please skip this section and proceed with the next one.

2.4.1 Accessory Check

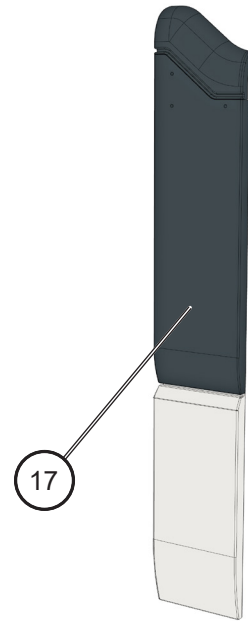
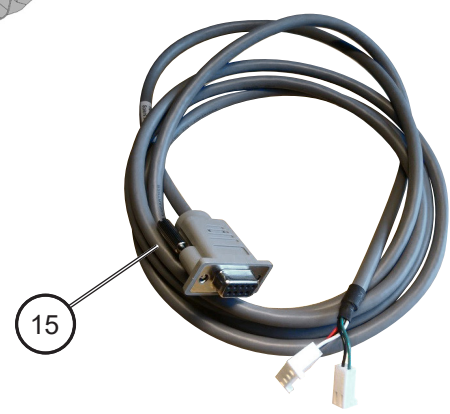
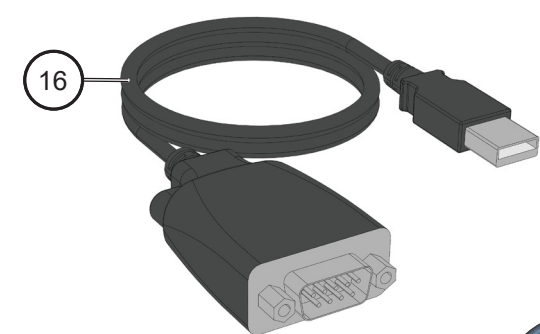
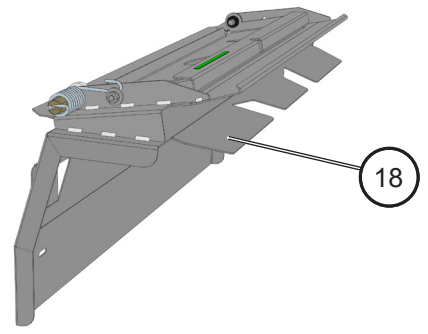
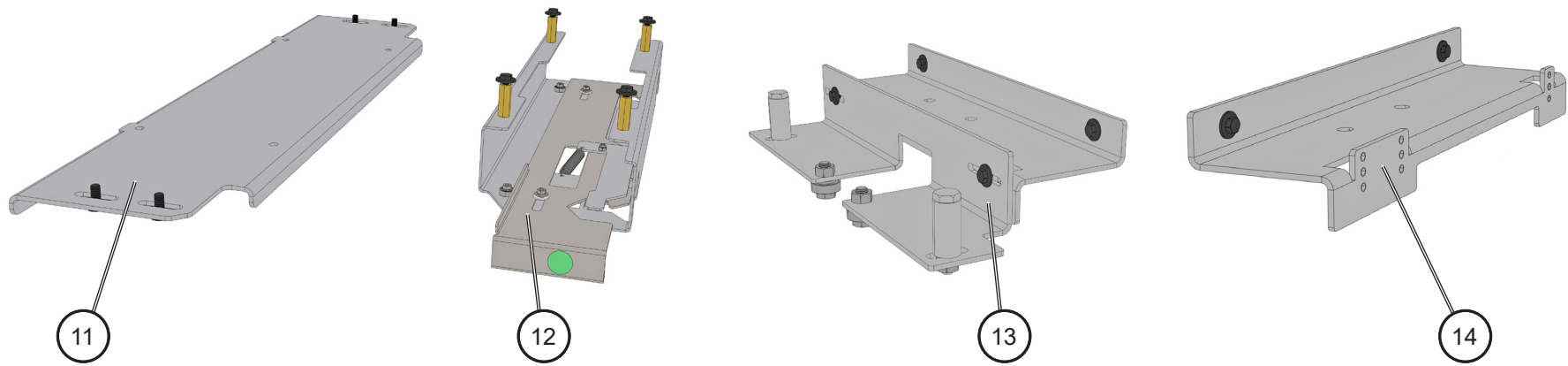


Check the quantity and condition of the accessories in the box against the following list:

Description	Q'ty
1. Power cord EUR/IEC 1.0 mm ² 80 mm	1
2. Power cord USA/IEC AWG-14 80 mm	1
3. Power cord UK/IEC 1.0 mm ² 80 mm	1
4. Power cord AUS/IEC 1.0 mm ² 80 mm	1
5. Power cord Swiss/IEC 1.0 mm ² 80 mm	1

Description	Q'ty
6. Power cord Denmark IEC 1.0 mm ² 80 mm	1
7. Extension cord 4,2 m	1
8. Cable protector	1
9. Communication cable*	2
10. Waste Box	1

*Use second cable as extension cord.



Description	Q'ty
11. Docking plate	1
12. Upstream (in-feed side) Docking Bracket, Booklet Maker	1
13. Downstream (exit side) Docking Bracket, RCT	1
14. Upstream (in-feed side) Docking Bracket, RCT	1
15. Software Loading Cable	1
16. USB to RS232	1
17. Intermediate Cover	1
18. In-Feed Bracket	1

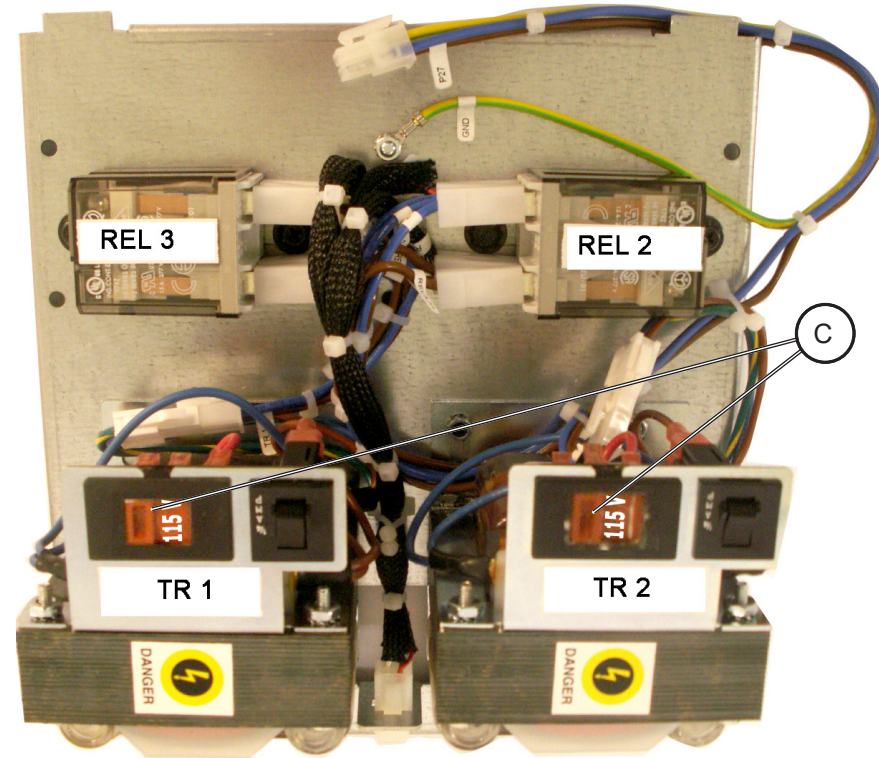
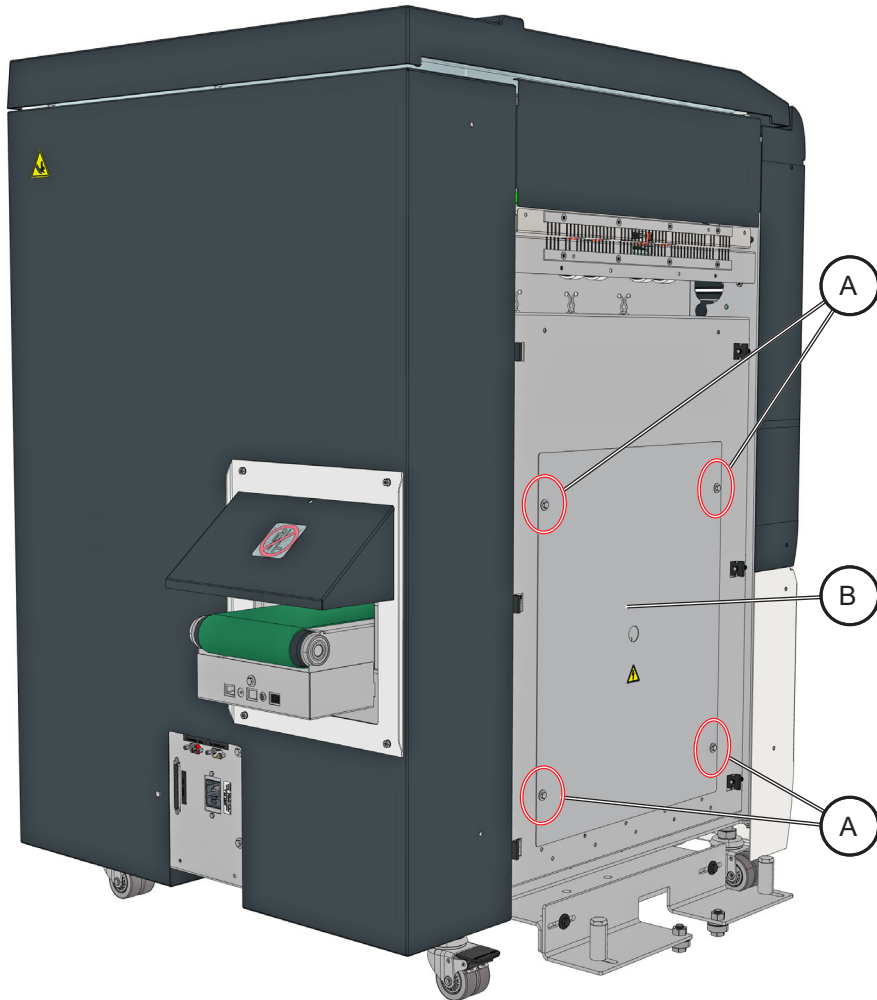
NOTE: RCT Module valid until Serial Number L122Y00_____

2.4.2 Setting the voltage switches for the optional antistatic bar kit

This section describes how to check the voltage setting on the optional antistatic bar kit for the RCT.

NOTE!

If the Rotate Crease Trim Module which you are about to install is not equipped with the optional antistatic bar kit, please skip this section and proceed with the next one.

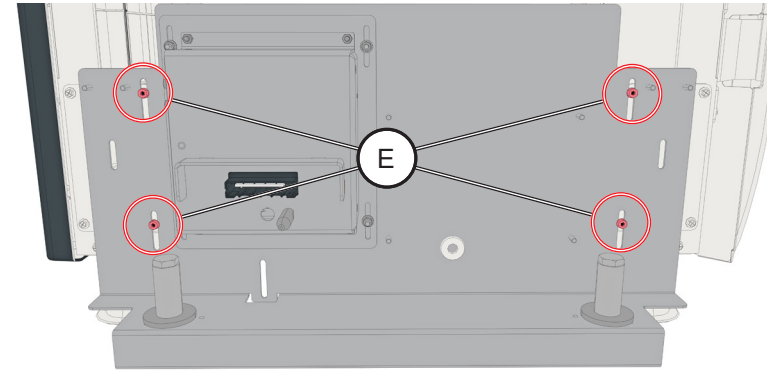


1. Remove screws [A] (4x);
2. Remove safety cover [B];
3. The optional, pre-installed, antistatic bar kit is set by default to 230V.
 - For regions with Main Voltage 100-127 V, set the Switch [C] to 115 V on both transformers;
 - For regions with Main Voltage 128-240 V, make sure the Switch [C] is set to 230 V on both transformers.
4. Reinstall safety cover.

The optional antistatic bar kit will need to be enabled via the service menu. This will be described later on in this manual, when the system will be up and running.

Continue with next section below.

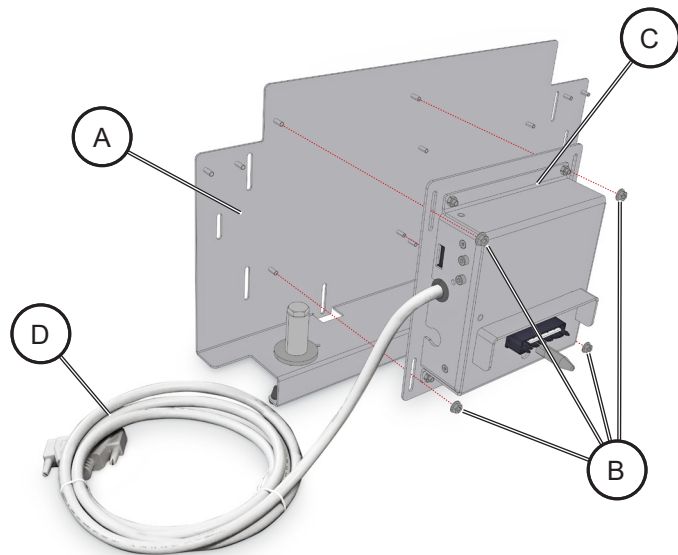
2.4.3 Upstream Device Docking Bracket and Rail Unit



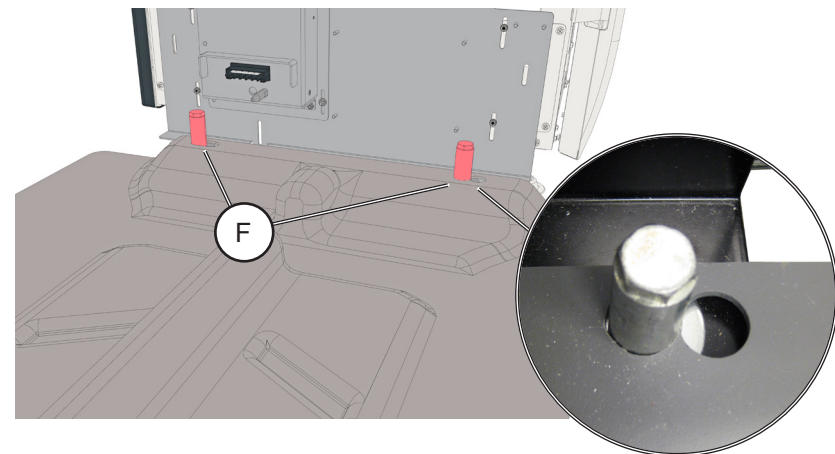
1. Install the Docking Assembly to the Upstream Device using the four screws [E] that came together with the Docking Assembly.

 **NOTE!**

If optional Railing Unit is installed, follow the next 4 steps. If not, then skip to next section.



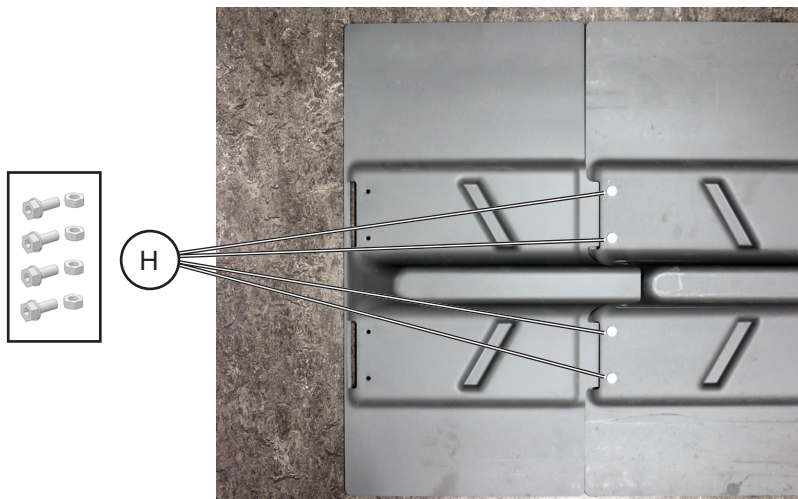
In order to install the RCT to an Upstream Device, a Docking Assembly must have been installed to the Upstream Device. If not already installed, obtain the Docking Bracket [A] and nuts (4x) [B] from the installation kit that comes with the Booklet Maker. The Docking Bracket comes with a Communication Box [C] and Communication Cable [D].



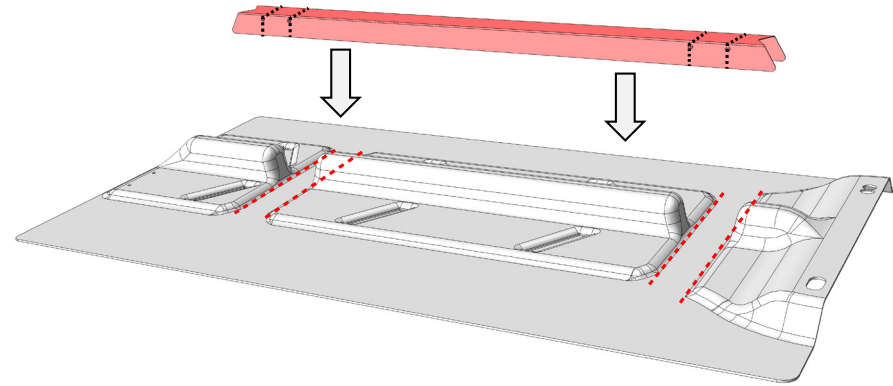
2. Attach main rail on pins [F]. Use the left hole on the main rail unit.



3. Insert rail extension/s [G]. Three extra are required to also accommodate the RCT.



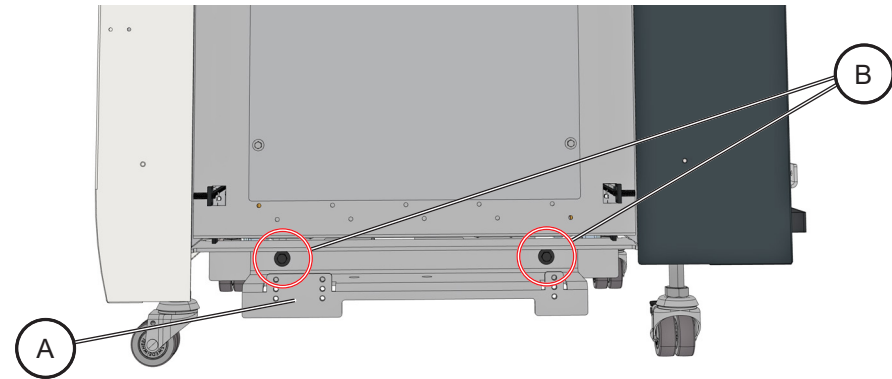
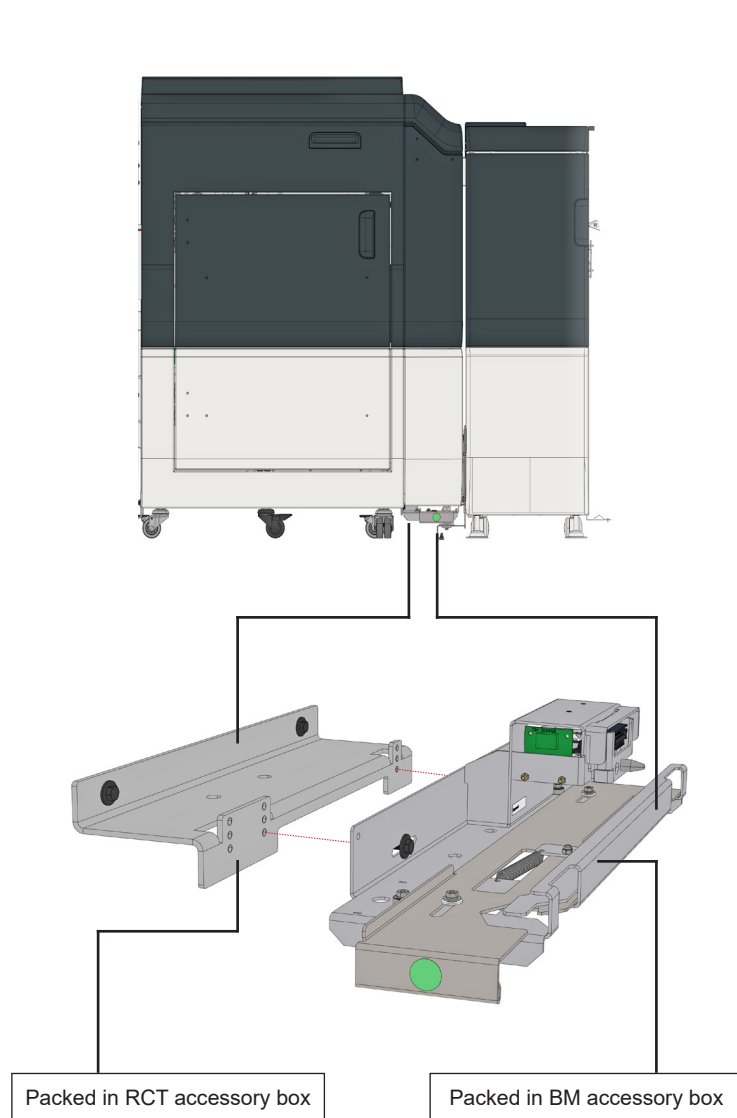
4. Secure by installing the screws and nuts [H] (4x).



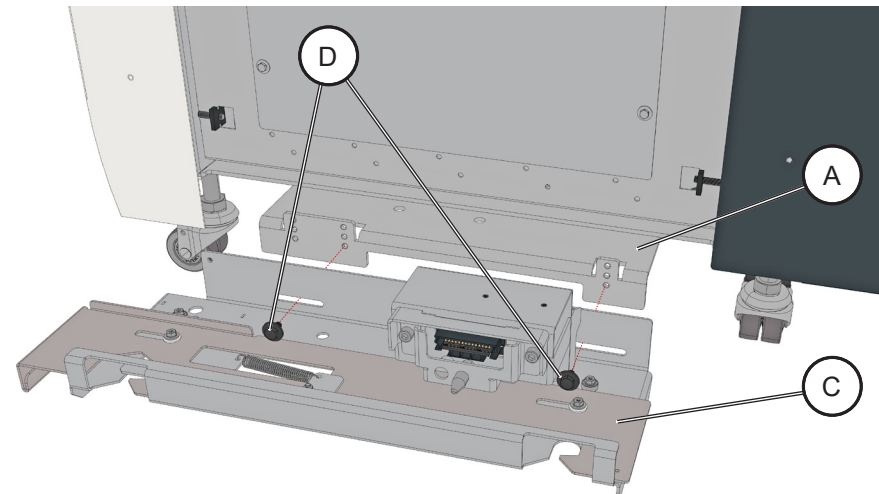
5. Install the rail add-on to the main part of the rail.



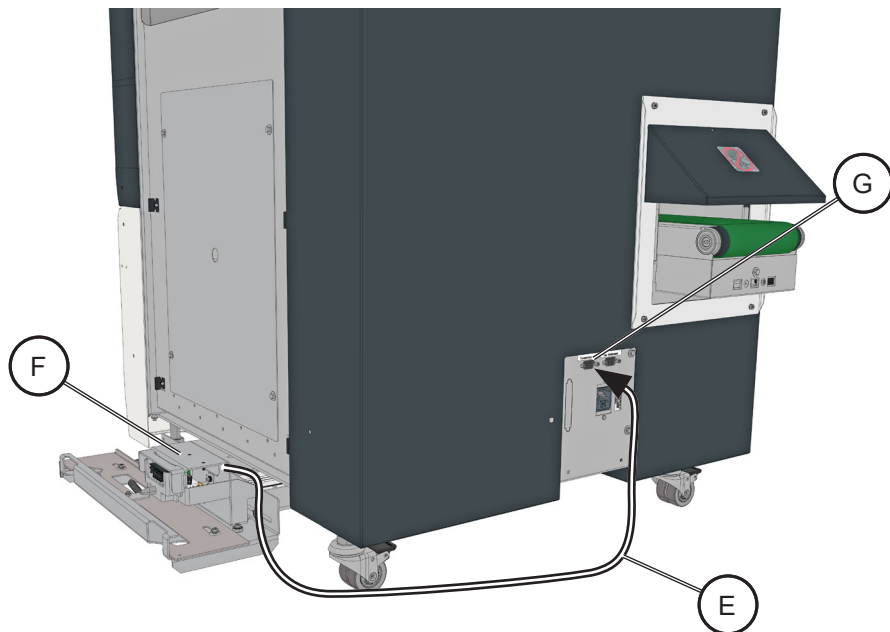
2.4.4 RCT Upstream Docking Bracket and Intermediate Cover



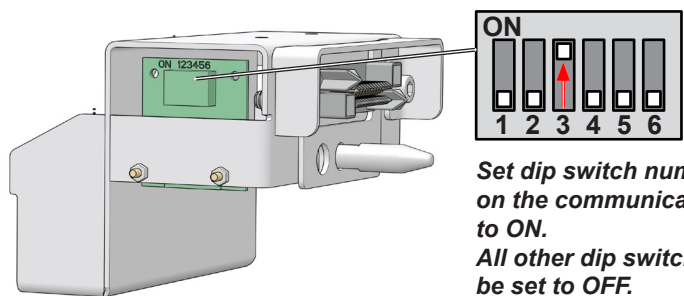
1. Retrieve inner docking bracket [A] from the accessory box shipped with RCT, then install it to the In-Feed side of the RCT using screws [B] (2x).



2. Retrieve outer docking bracket [C] and install it to the inner docking bracket [A] with screws [D] (2x). Note that screws can be moved up or down to compensate for different floor characteristics if needed.

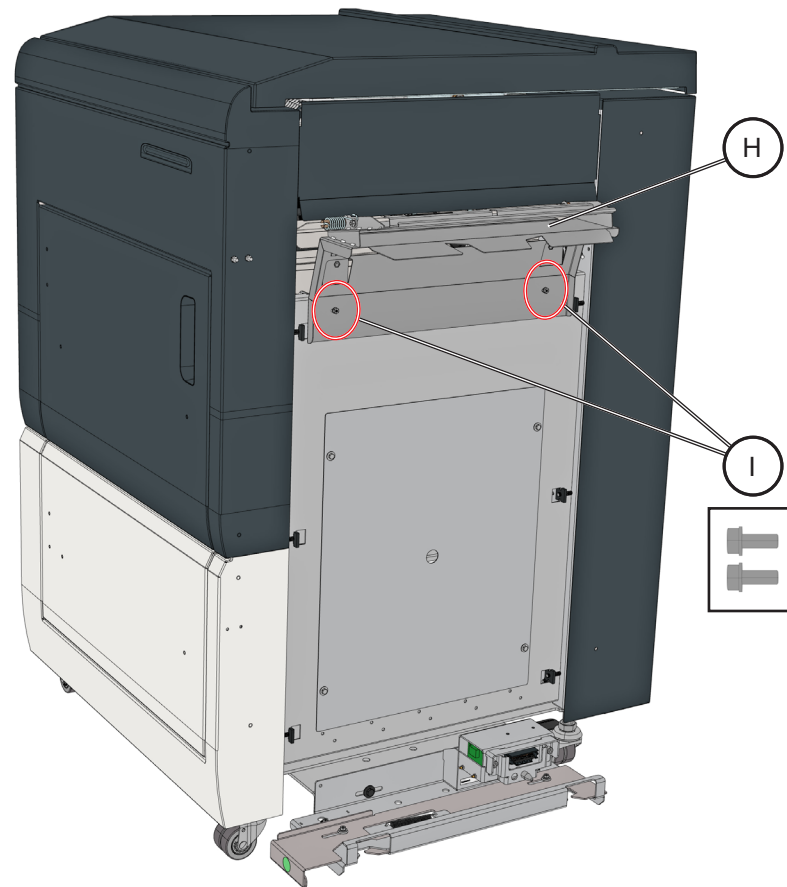


3. Take the Can Cable [E] coming out of Communication box [F] and plug it in upper left D-Sub connection [G] on rear of RCT.



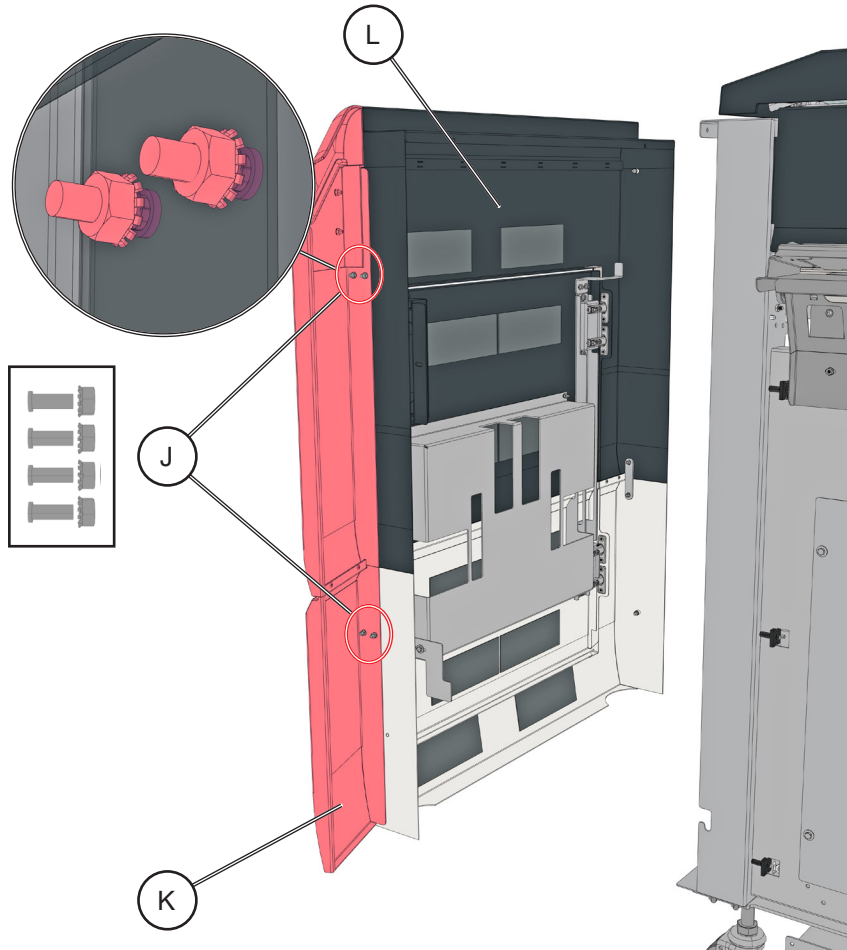
Set dip switch number three on the communication PCB to ON. All other dip switches should be set to OFF.

4. Check that DIP switches on the Communication box are set correctly.



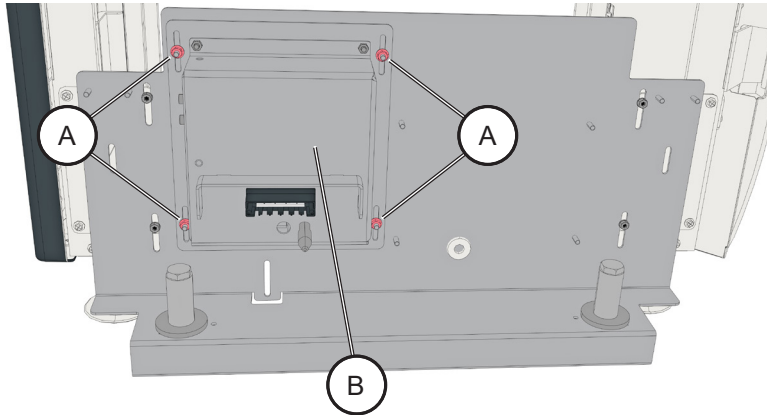
5. Retrieve In-Feed Bracket [H] from the accessory box shipped with the RCT.
6. Attach Bracket [H] to RCT using screws [I] (2x).

7. With screws and nuts [J] (4x) fasten the Intermediate Cover [K] to the Front Cover of RCT unit [L] which at this point is still removed and must be installed later.



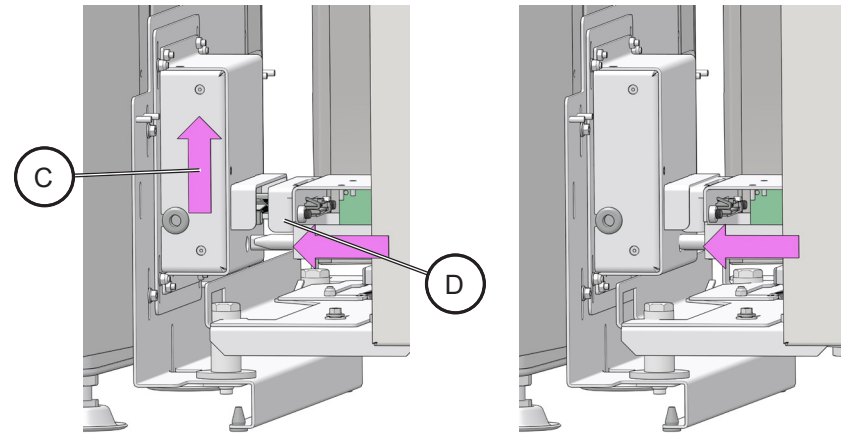
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2.4.5 Docking RCT to upstream device

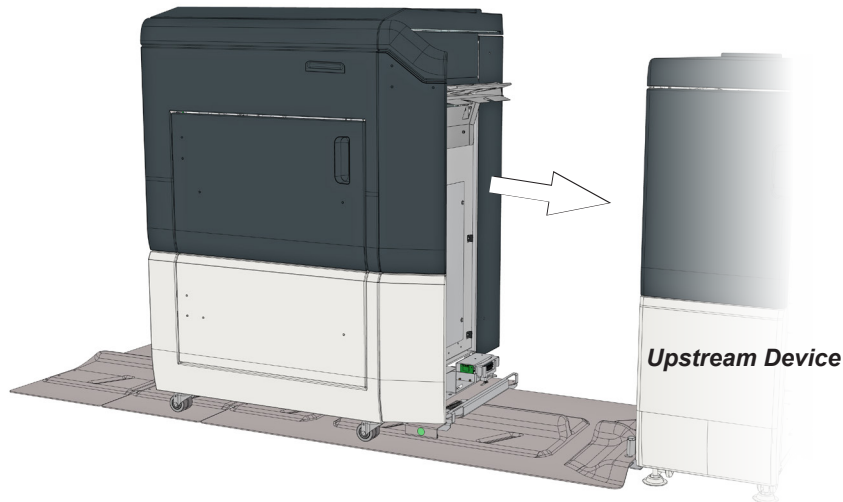


1. Loosen the four nuts [A] securing the Communication box [B] to make height adjustment possible later on in the installation procedure.

2. Bring the RCT up close to the Upstream Device but do not dock yet. The purpose is to check/adjust the alignment top to bottom and the height adjustment between the RCT and the Upstream Device as well as to check/adjust the height of the Communication boxes.



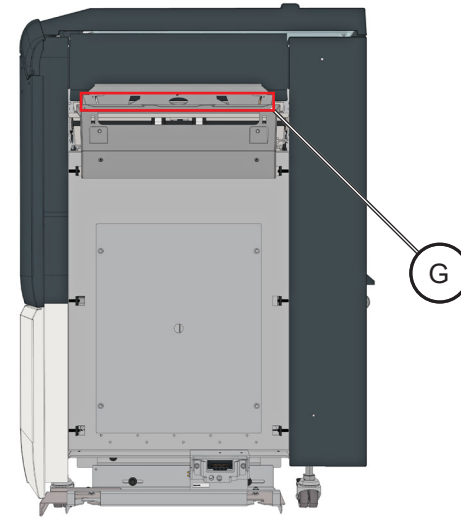
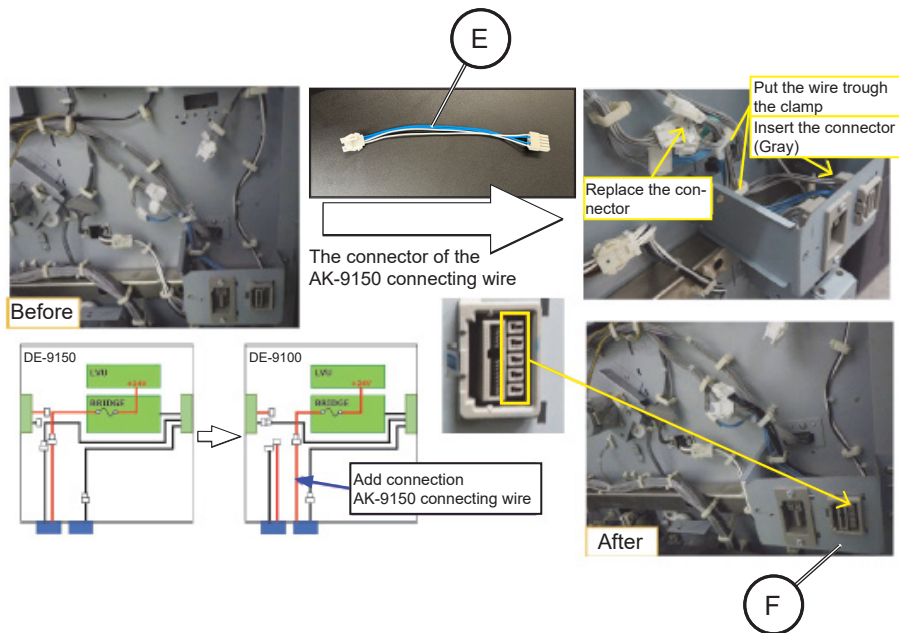
3. Dock the RCT to the Upstream Device while lifting the Communication box on the Upstream Device [C] so it can mate with the Communication box on the RCT [D].



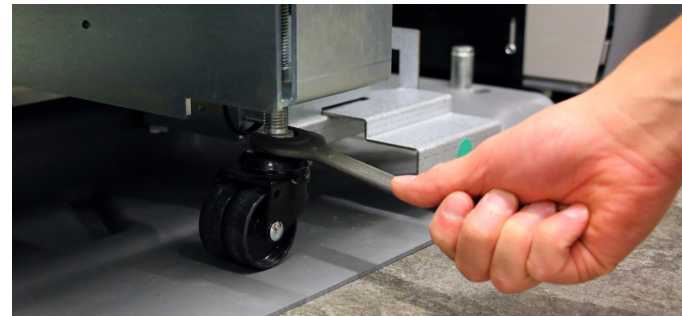
NOTE!

The next 4 steps are just for reference. The correct procedure is described in the printer's Installation manual.

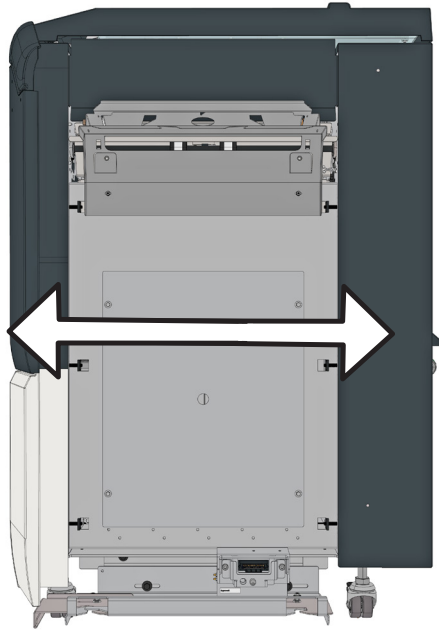
4. Turn off the printer and its components and disconnect the power cord.
5. Obtain the Replacement connector [E].
6. Replace the existing connector. Route the replacement connector through cable clamp and fasten the connector into connector bracket [F].
7. Connect the AK-9150 connection wire to DE-9100.



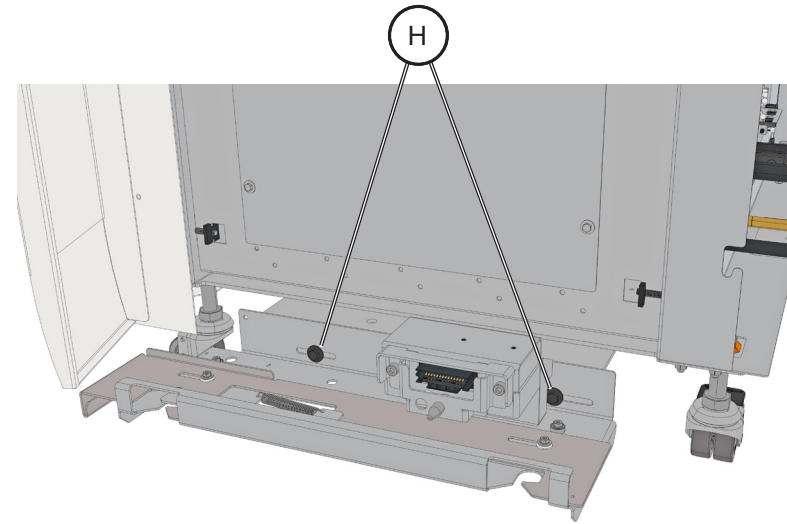
8. Both height and side-to-side adjustments are correct when paper path [G] on the In-Feed bracket matches with paper path on the exit side of the Upstream device.
 - If height adjustment is not correct, go to step 9
 - If side-to-side adjustment is not correct go to step 10
 - If both adjustments are correct, skip to step 11



9. If height adjustment is not correct, adjust casters using the 24 mm open wrench supplied with the Booklet Maker. Do not turn each wheel more than two full revolutions before adjusting the other wheels, otherwise the module might become unstable and tilt over. Once adjustment is correct, use a spirit level to make sure the RCT sits levelled. If RCT does not sit levelled, continue adjusting casters until RCT is levelled.

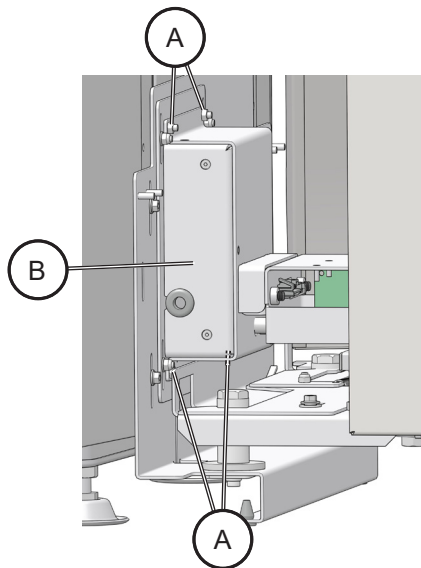


10. If side-to-side adjustment is not correct, move the RCT, while keeping it docked, in the direction shown by the arrows until correct adjustment is achieved.

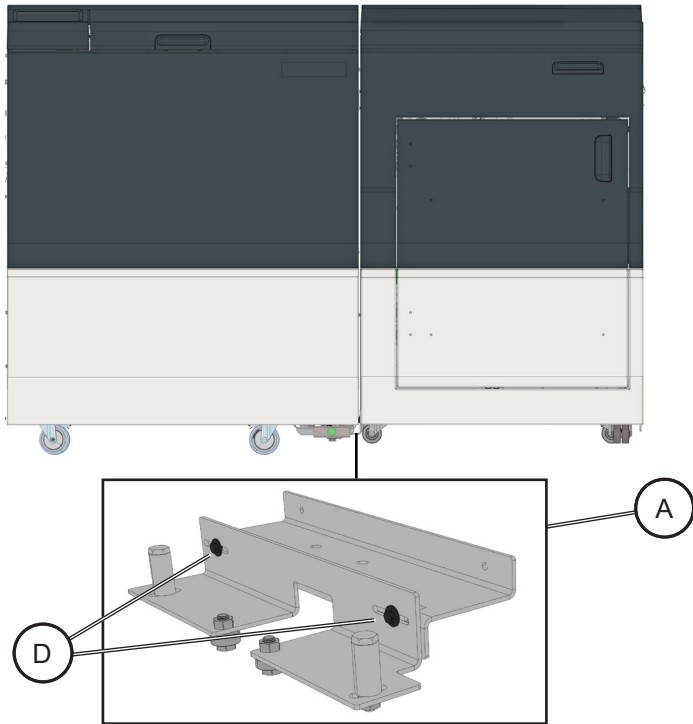


11. Once height and side-to-side adjustments are correct:

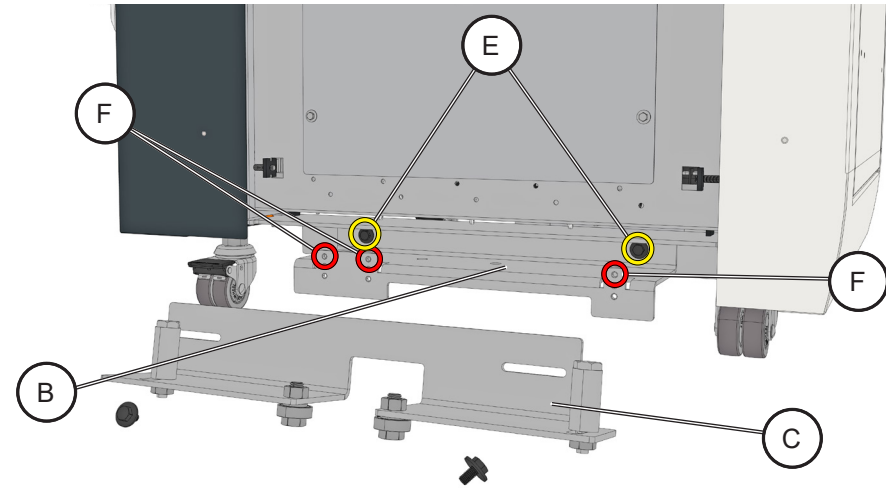
- Secure Counter Nut s on RCT's wheels;
- Tighten the four lock nuts [A] securing the Communication Box [B];
- Tighten the two screws [H] securing the Docking Bracket on the RCT.



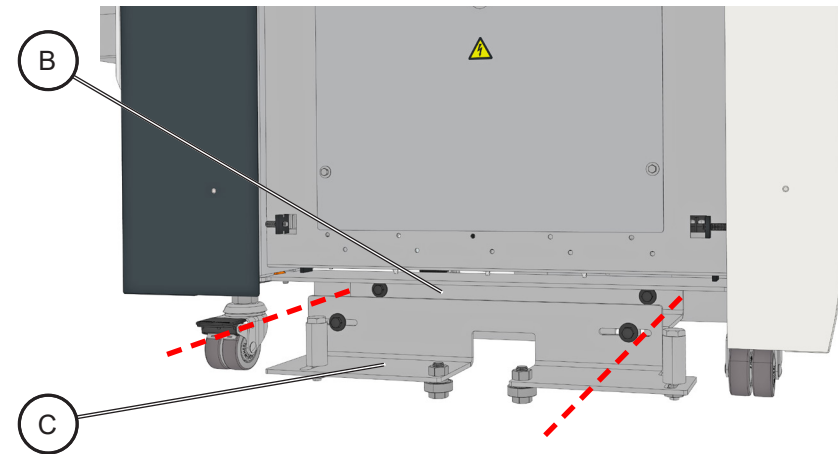
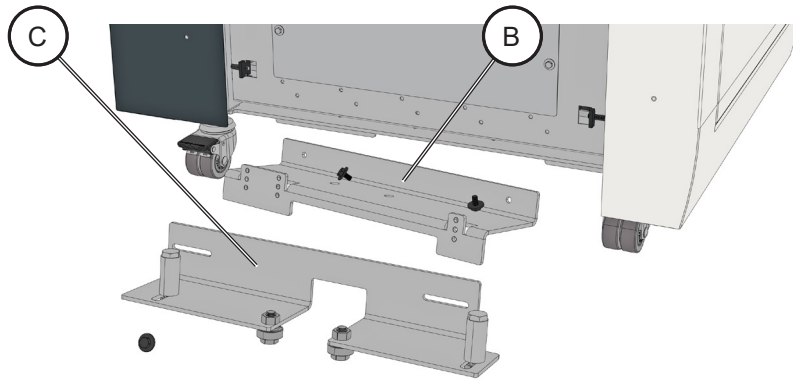
2.4.6 RCT Downstream Docking Bracket



1. Retrieve the Downstream Docking Bracket [A] from the RCT accessory box.
2. The Downstream Docking Bracket [A] is composed of two different parts [B] and [C]: separate the two parts by removing screws [D] (2x).

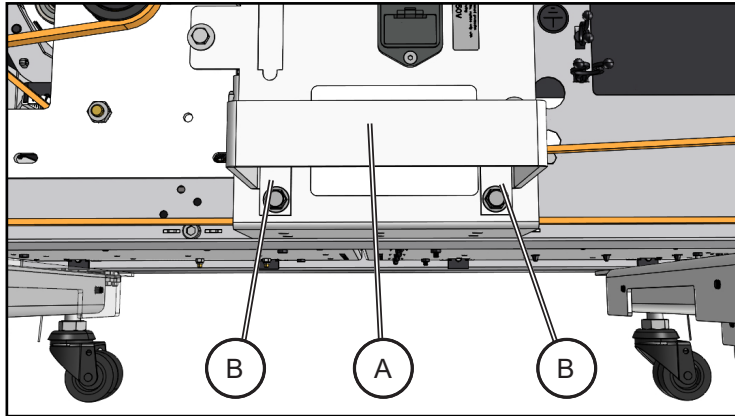


3. Install inner part [B] on the Out-Feed side of the RCT using screws in holes [E].
4. Install outer part [C] on inner part [B], using the uppermost holes [F] but do not tighten screws fully. Note that the selection of holes might need to change depending on floor characteristics.



5. Align edges of part [B] to edges of part [C].

2.4.7 Cable protector and Waste Box

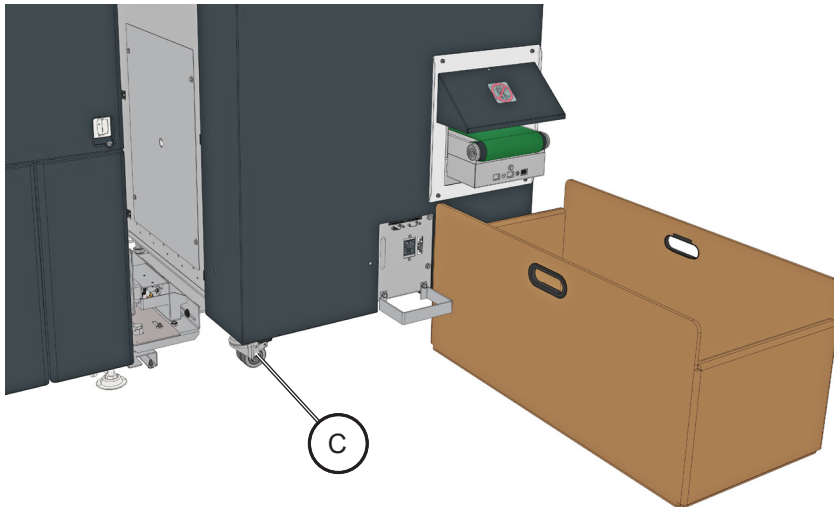


1. Position the Cable Protector [A]. Secure with screws [B] (2x).



NOTE!

If Trim Waste Conveyor will be installed, don't attach cable protector.



2. Assemble the Waste box and place it under the waste transporter and against the Cable Protector.
3. Lock rear casters with brake [C] (2x) on the RCT.
4. Reinstall Covers on RCT.

This is the end of the Rotate Crease Trim Module installation procedure. The RCT is automatically detected and enabled upon power on. Installing connectors and cables and checking of installation will be done later on.

Continue with next section below.

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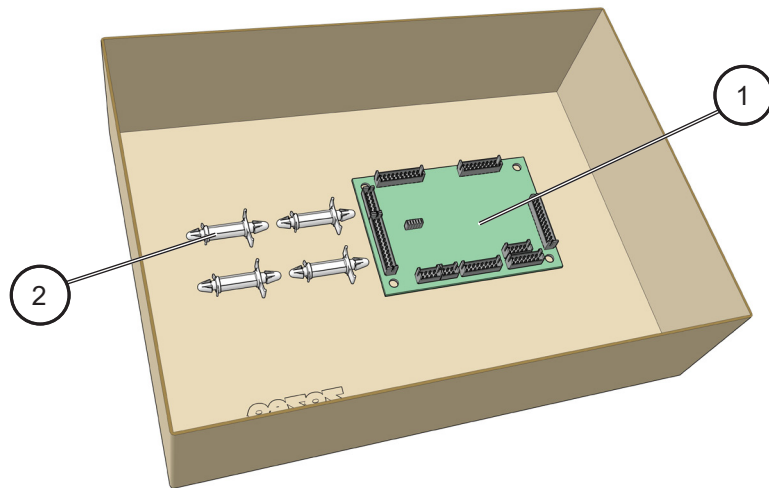
2.5 Optional 50 sheet performance upgrade kit

This section describes how to install a optional 50 sheet performance upgrade kit to the Booklet Maker.

NOTE!

If you do not have the optional 50 sheet performance upgrade kit, please skip this section and proceed with the next one.

2.5.1 Accessory Check



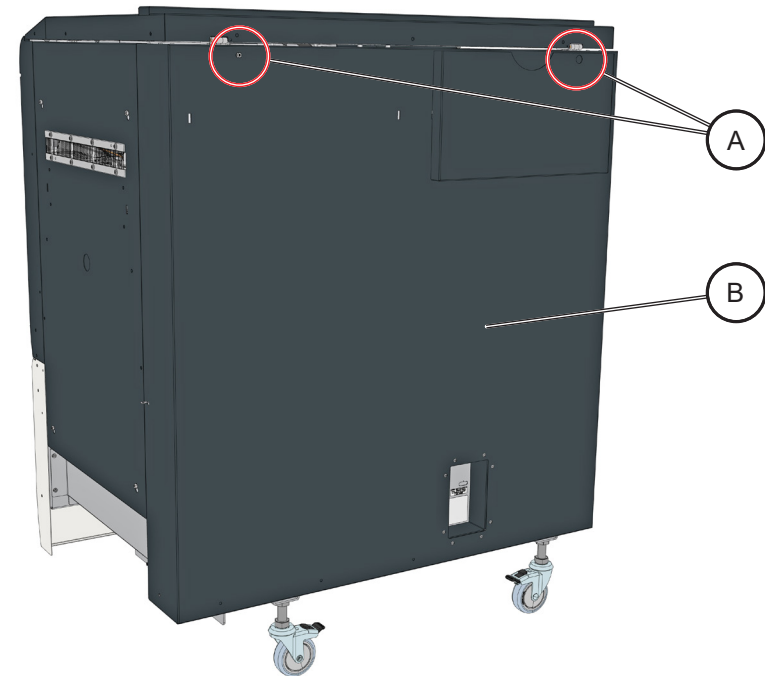
Check the quantity and condition of the accessories in the box against the following list:

Description	Q'ty
1. Optional 50 sheet performance upgrade kit (PCB CC)	1
2. PCB Spacer, snap-in	4

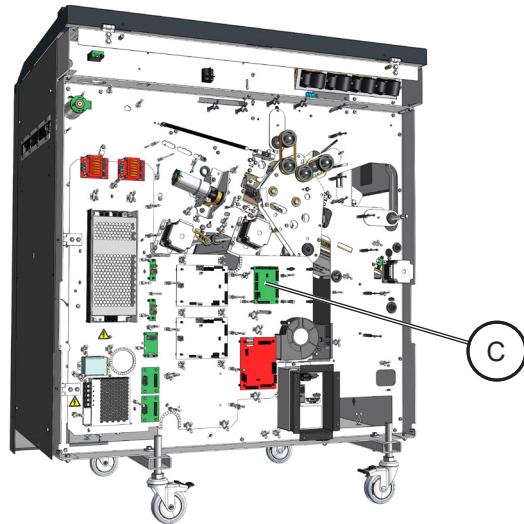
2.5.2 Installation procedure

CAUTION:

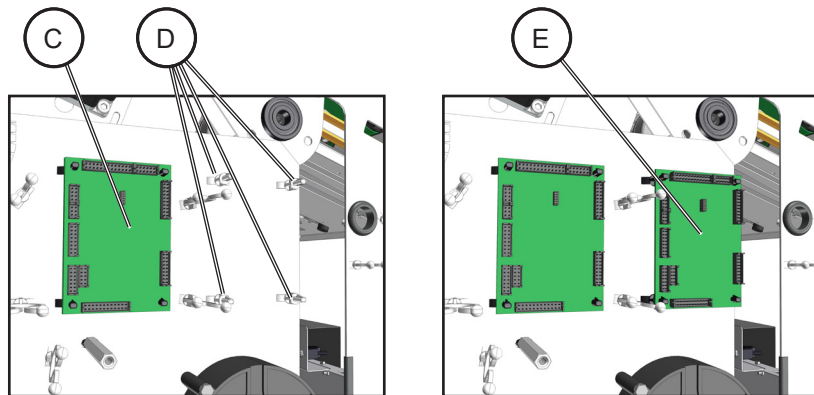
ESD Hazard! ESD (Electrostatic Discharge) can cause hardware crashes, data and/or communications problems. Failure to use proper ESD procedures will cause damage to the electronics of the machine (PCBs for example). ESD problems can be minimized by maintaining all machine ground connections, ensuring the proper handling of circuit boards / sensors. Use a ground strap or other ESD protection when working near PCBs. Failure to use ESD protection is likely to result in a PCB failure.



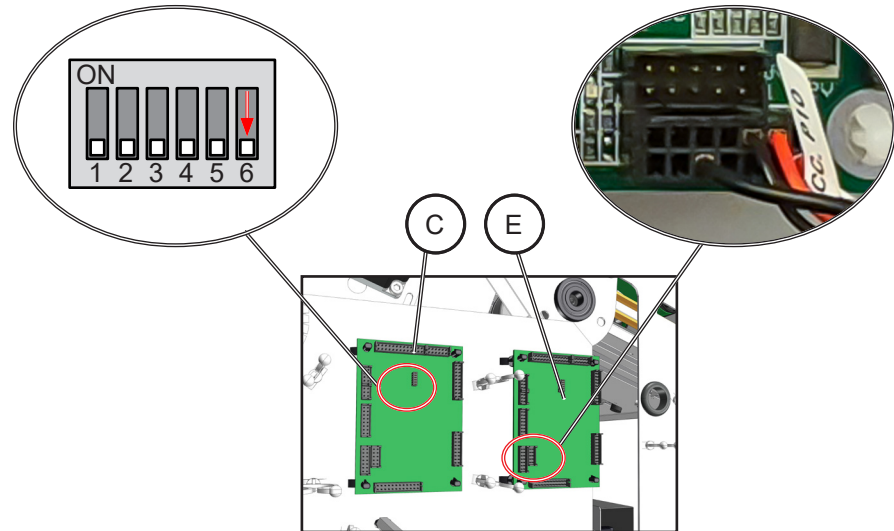
1. Remove screws [A] (x2) and remove the Rear Cover [B] from the Booklet Maker.



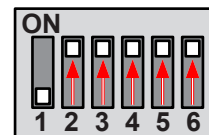
2. Locate PCB A [C] on the Booklet Maker: the optional 50 sheet performance upgrade kit PCB will be installed to the right of PCB A.



3. If not already present, install the PCB Spacers [D] (x4) to the Booklet Maker.
4. Install the optional 50 sheet performance upgrade kit PCB [E] on the PCB Spacers [D].



5. Connect plug CC,P10 in the Booklet Maker (originating from PCB A, plug A,P6) to lower leftmost jack on the optional 50 sheet performance upgrade kit PCB [E] just installed.
6. On PCB A [C], move the number 6 DIP switch from ON to OFF position. The ON position is for 35 sheet configuration.



7. Check that DIP switches on PCB CC are set correctly.
8. Do not reinstall the Rear Cover on the Booklet Maker yet.

This is the end of the optional 50 sheet performance upgrade kit installation procedure.
The optional 50 sheet performance upgrade kit is automatically detected and enabled upon power on.

Continue with next section below.

2.6 Booklet Maker

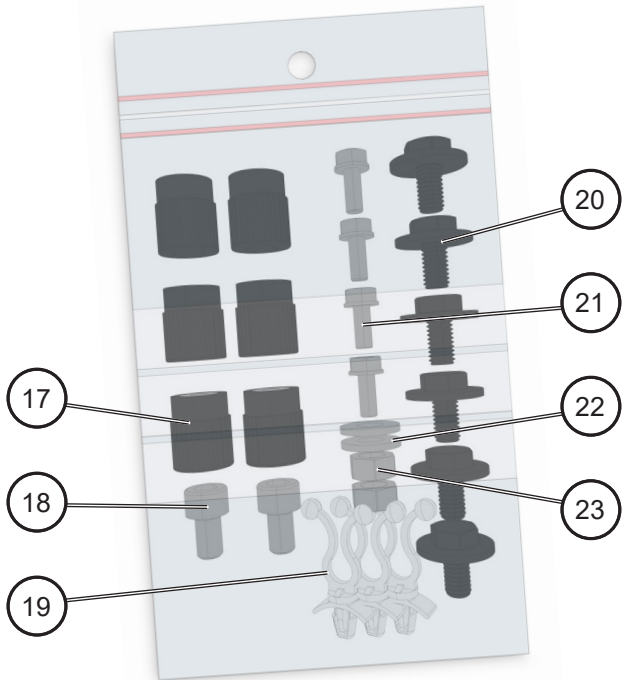
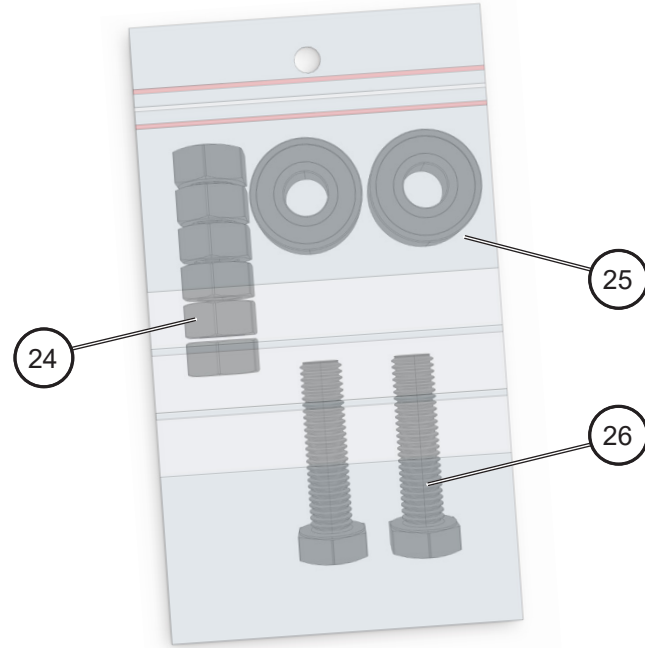
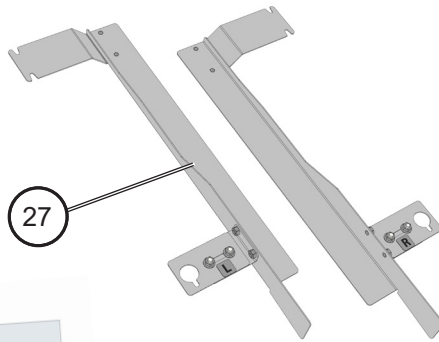
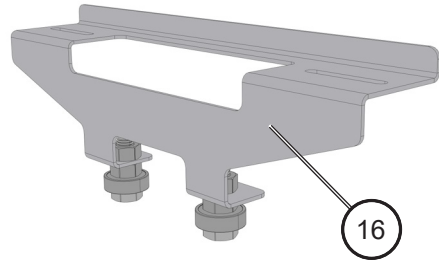
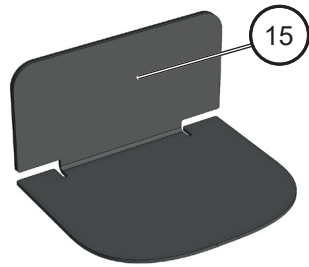
This section describes how to install a Booklet Maker.

2.6.1 Accessory Check



Check the quantity and condition of the accessories in the box against the following list:

Description	Q'ty	Description	Q'ty
1. Power cord EUR/IEC 1.0 mm ² 80 mm	1	8. Termination plug	1
2. Power cord USA/IEC AWG-14 80 mm	1	9. 24 mm open wrench	1
3. Power cord UK/IEC 1.0 mm ² 80 mm	1	10. Docking Bracket Upstream device	1
4. Power cord AUS/IEC 1.0 mm ² 80 mm	1	11. Operator manual's tray	1
5. Power cord Swiss/IEC 1.0 mm ² 80 mm	1	12. Inner Docking Bracket BM	1
6. Power cord Denmark IEC 1.0 mm ² 80 mm	1	13. Outer Docking Bracket BM	1
7. Extension cord 4,2 m	1	14. Machine Decals Pro450e ^U / Pro435e ^U	2

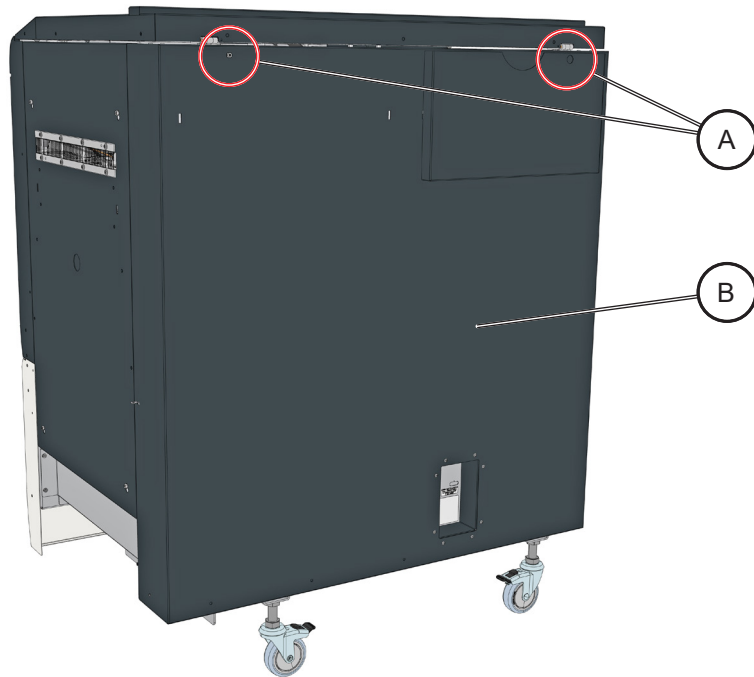


Description Q'ty

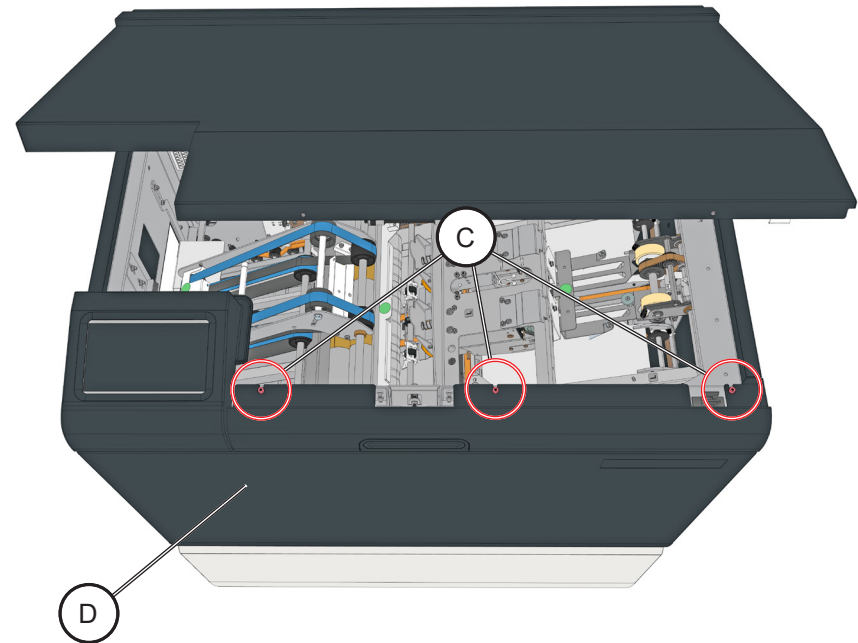
15. Stop bracket, stacker*	1
16. Guide bracket	1
17. Knob	6
18. Screw M6x10	2
19. Cable fastener	3
20. Screw M6x12	6
21. Screw M4x10	4
22. Washer	2
23. Nut M6	2
24. Nut M10	6
25. Bearing	2
26. Screw M10x40	2
27. Small paper kit	1

*Hand over the Stop Bracket to operator and refer to the operator manual for how to use it.

2.6.2 Covers removal



1. Remove screws [A] (2x) and remove the Rear Cover [B] from the Booklet Maker.

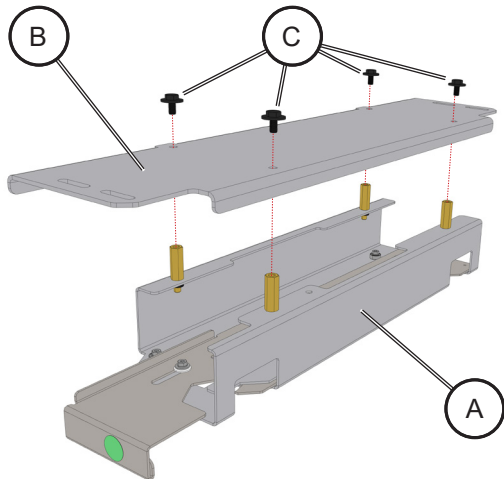
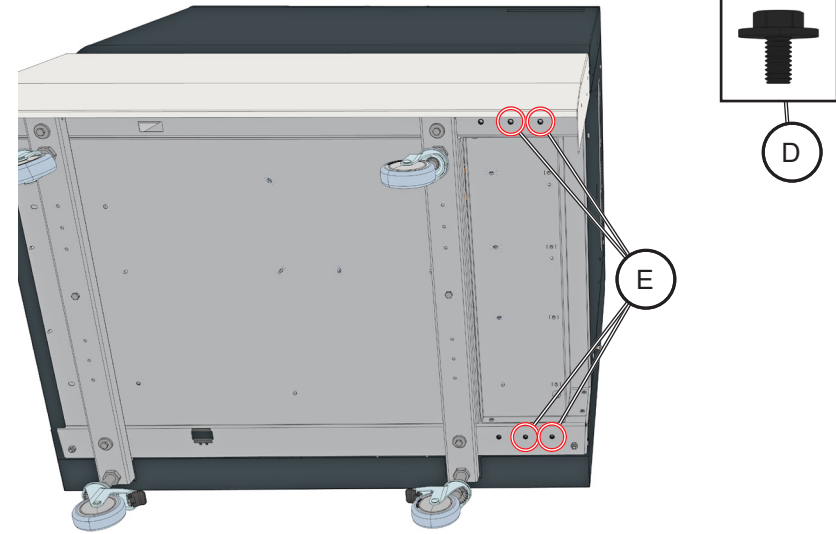
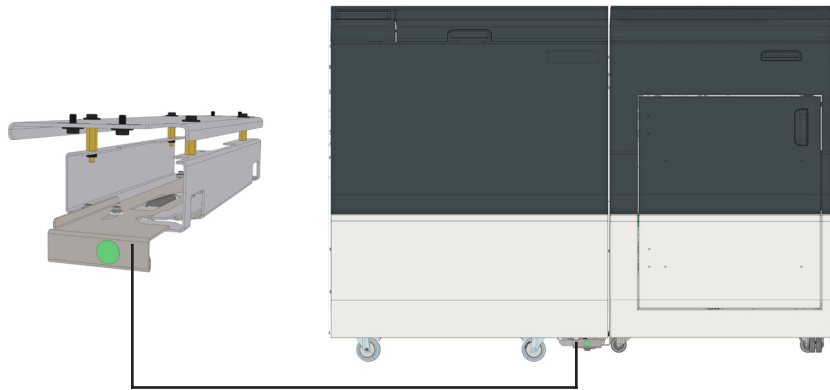


2. Loosen screws [C] (3x) to remove Front Cover [D].

2.6.3 Installation BM to RCT and Guide Brackets

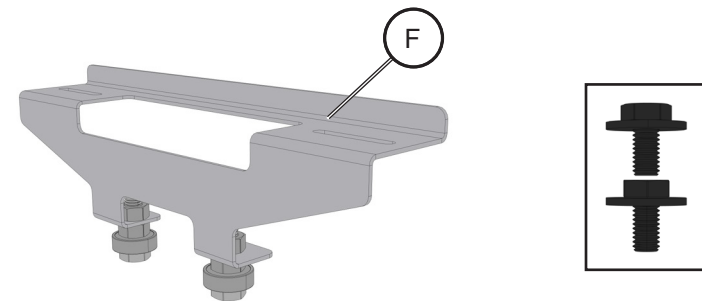
NOTE!

If you did not install an RCT, see next section instead.

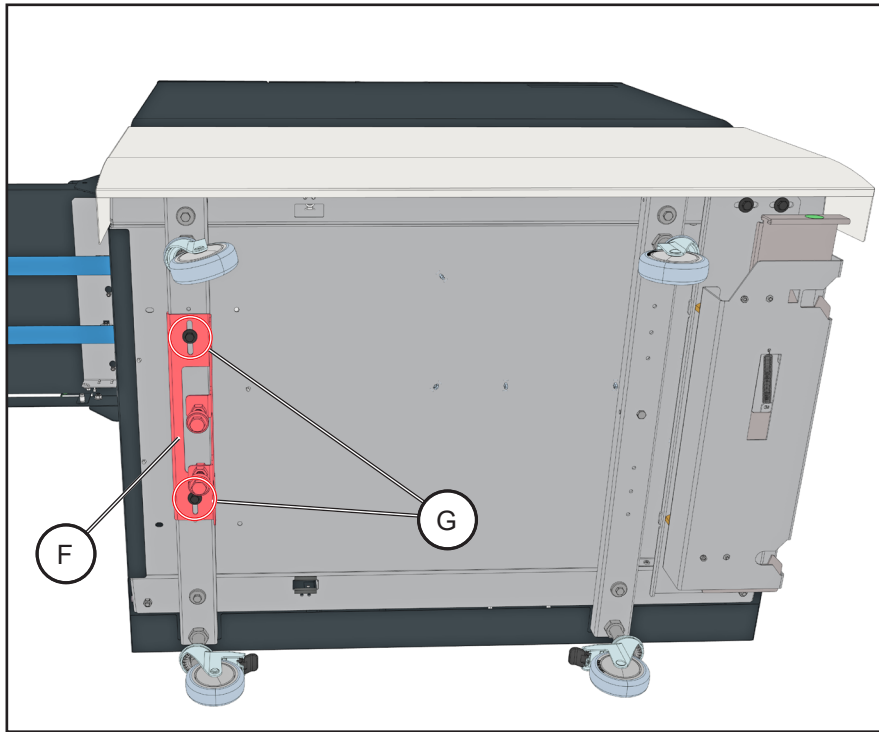


1. Retrieve Docking Bracket [A] and Docking Plate [B] from the accessory box shipped with the RCT module. Put them together and fasten with screws [C] (4x) as shown above.

2. Install Docking Bracket assembly on the in-feed side of the Booklet Maker using screws [D] (4x) and threaded holes [E] (4x).



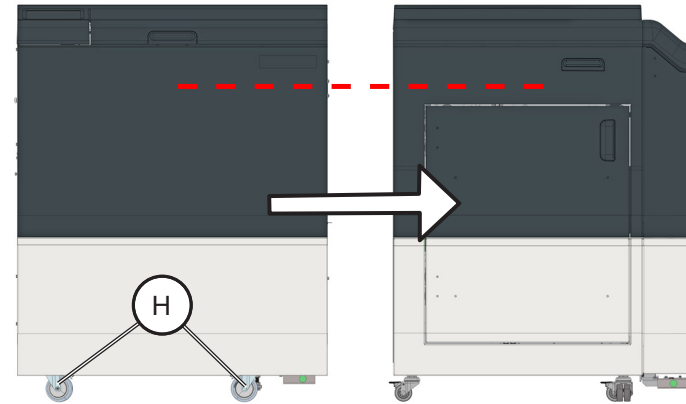
3. Retrieve Guide Bracket [F] and screws [G] (2x) from the accessory box shipped with the Booklet Maker.



4. Install Guide Bracket [F] on Caster supports with screws [G] (2x).

NOTE!

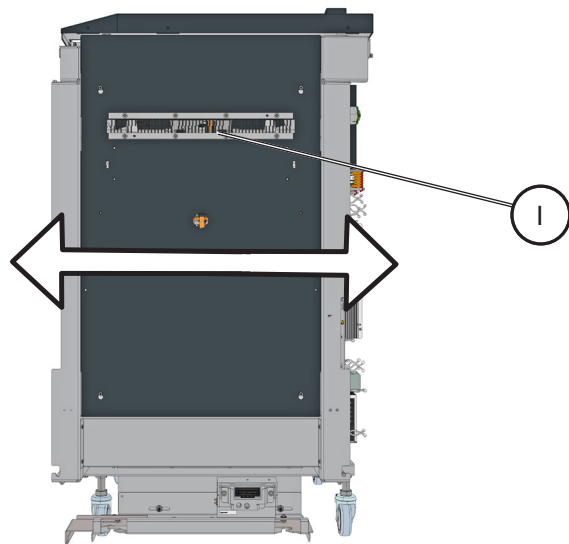
If Booklet Maker is used together with Finishing Module, then don't install Guide bracket on Booklet Maker. It must be installed on the Finishing Module.



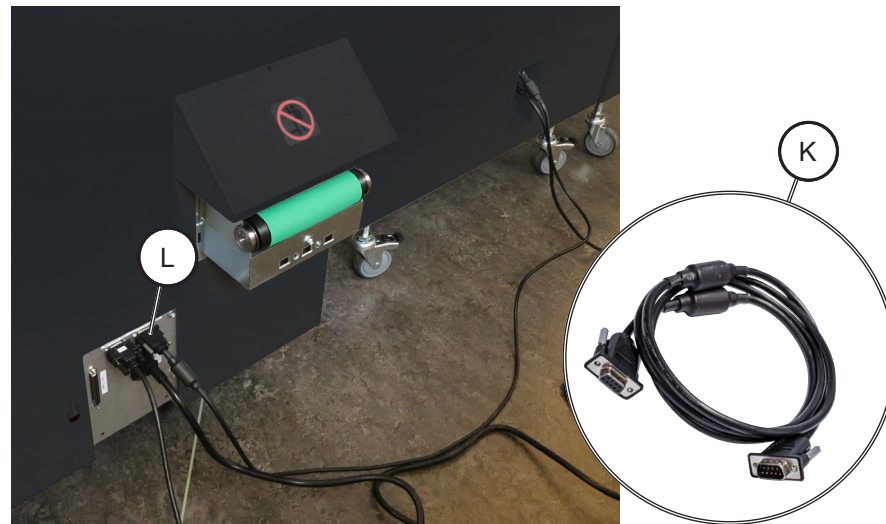
5. Push the Booklet Maker Towards the RCT to make sure that the paper paths on both modules are aligned height-wise. If the paper paths are not aligned, adjust casters [H] (4x) on the Booklet Maker module. Do not turn each wheel more than two full revolutions before adjusting the other wheels, otherwise the module might become unstable and tilt over.
6. Once adjustment is correct, use a spirit level to make sure the BM sits levelled. If BM does not sit levelled, continue adjusting casters until BM is level. Once level secure the casters [H] (4x) with the Counter Nut.



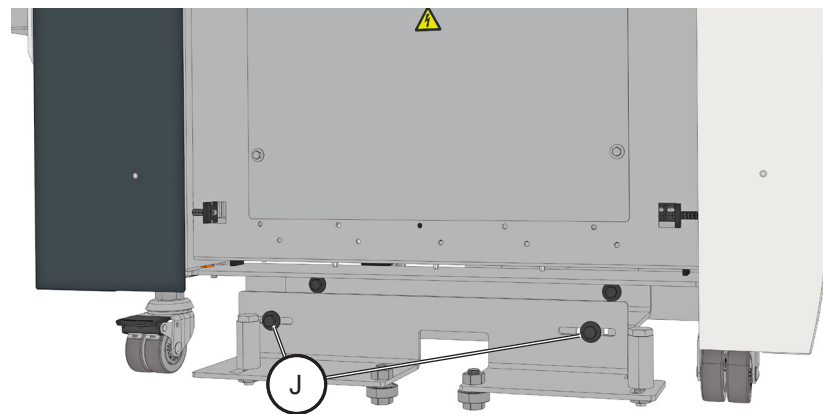
7. Dock the two modules to make sure that side-to-side alignment is correct. Side-to-side adjustment is correct when the paper path [I] on the BM aligns with paper path on the RCT and/or the front covers are aligned (if the covers are removed, use the machine frames as the reference).



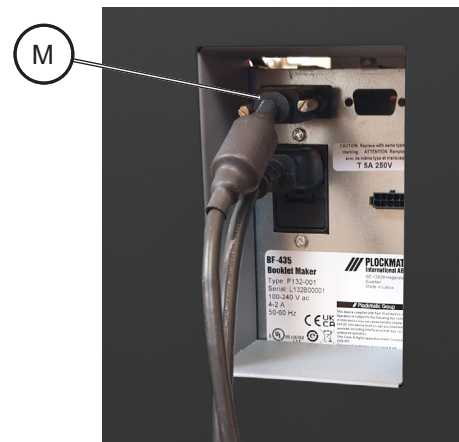
8. If adjustment is not correct, with the BM docked, move the BM in the direction shown by the arrows until the correct adjustment is achieved.



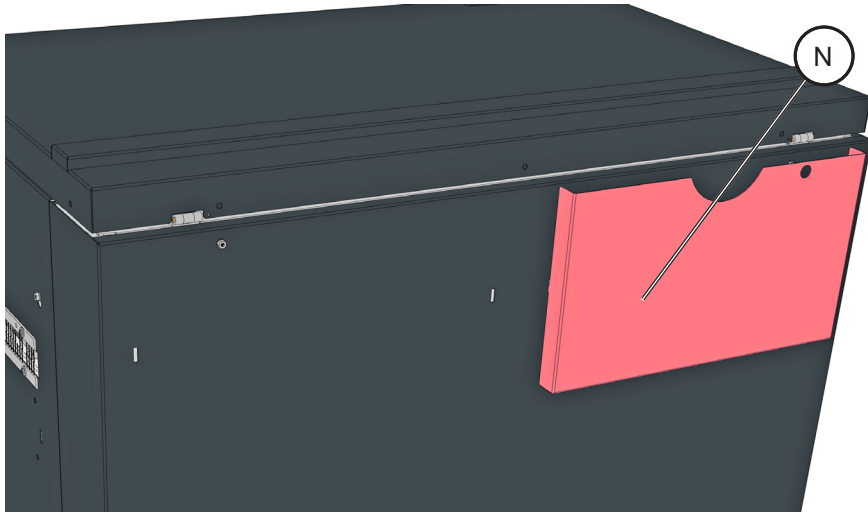
10. Obtain communication cable [K] from RCT accessory box and connect it to the rear of the RCT to the sub named “com. booklet maker” [L].



9. Once the correct alignment is achieved, undock the modules and tighten screws [J] (2x) on the downstream docking bracket mounted on the RCT.



11. Connect the other side of the cable to the BM [M]. **Do not connect power cables yet.**

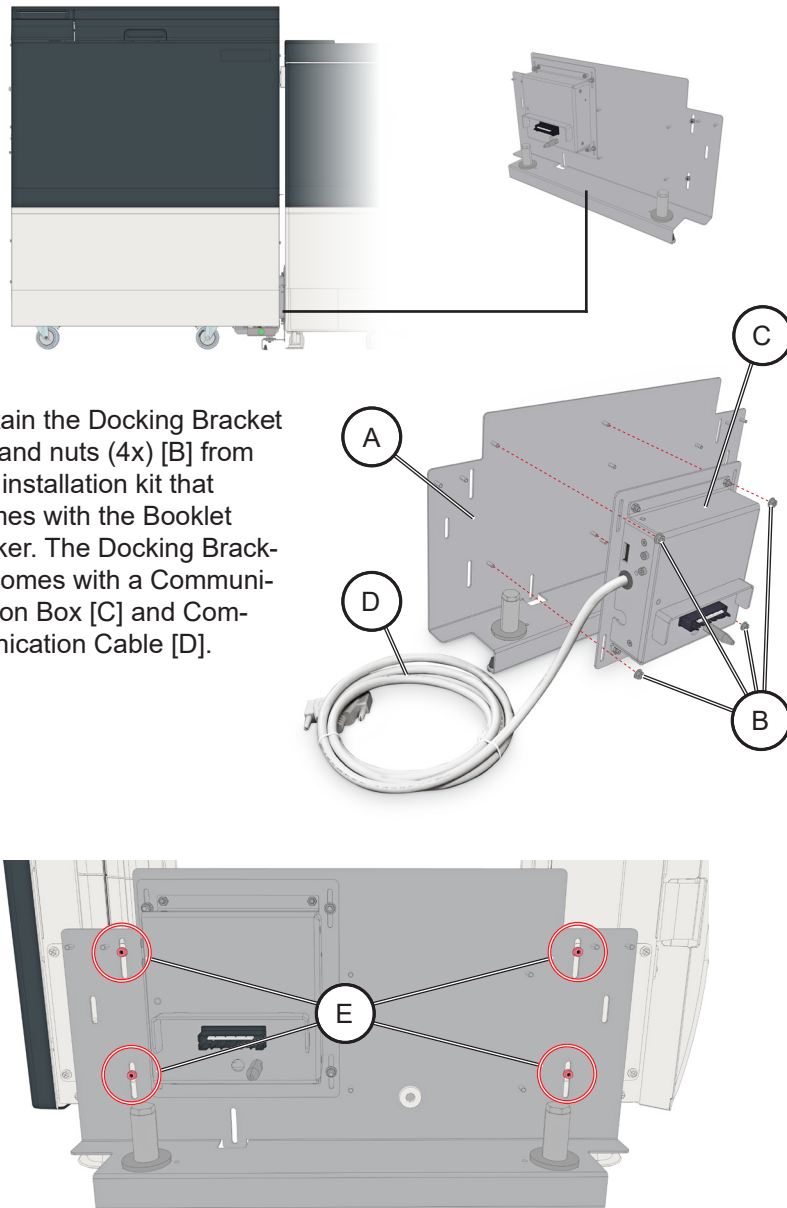


12. Reinstall Rear Cover, then install the Operator's manual tray [N] on the rear of the BM. The tray has two hooks that mate two holes in the rear cover of the module.
 13. Lock casters with brakes on the BM.
- This is the end of the Booklet Maker installation procedure. Do not reinstall front cover yet.
Continue with section 1.7.

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2.6.4 Upstream Device Docking Bracket and Rail Unit

1. Obtain the Docking Bracket [A] and nuts (4x) [B] from the installation kit that comes with the Booklet Maker. The Docking Bracket comes with a Communication Box [C] and Communication Cable [D].

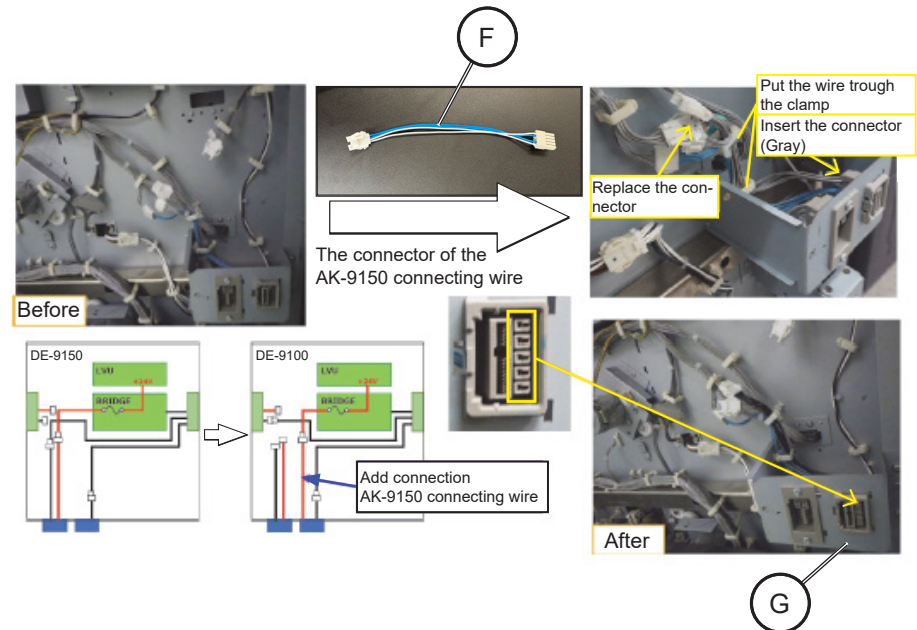


2. Install the Docking Assembly to the Upstream Device using the four screws [E] that came together with the Docking Assembly.

NOTE!

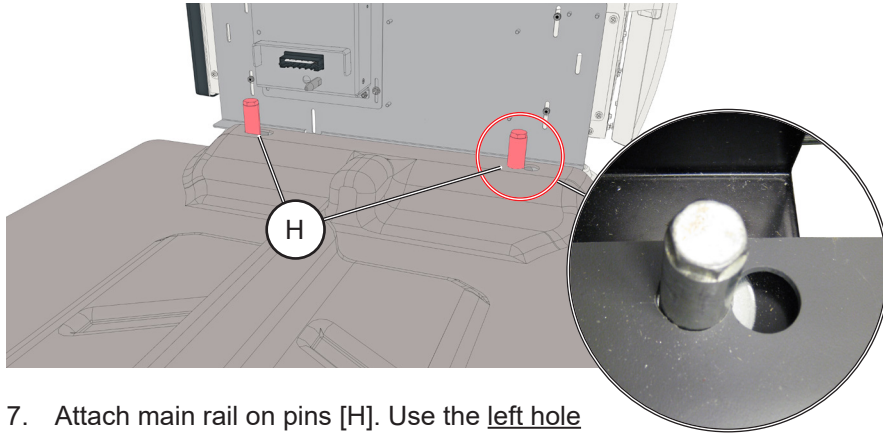
The next 4 steps are just for reference. The correct procedure is described in the printer's Installation manual.

3. Turn off the printer and its components and disconnect the power cord.
4. Obtain the Replacement connector [F].
5. Replace the existing connector. Route the replacement connector through cable clamp and fasten the connector into connector bracket [G].
6. Connect the AK-9150 connection wire to DE-9100.

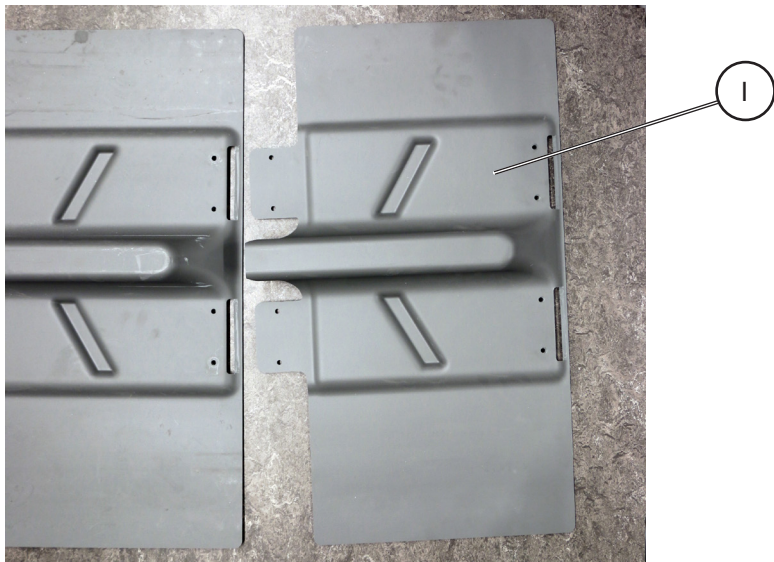


 **NOTE!**

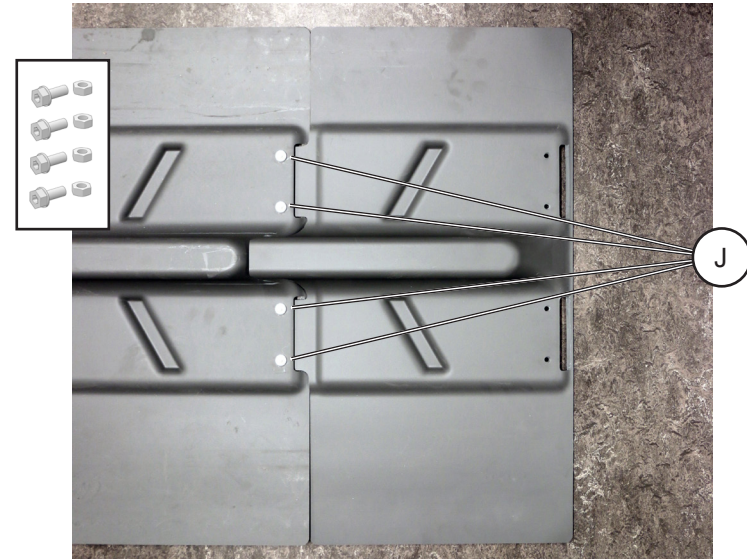
If optional Railing Unit is installed, follow the next 4 steps. If not, then skip to next section.



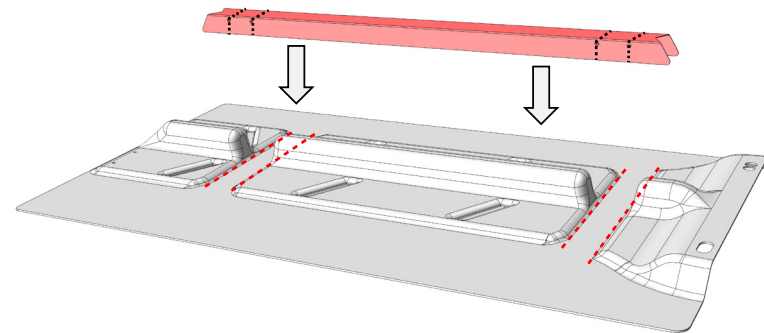
7. Attach main rail on pins [H]. Use the left hole on the main rail unit.



8. Insert rail extension/s [I].



9. Secure by installing the screws and nuts [J] (4x).

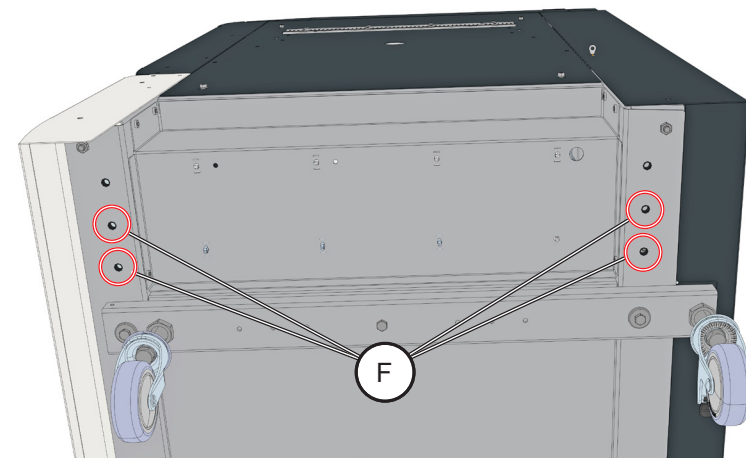
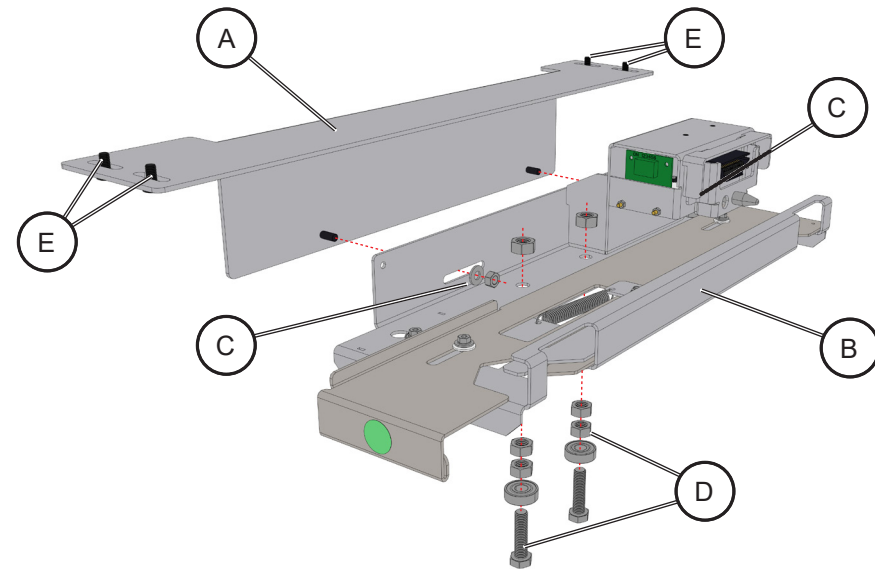
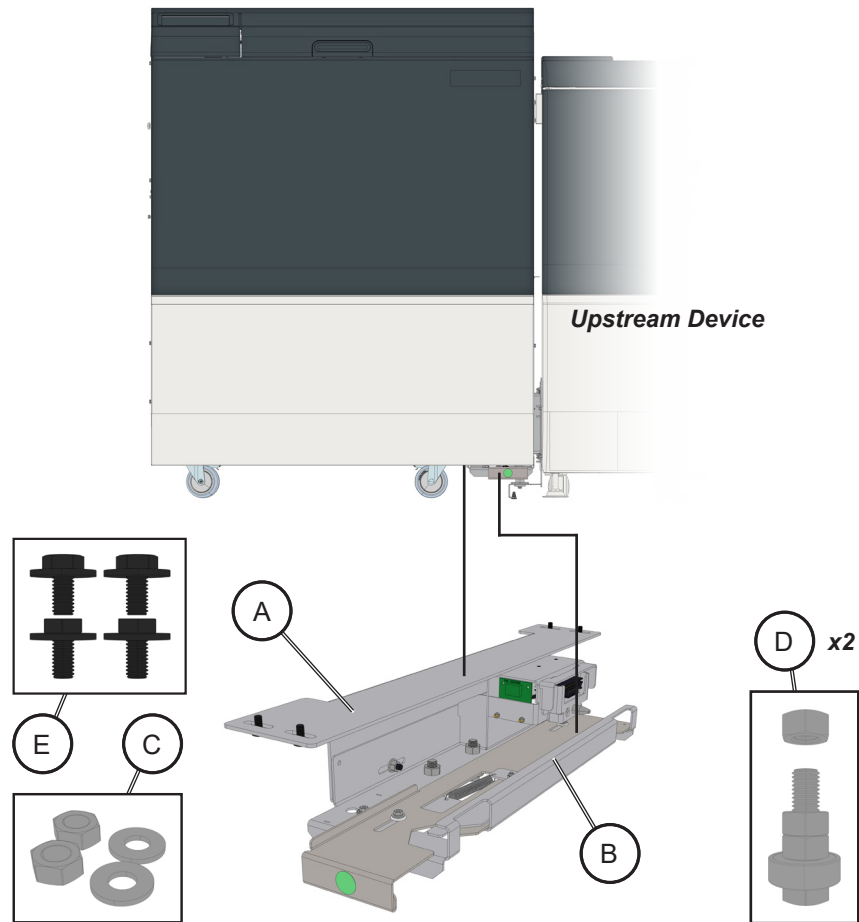


10. Install the rail add-on to the main part of the rail.

2.6.5 BM Docking Bracket and Guide Bracket

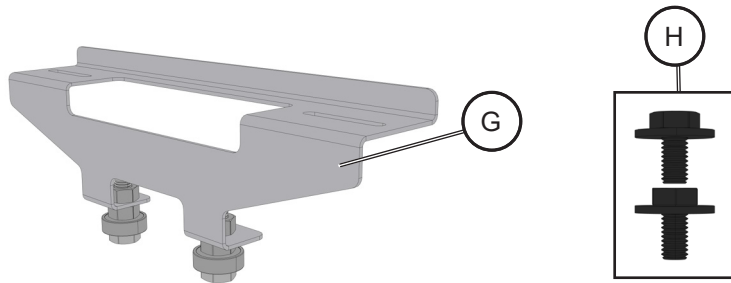


NOTE!
Perform this procedure only if you did not install an RCT.

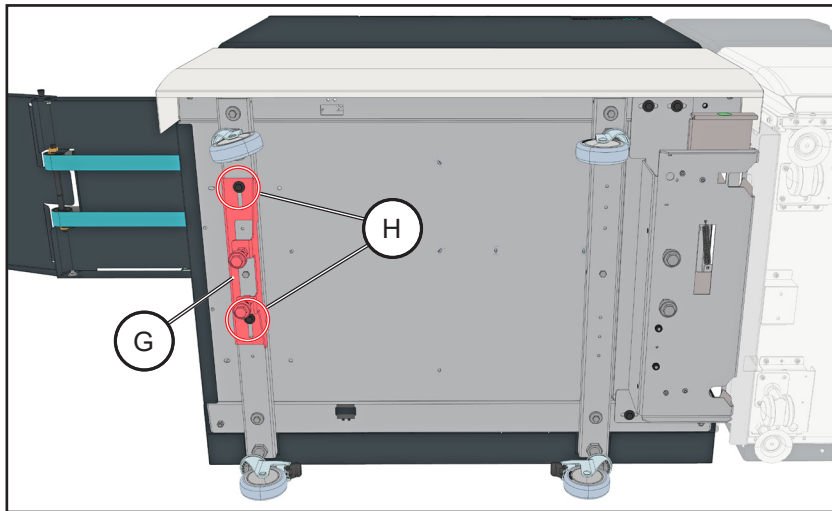


1. Retrieve Inner Docking Bracket [A] and Outer Docking Bracket [B] from Booklet Maker's accessory box.
2. Install Outer Docking Bracket [B] to Inner Docking Bracket [A] using washers and nuts [C] (2x), but do not tighten nuts [C] fully yet.
3. Retrieve Screws, Nuts and Bearings [D] from Booklet Maker's accessory box. Install Bearings [D] to the Outer Docking Bracket [B].

4. Retrieve Screws [E] (4x): these will be used to install Inner Docking Bracket [A] to the Booklet Maker.
5. Locate threaded holes [F] (4x) on the bottom part of the Booklet Maker, then install Inner Docking Bracket [A]. Do not tighten screws [E] fully yet.

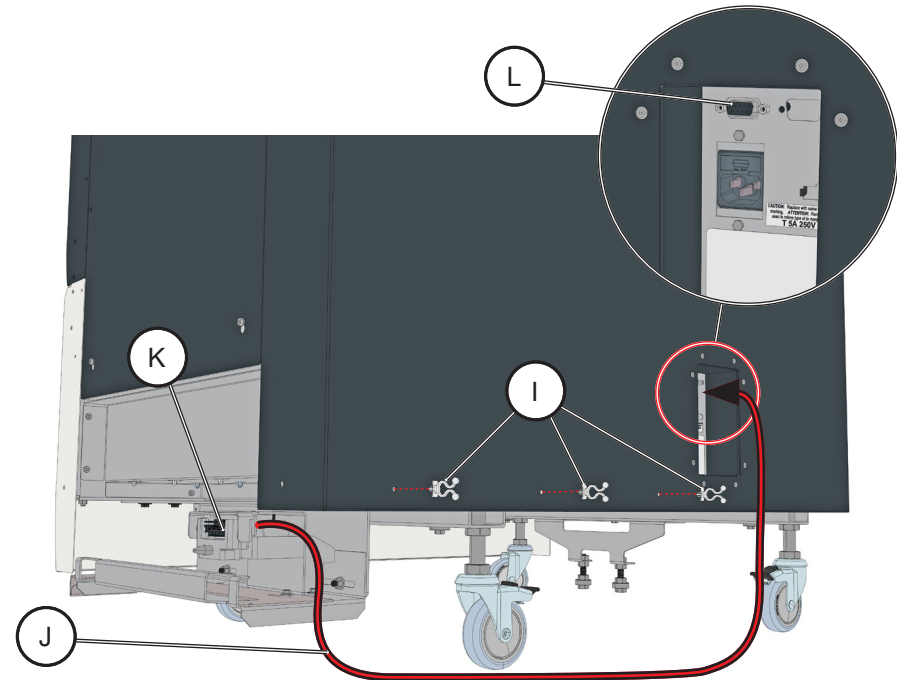


6. Retrieve Guide Bracket [G] and screws [H] (2x) from the accessory box shipped with the Booklet Maker.

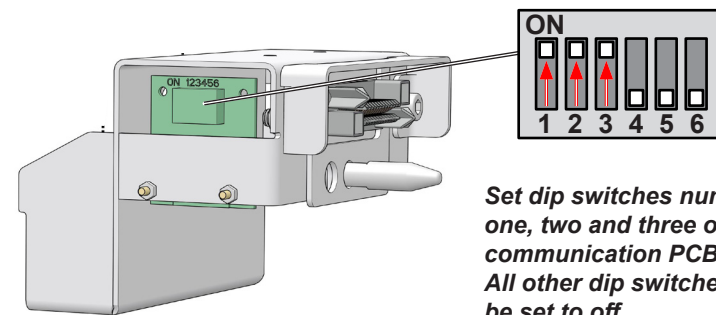


7. Install Guide Bracket [G] on Caster support with screws [H] (2x).

NOTE!
 If Booklet Maker is used together with Finishing Module, then don't install Guide bracket on Booklet Maker. It must be installed on the Finishing Module.



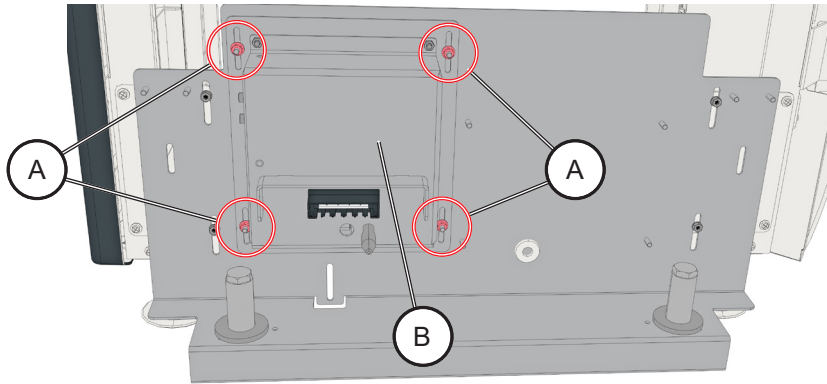
8. Retrieve Cable Fasteners [I] (3x) from accessory box and install on Booklet Makers Rear Cover.
 9. Take the Can Cable [J] coming out of Communication box [K] and plug it in upper left D-Sub connection [L] on rear of Booklet Maker. Fasten the Can Cable in Cable Fasteners.



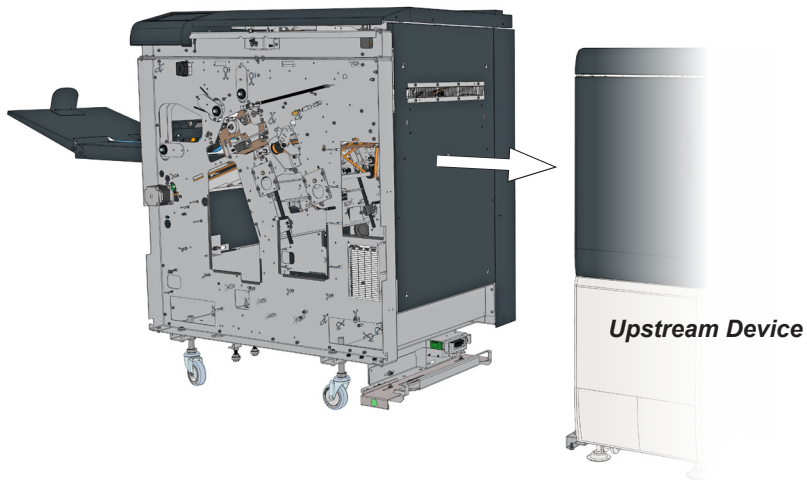
Set dip switches number one, two and three on the communication PCB to on. All other dip switches should be set to off.

10. Check that DIP switches on the Communication box are set correctly.

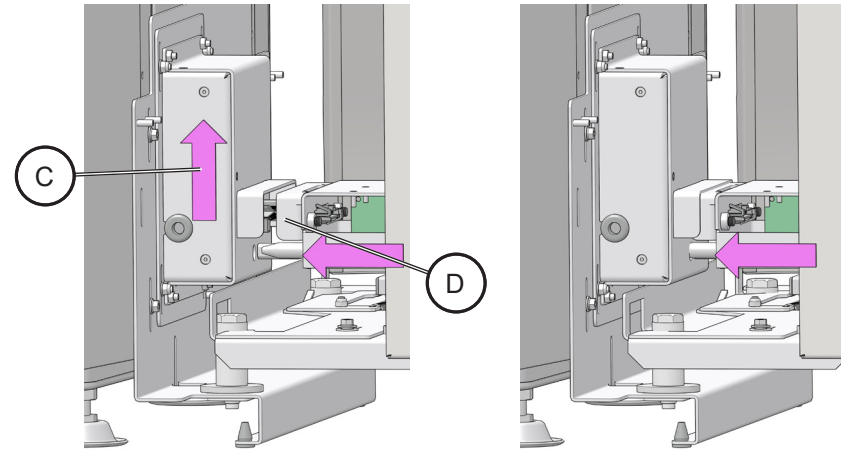
2.6.6 Docking BM to Upstream Device



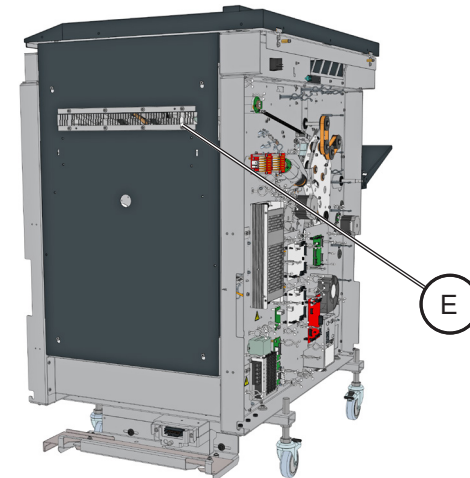
1. Loosen the four nuts [A] securing the Communication box [B] to make height adjustment possible later on in the installation procedure.



2. Bring the BM up close to the Upstream Device. The purpose is to check/adjust the alignment top to bottom and the height adjustment between the BM and the Upstream Device as well as to check/adjust the height of the Communication boxes.

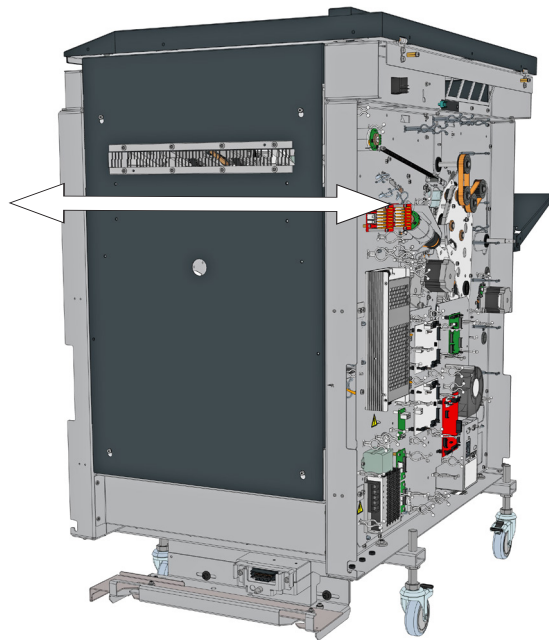
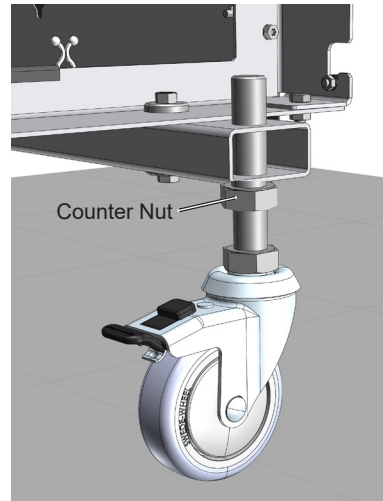


3. Dock the BM to the Upstream Device while lifting the Communication box on the Upstream Device [C] so it can mate with the Communication box on the BM [D].

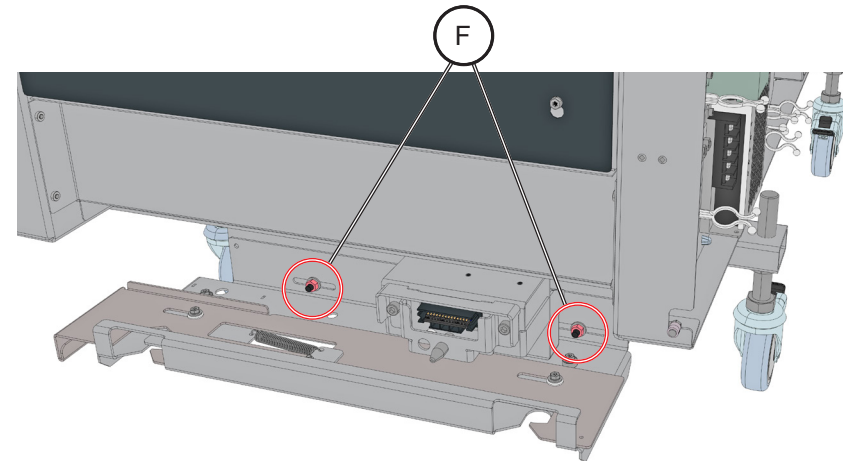
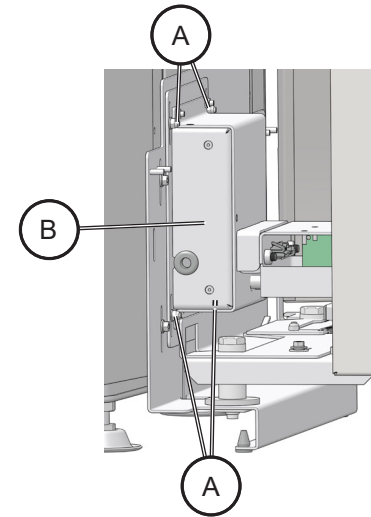


4. Both height and side-to-side adjustments are correct when paper path [E] on the BM matches with paper path on the exit side of the Upstream device.
 - If height adjustment is not correct, go to step 5
 - If side-to-side adjustment is not correct go to step 6
 - If both adjustments are correct, skip to step 7

5. If height adjustment is not correct, adjust casters using the 24 mm open wrench supplied with the Booklet Maker. Do not turn each wheel more than two full revolutions before adjusting the other wheels, otherwise the module might become unstable and tilt over. Once adjustment is correct, use a spirit level to make sure the BM sits levelled. If BM does not sit levelled, continue adjusting casters until BM is levelled. Once level secure the casters with the Counter Nut.

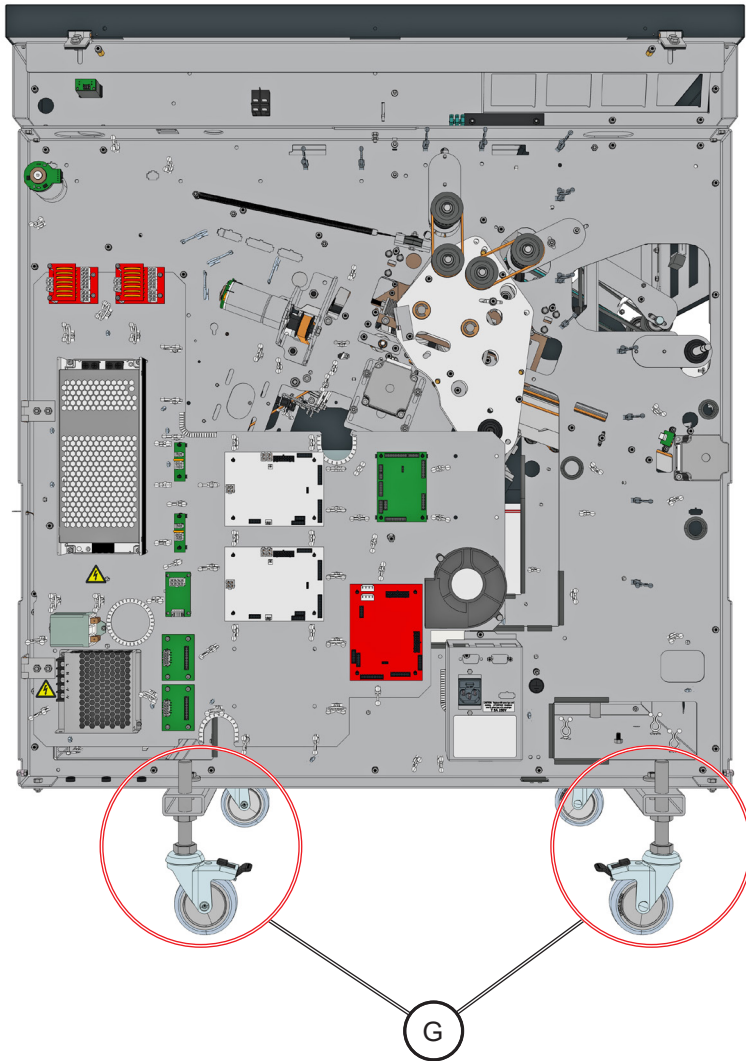


6. If side-to-side adjustment is not correct, move the BM, while keeping it docked, in the direction shown by the arrows until correct adjustment is achieved.

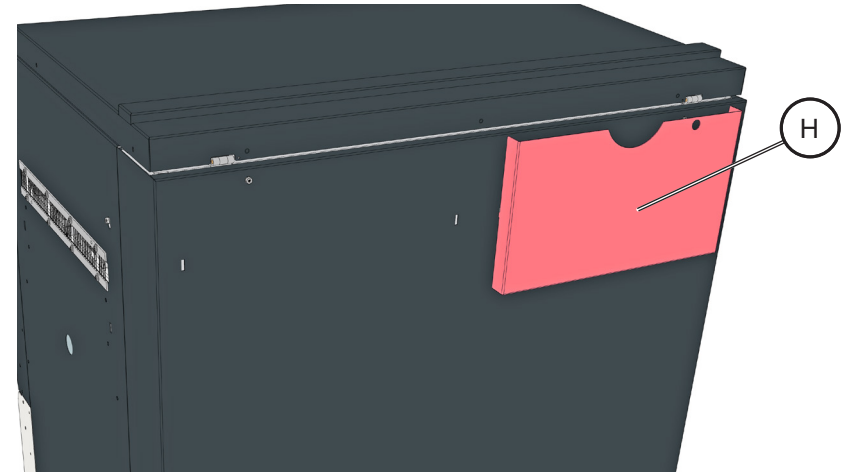


7. Once height and side-to-side adjustments are correct:

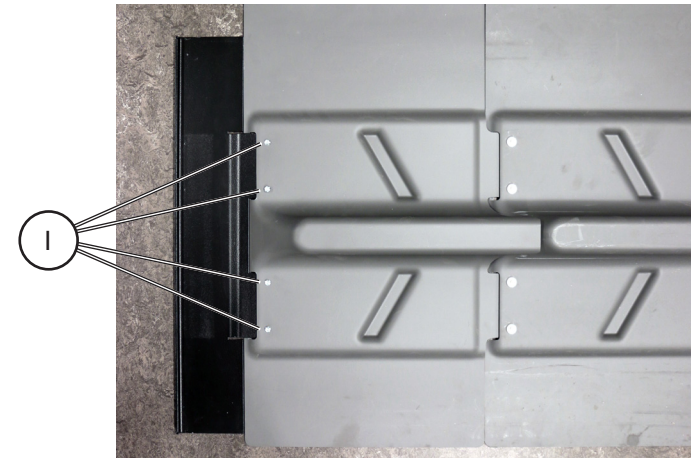
- Tighten the four lock nuts [A] securing the Communication Box [B];
- Tighten the two screws [F] securing the Outer Docking Bracket on the BM.



8. Lock casters with brake [G] (2x) on the Booklet Maker's rear side.



9. Reinstall Rear Cover, then install the Operator's manual tray [H] on the rear of the BM. The tray has two hooks that mate two holes in the rear cover of the module.
10. Complete steps 17 to 21 from '1.6.3 Docking Procedure, BM to RCT'.



11. If the optional Rail unit is installed and all modules are rolled on to it, insert rail stop and secure with screws [I] (4x). If you are also using the Finishing Module, then skip this step.


This is the end of the mechanical installation procedure of the Booklet Maker. Do not reinstall front cover yet. Continue with next section below.

2.7 Finishing Module

This section describes how to install the Finishing Module.

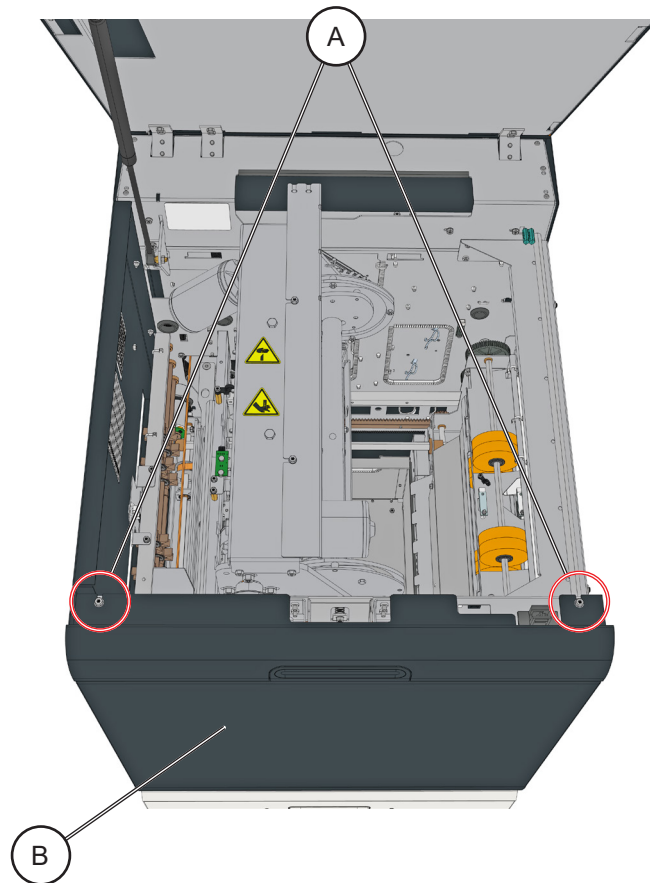
 **NOTE!**

If you do not have the optional Finishing Module, please skip this section and proceed with the next one.

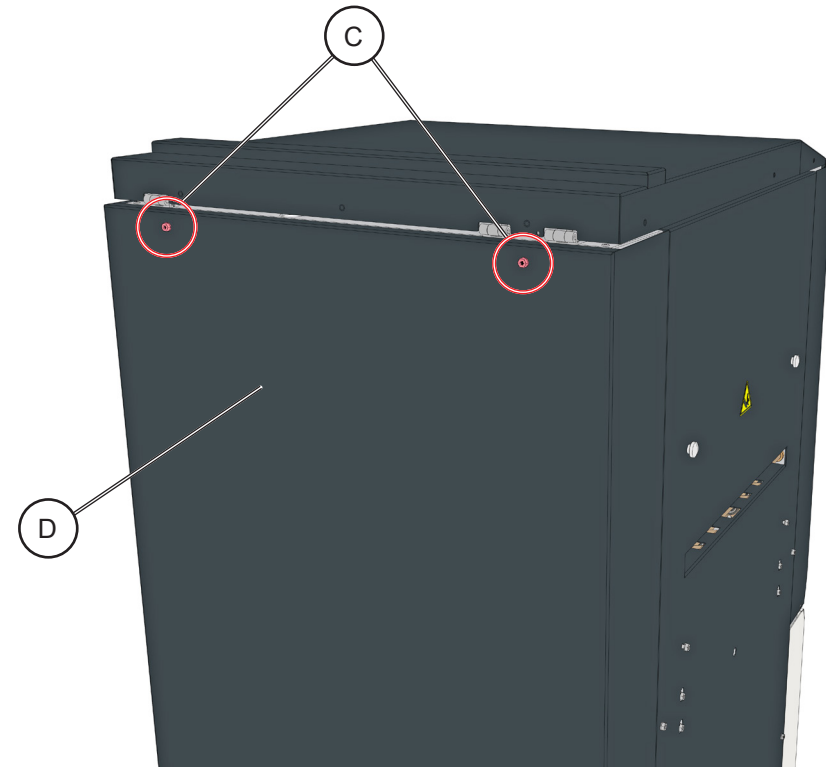
 **NOTE!**

No accessories are shipped with the Finishing Module.

2.7.1 Covers removal



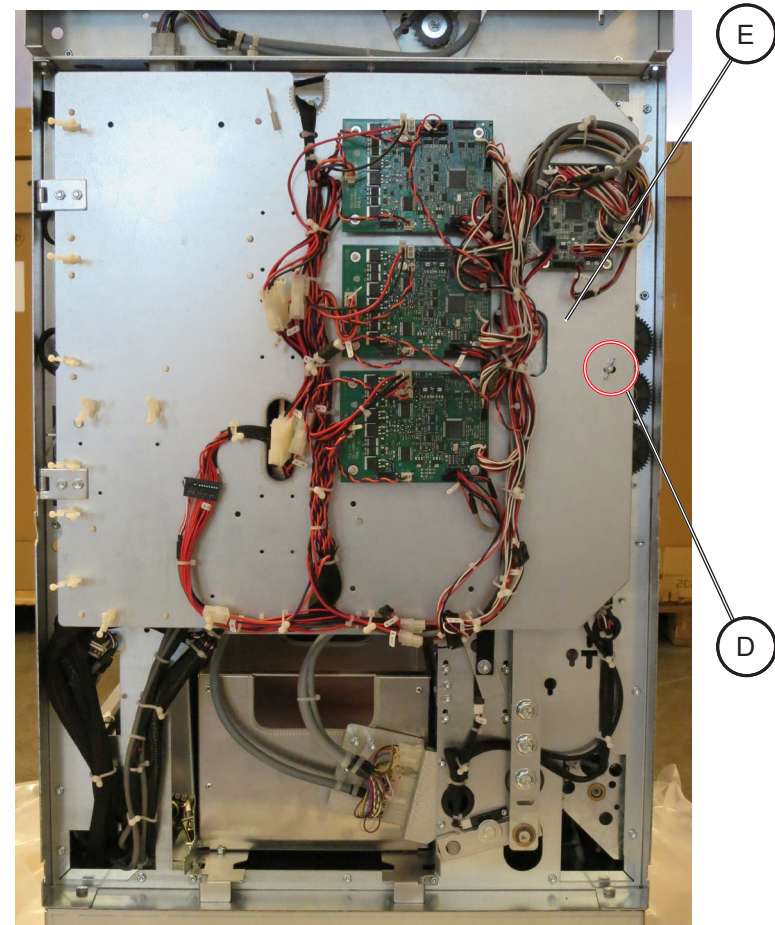
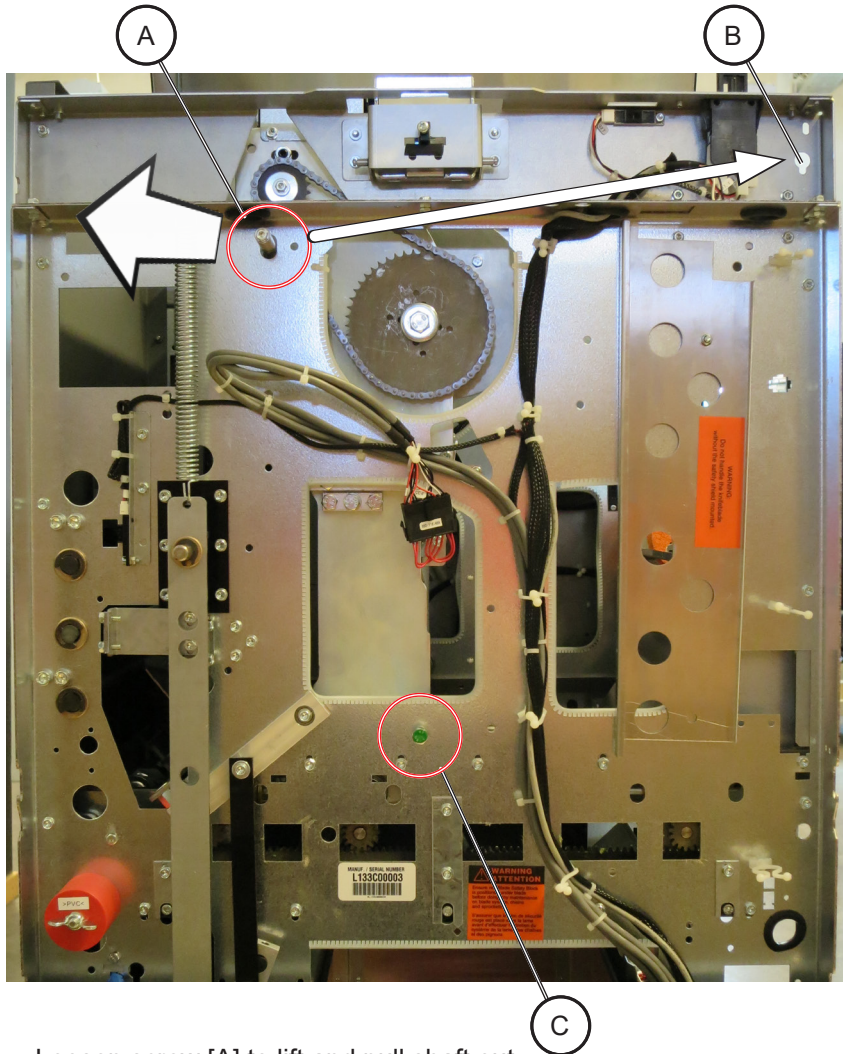
1. Loosen screws [A] (2x) to remove Front Cover [B].



2. If not done during unpack, remove screws [C] (2x) to remove rear cover [D].

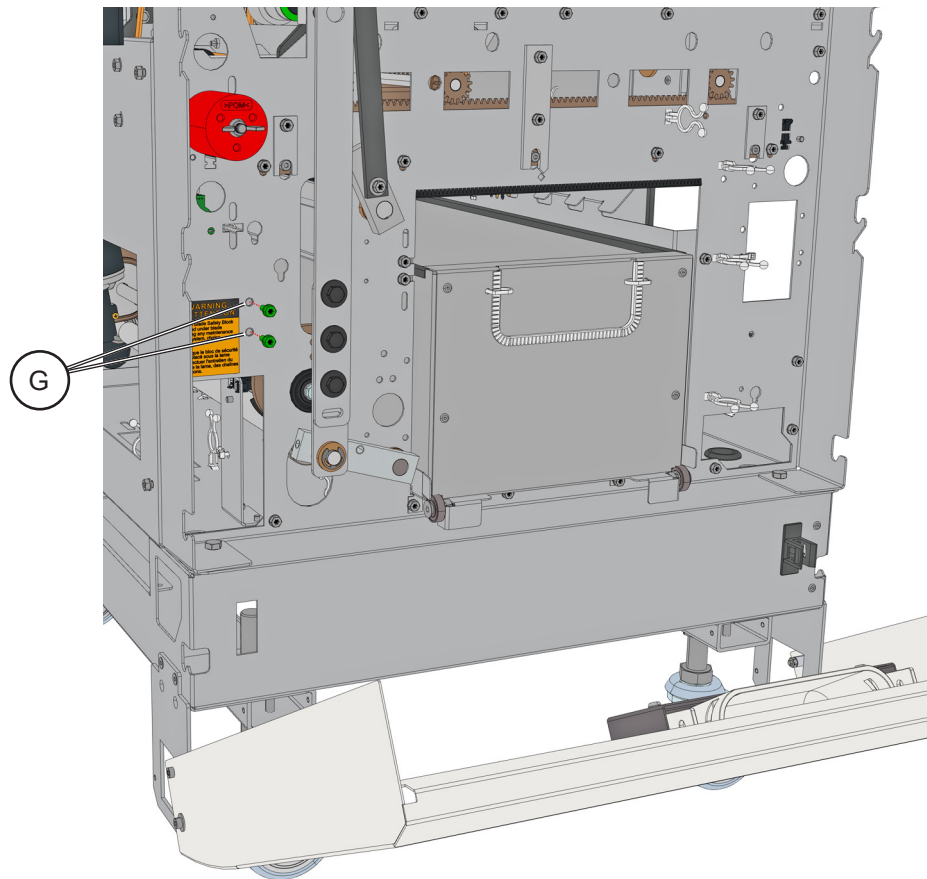
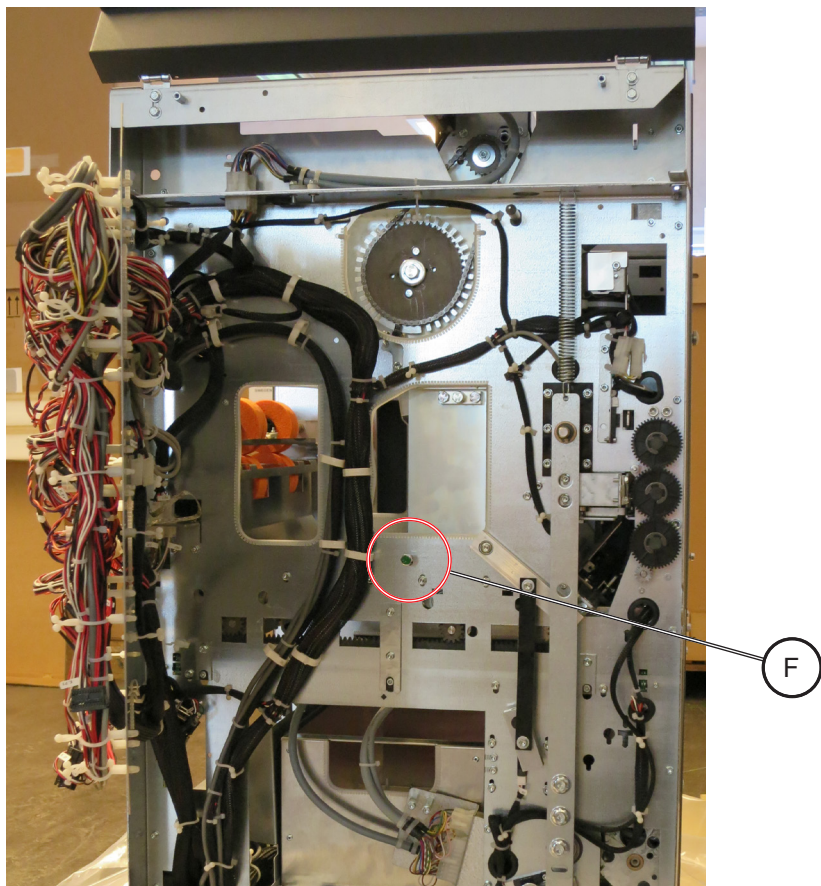
2.7.2 Trimmer security screws and shaft removal

The Finishing Module is shipped with two security screws and a security shaft installed through the Trim Module to prevent it from moving during shipment. These three items need to be removed before starting the machine. **⚠ CAUTION: failure remove screws and shaft will damage the machine, as it will start to initialize as soon as it is turned on. Follow the procedure for how to remove these items in the next pages.**



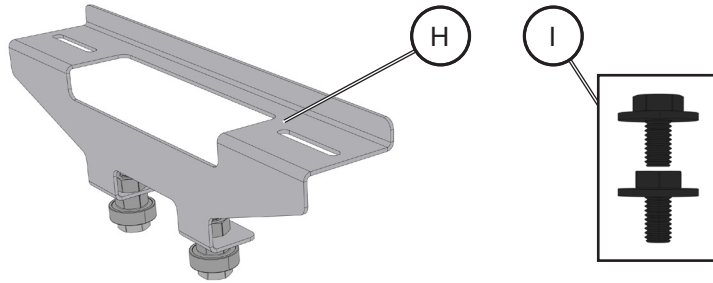
1. Loosen screw [A] to lift and pull shaft out.
2. Install shaft in hole [B] and secure it with screw [A].
3. Remove screw [C] in the front of the machine (do not discard screw [C], it will be needed in the future if the module is shipped again).

4. Remove wingnut [D] to open electrical panel [E].

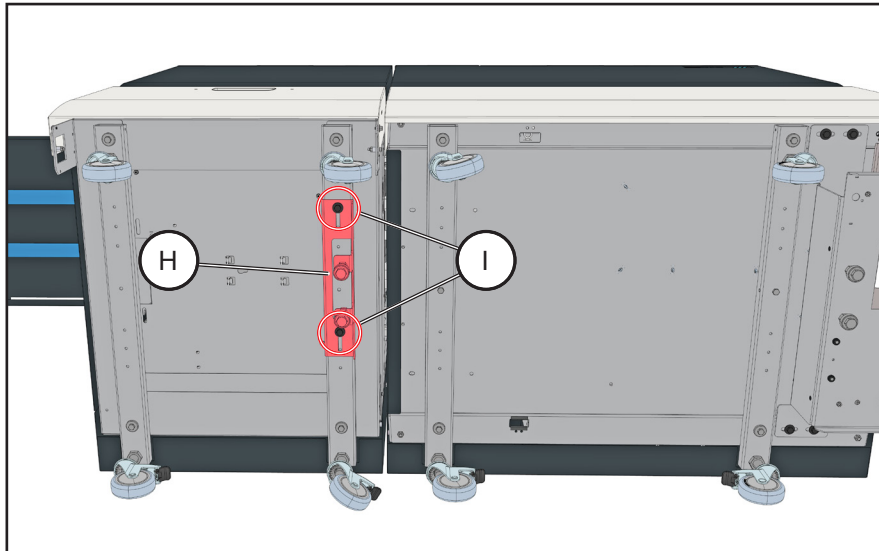


5. Remove screw [F] from the rear of the machine (do not discard screw [F], it will be needed in the future if the module is shipped again).

- 6. Fasten screws [C] and [F] in the tapped holes [G] (2x) in the front side of the machine for safekeeping.
- 7. Reinstall electrical panel wingnut [D]. Do not overtighten wingnut [D], as to do so will break the stud.



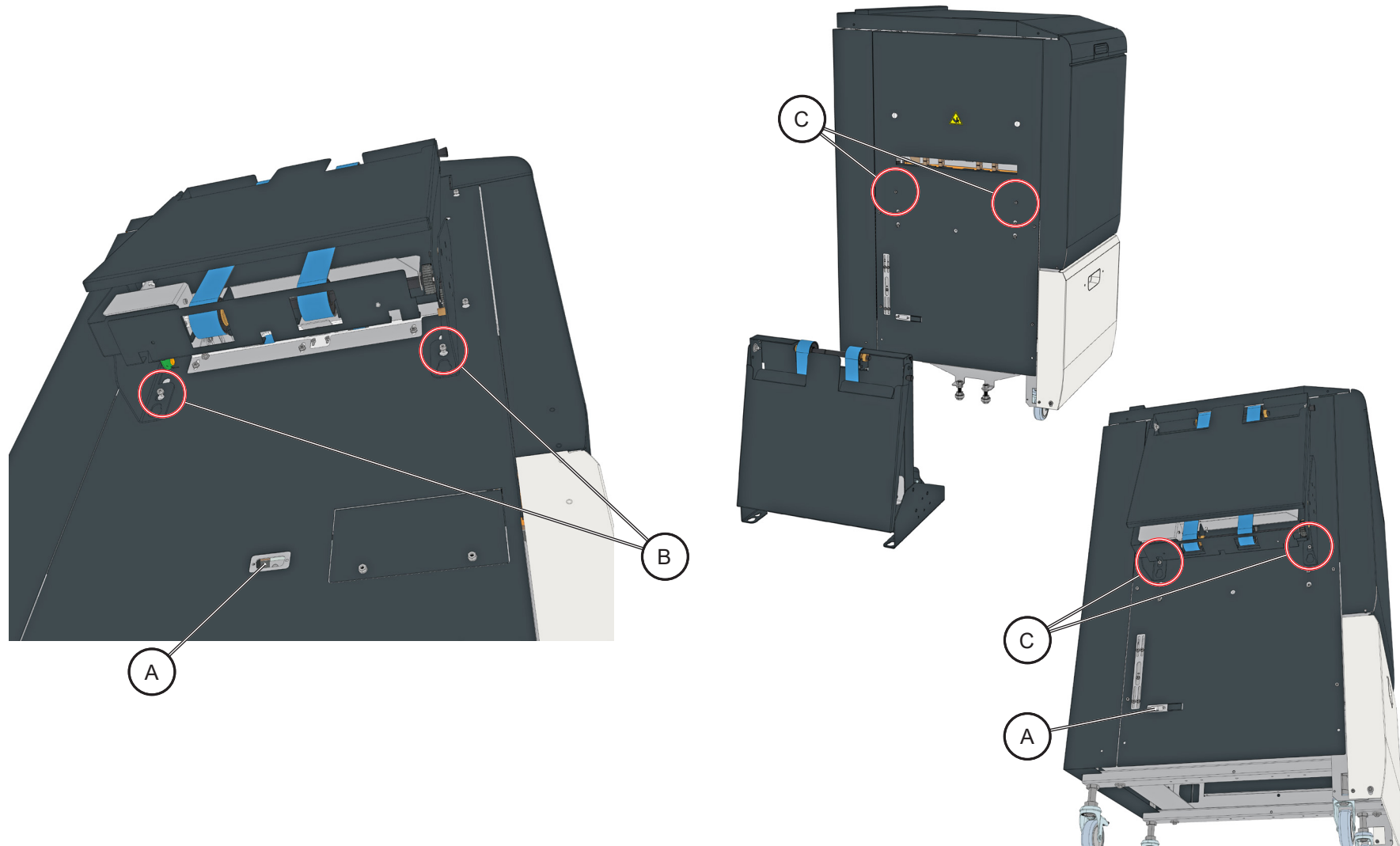
8. Retrieve Guide Bracket [H] and screws [I] (2x) from the accessory box shipped with the Booklet Maker.



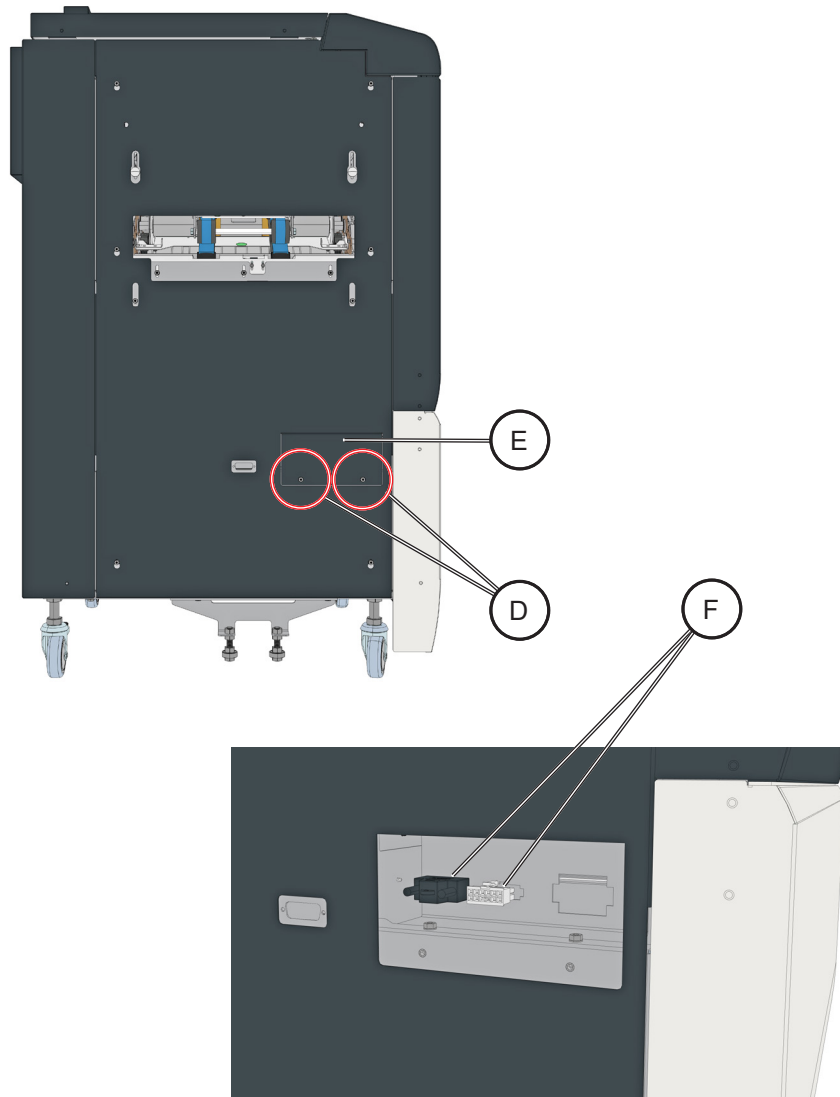
9. Install Guide Bracket [H] on Caster support of Finishing Module that's closer to the in-feed side with screws [I] (2x).
10. Reinstall Front and Rear cover on the Finishing Module.

Intentionally blank

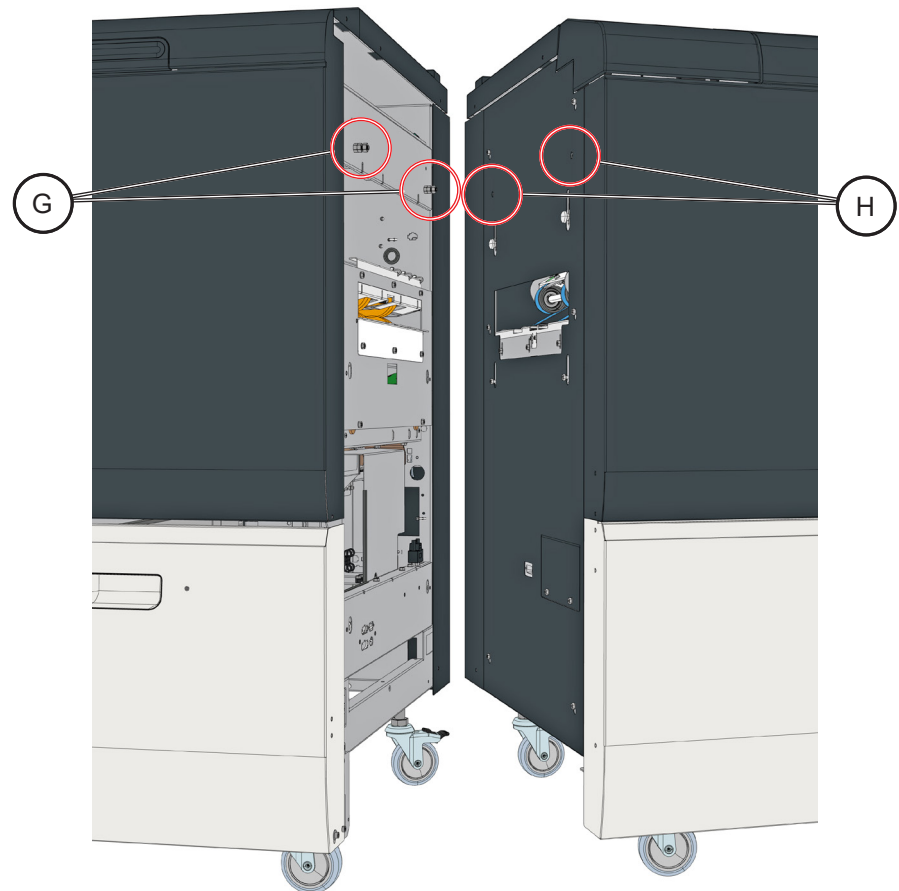
2.7.3 Installation procedure



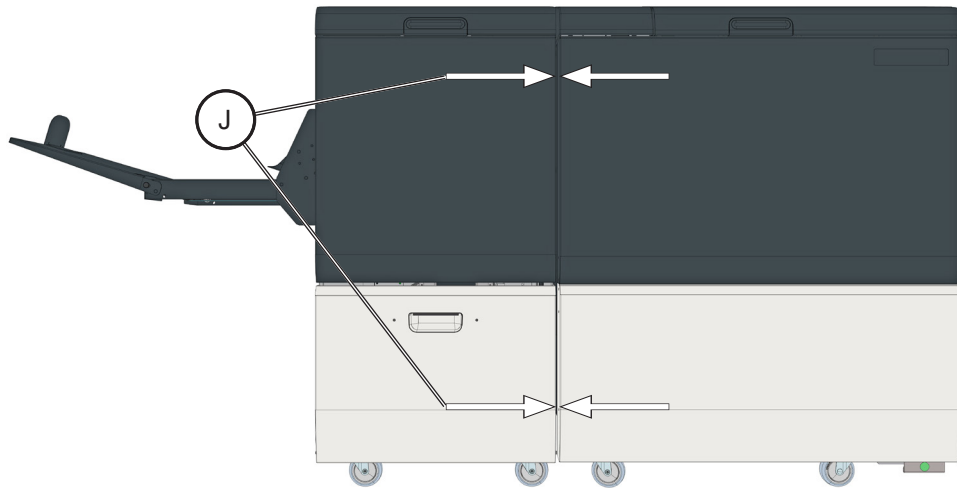
1. Remove the Belt Stacker connector [A] from the Booklet Maker.
2. Through the holes in the Belt Stacker Table, loosen the screws [B] (x2) securing the Belt Stacker to the Booklet Maker.
3. Lift the Belt Stacker from the Booklet Maker.
4. Tighten the screws [B] (2x) on the Booklet Maker.
5. Loosen screws [C] (2x) on the Finishing Module.
6. Hang the Belt Stacker on to the Finishing Module.
7. Through the holes in the Belt Stacker Table, secure the Belt Stacker to the Finishing Module by tightening the screws [C] (2x).
8. Install the Belt Stacker connector [A] to the Finishing Module.



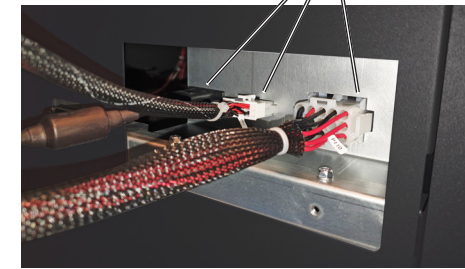
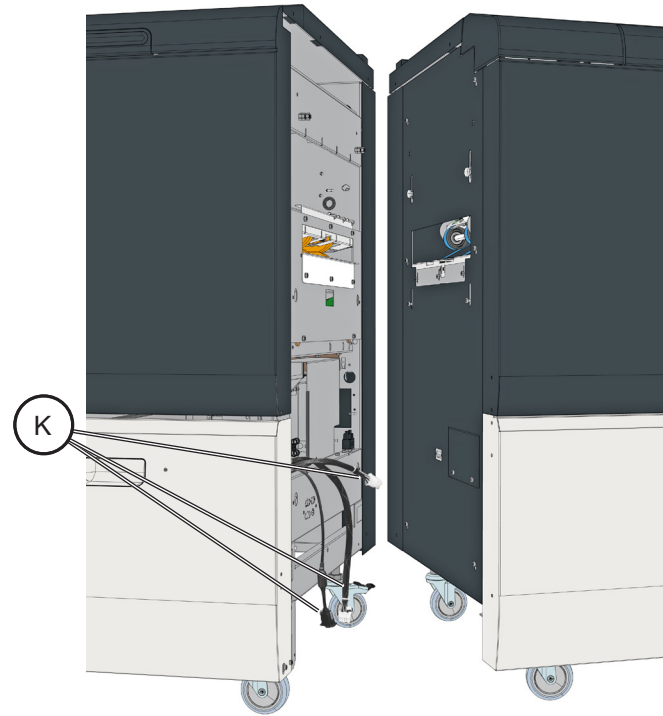
9. Remove the screws [D] (2x) on the Booklet Maker.
10. Remove the Cover [E].
11. Remove the Termination Plugs [F] (2x) and store them for possible future use.



12. Remove and keep the outermost nuts (2x) from the docking studs [G] on the Finishing Module. These nuts will later be used to secure the Finishing Module to the Booklet Maker after docking.
13. Bring the Finishing Module up close to the Booklet Maker to check if the height adjustment matches so that the two modules can be docked.
Height adjustment is correct when the docking studs [G] on the Finishing Module fit in the corresponding holes [H] on the Booklet Maker.



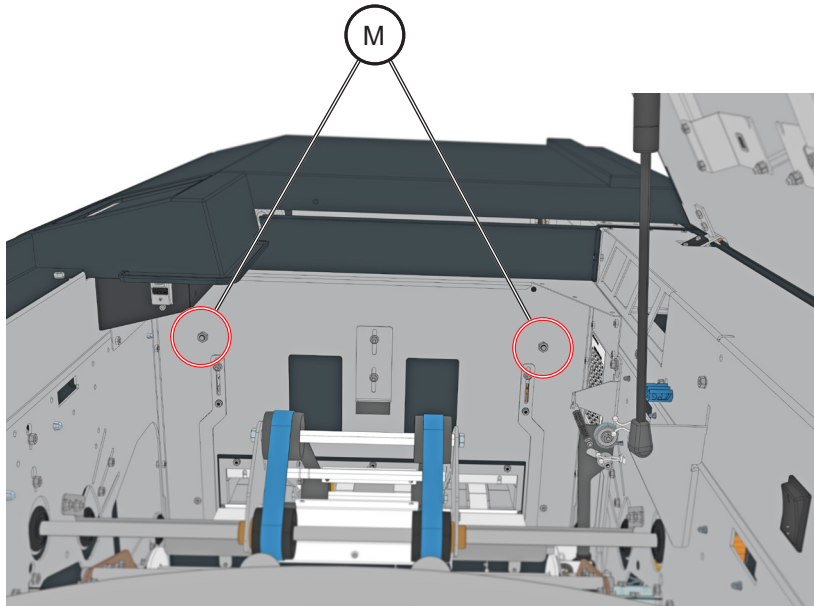
Alignment is correct when the distance between the Finishing Module and the Booklet Maker Covers is equal top to bottom [J].
 If height adjustment and/or alignment is not correct, adjust the casters on the Finishing Module. Do not turn each caster more than 2 full revolutions before the other casters, otherwise the module might become unstable and tilt over. Use a spirit level to check that Finishing Module sits level. Once level secure the casters with the Counter Nut.



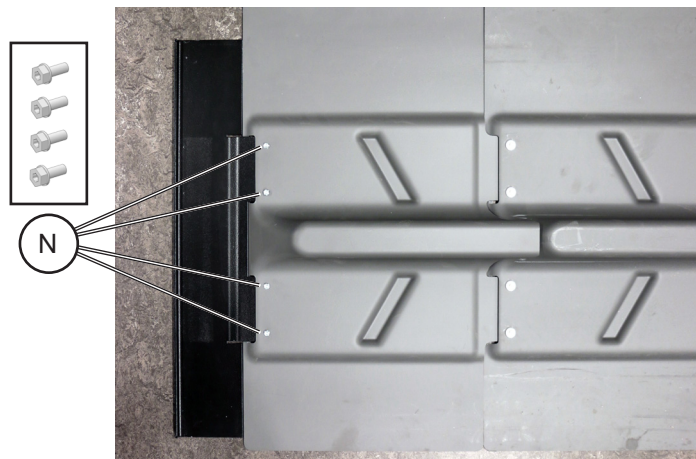
14. Separate the Finishing Module from the Booklet Maker and locate the 3 loose plugs [K] in the Finishing Module.
15. Connect the three plugs (CAN, P12, P110) to the jacks on the Booklet Maker [L] as indicated in the picture above.

⚠ CAUTION:

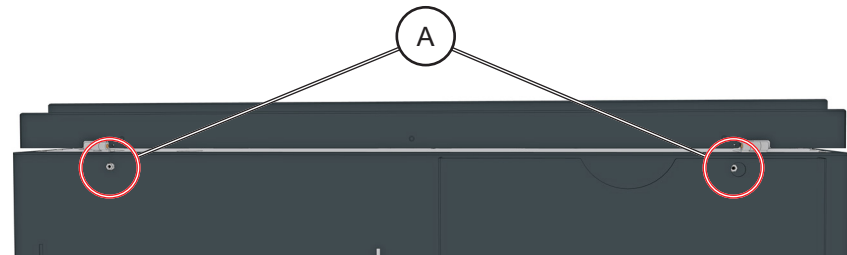
Be careful when moving the modules around from now on as they are connected to each other: the harnesses cannot stretch and will break if pulled too much.



16. Dock the Finishing Module to the Booklet Maker.
17. Secure the Finishing Module to the Booklet Maker using the nuts that were earlier removed from the Finishing Module's docking studs.
18. If the optional Rail unit is installed and all modules are rolled on to it, insert rail stop and secure with screws [N] (4x).



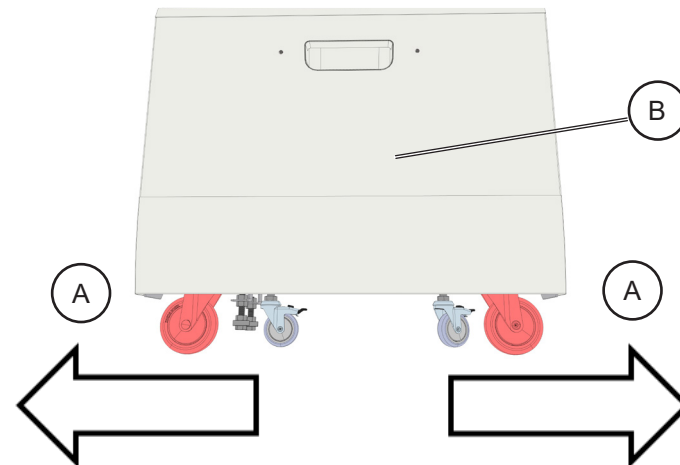
2.7.4 Earth Bonding



⚠ CAUTION:
The bare metal areas behind the screws [A] are for safety earth bonding between the Rear Cover and the machine chassis frame. Make sure you have good earth bonding between these areas, the screws and the chassis frame of the machine.

2.7.5 Caster Locking Position

To prevent the Casters [A] from damaging or stopping the Front Waste Bin Cover [B] from opening they must be aligned as shown in the below image.

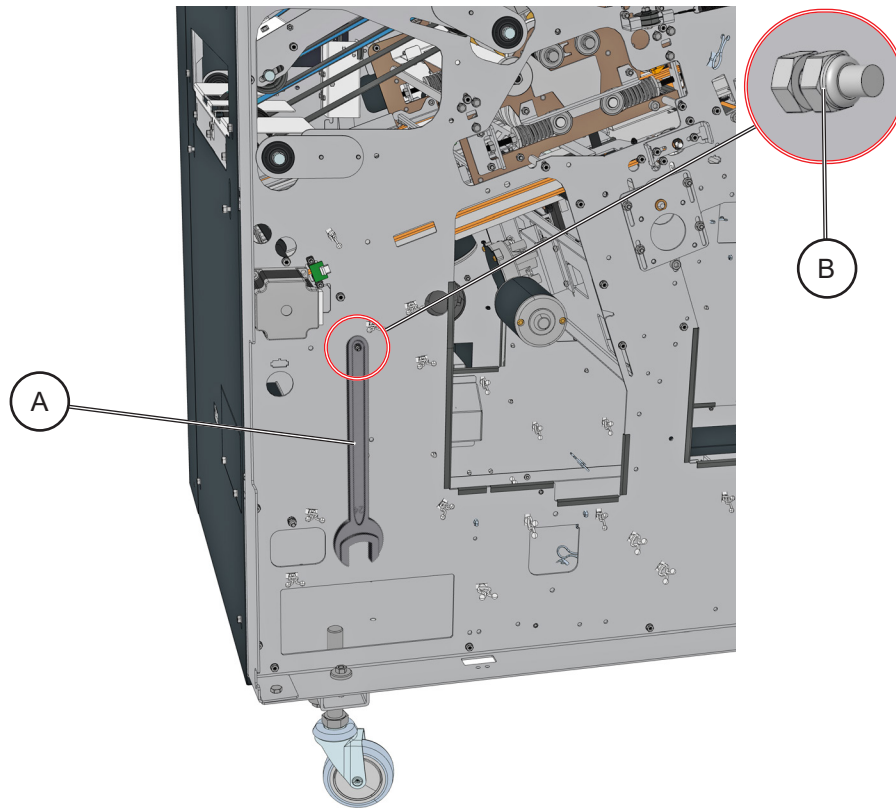


This is the end of the Finishing Module installation procedure. The FM is automatically detected and enabled upon power on.

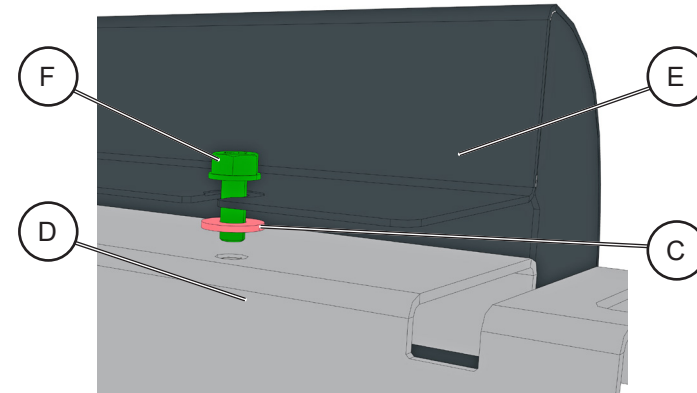
Continue with next section below.

2.8 Wrench and Decal Installation

2.8.1 Wrench

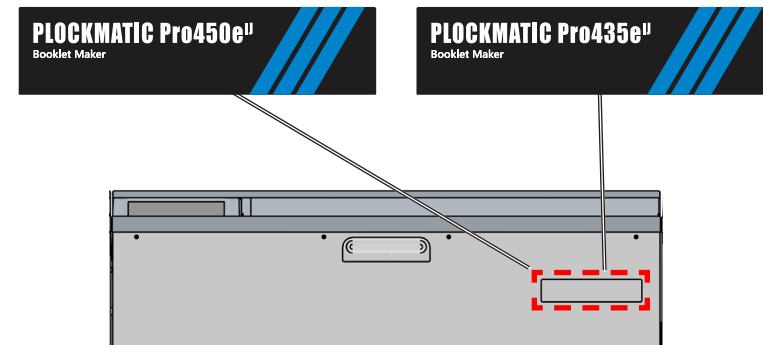


1. Reinstall wrench [A] used for caster's adjustments in the front side of the BM, using nuts and screw [B].



2. Reinstall front cover on the Booklet Maker. Make sure washer [C] is placed between the frame of the machine [D] and the front cover [E] when tightening screw [F].

2.8.2 Decal



1. If the optional 50 sheet performance upgrade kit is installed to the Booklet Maker, apply the Pro450e^U decal, if the optional 50 sheet performance upgrade kit is NOT installed to the Booklet Maker, apply the Pro435e^U decal.

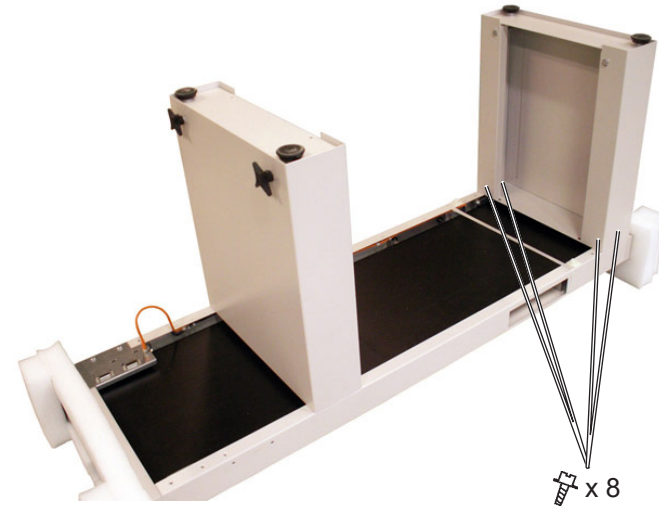
2.9 BST4000-1 Belt Stacker Module

This section describes how to install a BST4000-1 Belt Stacker Module.

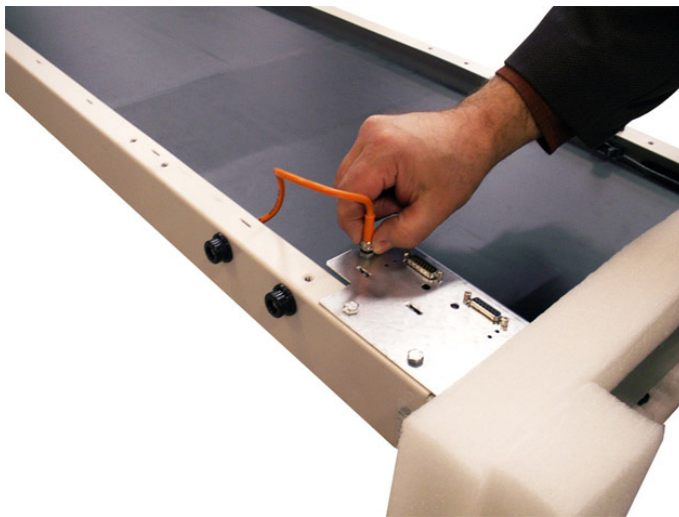
NOTE!

If you do not have the optional BST4000-1 Belt Stacker Module, please skip this section and proceed with the next one.

2.9.1 Installation procedure



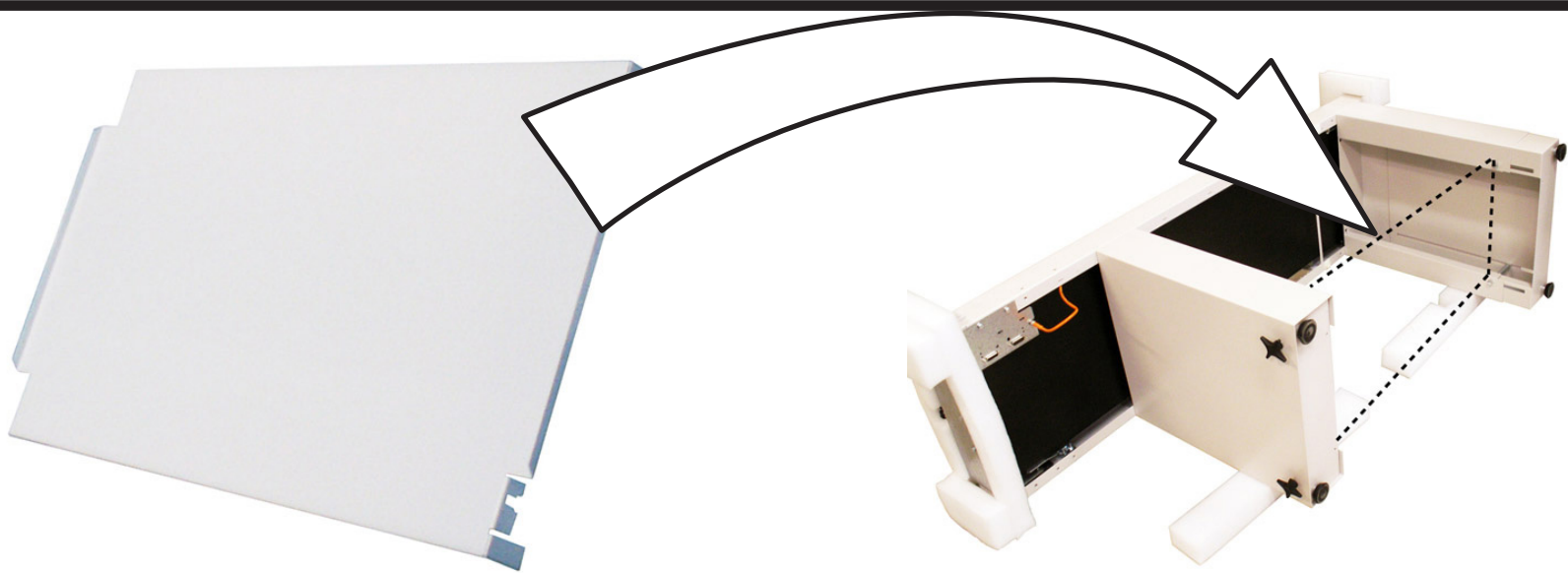
2.



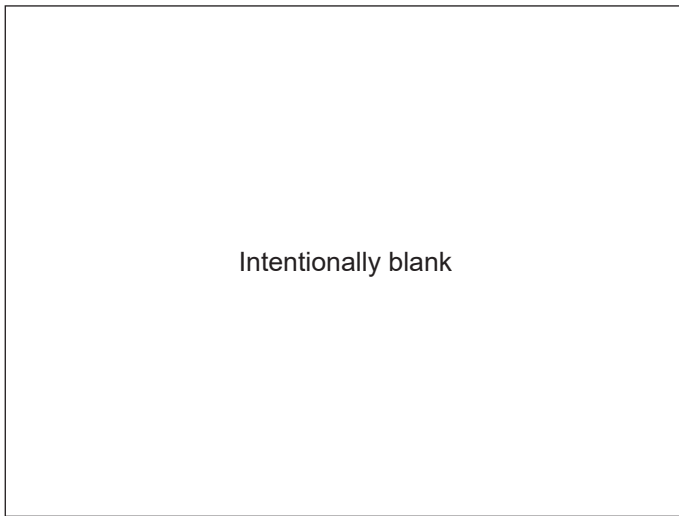
1.



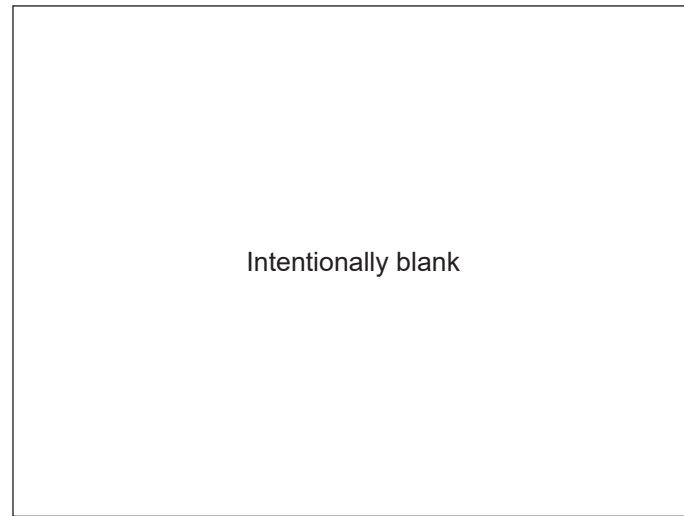
3.



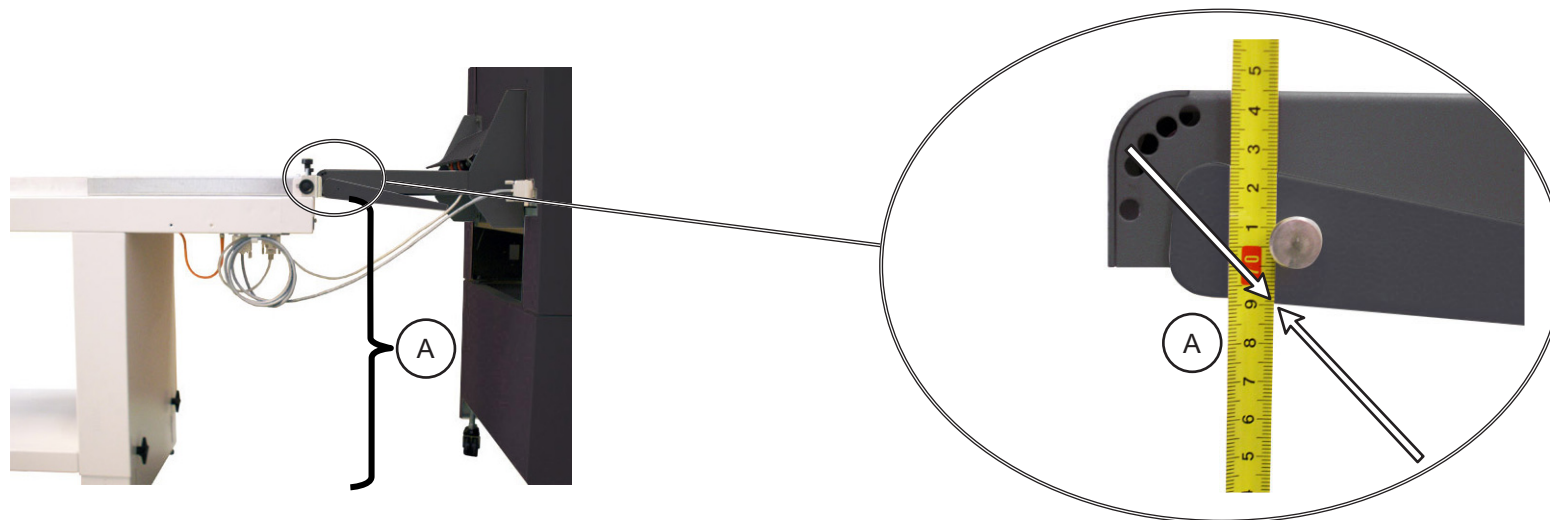
4.



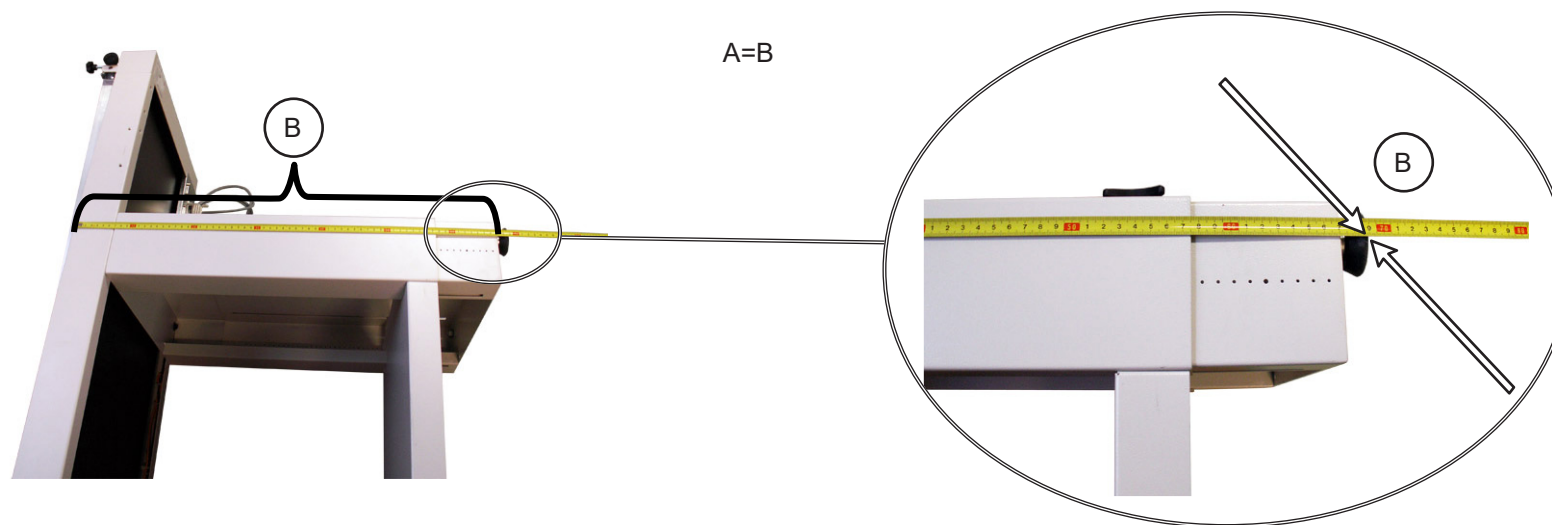
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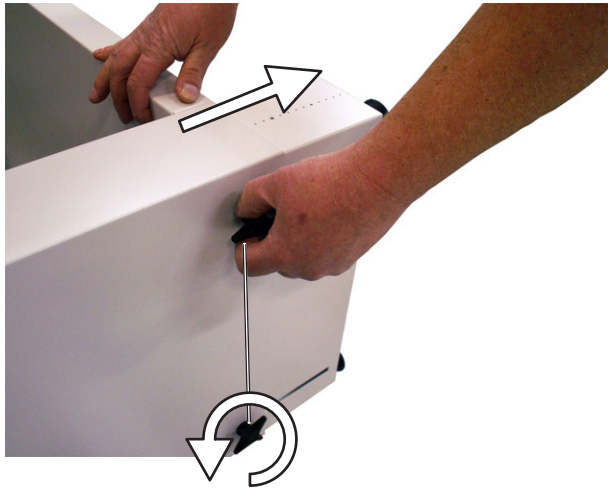
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5. Measure height [A]



6. Adjust distance [B] to match height [A]



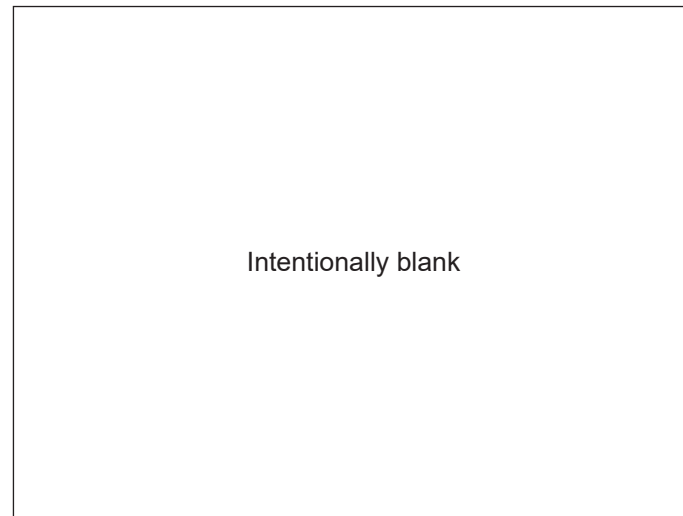
7.



9.



8.



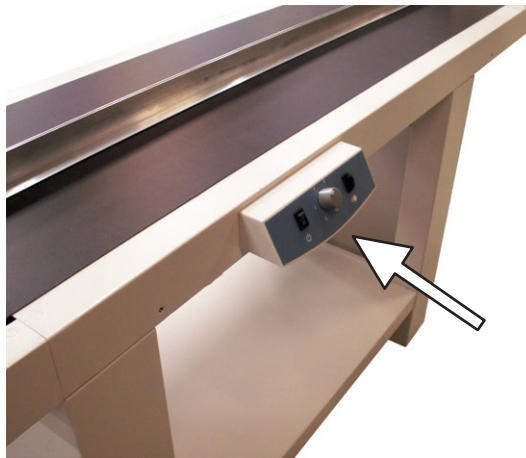
10.



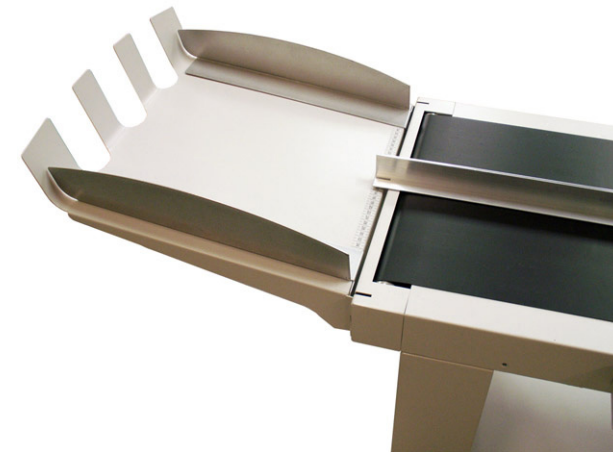
11.



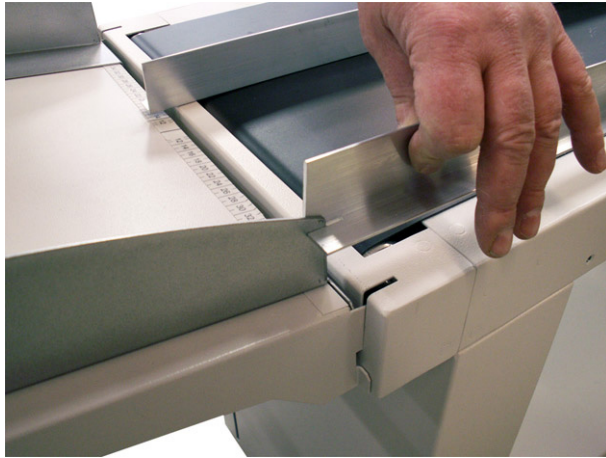
13.



12.



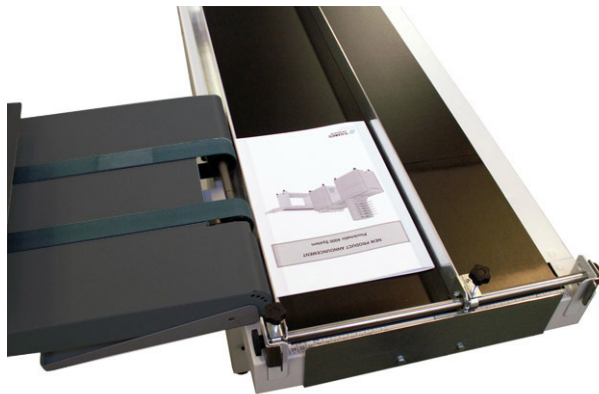
14.



15.



Alt. 2



Alt. 1

This is the end of the BST4000-1 Belt Stacker installation procedure. Installing connectors and cables will be done later on.

Continue with next section below.

2.10 Cables, plugs, jumpers and switches

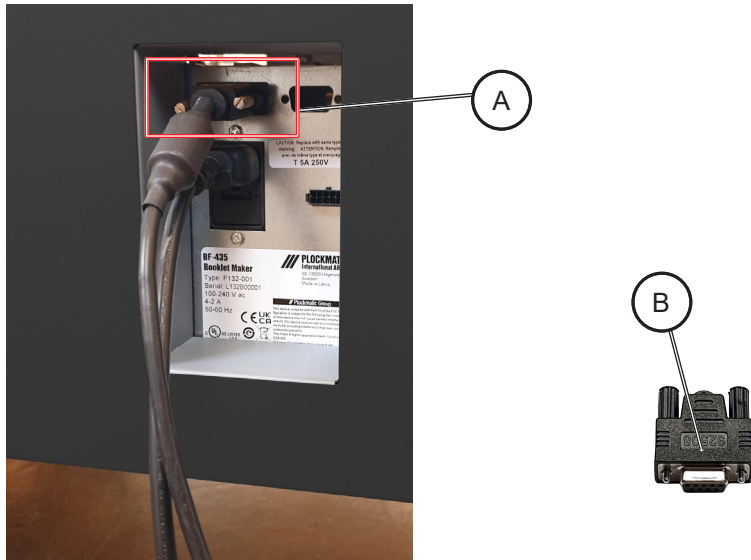
This section describes schematically how to connect communication cables, power cords, terminator plugs, interlock jumpers and set switches on all possible system configurations.

⚠ **WARNING:**

Before connecting the machines to the power supply, make sure that each cover on each module has been replaced and that any part of the machine that was disassembled during installation was put back in place.

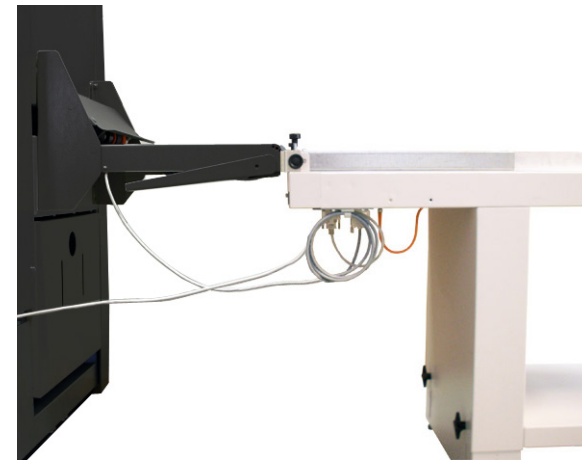
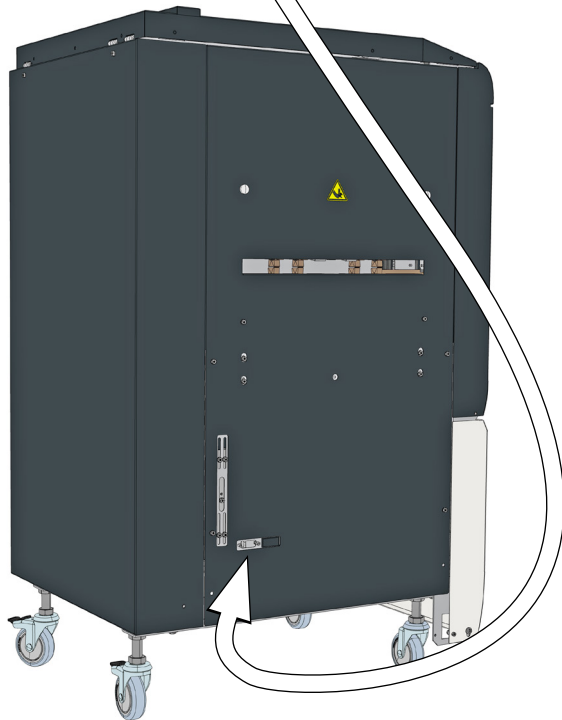
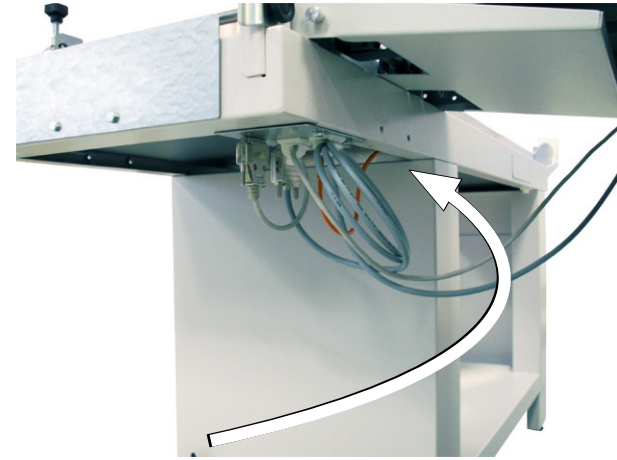
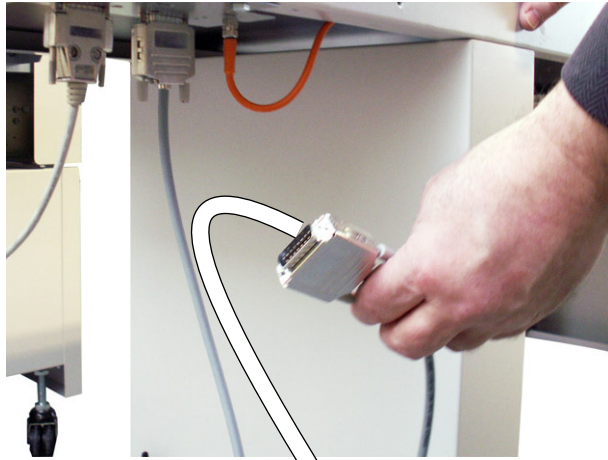
Do not connect the machines to the power supply if covers are off or if any module is (even partially) disassembled.

2.10.1 Termination Plug to Booklet Maker



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If you want to hand feed the Booklet Maker and therefore use it in offline mode - disconnected from its upstream device - disconnect communication cable [A] and use termination plug [B] instead. This is only necessary if Booklet Maker is to be used in offline mode, without the possibility to connect to upstream device.



NOTE: RCT Module valid until Serial Number L122Y00____

2.10.3 Main Power cords, General information

⚠ WARNING:
 For Denmark the max allowed leakage current is 3.5 mA. Make sure you use a proper polarized grounding plug in the wall outlet and use only the power cord with Plug DK2-1a. When using a non-polarized plug, touch current may reach 4.5 mA but does not exceed 5 mA.

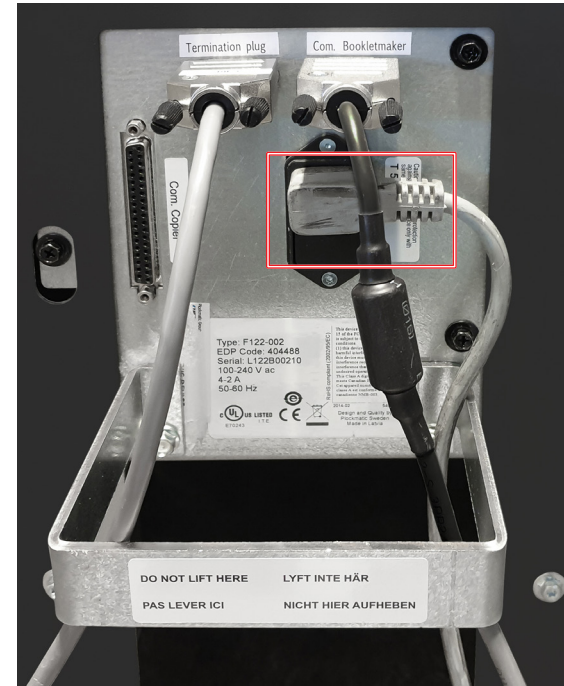


Description: Denmark type plug			
Yung-Li ref.:	YP-26	YP-26A	YP-26H
standard:	Denmark SB 107-2-D1 DK 2-5a	Denmark SB 107-2-D1 DK 2-1a	Denmark SB 107-2-D1 DK 2-8a
approvals:	UL DEMKO	UL DEMKO	UL DEMKO

⚠ WARNING:
 Make sure you use a proper grounded plug in the wall outlet. NEVER plug in the module to a non grounded plug.

2.10.4 Main Power cord, Rotate Crease Trim Module

⚠ WARNING:
 Make sure you use a proper grounded plug in the wall outlet. NEVER plug in the module to a non grounded plug.



NOTE: RCT Module valid from Serial Number L122Y00___ (valid from TAG 43 Serial Number)

2.10.3 Main Power cords, General information

2.10.4 Main Power cord, Rotate Crease Trim Module

⚠ WARNING:

For Denmark the max allowed leakage current is 3.5 mA. Make sure you use a proper polarized grounding plug in the wall outlet and use only the power cord with Plug DK2-1a. When using a non-polarized plug, touch current may reach 4.5 mA but does not exceed 5 mA.



Description: Denmark type plug			
Yung-Li ref.:	YP-26	YP-26A	YP-26H
standard:	Denmark SB 107-2-D1 DK 2-5a	Denmark SB 107-2-D1 DK 2-1a	Denmark SB 107-2-D1 DK 2-8a
approvals:	UL DEMKO	UL DEMKO	UL DEMKO

⚠ WARNING:

Make sure you use a proper grounded plug in the wall outlet. NEVER plug in the module to a non grounded plug.

⚠ WARNING:

Make sure you use a proper grounded plug in the wall outlet. NEVER plug in the module to a non grounded plug.



2.10.5 Main Power cord, Booklet Maker

⚠ WARNING:

Make sure you use a proper grounded plug in the wall outlet. NEVER plug in the module to a non grounded plug.



Intentionally blank

2.10.6 Main Power cord, BST4000-1 Belt Stacker Module

⚠ WARNING:

Make sure you use a proper grounded plug in the wall outlet. NEVER plug in the module to a non grounded plug.




2.11 Powering on the machine

This section describes how to switch the system on and how to perform the initial configurations.

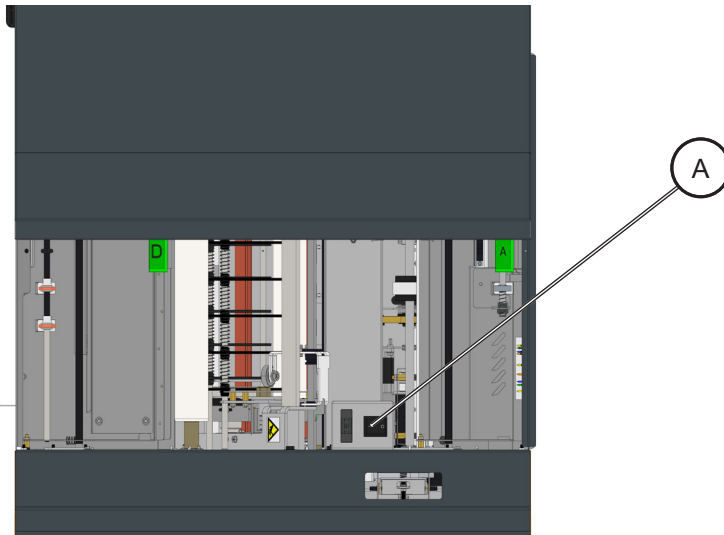
⚠ WARNING:

Before turning on the machines, make sure that each cover on each module has been reinstalled and that any part of the machine that was disassembled during installation was put back in place.

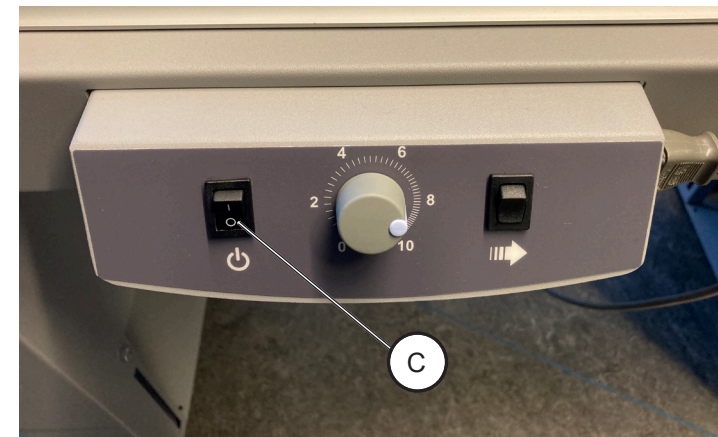
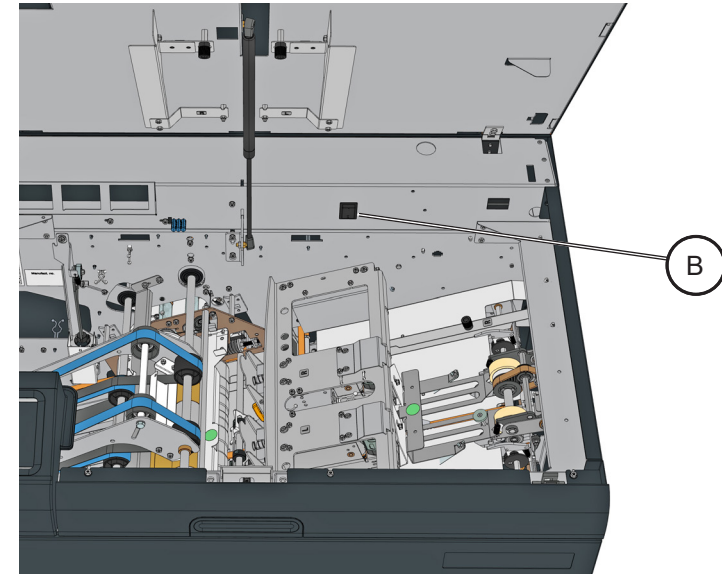
Do not turn the machines on if covers are off or if any module is (even partially) disassembled.

 **NOTE!** Before powering on the system, make sure that the upstream device is set up correctly to work with the Pro450e^U/435e^U system. Refer to Xerox's documentation for how to setup the upstream device correctly.

2.11.1 Powering on the system



1. Open the RCT top cover (if installed) and turn the switch [A] on.



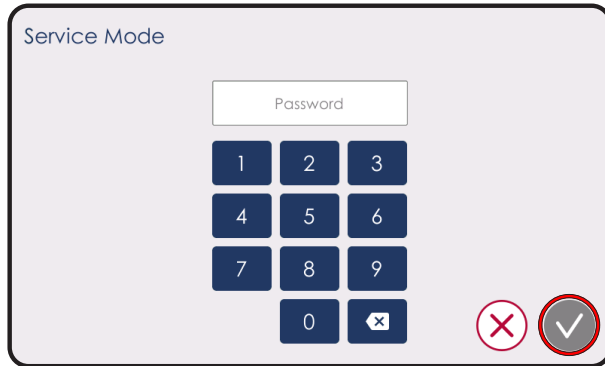
2. Open the Booklet Maker top cover and turn the switch [B] on.
3. If installed, turn on the Belt stacker's switch [C].

NOTE!

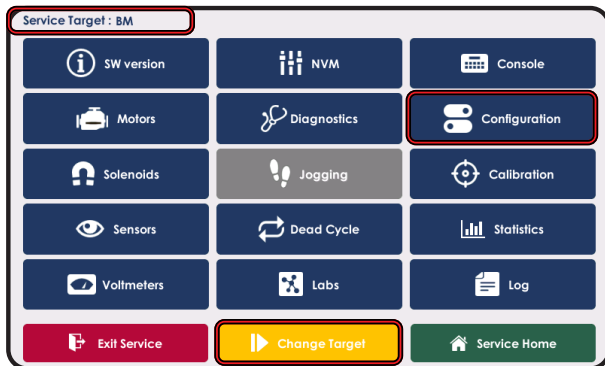
If you have an error code regarding communication, ignore it for now and go to next section.

2.11.2 Selecting the correct configuration

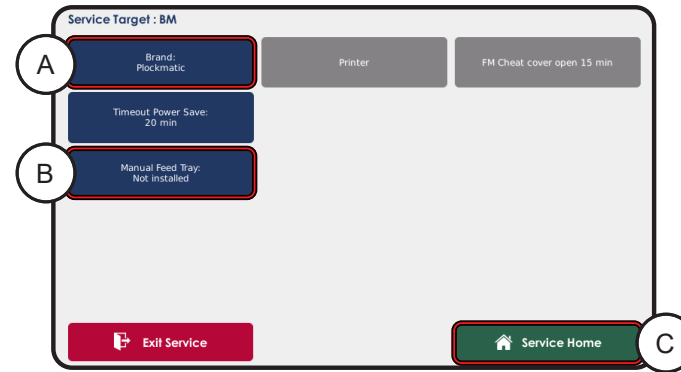
1. Turn off the BM.
2. Push and hold anywhere on the screen and turn on the machine



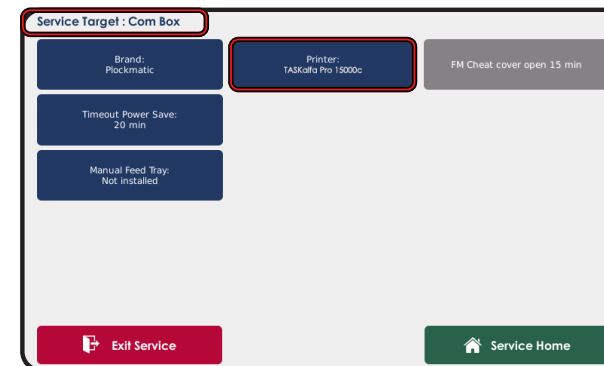
3. Key in password: **107** and select the check mark to enter Service Mode.



4. In the service menu, push the yellow button [Change Target] until the Service Target changes to “BM” In the upper left corner of the UI.
5. Select [Configuration].

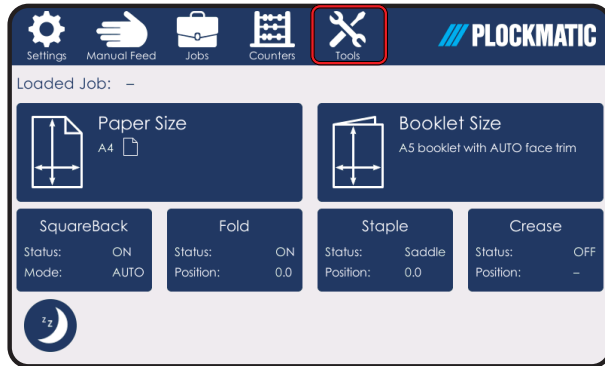


6. Brand [A]: tap to toggle between Plockmatic / Morgana.
7. Manual Feed Tray [B]: always leave set to “Not Installed”.
8. Tap [Service Home] [C].

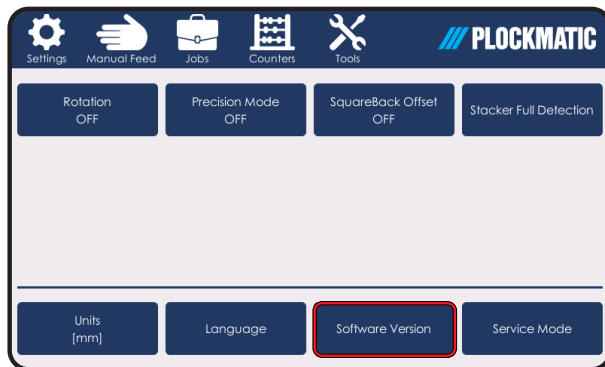


9. In the service menu, push the yellow button [Change Target] until the Service Target changes to “Com Box” In the upper left corner of the UI, then tap again on [Configuration].
10. Tap [Printer] to cycle through the Printers and select the Printer to which the system has been installed to.

2.11.3 Checking the software



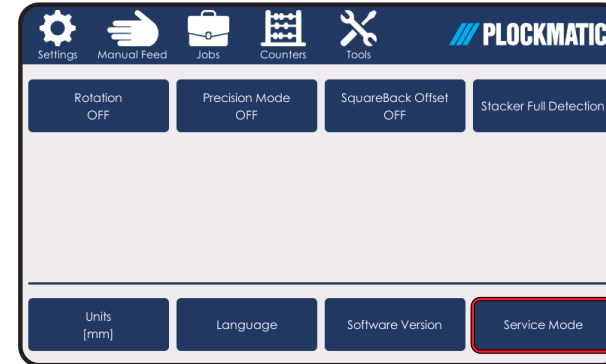
1. Select the Tools button from the booklet maker's UI.



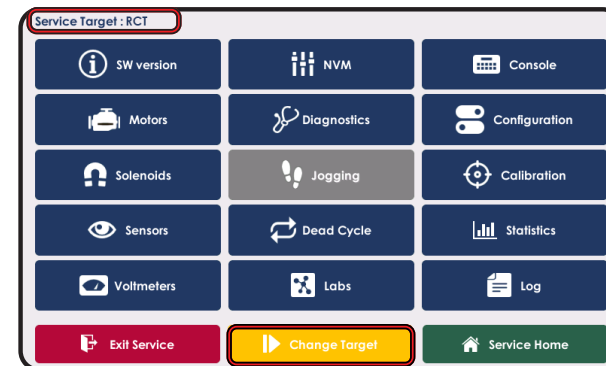
2. Select [Software Version].
3. Go to GSN.
4. Check the latest software release and compare it with the software version installed on the modules.
5. If the software is outdated, download the latest revision from Xerox's website and follow procedure described in Software Package to update the system.

2.11.4 Enabling the optional antistatic bar kit on the RCT

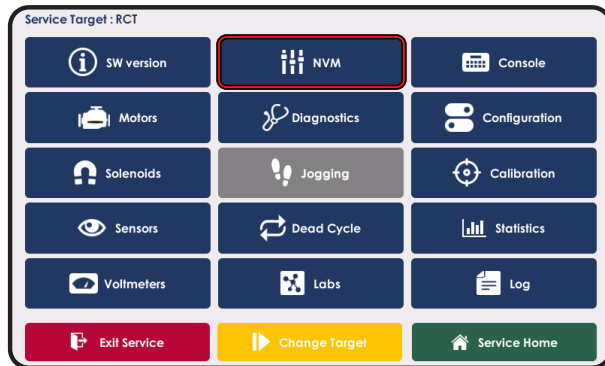
Perform this procedure only if the optional antistatic bar kit is installed to the Rotate Crease Trim Module (RCT).



1. Access [Service Mode] as described earlier in procedure.



2. In the service menu, push the yellow button [Change Target] until the Service Target changes to "RCT" In the upper left corner of the UI.



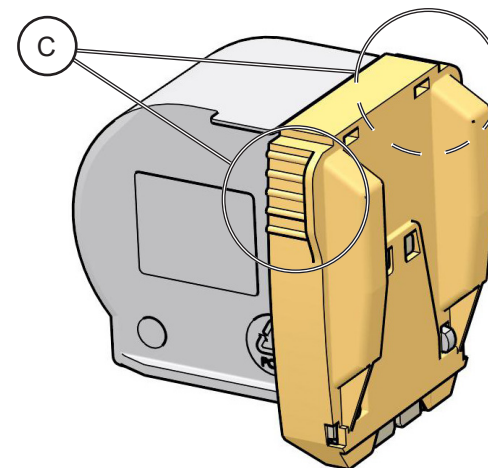
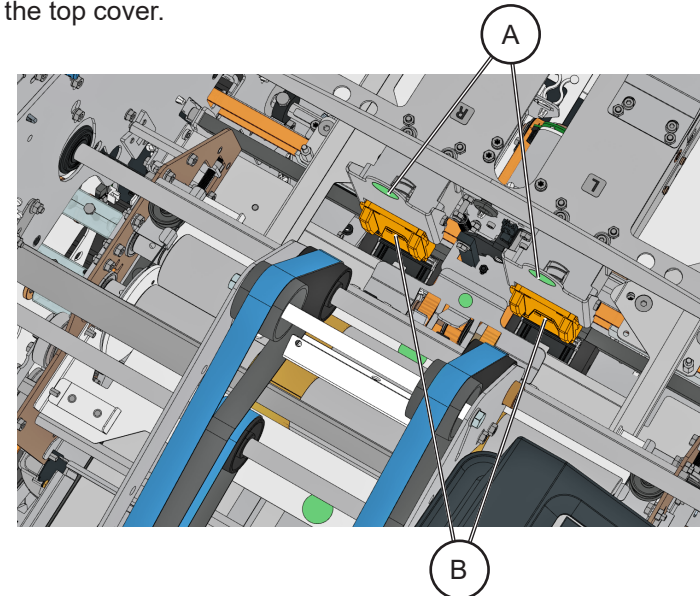
3. Access the NVM Values sub-menu.

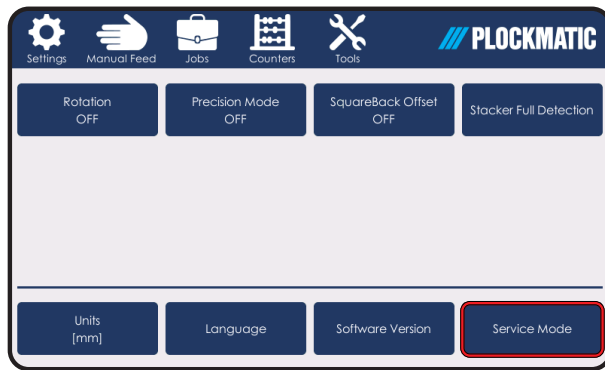
#	Name	Description	Setting
11	Antistatic Out	On/Off switch for Antistatic device in Exit. 0=Off 1=On	Set to 1
12	Antistatic Waste	On/Off switch for Antistatic device in Waste channel. 0=Off 1=On	Set to 1

4. Scroll the NVM list to #11 and #12, both values should be set to 1:
- If they are already set to 1 continue with the next section;
 - If they are set to 0, change to 1 then continue with the next section.

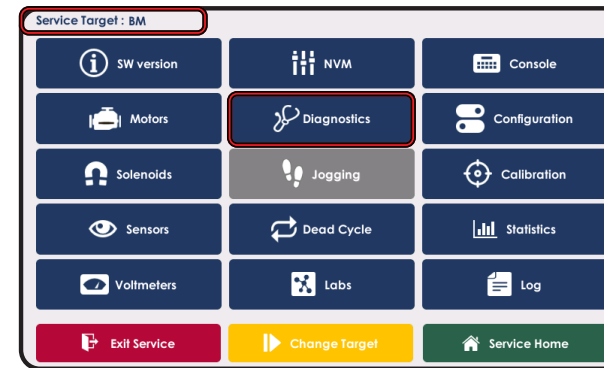
2.11.5 Performing a self diagnostic

1. Open the Booklet Maker's Top Cover.
2. Press the staple cartridge ejector lever [A] and pull out the staple cartridge [B] using the grip [C] at both sides at the top of the staple cartridge.
3. Remove any sheet present in the system.
4. Close the top cover.

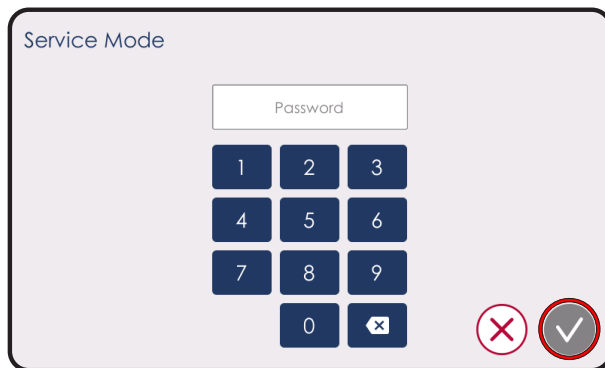




5. Select [Service Mode].



7. Check which Service Target is selected (e.g. BM).
8. Press [Diagnostics] then [Start].
9. When message: "Complete! 0 errors found" appears, continue with next step below.
10. Select [Change Target] to change the Service Target.
11. Repeat steps 7 to 10 until all modules have been diagnosed.
12. Should you get a fault code after performing a Detailed self diagnostic, a service manual is required to solve the problem.



6. Enter password: **107** and select the green check mark to enter Service Mode.

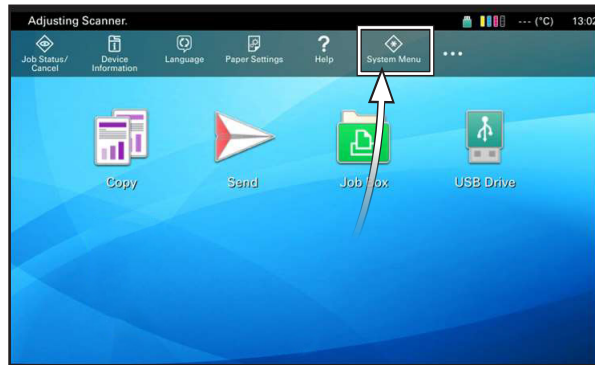
2.12 Printer configuration

2.12.1 Interface kit setting

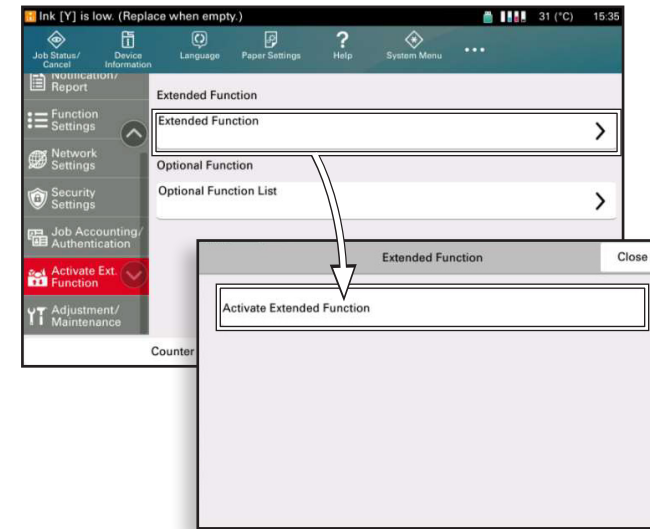
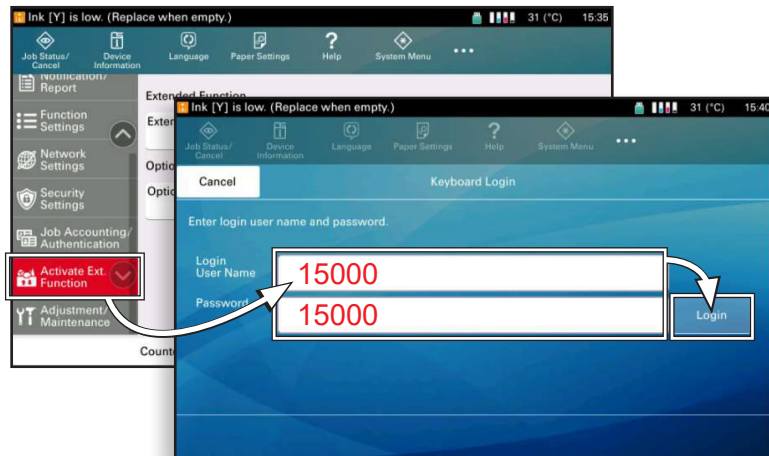


NOTE!

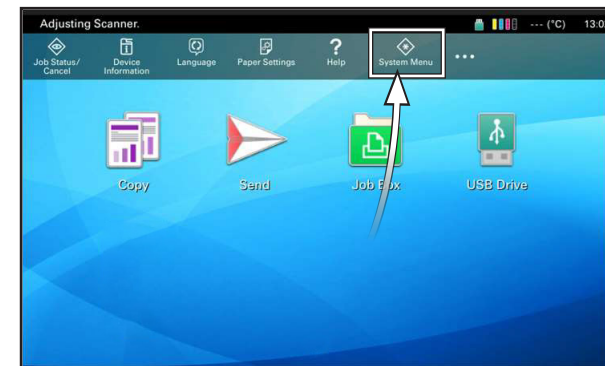
If “Interface Kit Setting” icon is displayed, skip this section.



1. Select the “System Menu” icon.
2. Select “Activate Ext. Function”.
3. A prompt will ask to enter a User Name and Password, so enter 15000 for both and select “Login”.

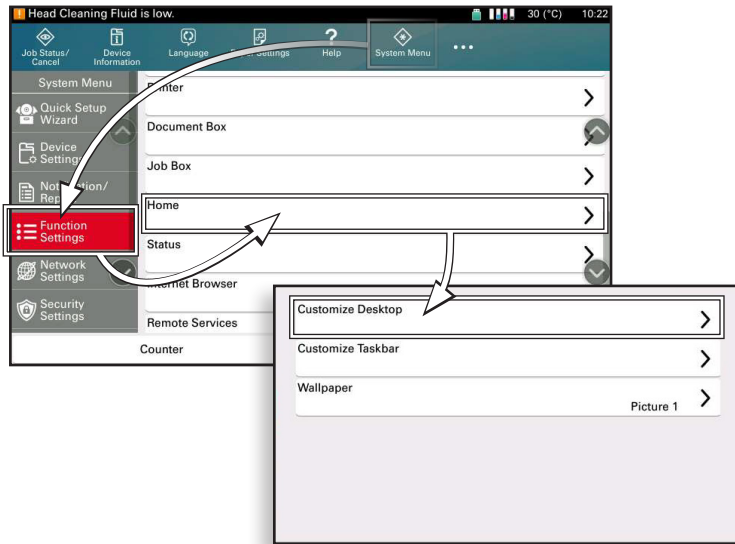


4. Select “Extended Function”.
5. Select “Activate Extended Function”. It is OK if “complete” is displayed on the panel.

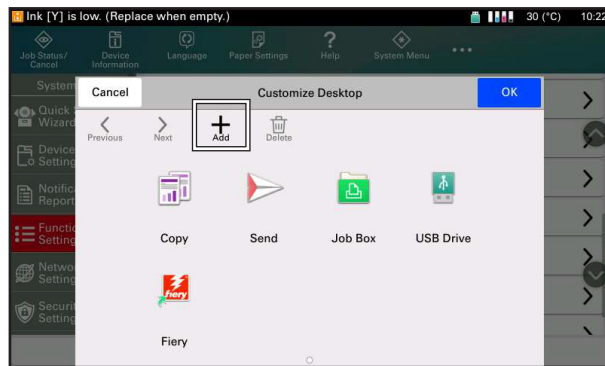


6. Select the “System Menu” icon again.

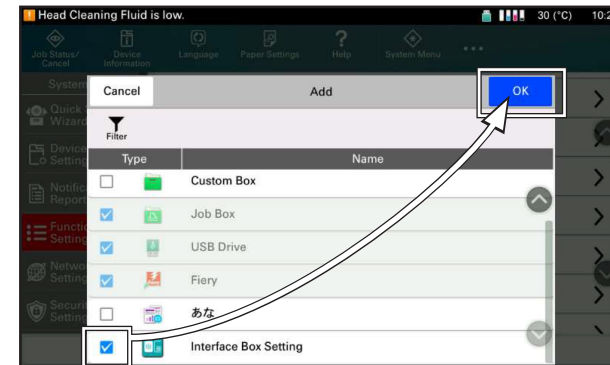
7. Select "Function Settings".
8. Select "Home".
9. Select "Customize desktop".



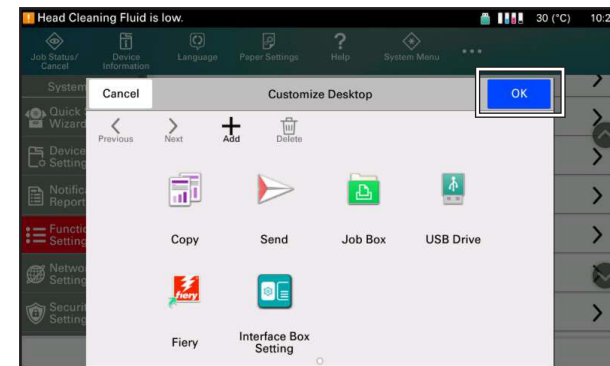
10. Select "+Add".



11. Scroll down and tick the check box next to "Interface Box Setting" and select "OK".

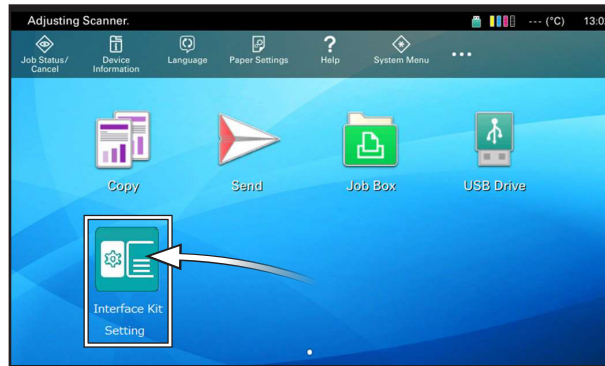


12. Select "OK" once more.

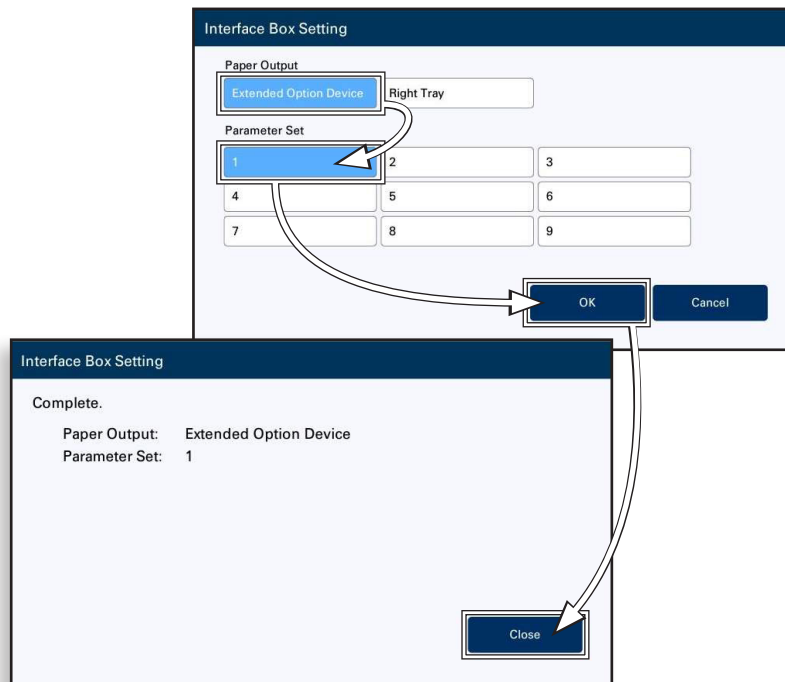


2.12.2 Extended Option Device

1. Select “Interface Kit Setting” icon.



2. Select “Extended Option Device”, set the parameter to “1” and select “OK”.
3. Select “Close” to exit.



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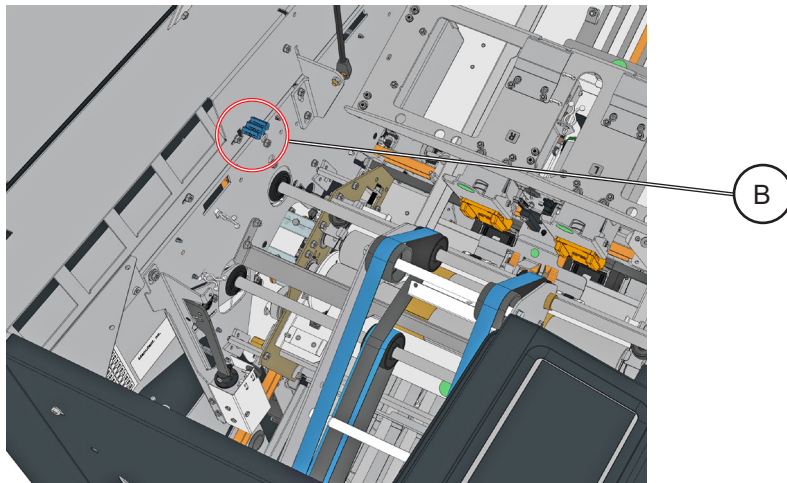
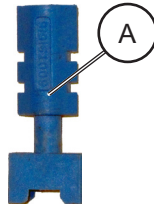
2.13 Checking the installation

This section describes how to perform tests to verify that the system is properly installed and that the output from the system equals to the specifications. Should booklet quality issues be found, a trained service technician and a service manual is needed. Make a note of this issue and pass it on to a trained service technician. If needed, refer to the operator manual to understand how to run the system.

Depending on how you system is configured, some settings may not be applicable and tests may be ignored. For example - if you do not have a RCT installed, setting bleed trim is not possible and test involving the RCT can be ignored. If needed, please refer to the Operator manual for how to use the machine.

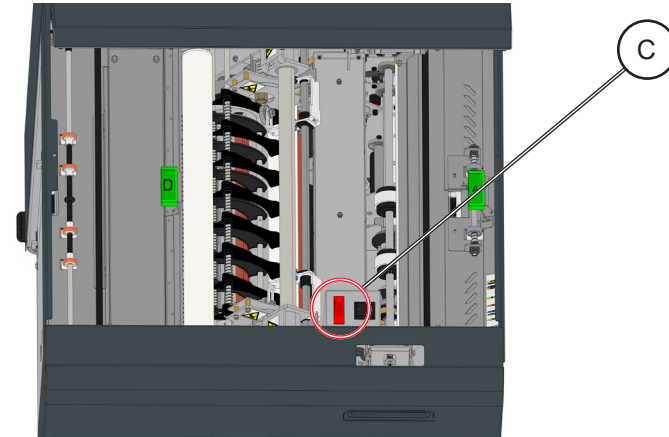
2.13.1 System alignment

1. To be able to perform this adjustment, an interlock cheater [A] will be needed. Interlock cheaters are used to operate the machine with the covers open. Be extremely careful when you operate the machine with the interlock cheaters installed.
2. Open the top cover of the Booklet Maker and locate the interlock cheaters. The interlock cheaters are kept in place with a screw. Loosen the screw [B] and take one of the cheaters.



⚠ WARNING

Do not expose fingers or other parts of the body to moving, rotating or cutting devices when running the machine with the interlock cheater installed. Do not wear ties, lanyards or other things that might get trapped into the rollers and cause injuries.



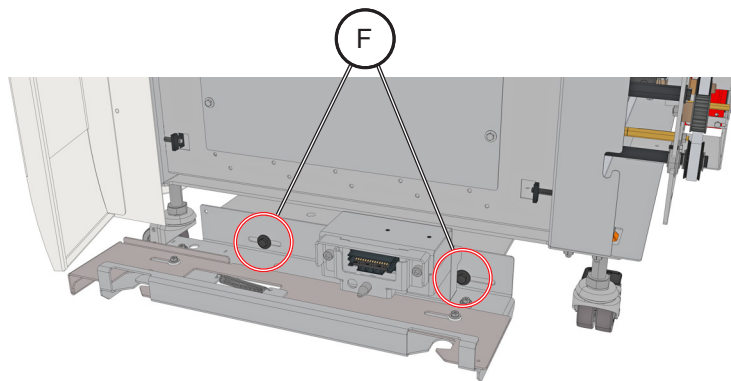
3. Open the RCT top cover and install an interlock cheater [C] to be able to run the RCT with the top cover open.
4. Set up the Booklet maker to:
Paper Size: SRA3 or 12 x 18"
Face Trim: 0,0 mm or 0.000"
Bleed Trim: 0,0 mm or 0.000"
Staple: ON
Cover: OFF
Book Fold: OFF
Fold position: AUTO
Crease: Status: OFF, Offset: -
5. Using 80 gsm / 20 lb Bond sheets, send five sets of 2 sheets of SRA3 / 12 x 18" 80 gsm / 20 lb Bond (2 sheets of SRA3 / 12 x 18" equals a booklet containing 8 pages of SRA4 / 12 x 9") to the Booklet Maker system.
6. Check for the correct feeding of the sheets in the RCT and the Booklet Maker.

🔪 NOTE!

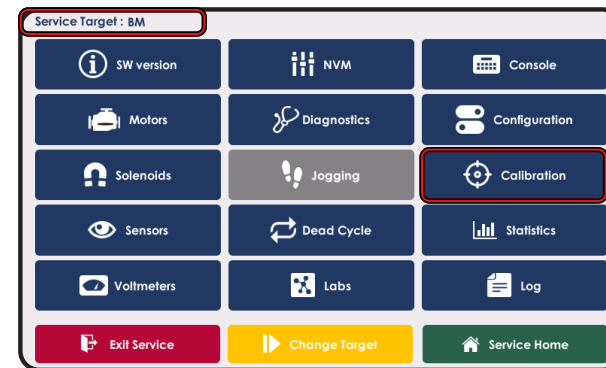
It is critical that you use SRA3 / 12 x 18" sheets during alignment. Use of smaller paper sizes during alignment can cause SRA3 / 12 x 18" to have in-feed issues.



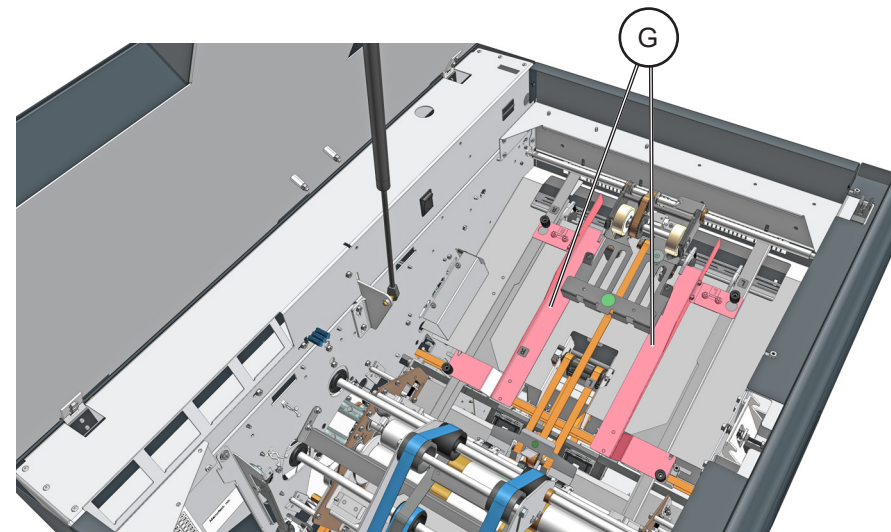
7. The sheet's operator side edges [D] should enter the RCT at the corresponding mark on the label [E] ± 3 mm (0.12"). If not, the In-Feed docking bracket on the RCT must be adjusted.



8. Turn off and undock RCT, Loosen screws [F] and adjust In-Feed Docking Bracket on the RCT to achieve tolerance (the picture above shows the Docking Bracket without the Communication box for picture clarity).
Repeat step 4 to 8 until alignment is correct.



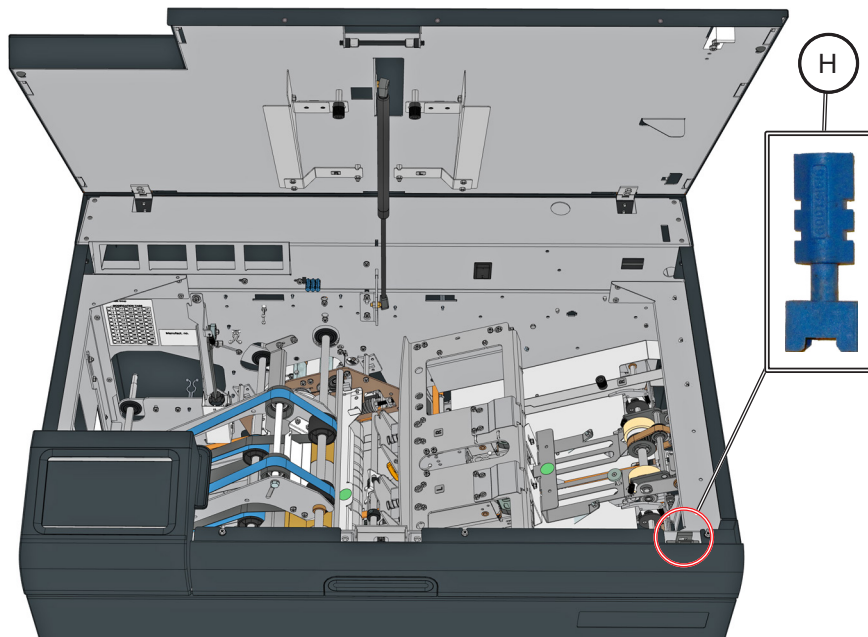
9. Access [Service Mode] as described earlier in procedure.
10. Make sure that Service Target is set to "BM".
11. Tap on [Calibration], then select [BM Center In-feed] and follow instructions on the screen.



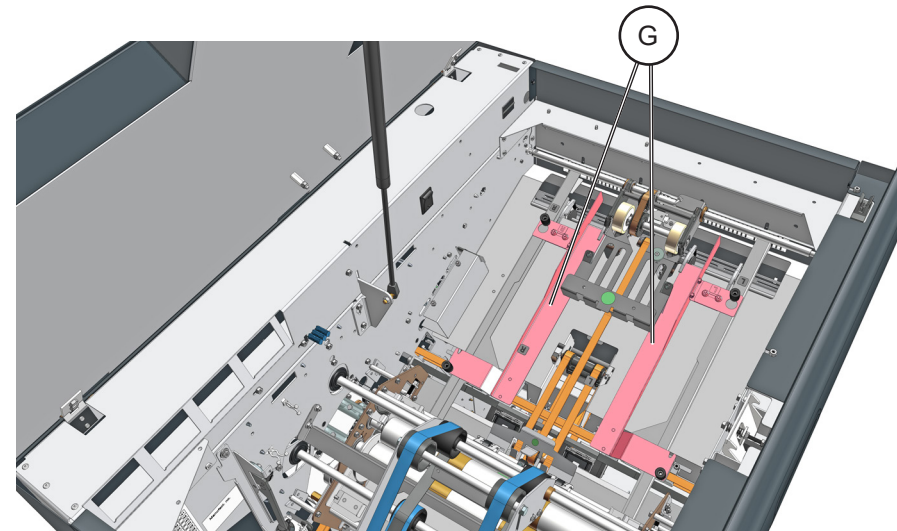
12. Install small paper kit [G] to the BM (see operator manual).

⚠ WARNING

Do not expose fingers or other parts of the body to moving, rotating or cutting devices when running the machine with the interlock cheater installed. Do not wear ties, lanyards or other things that might get trapped into the rollers and cause injuries.

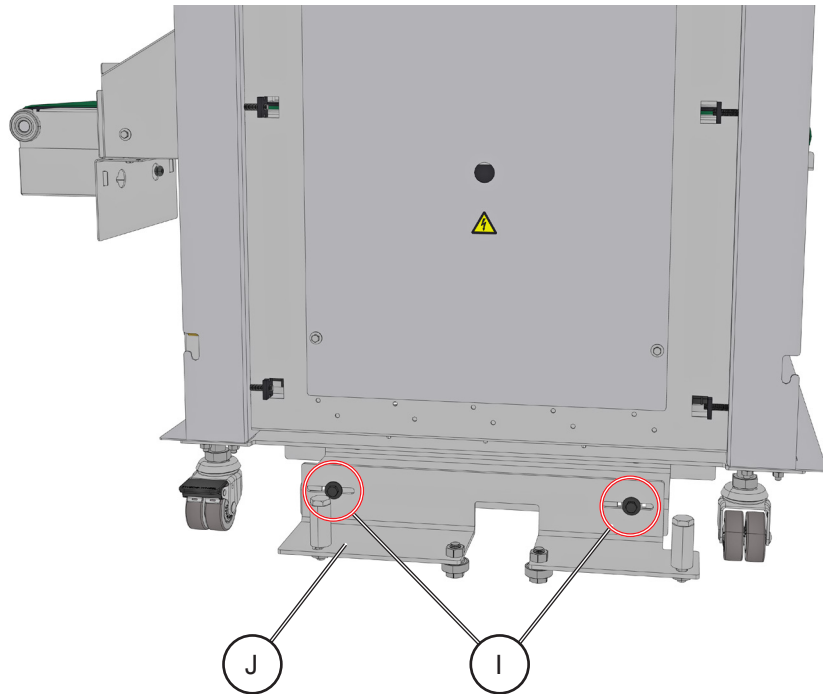


13. Install interlock cheater [H] to Booklet Maker's switch.
14. Use an A4 sheet (or 8.5 x 11"), select paper size on machine's UI and follow instructions to feed 1 set from the RCT / Upstream device.



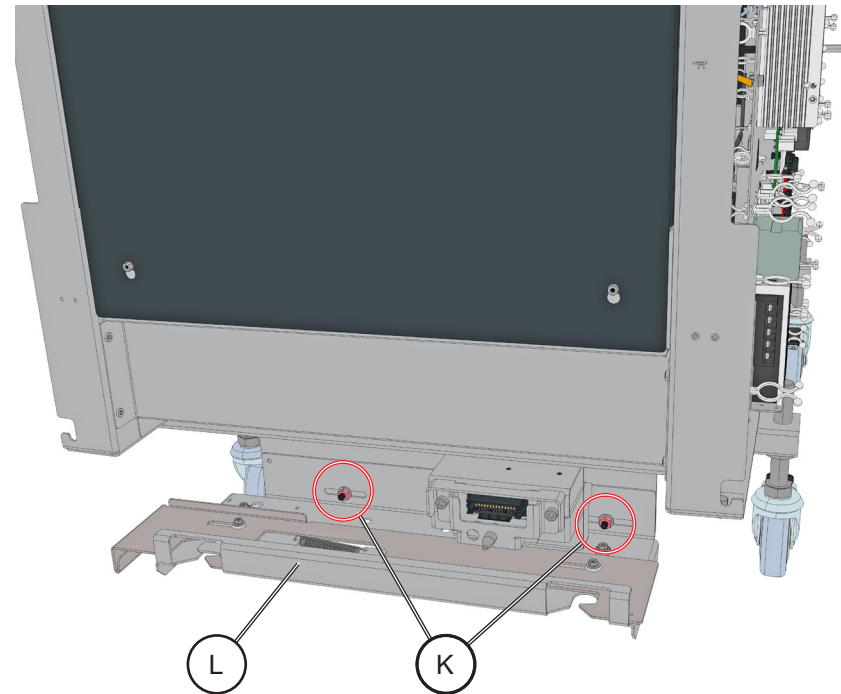
15. Check that sheets are entering centred in the BM side guides [G]. If not, the position of the Booklet Maker must be adjusted, see next page.

A. If an RCT is installed to the Booklet Maker, adjust the RCT exit docking bracket as follows.



- Undock the Booklet Maker from the RCT.
- On the RCT Exit docking bracket, loosen screws [I].
- Adjust Exit Docking Bracket [J] to achieve tolerance.
- Tighten screws and dock Booklet Maker to the RCT. Repeat calibration procedure and continue adjusting RCT exit docking bracket until alignment is correct.

B. If the Booklet Maker is connected directly to the Upstream Device, adjust the In-Feed Docking Bracket on the Booklet Maker.



- Undock the Booklet Maker from the Upstream Device.
- On the BM In-Feed Docking Bracket, loosen screws [K] (2x).
- Adjust the BM In-Feed Docking Bracket [L] to achieve tolerance.
- Tighten screws and dock Booklet Maker to the Upstream Device. Repeat calibration procedure and continue adjusting the BM In-Feed Docking Bracket until alignment is correct.

2.13.2 Adjusting/checking the RCT bleed trim

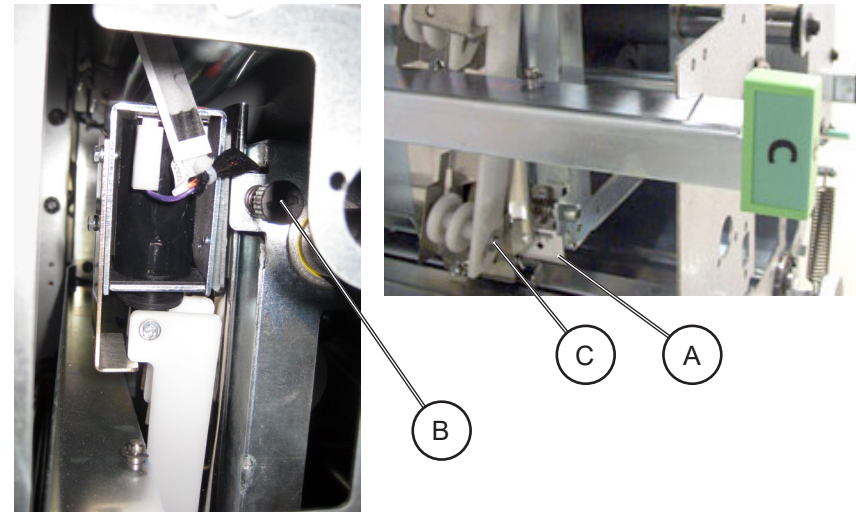
⚠ WARNING

Do not expose fingers or other parts of the body to moving, rotating or cutting devices when running the machine with the interlock cheater installed. Do not wear ties, lanyards or other things that might get trapped into the rollers and cause injuries.

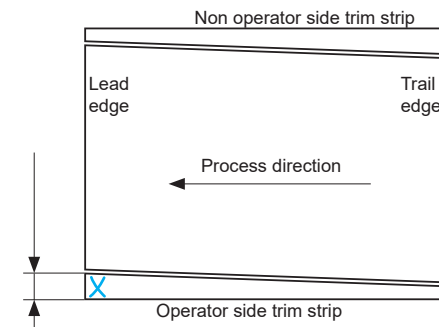
Purpose is to adjust RCT bleed trimmer registration angle in order to ensure a parallel cut.

1. Note indication on reference scale [A]. Turn adjustment screw [B] counter clockwise 1,5 - 2 turns. Make sure adjustment is reflected on reference scale [A]. If not, push at [C]. Purpose is to make Operator side trim strip lead edge wider than trail edge and also take up any slack.
2. In the UI, press [Booklet Size].
3. Press [Custom Booklet Size].
4. Press [Edit].
5. Set width to 297,0 mm/11.000" and press the green check-mark. You can see that you will receive booklets 297 mm / 11" high.
6. Press [OK]. You can now see that the SRA3 / 12 x 11" sheets will have a Bleed Trim of 11,5 mm/0.500" on each side.
Booklet maker setup should read:
Paper Size: SRA3 or 12 x 18"
Face Trim: 0,0 mm or 0.000"
Bleed Trim: **11,5 mm or 0.500"**
Staple: ON
Cover: OFF
Book Fold: OFF
Fold position: AUTO
Crease: Status: OFF, Offset: -
7. Make sure that you after run can identify lead edge of Operator side trim strip from RCT. Marking sheets is one solution.
8. Using 80 gsm / 20 lb Bond sheets, send five sets of 2 sheet SRA3 / 12 x 18" (2 sheets of SRA3 / 12 x 18" equals a booklet containing 8 pages) to the Booklet Maker system.
9. Compare Operator side trim strip lead edge and trail edge. Operator Side trim strip lead edge should now be wider than trail edge. If not, repeat step 1, 7 - 8.

10. Turn adjustment screw [B] clockwise and send five more sets of 2 sheet SRA3 / 12 x 18".
11. Compare Operator Side trim strip lead edge and trail edge. Repeat step 10 - 11 until Operator Side trim strip have the same width in both lead and trail edge. Trimmer cut is now parallel to registration (Operator Side) edge.
12. Check that the actual sheet width corresponds to sheet width set in [Custom booklet size] ± 0.5 mm / 0.02".
If not, this is a Booklet Quality issue. Not an Installation issue.
To correct this, a trained service technician and a service manual is needed. Make a note of this issue and pass it on to a trained service technician.



Turn adjustment screw clockwise to remedy this misalignment



NOTE!

Sheets may show wrinkles in the process direction if adjustment is set too tight. Turn adjustment screw counter clockwise until wrinkles disappear.

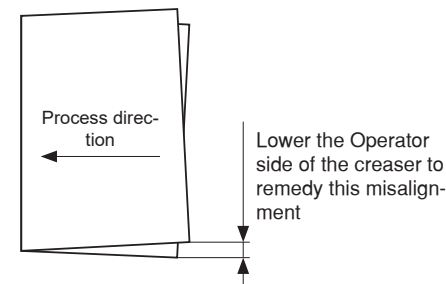
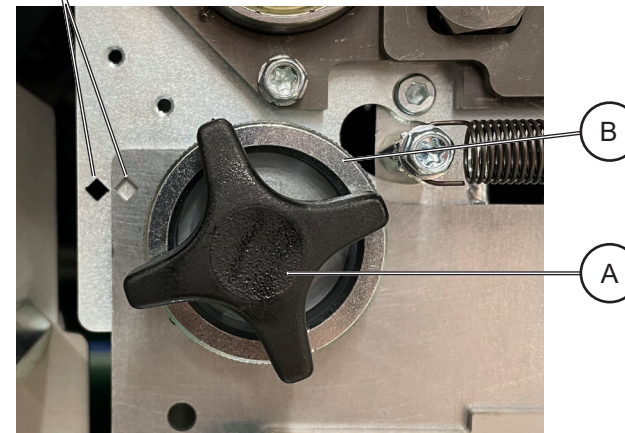
2.13.3 Checking the RCT crease

⚠ WARNING

Do not expose fingers or other parts of the body to moving, rotating or cutting devices when running the machine with the interlock cheater installed. Do not wear ties, lanyards or other things that might get trapped into the rollers and cause injuries.

1. In the UI, press [Crease].
2. Turn on and select [Fine].
3. Press the green checkmark.
Booklet maker setup should read:
Paper Size: SRA3 or 12 x 18"
Face Trim: 0,0 mm or 0.000"
Bleed Trim: 11,5 mm or 0.500"
Staple: ON
Cover: OFF
Book Fold: OFF
Fold position: AUTO
Crease: Status: **ON**, Offset: **0,0mm / 0.000"**
4. Using 120 gsm / 32 lb Bond sheets, send five sets of 1 sheet SRA3 / 12 x 18" to the Booklet Maker system.
5. Repeat check selecting [Coarse] in the Crease settings and using sheets of 220 gsm / 80 lb Cover.
6. Check that crease is perpendicular to the registration (Operator Side) edge. If not, loosen star shaped knob [A]. Turn knurled eccentric [B] to move reference mark in desired direction. Tighten star shaped knob [A]. Repeat step 4 - 6 until crease is perpendicular to registration (Operator Side) edge.
7. Check that the distance from the lead edge to the crease is half the sheet length according to [Paper Size] i.e. 225 mm / 9" \pm 0.5 mm / 0.02" on both Non Operator Side and Operator Side edge.
If not, this is a Booklet Quality issue. Not an Installation issue.
To correct this, a trained service technician and a service manual is needed. Make a note of this issue and pass it on to a trained service technician.

Reference marks



2.13.4 Checking the Booklet Maker

⚠ WARNING

Do not expose fingers or other parts of the body to moving, rotating or cutting devices when running the machine with the interlock cheater installed. Do not wear ties, lanyards or other things that might get trapped into the rollers and cause injuries.

1. Open the Booklet maker top cover and install an interlock cheater to be able to run the Booklet maker with the top cover open.
2. Set up the Booklet maker to:
Paper Size: SRA3 or 12 x 18"
Face Trim: 0,0 mm or 0.000"
Bleed Trim: 0,0 mm or 0.000"
Staple: ON
Cover: OFF
Book Fold: OFF
Fold position: AUTO
Crease: Status: **OFF**, Offset: 0,0 mm / 0.000"
3. Using 80 gsm / 20 lb Bond sheets, send five sets of 2 sheet SRA3 / 12 x 18" (2 sheets of SRA3 / 12 x 18" equals a booklet containing 8 pages) to the Booklet Maker system.
4. Using 80 gsm / 20 lb Bond sheets, send five sets of 20 sheet A3 / 11 x 17" (20 sheets of A3 / 11 x 17" equals a booklet containing 80 pages) to the Booklet Maker system.
5. Set up the Booklet maker to:
Paper Size: SRA4 or 12 x 18"
Face Trim: 0,0 mm or 0.000"
Bleed Trim: 0,0 mm or 0.000"
Staple: ON
Cover: OFF
Book Fold: OFF
Fold position: AUTO
Crease: Status: OFF, Offset: 0,0 mm / 0.000"
6. Using 80 gsm / 20 lb Bond sheets, send five sets of 2 sheet A4 / 8.5 x 11" (2 sheets of A4 / 8.5 x 11" equals a booklet containing 8 pages) to the Booklet Maker system.
7. Using 80 gsm / 20 lb Bond sheets, send five sets of 20 sheet A4 / 8.5 x 11" (20 sheets of A4 / 8.5 x 11" equals a booklet containing 80 pages) to the Booklet Maker system.

8. Check that the booklets are stapled and folded at the middle of the sheets.
If not, this is a Booklet Quality issue. Not an Installation issue.
To correct this issue, a trained service technician and a service manual is needed. Make a note of this issue and pass it on to a trained service technician.
9. Remove the interlock cheater and put it back to its original place.

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2.13.5 Checking the Folder in the Finishing Module

WARNING

Do not expose fingers or other parts of the body to moving, rotating or cutting devices when running the machine with the interlock cheater installed. Do not wear ties, lanyards or other things that might get trapped into the rollers and cause injuries.

1. In the UI, press [SquareBack].
2. Press [Auto].
3. Press the green check-mark.
4. Press [Crease].
5. Press [AUTO]
6. Press [OK]
Booklet maker setup should read:
Paper Size: SRA3 or 12 x 18"
Face Trim: 0,0 mm or 0.000"
Bleed Trim: 11,5 mm or 0.500"
Staple: ON
Cover: OFF
Book Fold: Status: **ON**, Mode: **Auto**
Fold position: AUTO
Crease: Status: **AUTO**, Offset: 0,0 mm / 0.000"
7. Using 80 gsm / 20 lb Bond sheets, send five sets of 2 sheet SRA3 / 12 x 18" (2 sheets of SRA3 / 12 x 18" equals a booklet containing 8 pages) to the Booklet Maker system.
8. Check that the booklet cover **does have** a crease and that the booklets **do not have** a Book Folded spine.
9. Send five sets of 10 sheet SRA3 / 12 x 18" (10 sheets of SRA3 / 12x 18" equals a booklet containing 40 pages) to the Booklet Maker system.
10. Check that the booklet cover **do not have** a crease and that the booklets **do have** a Book Folded spine.

2.13.6 Checking the Trimmer in the Finishing Module

WARNING

Do not expose fingers or other parts of the body to moving, rotating or cutting devices when running the machine with the interlock cheater installed. Do not wear ties, lanyards or other things that might get trapped into the rollers and cause injuries.

1. In the UI, press [Booklet Size].
2. Press [Custom Booklet Size].
3. Press [Edit].
4. Set length to 210,0mm / 8.500" and press [OK]. You can see that you will receive booklets 297mm / 11" high and 210 mm / 8.5" wide.
5. Press [OK].
You can now see that the SRA3 / 12 x 11" sheets will have a Bleed Trim of 11,5 mm / 0.500" on each side and Face Trim of 15,0mm / 0.500.
Booklet maker setup should read:
Paper Size: SRA3 or 12 x 18"
Face Trim: **15,0 mm** or **0.500"**
Bleed Trim: 11,5 mm or 0.500"
Staple: ON
Cover: OFF
Book Fold: Status: ON, Mode: Auto
Fold position: AUTO
Crease: Status: ON, Offset: 0,0mm / 0.000"
6. Using 80 gsm / 20 lb Bond sheets, send five sets of 2 sheet SRA3 / 12 x 18" (2 sheets of SRA3 / 12 x 18" equals a booklet containing 8 pages) to the Booklet Maker system.
7. Check that the booklets are trimmed and 210,0 mm / 8.500" wide.

2.13.7 Reinstalling the Interlock Cheaters

Remove all interlock cheaters and reinstall them in the Booklet Maker.

