Plockmatic PBM5035s/5050s Booklet Maker - Offline

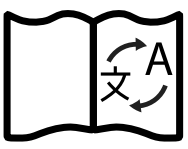
Operator Manual



Read this manual carefully before you use this product and keep it handy for future reference.
For safety, please follow the instructions in this manual.

Doc no: T10261_EN_A PBM5000s
Date: 23 September 2026





Scan the QR code to access translated versions of this manual in German, Italian, French, and Spanish.

Visit https://plockmaticgroup.com/plockmatic/product/pbm5000-series/ to view the manual in your preferred language.

Introduction

This manual contains instructions on the operation and maintenance of this machine. To get maximum versatility from this machine all operators should carefully read and follow the instructions in this manual. Keep this manual in a handy place near the machine.

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.

A QR code is shown when there is an instructional video available. To watch the video, on your mobile device:

1. Open the Camera app.
2. Hold your device so that the QR code appears in the viewfinder in the Camera app. Your device recognizes the QR code and shows a notification.
3. Tap the notification to open the link associated with the QR code.

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 tor 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.**

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.**

continued on next page

Safety during operation, continued

⚠ WARNING

- **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.*

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.*

continued on next page

Safety Information, continued

Description of Safety/Warning labels in the product

1



Crushing Hazard
Risk for crushing or squeezing body parts.

2



Cutting Hazard
Sharp objects inside machine.

3



Entanglement Hazard
Risk for loose hanging hair, jewelry, or clothes to get caught.

4



Hazardous Voltage
High voltage inside machine.

5



Do Not Step
A surface of the machine not to step/stand upon.

6



Hot Surface
Do not touch with bare hands.

7



Protective gloves
Protective gloves must be worn.

8



Hearing Protection
Hearing Protection must be worn.

9



Tight clothes
Tight clothes must be worn.

10



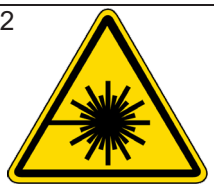
Earth / Ground
Always ground the equipment.

11



Warning / Caution
Indicates a generic warning or caution.

12



Laser Hazard
Laser beam: do not stare into beam.

13



Tropical conditions
Use only in non-tropical conditions.

14



Pinch Point Hazard
Risk for pinching or squeezing body parts.

15



Respirator mask
Respirator mask, suitable for removing used glue, must be worn.

16



Earth continuity
Shows earth connection point. A separate earth connection needs to be fitted during installation.

17



Read user or service manual
Do not operate unless you have read and understood the user manual. Refer to service manual for more information.

18



Altitude
Do not use at altitudes over 2000m above sea level.

19



High touch current
Follow specific instructions in install manual.

20



Tilt hazard
The equipment might tip over under certain cirtumstances.

21



UV Light Hazard
UV lights can cause skin burns, eye damage, including permanent blindness and skin cancer.

22



Scandinavian Earthing Label
Connect equipment only to an earthed (grounded) outlet.

23



Eye protection
Eye protection, against possible splashes of glue, must be worn.

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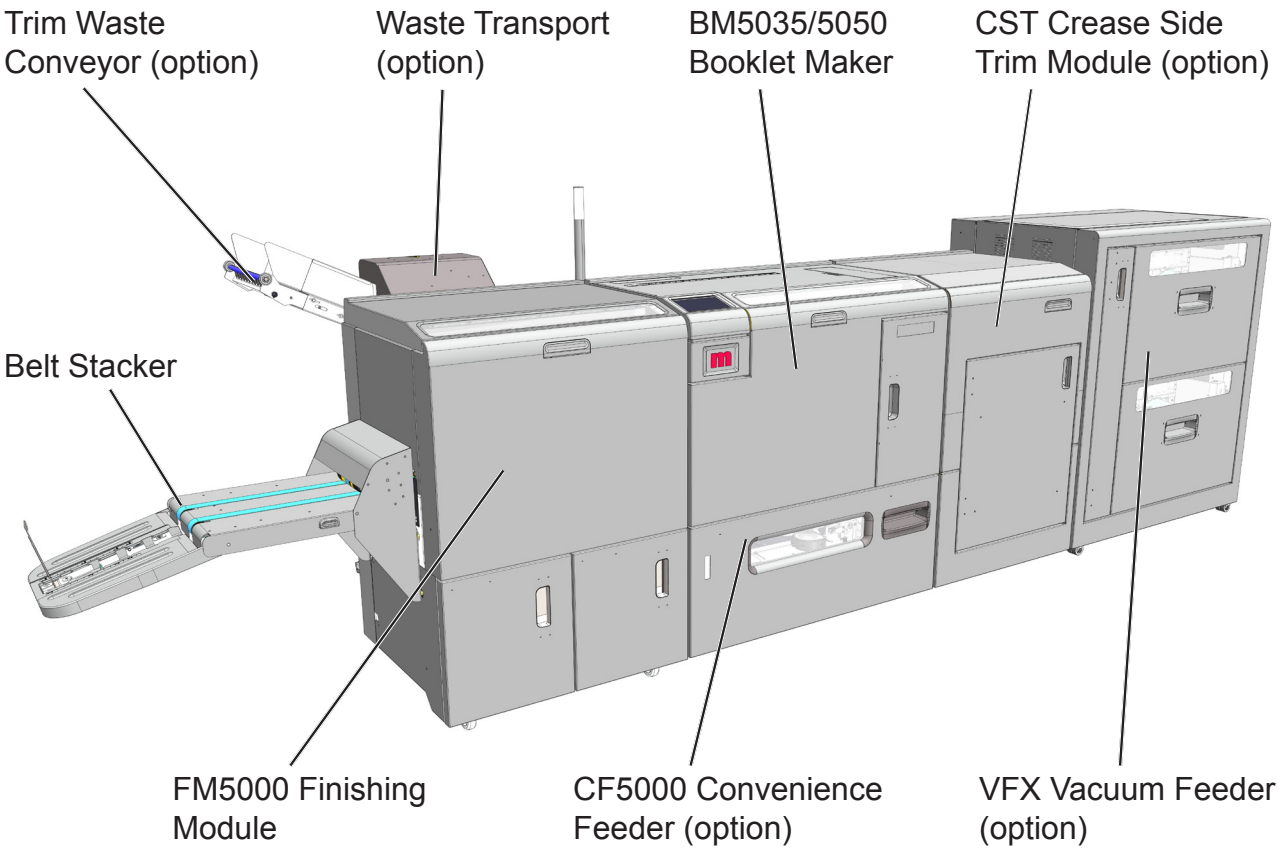
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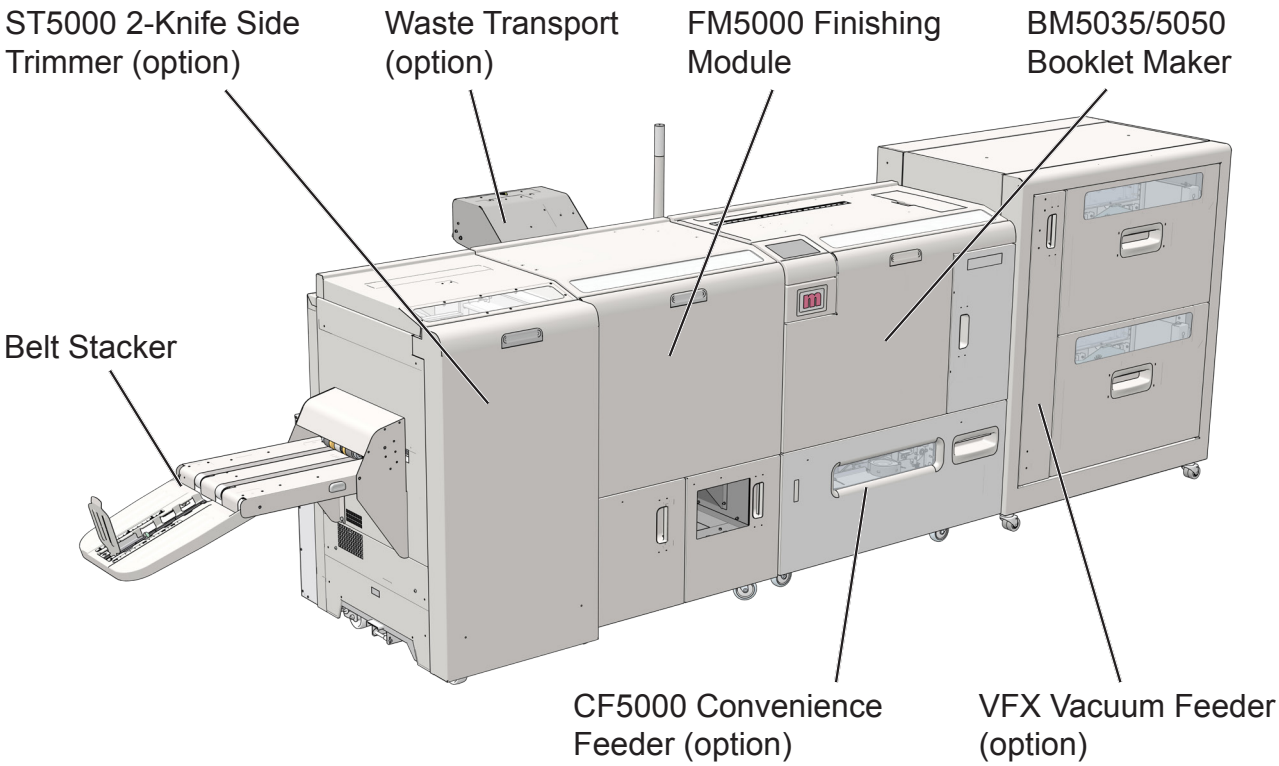
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What You Can Do With This Machine





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The Plockmatic BM5050s or BM5035s Booklet Maker System can consist of:
VFX Vacuum Feeder (optional) a two tray high capacity vacuum feeder, also referred to as the VFX or the external Feeder

- **CST 3.0 Crease Side Trim Module** (optional), also referred to as the CST Module or the CST
- **BM5050s or BM5035s Booklet Maker**, also referred to as the BM5050s/BM5035s, the Booklet Maker or the BM
- **CF5000 Convenience Feeder** (optional), also referred to as the Feeder
- **ST5000 Side Trimmer** (optional)**,** a 2-knife side trimmer, also reffered to as the Side Trimmer or the ST
- **Waste Transport** (optional), also referred to as the WT
- **FM5000 Finishing Module,** also referred to as the Finishing Module or the FM
- **Trim Waste Conveyor** (optional), also referred to as the TWC
- **BST4000-1 Belt Stacker Module** (optional), also referred to as the BST Module or the BST

Together they can form a system that allows full bleed booklet making. The BM5050 upgrade kit raises the capacity of the BM5035 Booklet maker from 35 sheets to 50 sheets. This means that instead of 140 page booklets, 200 page booklets are now possible.

The optional VFX contains two vacuum fed paper trays which allows for custom sequencing of sheets from three different sources (the two trays in the VFX and the optional Convenience Feeder in the Booklet Maker. From the VFX the sheets are fedinto either the optional CST or directly into the BM5050 or BM5035 Booklet Maker where they are compiled in the stapler area.

In order to avoid toner cracking at the spine when folded, the CST can be programmed to crease the cover sheet. The CST can also trim the long sides (head and foot) of the booklet sheets to deliver booklets in the desired size.

From the CST, the sheets are transported into the BM5050s or BM5035s Booklet Maker where they are compiled in the stapler area.

If a CF5000 Convenience Feeder is installed in the Booklet Maker, it can add any type of cover, sheet or centerfold, in colour or black and white, to the set. The Booklet Maker jogs and staples the set. There are three types of stapling that can be selected.

Saddle Staple

The set is then transported further into the Booklet Maker to the folding area where the set is folded into a booklet and delivered to the attached Finishing Module. The Finishing Module contains a SquareFold Module and a Face Trimmer.

The stapled and folded books will first enter the SquareFold Module where the spine of the booklets are flattened square. The booklets will now have the look of a perfect bound book. The booklets are then fed into the Face Trimmer.
When a larger number of sheets are folded, an effect called creeping occurs. In order to eliminate creep, the front edge can be cut off in the Face Trimmer. The Face Trimmer combined with an CST Module in front of the Booklet Maker allows the possibility to create full bleed booklets.

An alternative method to create full bleed saddle stapled booklets is to install the optional ST5000 2-Knife Side Trimmer after the Finishing Module. The ST5000 trims the head and foot of the booklets before they are fed onto the belt stacker.

To allow longer, unattended runs there is an optional high capacity belt stacker available. The BST4000-1 Belt Stacker Module will stack up to 1000 A4 or 8.5 × 11″ booklets of 4 pages.

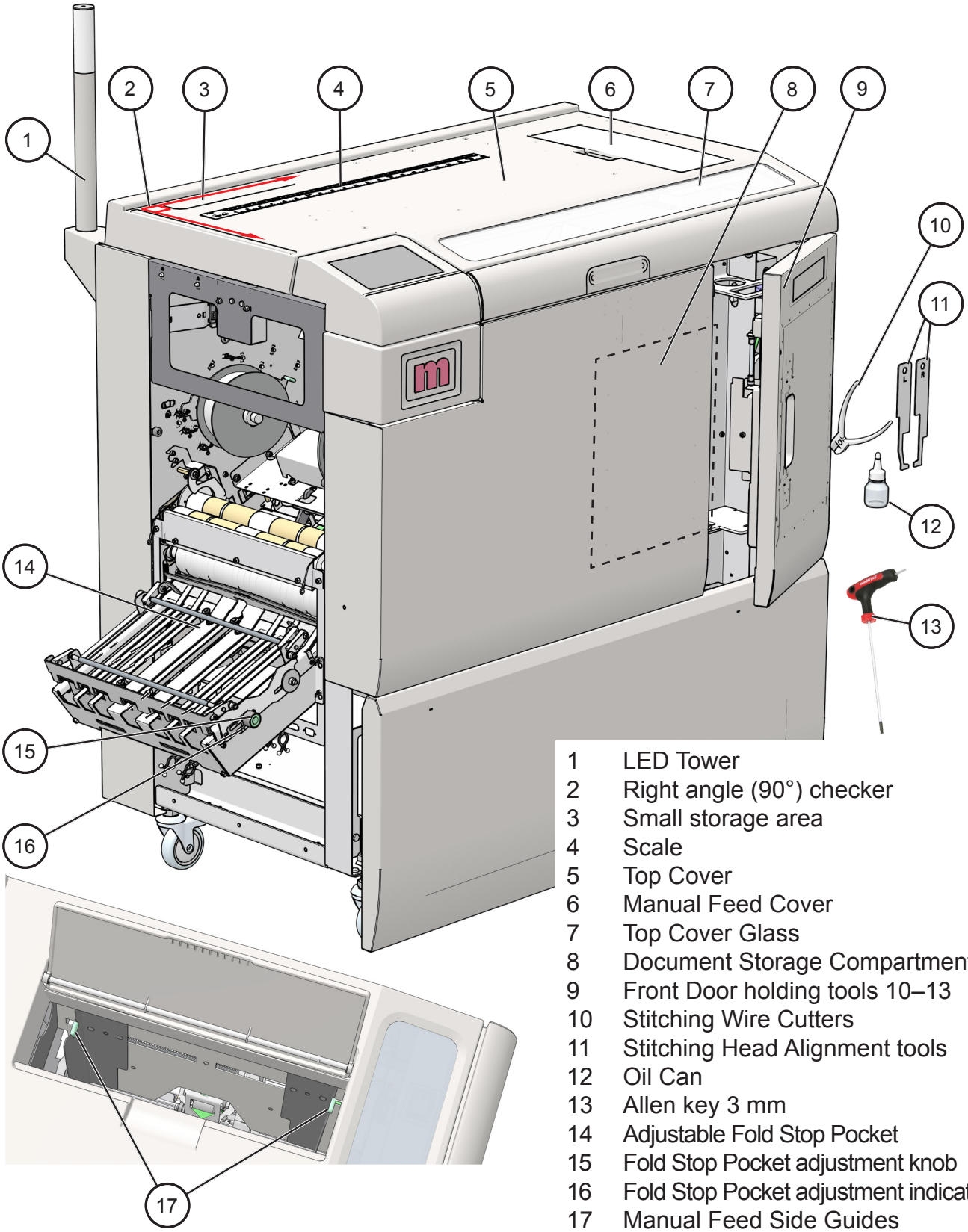
Edge and Corner Staple
After the sets have been stapled in the Booklet Maker, they are fed to the stacker integrated in the Finishing Module.

NOTE:
Edge and corner stapling capability might not be available on all systems.

Guide To Components

Booklet Maker

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.

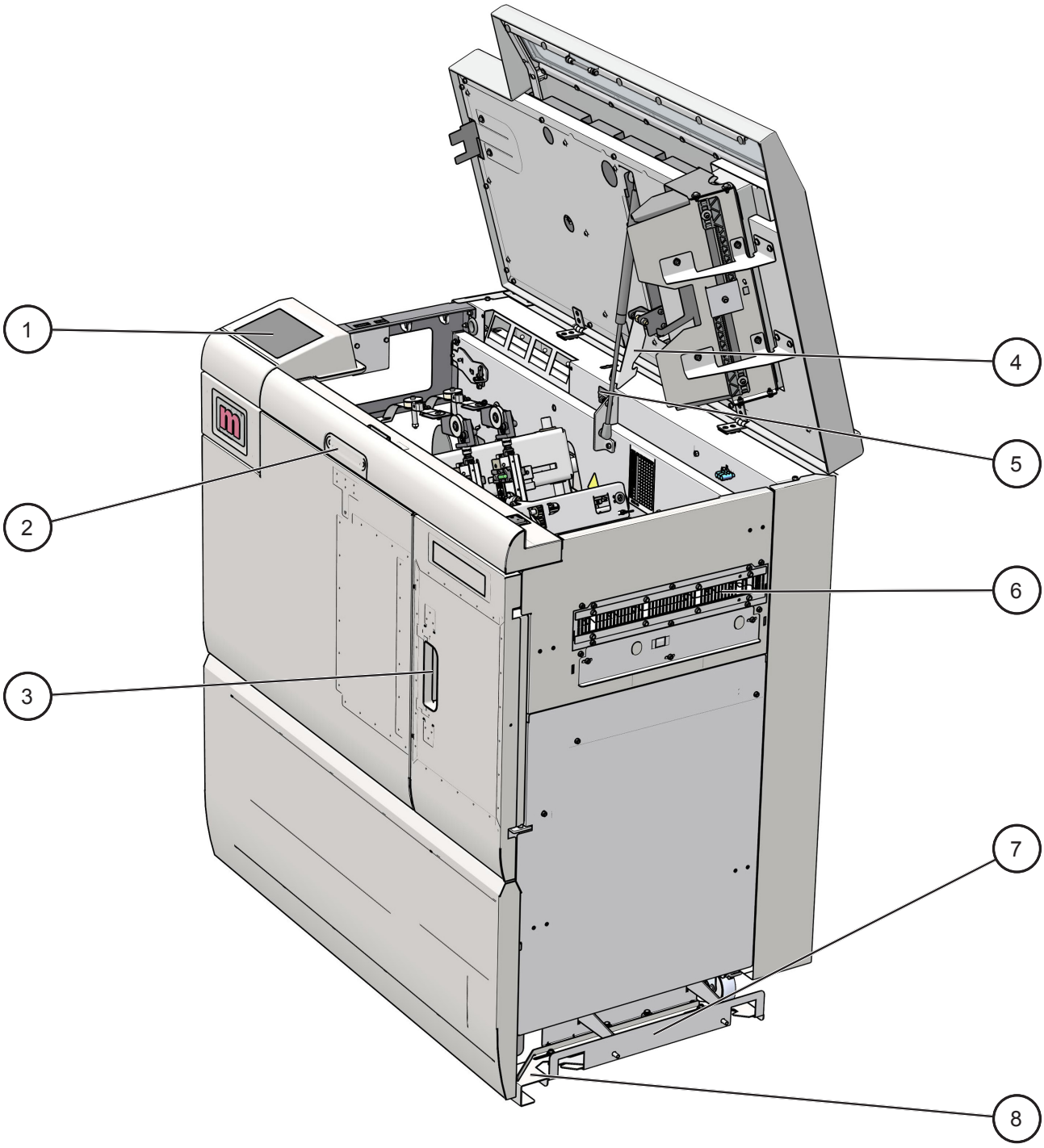


1 LED Tower
2 Right angle (90°) checker
3 Small storage area
4 Scale
5 Top Cover
6 Manual Feed Cover
7 Top Cover Glass
8 Document Storage Compartment
9 Front Door holding tools 10–13
10 Stitching Wire Cutters
11 Stitching Head Alignment tools
12 Oil Can
13 Allen key 3 mm
14 Adjustable Fold Stop Pocket
15 Fold Stop Pocket adjustment knob
16 Fold Stop Pocket adjustment indicator
17 Manual Feed Side Guides

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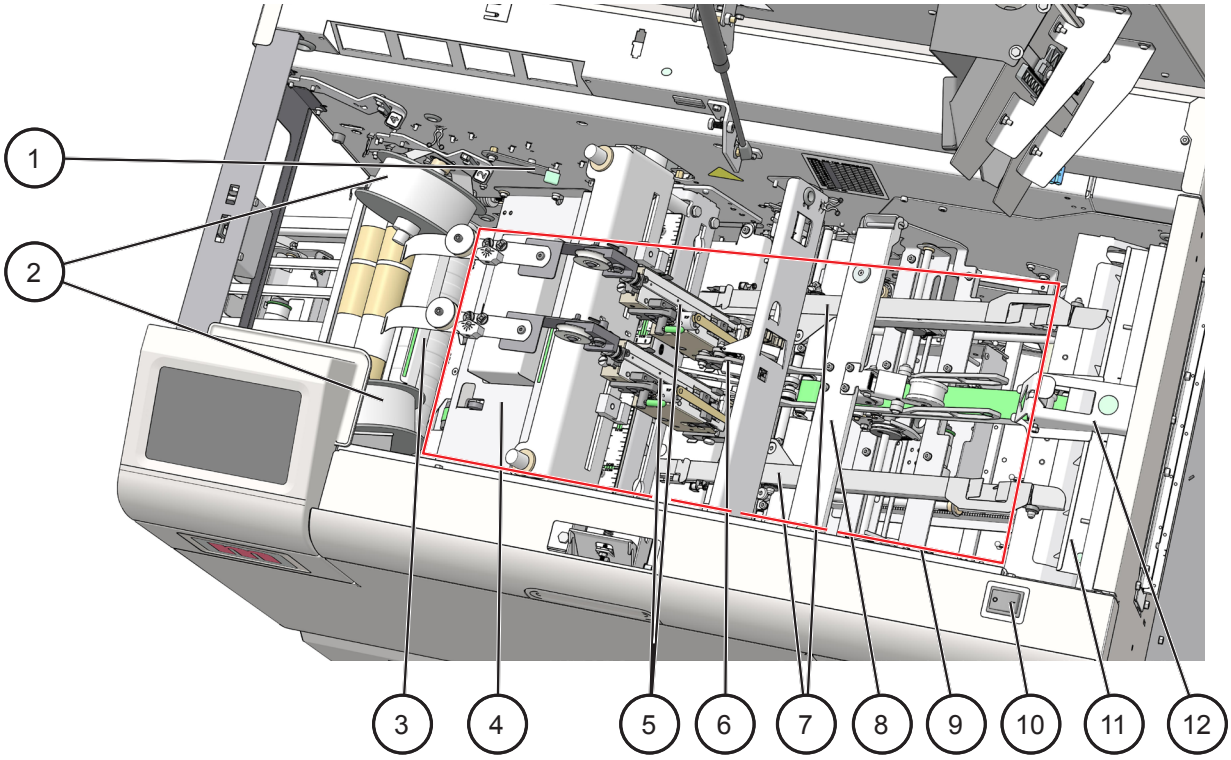
Booklet Maker, continued

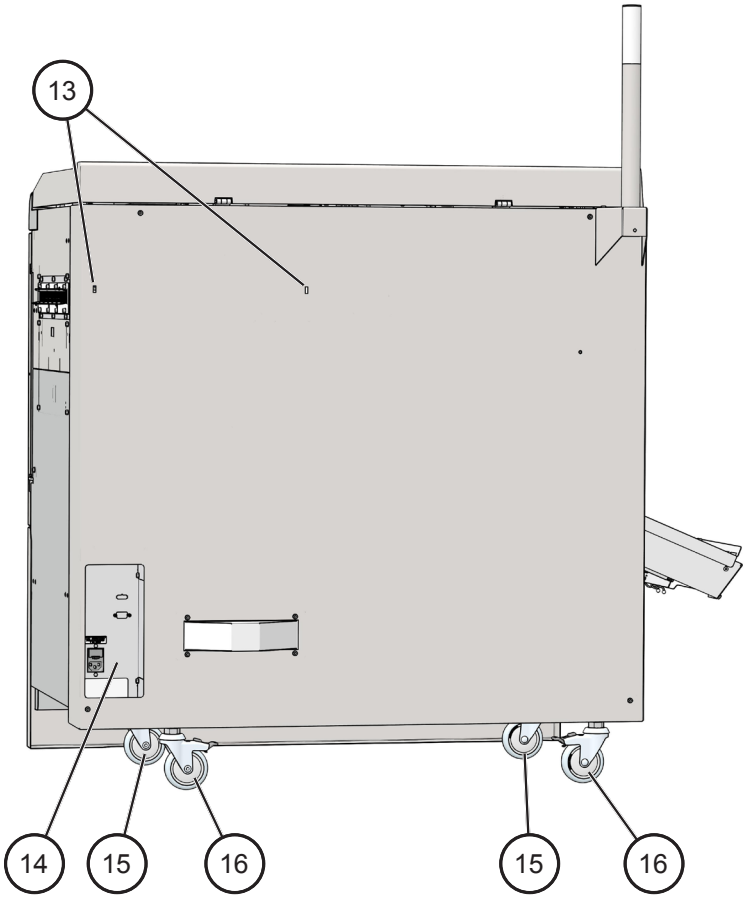
Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.



1	User Interface	5	Counter
2	Top Cover Latch Handle	6	Infeed Area
3	Front Door Latch Handle	7	Upstream Docking assembly, CST
4	Top Cover Opening Limiting device (disengaged)	8	Docking Latch

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.



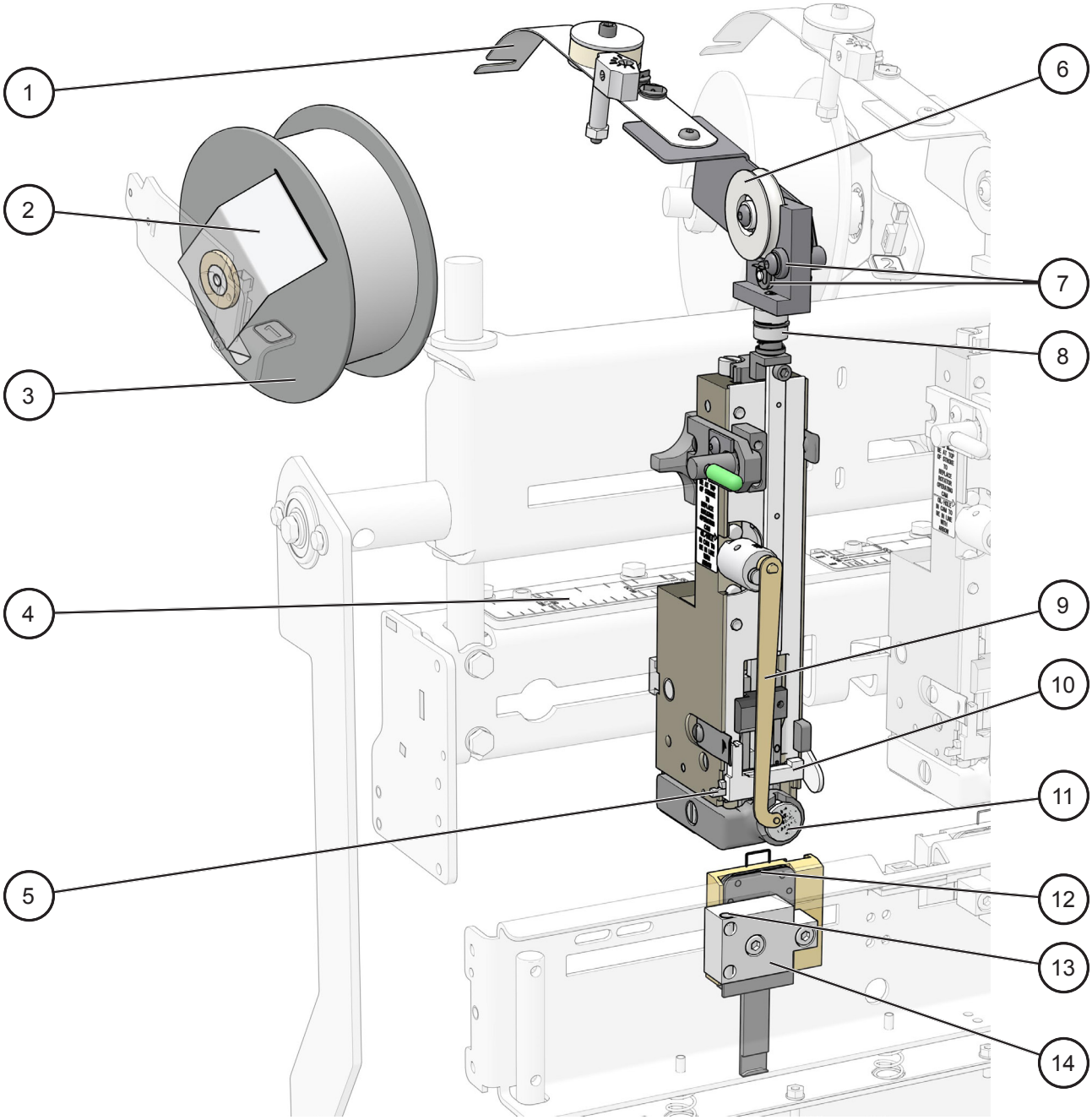


1 Paper Transport Latch
2 Wire Spools
3 Fold Roller Paper Guide
4 Paper Transport
5 Stitching Heads
6 Set thickness sensor
7 Side Joggers
8 Back Jogger Beam
9 Compiler area (red color)
10 Main power switch
11 Upper Infeed Paper Path
12 Infeed Roller assembly
13 Holes for hanging the Manual Feed Tray (optional)
14 Connections
15 Operator Side Casters, no brakes
16 None Operator Side Casters, with brakes

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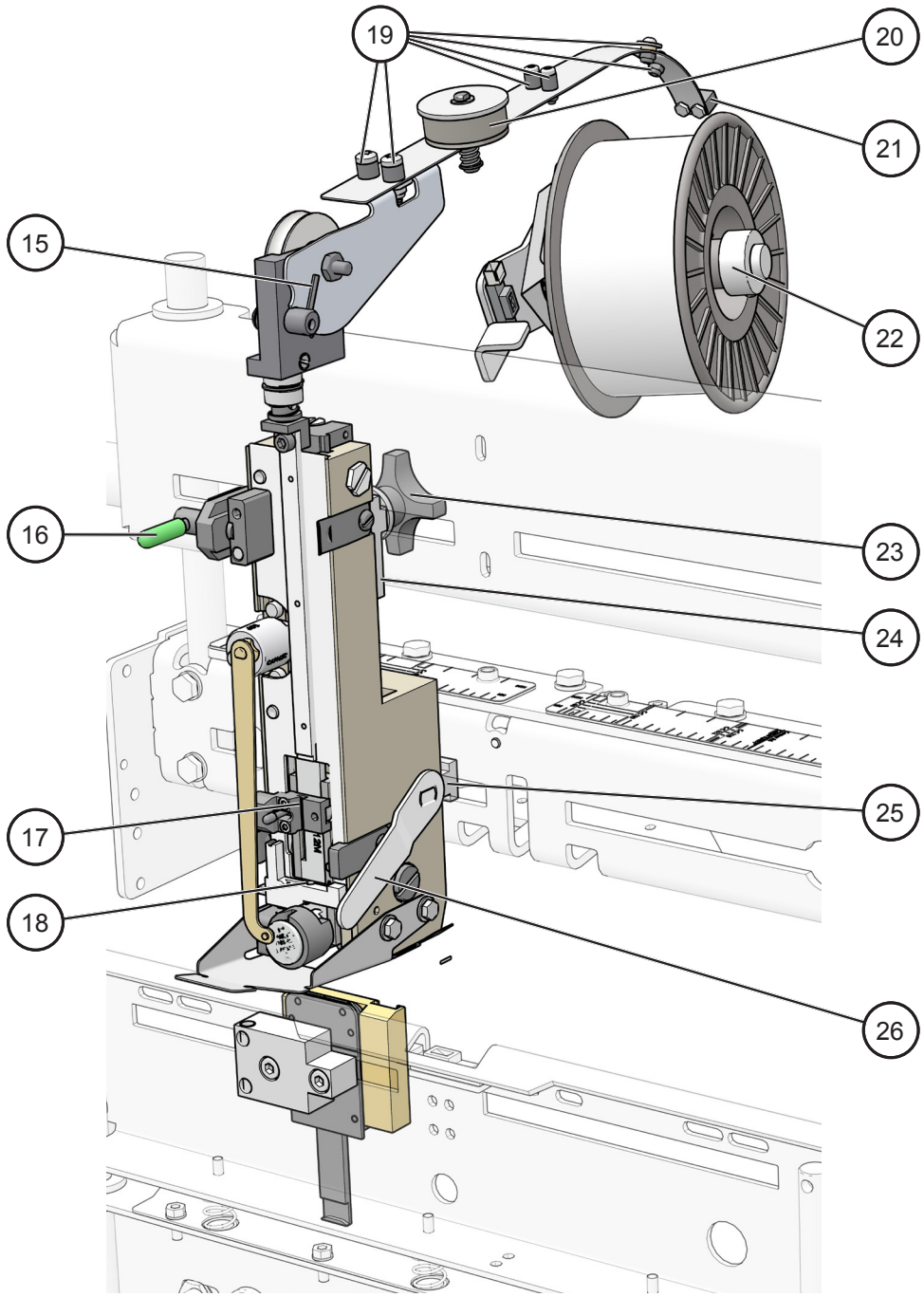
Booklet Maker, continued

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.



1	Wire Guide Spring assy	8	Check Pawl Collar
2	Wire Spool Spring	9	Rotator Operator Spring
3	Wire Spool	10	Face Plate assy
4	Stitching Head positioning scale	11	Magnetic Rotator
5	Cutter	12	Clincher
6	Wire Guide Pulley	13	Clinch Lock Set Screw
7	Straigthening Rollers	14	Clinch Lock

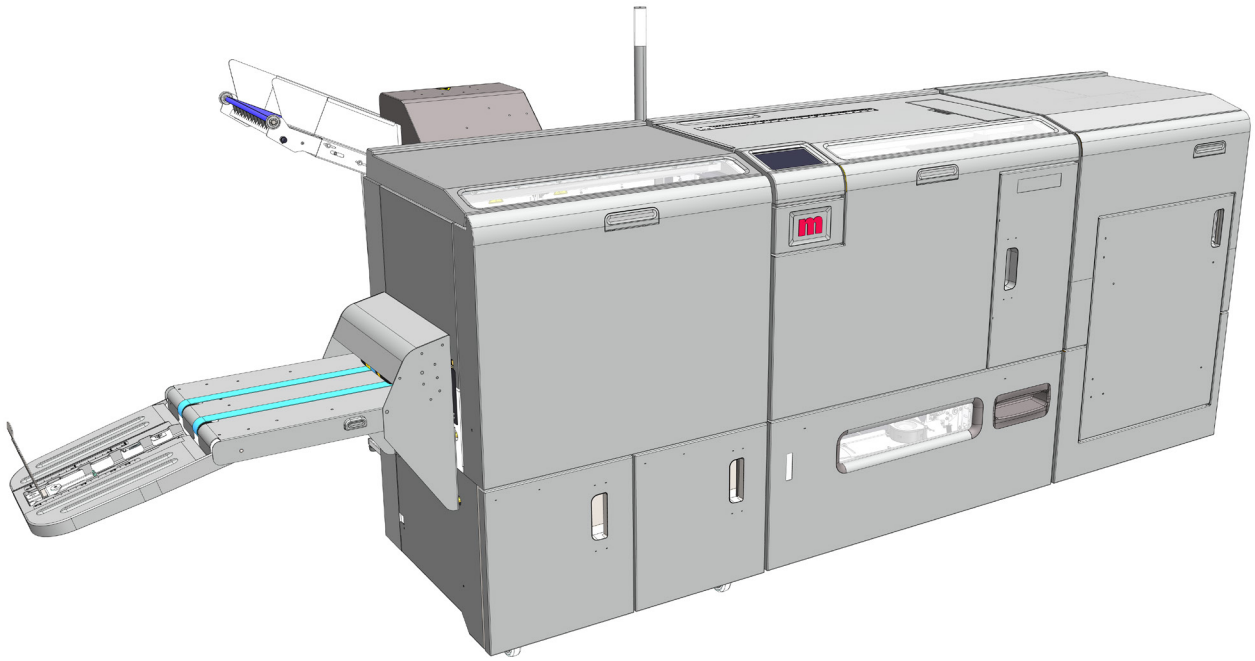
Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.



15 Threading Lever
16 Wire Draw Adjuster Lever
17 Gripper
18 Hole in Face Plate assy
19 Wire Guide Spring Rollers
20 Felt Pads
21 Thread Guide Block
22 Set Collar
23 Star Knob
24 Stitching Head Clutch
25 Bonnet Clamp Block
26 Bonnet Clamp Eccentric Handle

Booklet Maker, continued

LED Tower



LED Tower
The LED Tower behind the Booklet Maker makes the state of the system visible from a distance. They will signal status as follows:

Not illuminated - System is off, in power save mode or is cycling down.

Steady blue - System is on and cycling up or is in production.

Steady red - Jam or malfunction.

Steady yellow - Soft stop (staples low, cover low, stacker full, waste bin full) or preparing to receive next set when in Manual Feed Mode.

Steady green - Ready to receive next set when in Manual Feed Mode.

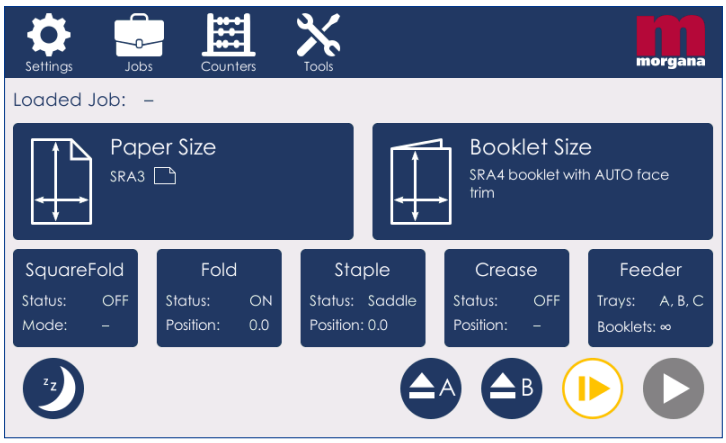
User Interface

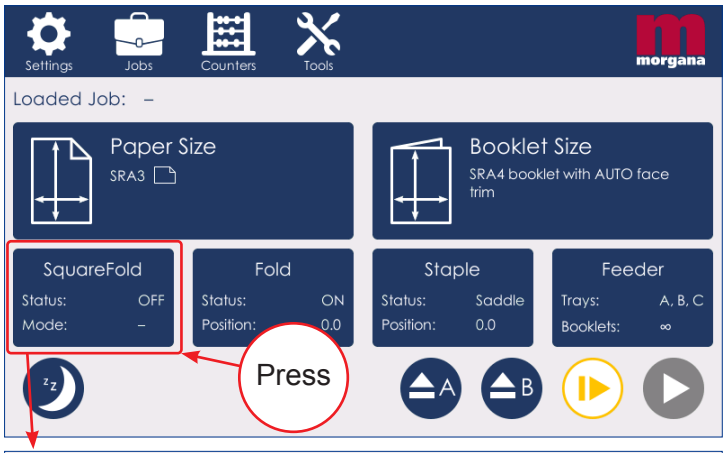
The Plockmatic 5050s or 5035s Booklet Maker System is controlled from a panel located on the Booklet Maker. The User Interface will allow you to set up, adjust and operate the complete system.

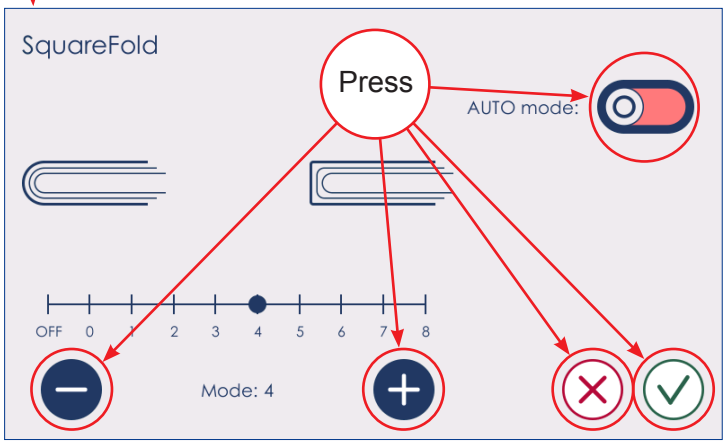
NOTE:
Depending on features installed, the screen may look different from what you see here. Some functions are disabled (grayed out or not visible at all) and remaining buttons may stretch to fit the screen. This manual will most often show a fully configured system.

User Interface

The User Interface is of resistive touch screen type. Point at the screen and press the "button" to reach the desired function or change the desired setting.







The Start Screen

When the system power is switched on, the Start screen will be shown. From here you can reach all detailed Settings needed to set up a job, perform a Guided Start, retrieve stored Jobs, check Counters or access the Tools menu.
The Start Screen adapts to the system setup. This upper screenshot shows a system including an CST

This lower screenshot shows a system without an CST. In this case, the possibility to set the Crease is removed.

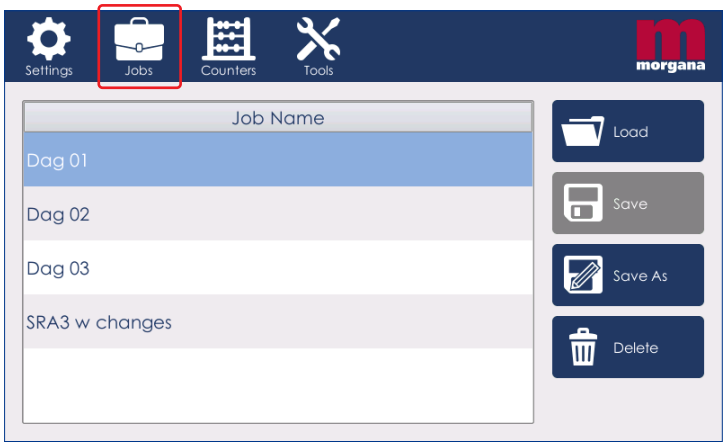
Pressing, for example, the [SquareFold] button in the Start screen opens the SquareFold Settings sub screen.

Detailed Settings

Press the switch symbol for On or Off and the plus or minus symbol to change value/setting. Confirm your changes by pressing the green check mark button or exit without making any changes by pressing the red X. Explore this and other settings more thoroughly in section 2, "Making Booklets".

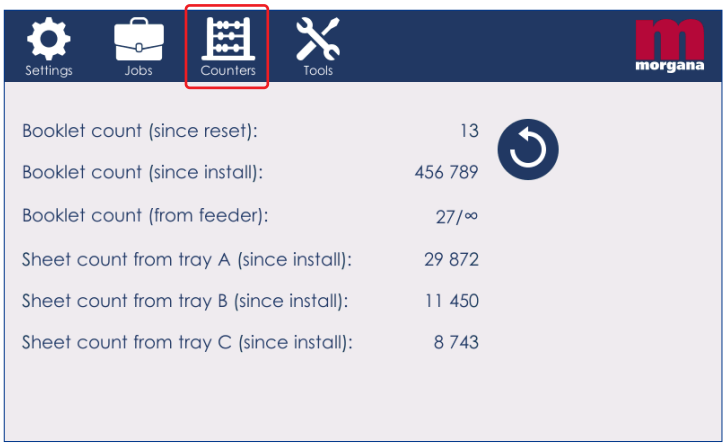
continued on next page

User Interface, continued



The Jobs Screen

Pressing the [Jobs] button in the Start screen opens the Jobs screen. From here you can open a saved job. Jobs can be stored, deleted, customized etc. Handling jobs is described in section 4, “Jobs”.



The Counter Screen

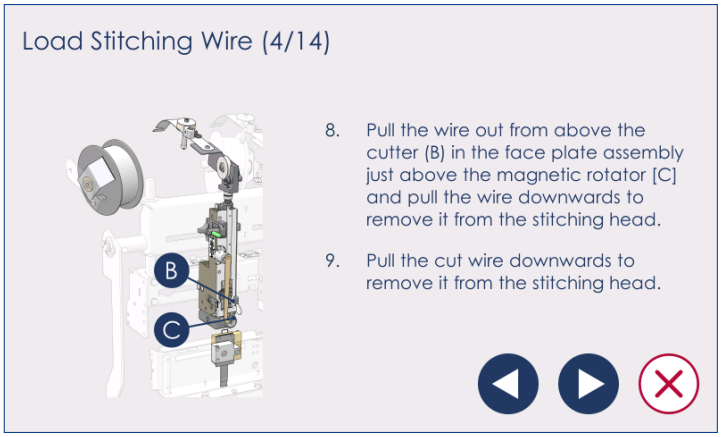
Pressing the [Counters] button in the Start screen opens the Counters screen.



The Guides Screen

Pressing the [Guides] button opens the Guides screen.

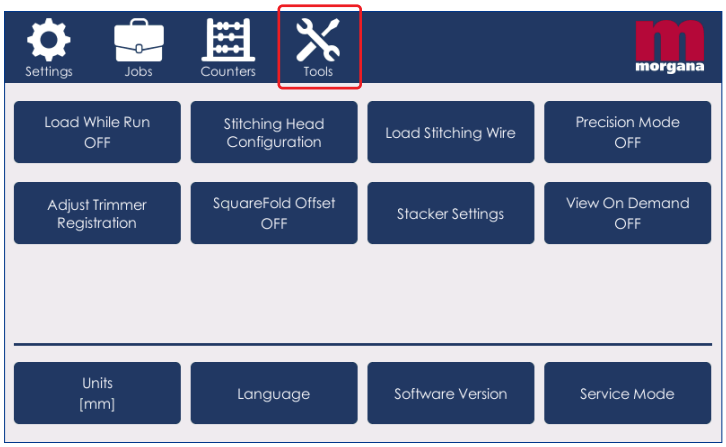
Add Guides screen to log file



From here you can press the [Load Stitching Wire] button for a step by step instruction how to replace the stitching wire.

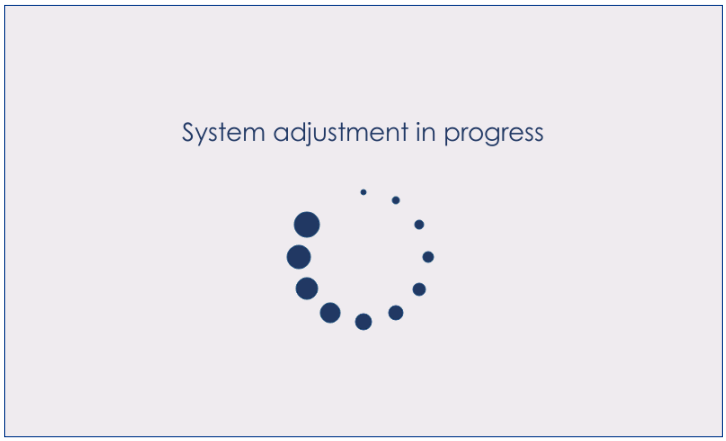
continued on next page

User Interface, continued



The Tools Screen

Pressing the [Tools] button opens the Tools screen. From here you can change basic settings like the display language, setting units from millimeters to inches and more. See section 3, ”Tools” for how to work with the Tools screen.



The System adjustment screen

While the machine sometimes needs time to perform changes in settings, the Please wait screen will be shown.



Power save mode

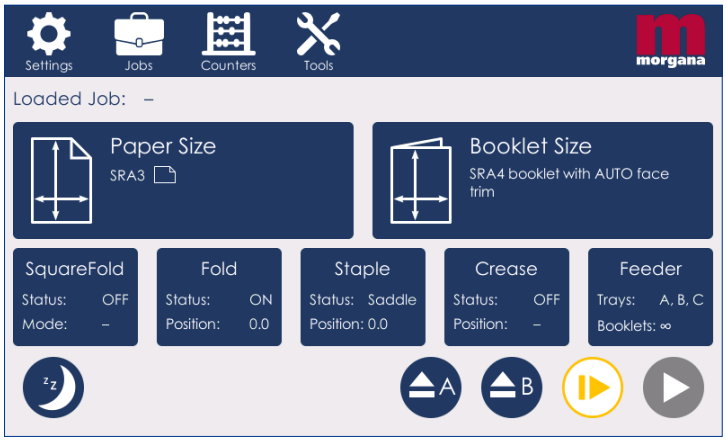
When the Booklet Maker System is in a ready state, it will enter power save mode after 20 minutes of inactivity.

To recover from Power save mode, touch the screen or send a print job to the Booklet Maker System.

When the Booklet Maker system is processing or when there is a jam state it will not enter power save mode.

continued on next page

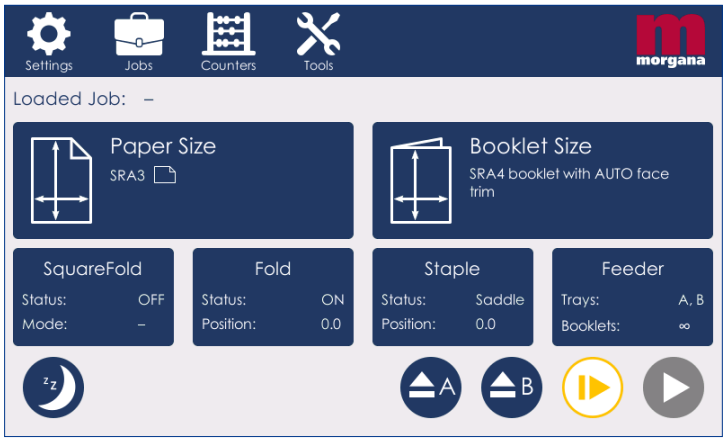
User Interface, continued



Information on screen

Depending on how the system is configured, the information on the screen changes and the size of the buttons will adapt to fit the screen.

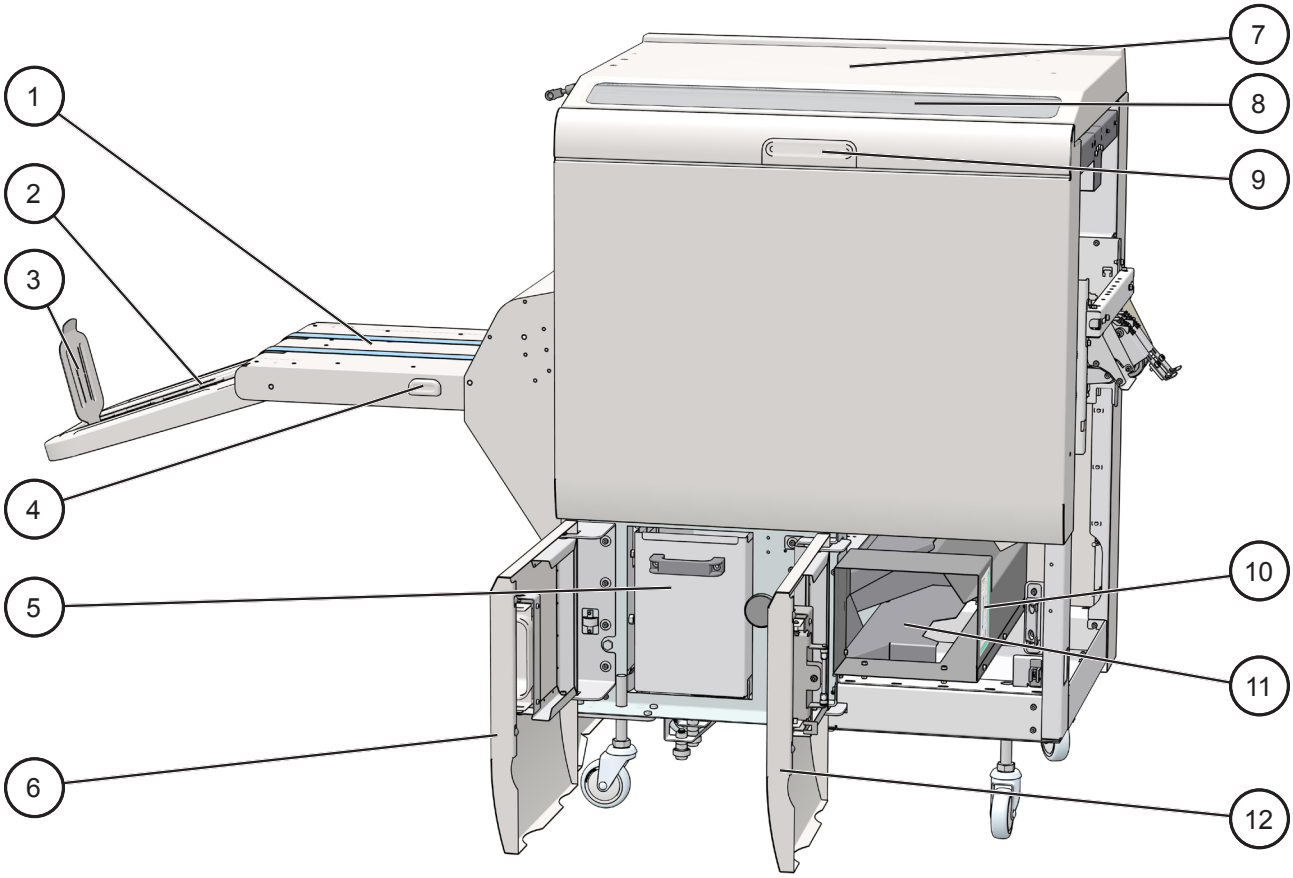
This sample screen shows a fully configured Booklet Maker system with CST and internal Convenience Feeder.

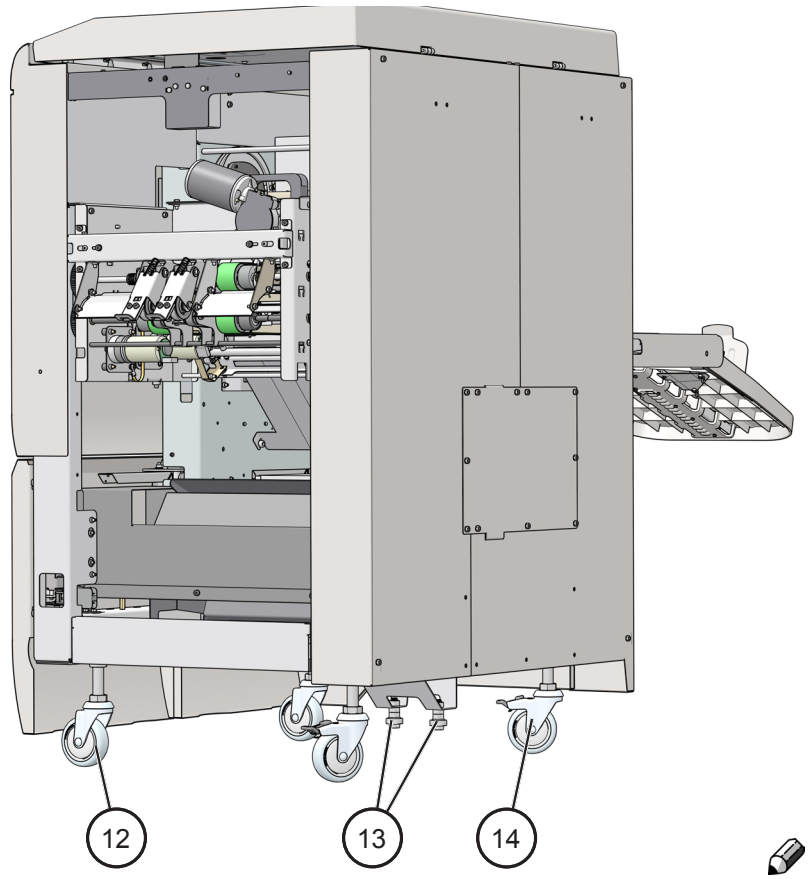


This sample screen shows exactly the same screen as above but this time the system is configured whithout optional CST and without optional Convenience Feeder.

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Finishing Module

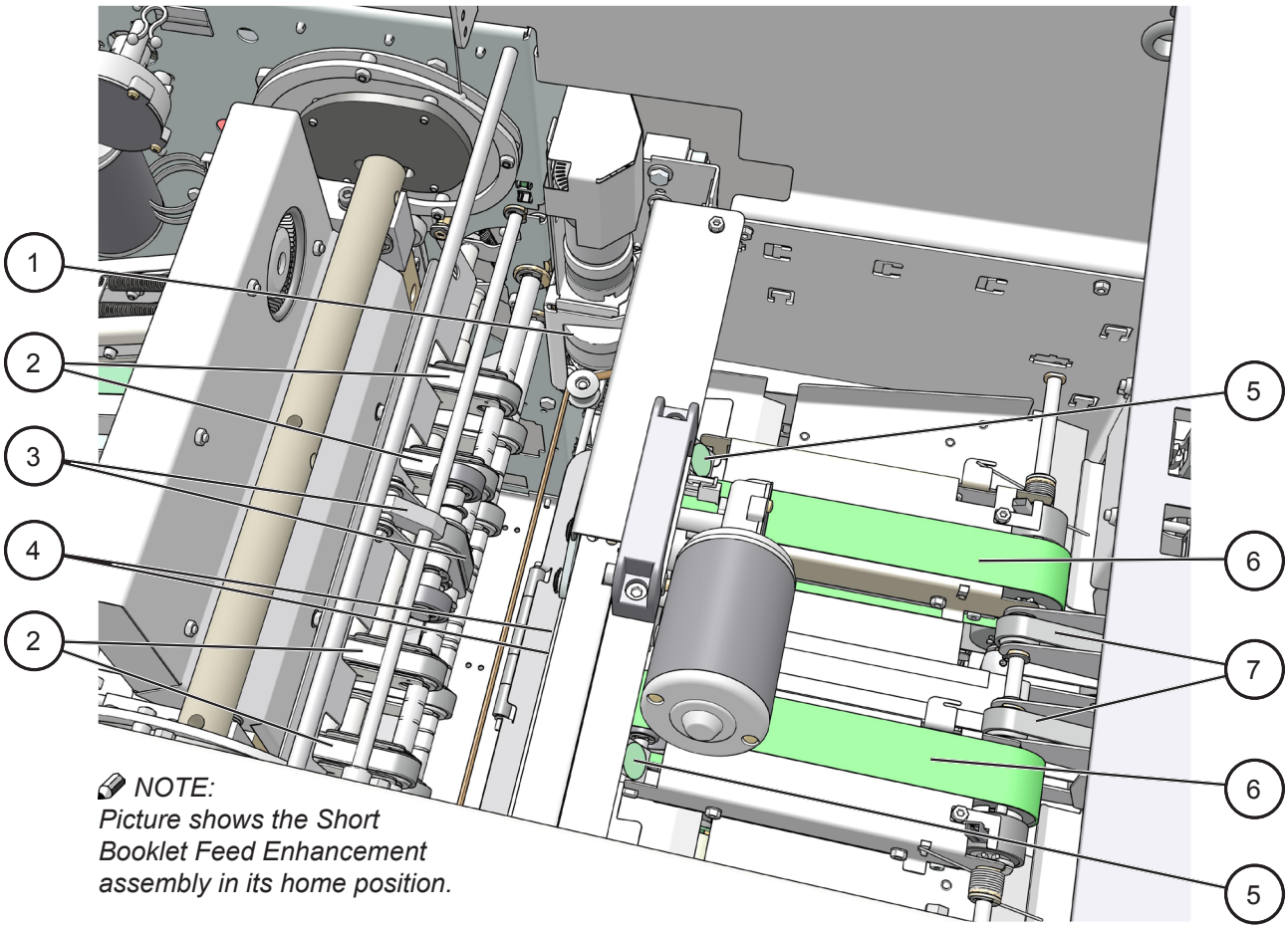




1 Belt Stacker Chassis
2 Belt Stacker Table
3 Belt Stacker Stop Gate
4 Belt Stacker Table Release Button
5 Trim Waste Bin
6 Door to Trim Waste Bin
7 Top Cover
8 Top Cover Glas
9 Top Cover Latch Handle
10 Fold Stop Pocket adjustment instruction
11 Edge and Corner Stapling Stacker
12 Door for jam clearance
13 Operator Side Casters, no brakes
14 Rail Guides
15 None Operator Side Casters, with brakes

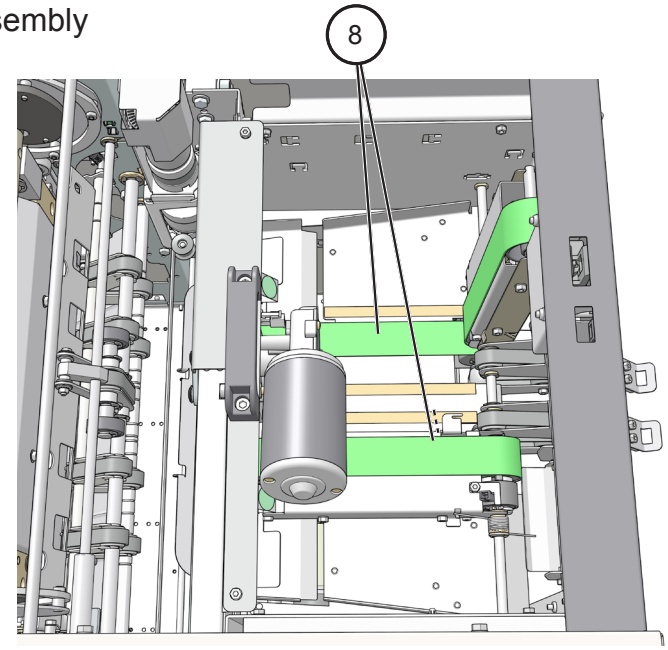
NOTE:
Edge and corner stapling capability might not be available on all systems.

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.



NOTE:
Picture shows the Short Booklet Feed Enhancement assembly in its home position.

1 Pressure Roller
2 Upper Transport Belt assembly
3 Short Booklet Feed Enhancement assembly
4 Upper and Lower Clamp Beam
5 Upper Feed Belt Release Latch
6 Upper Feed Belts
7 Upper Infeed Belts
8 Lower Feed Belts



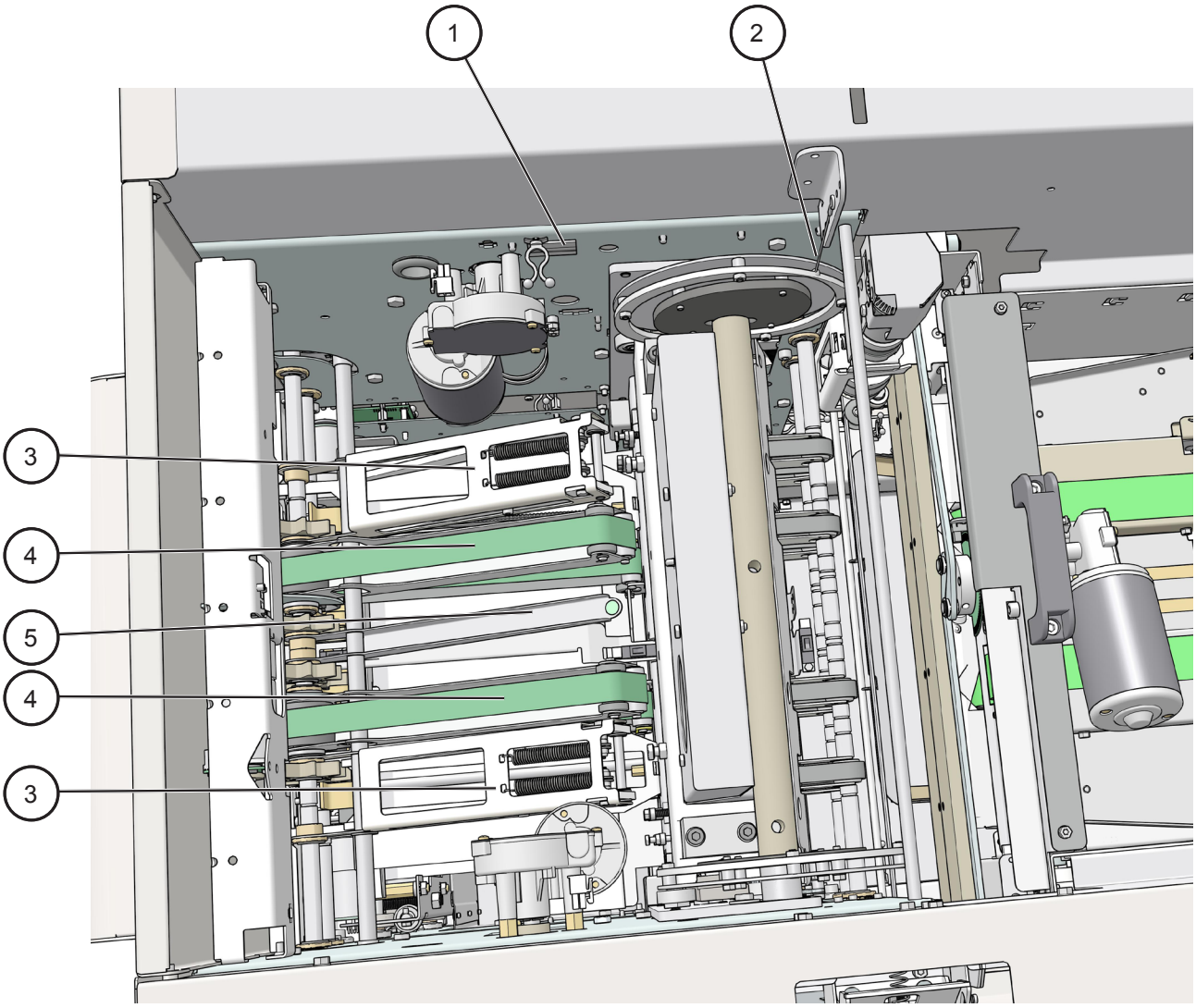
Finishing Module, Upper Feed Belt and Transport Belt assembly lifted up

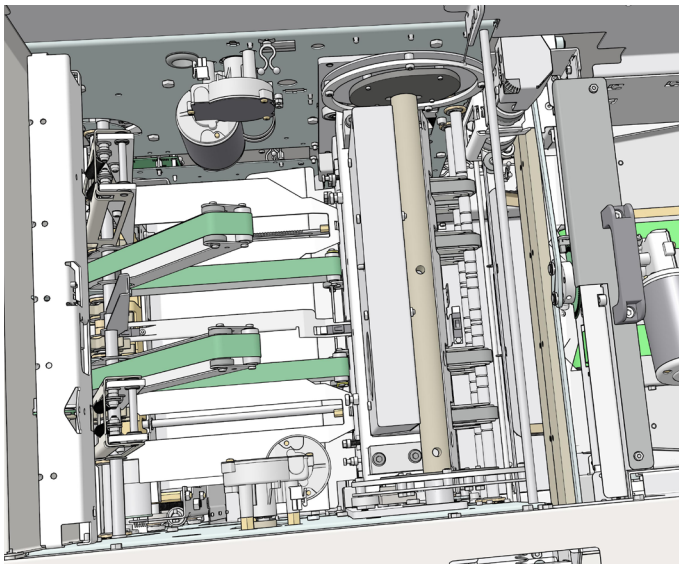
NOTE:
Upper feed belt on the operator side cannot be lifted fully

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Finishing Module, continued

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.



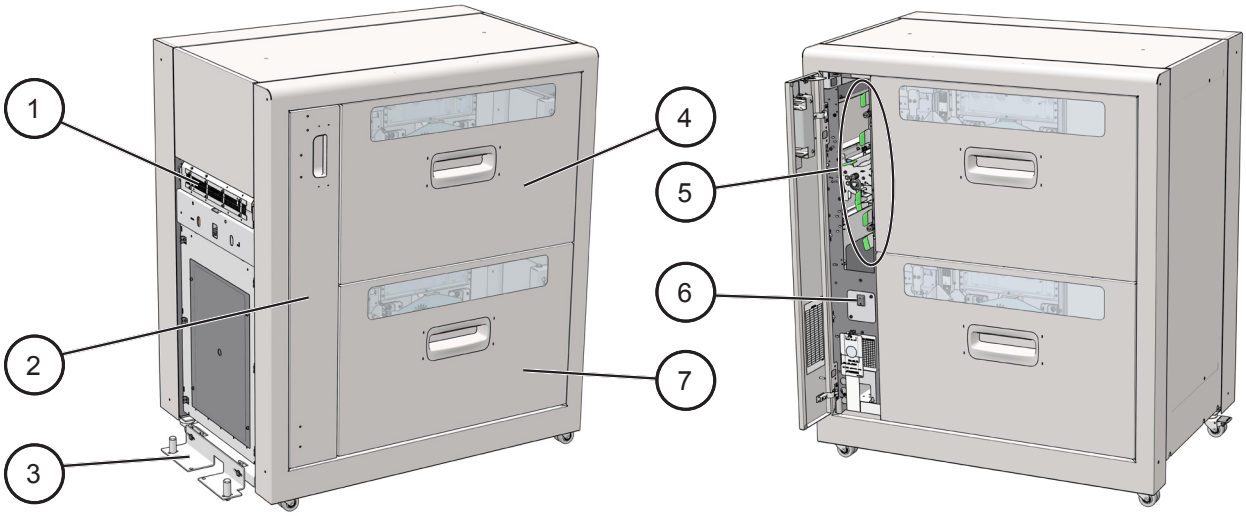


1 Set Counter
2 Top Cover Opener Limiting device
3 Exit Compressing Brackets
4 Upper Exit Transport Belts
5 Lift Lever, Upper Exit Transport assembly

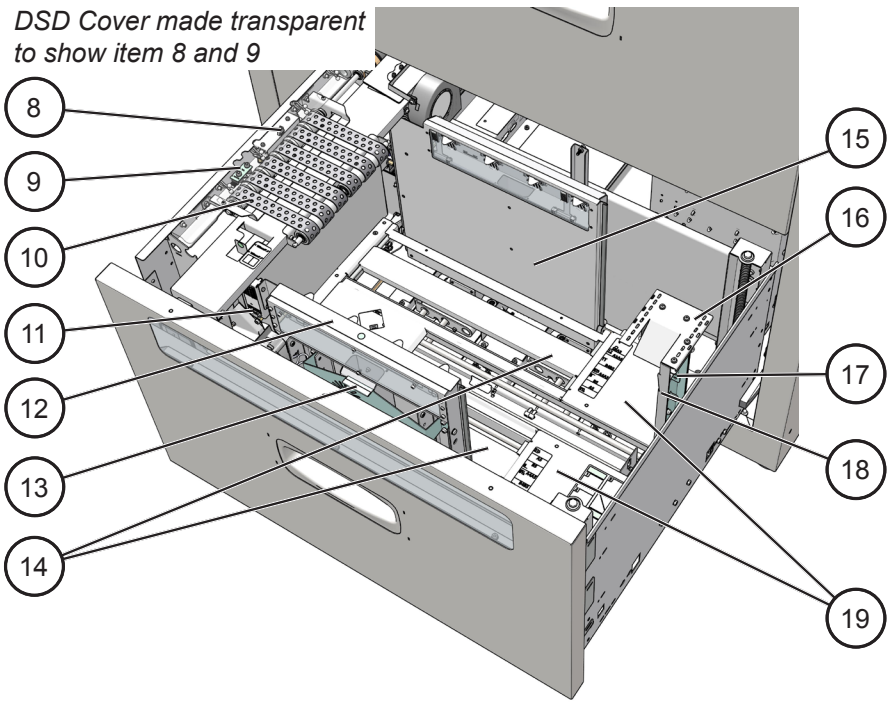
Finishing Module, Upper Exit Transport lifted up

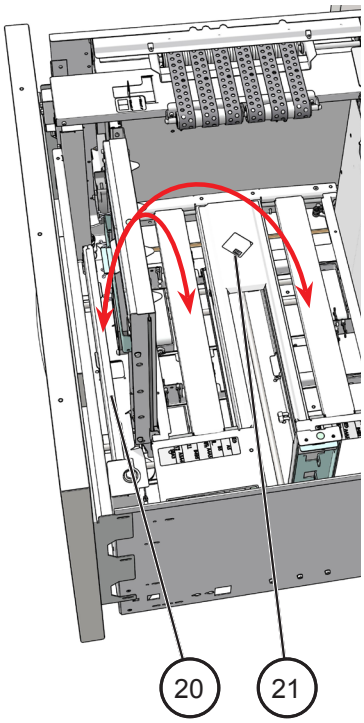
Options

VFX Vacuum Feeder



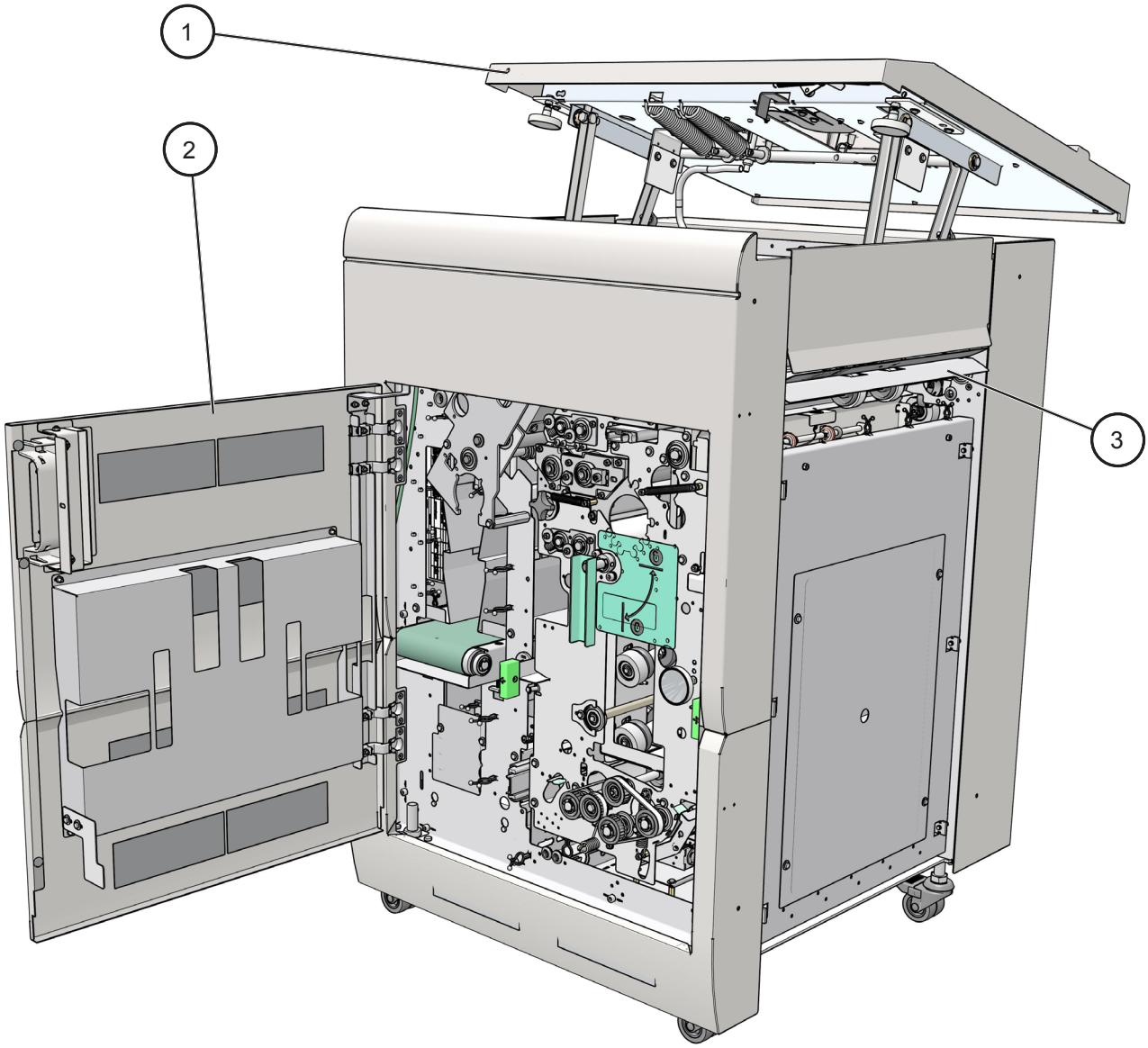
DSD Cover made transparent to show item 8 and 9





1 Exit area
2 Door
3 Docking bracket
4 Upper Tray / Tray A
5 Jam clearance baffles (green)
6 Main power switch
7 Lower Tray / Tray B
8 Ultrasonic Double Sheet Detection (DSD) sensors (Q102, Q202)
9 Optical Double Sheet Detection (DSD) sensors (Q101, Q201)
10 Vacuum feed belts
11 Stacked Paper Sensor (Process Position Sensor) “CC” (upper), “Y” (lower)
12 Front paper guide with blower fans
13 Front and Rear guide lock release
14 Wide paper supports
15 Rear paper guide with blower fans
16 Barcode reader (optional)
17 Side paper guide lock release
18 Side paper guide
19 Elevated bin bottom
20 Wide paper supports storage position
21 Tray empty sensors (Q105, Q205)

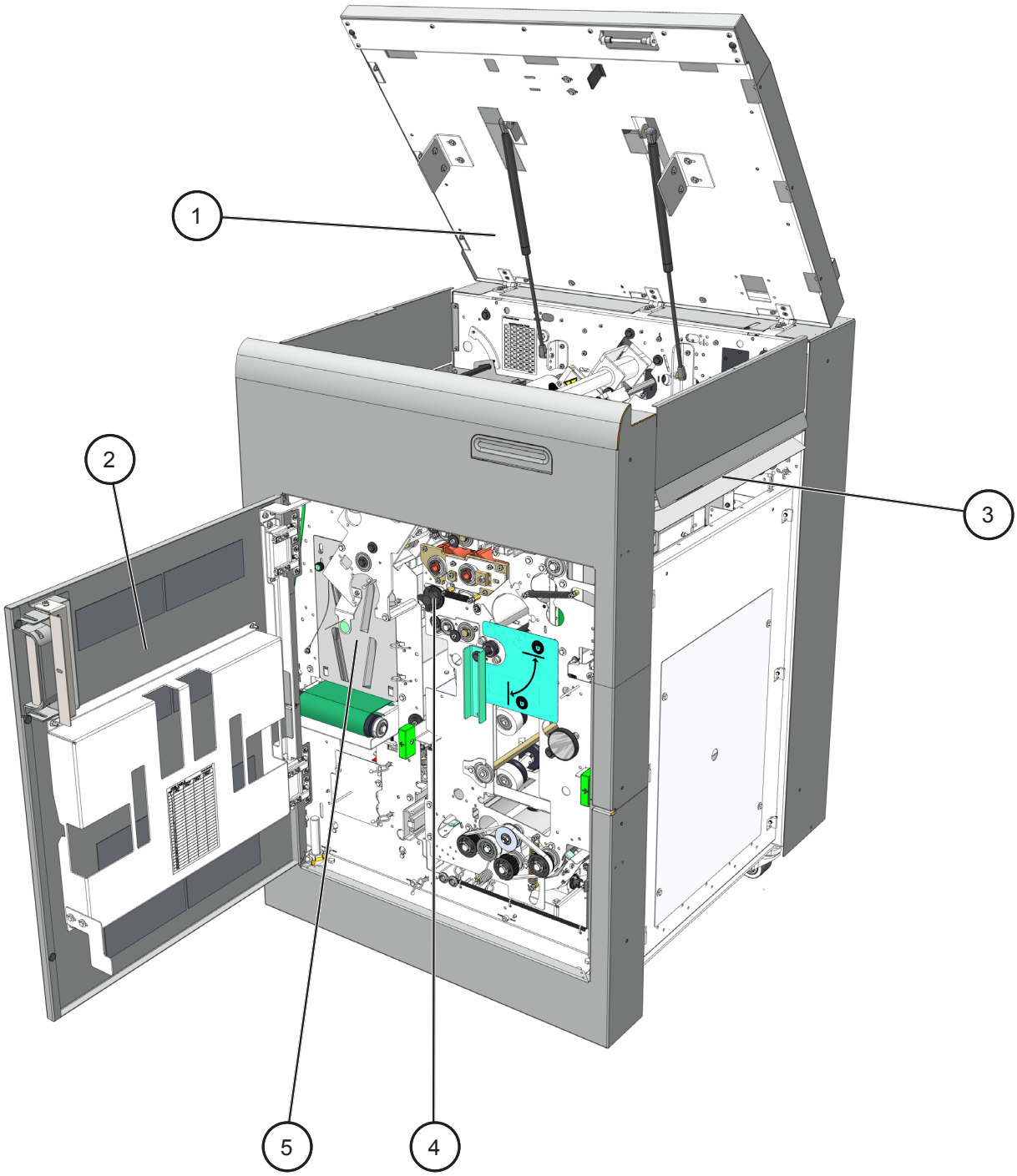
Crease Side Trim Module



1 Top Cover
2 Slide Door
3 Infeed Slot

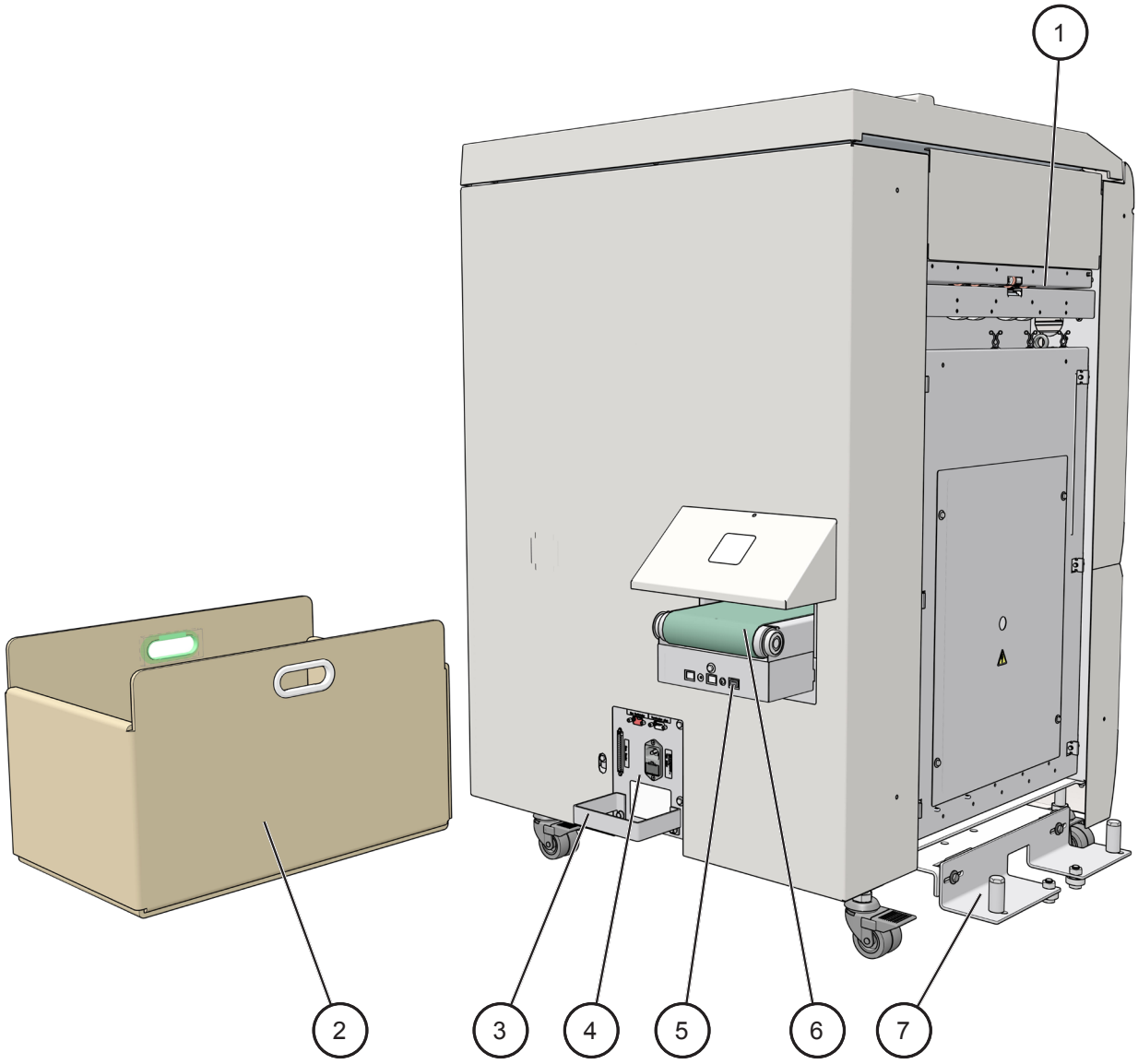
Rotate Crease Trim Module, continued

NOTE:
The Top cover may vary depending on the CST Module.



1 Top Cover
2 Slide Door
3 Infeed Slot
4 Star shaped knob
5 Front Waste Cover

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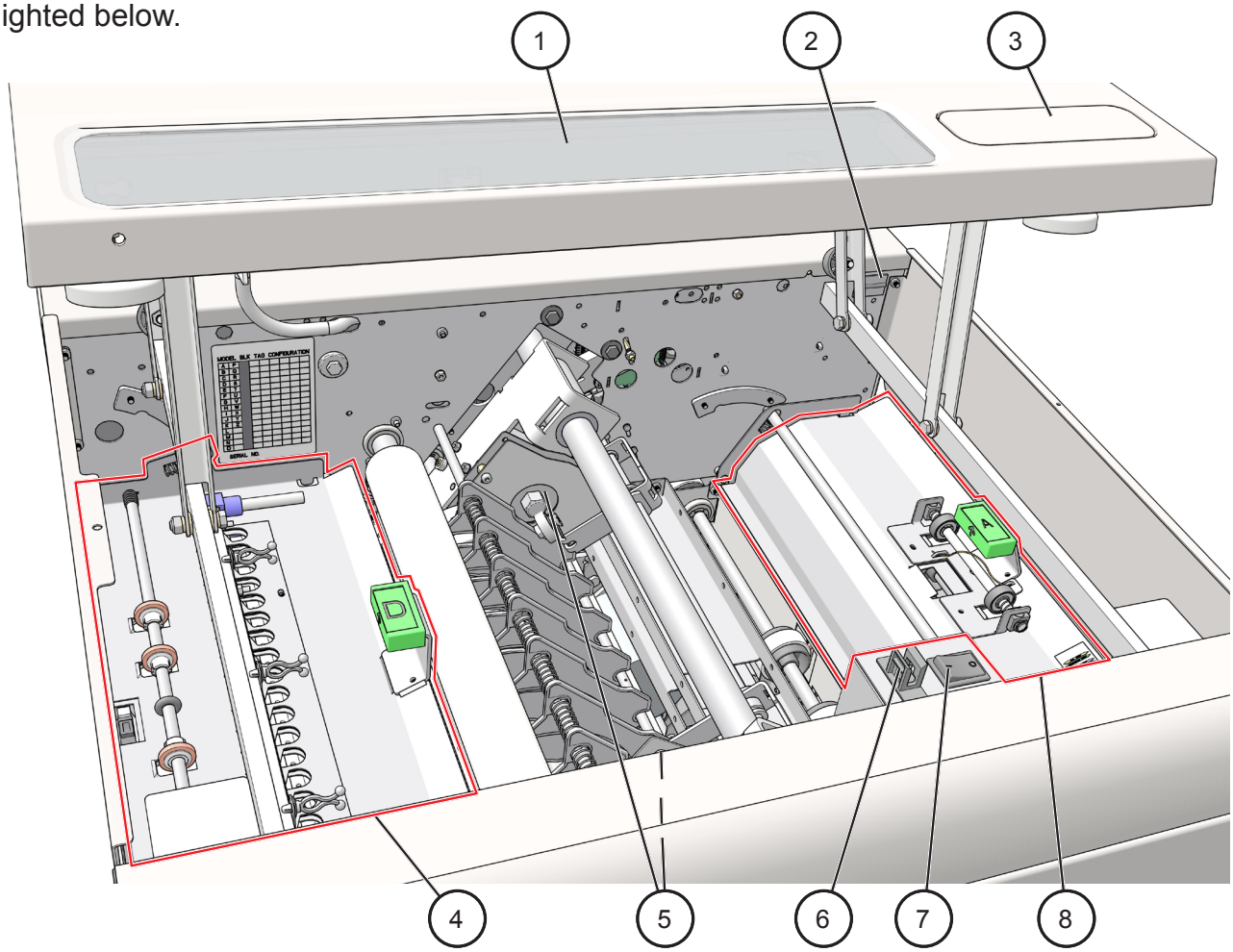


1	Exit slot	5	Waste Bin full Detection
2	Waste Bin	6	Trim Waste Transport
3	Cable Protector	7	Downstream Docking assembly
4	Connections		

continued on next page

Crease Side Trim Module, continued

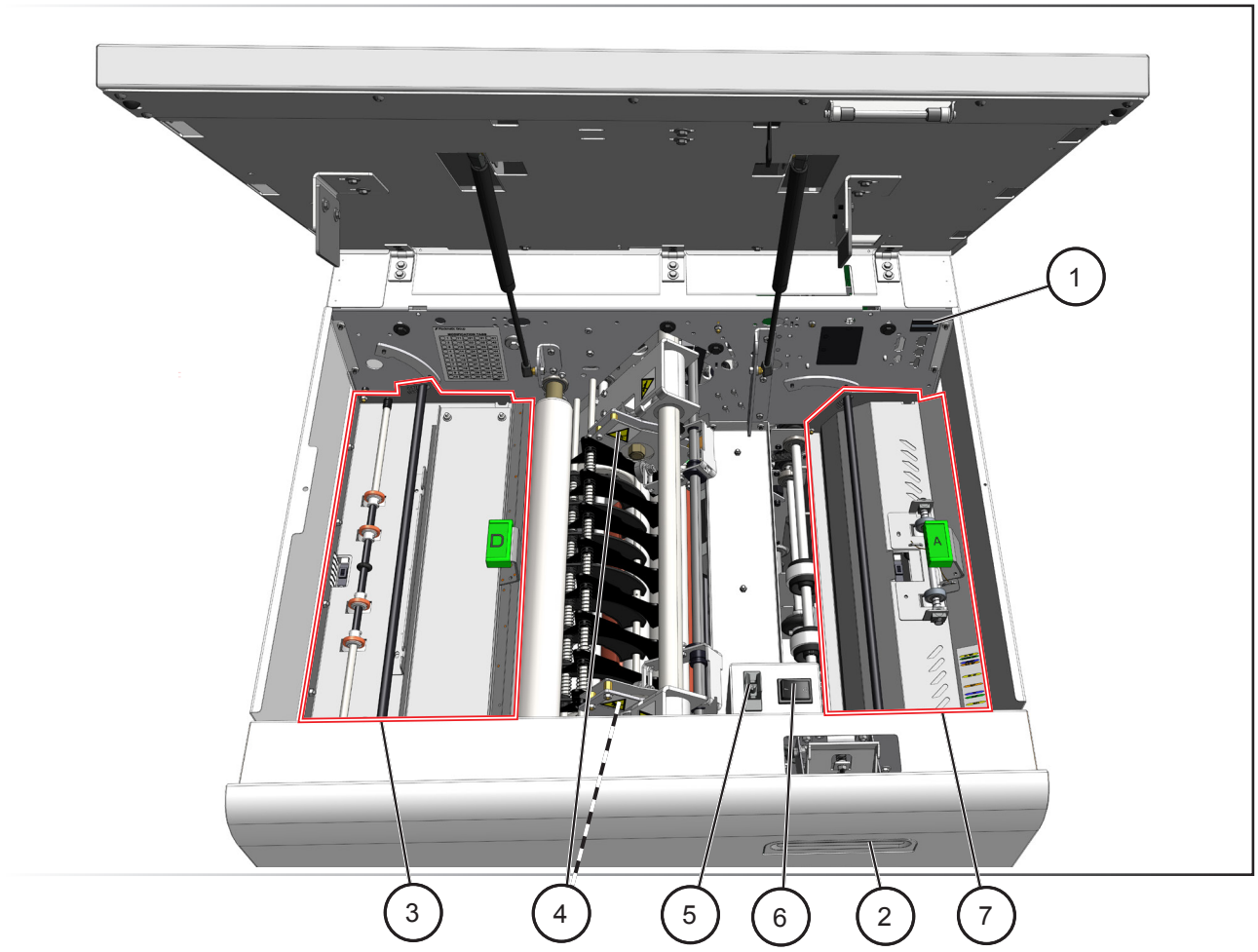
Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.

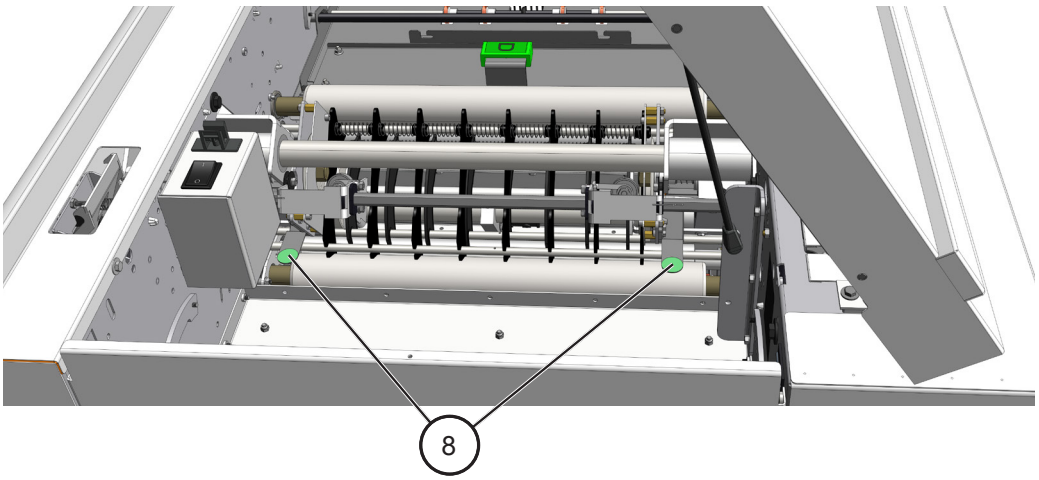


1	Top Cover Glass	6	Interlock switch
2	Counter	7	Main switch
3	Top Cover Latch	8	Infeed area “A”
4	Exit area “D”	9	Trim waste guides
5	Side trimmer circular knives		

Crease Side Trimmer Module, continued

NOTE:
The Top cover may vary depending on the CST Module.

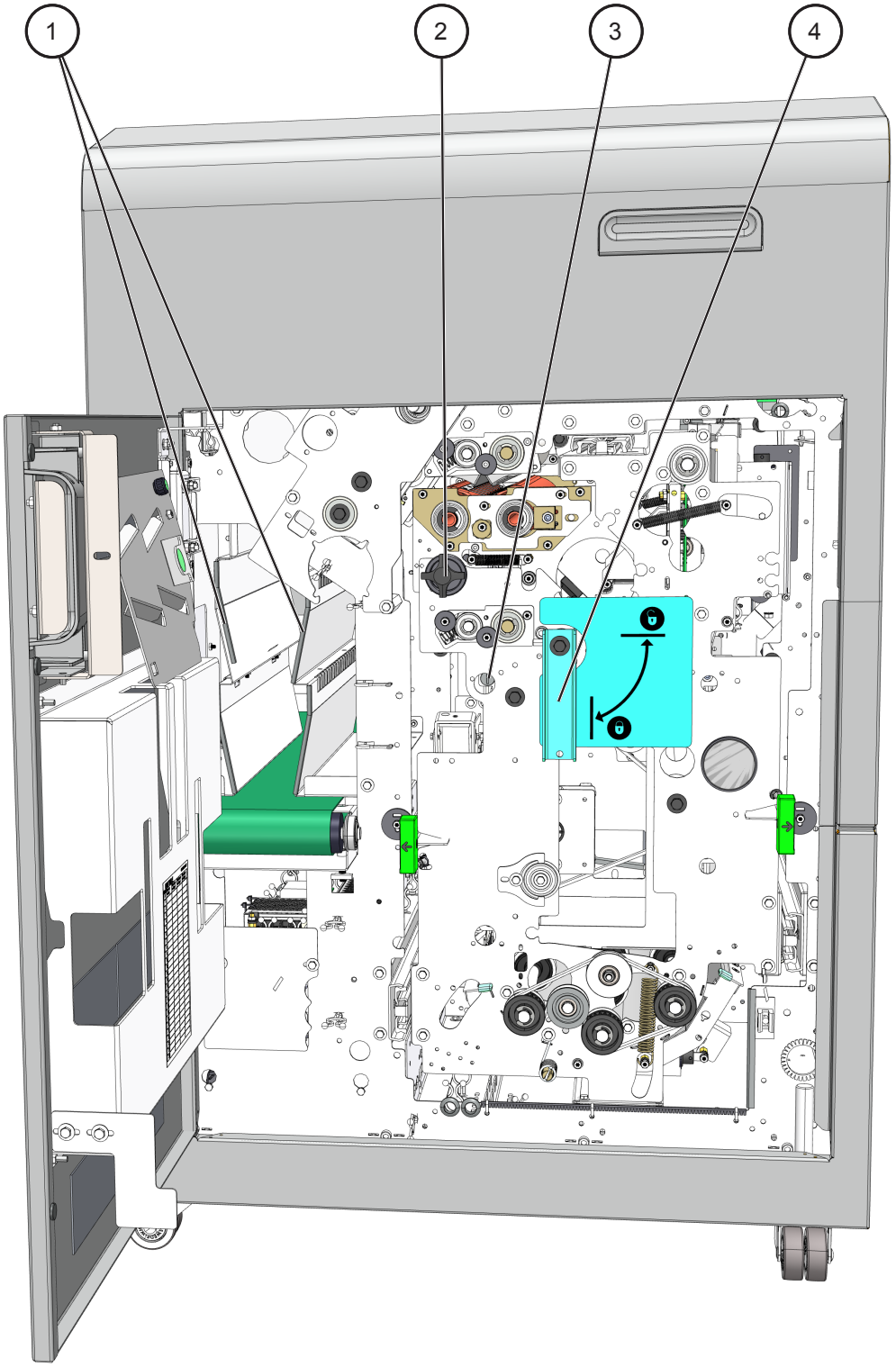




1	Counter	5	Interlock switch
2	Lock Button	6	Main switch
3	Exit area “D”	7	Infeed area “A”
4	Side trimmer circular knives	8	Trim waste guides

continued on next page

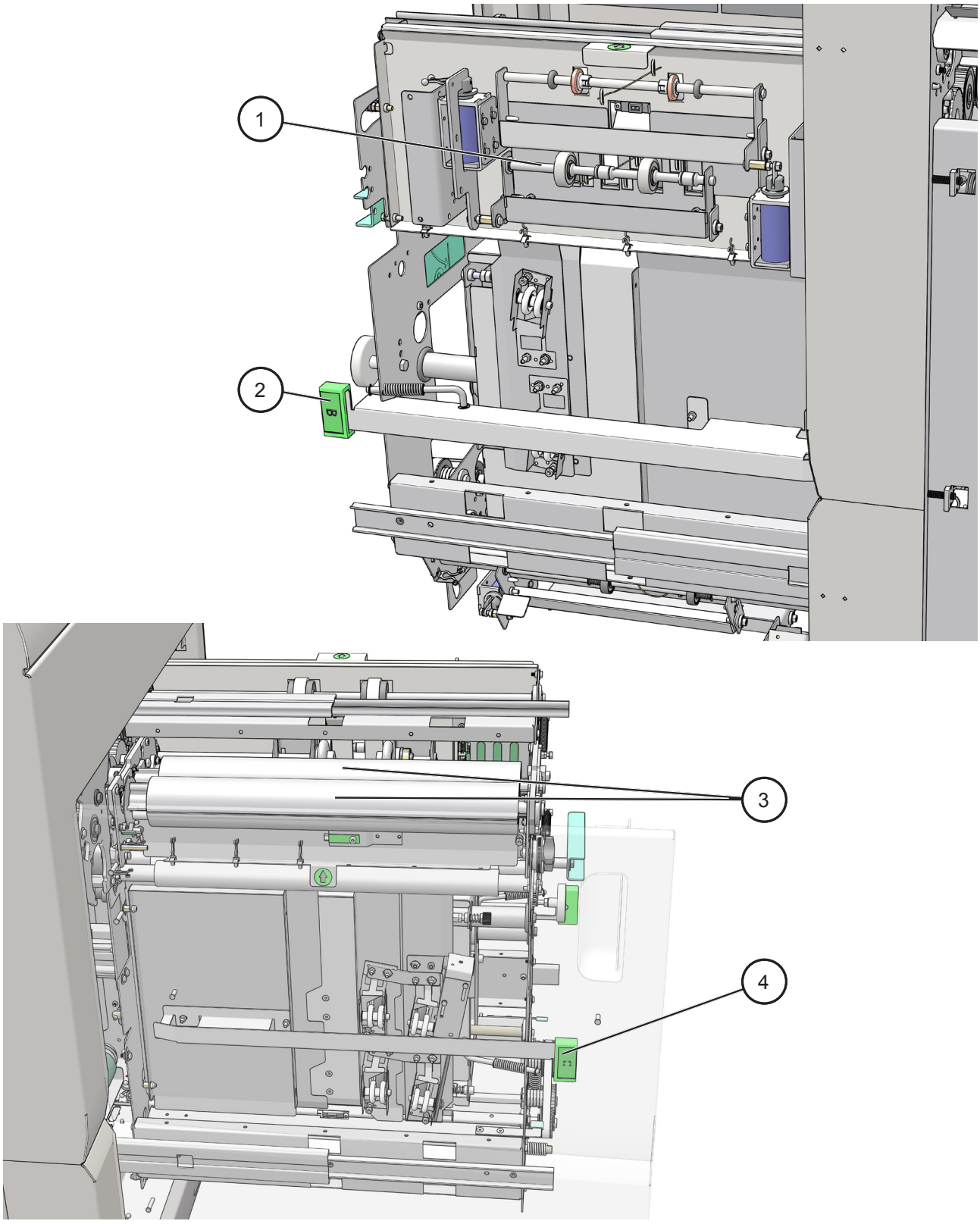
Crease Side Trimmer Module, continued



1 Waste chute(s)
2 Creaser registration adjustment
3 Bleed trimmer registration adjustment
4 Latch handle, slide

continued on next page

Crease Side Trim Module, continued



1	Rotator	3	Creaser tools
2	Jam Clearance Baffle, coarse registration, area “B”	4	Jam Clearance Baffle, fine registration, area “C”

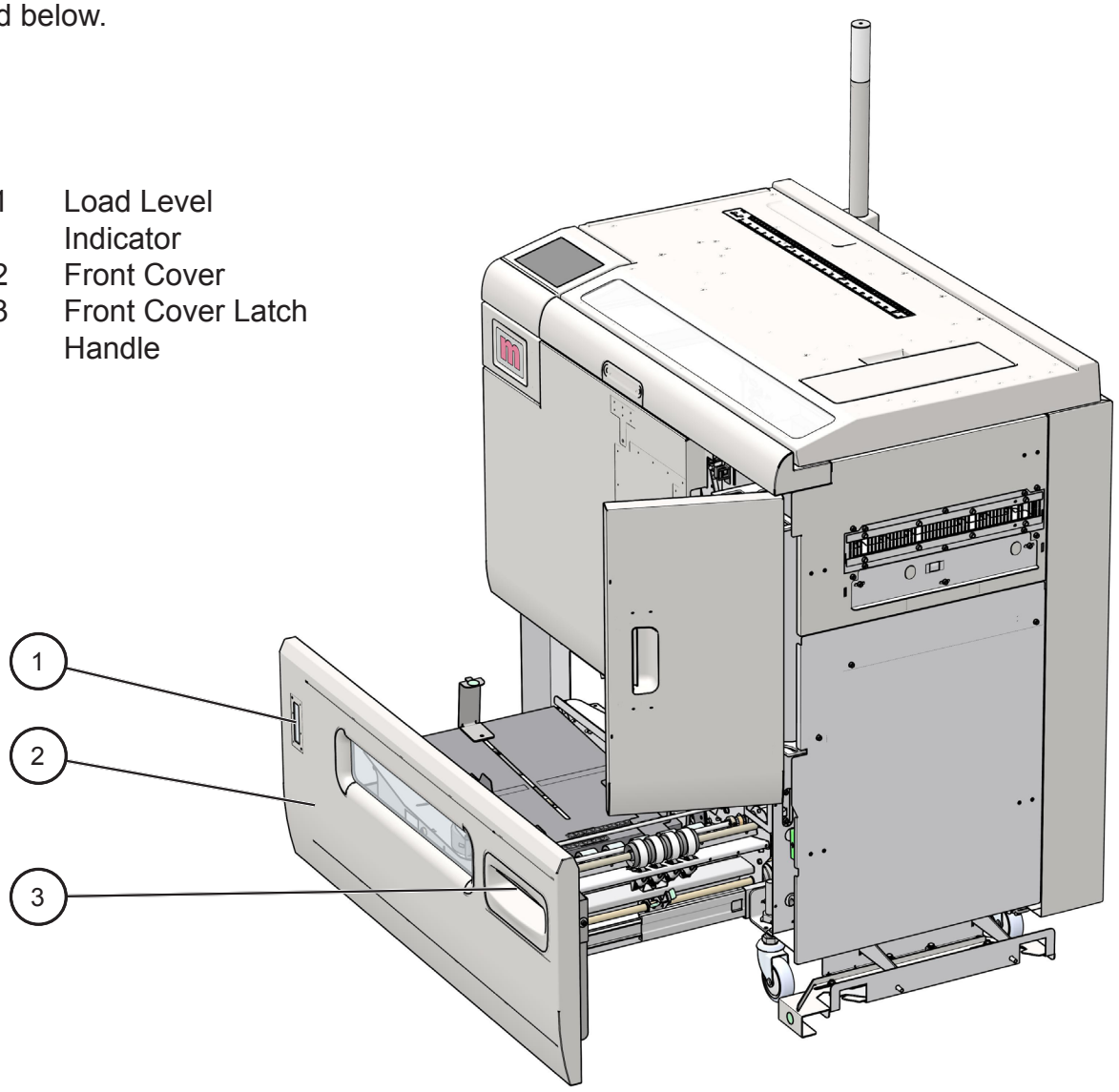
Booklet Maker

Convenience Feeder

The optional Convenience Feeder has a loading capacity of 80 mm (3.15″) which equals 800 sheet of 80 gsm (20 lb Bond). It will often be used as a cover feeder but due to its capacity it can also be used as a regular feeder. The paper stack is pre-separated using air and the sheets are then fed to the Booklet Maker using a Friction Feed Roller. When loading level is less than 5%, soft stop will occur.

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.

1 Load Level Indicator
2 Front Cover
3 Front Cover Latch Handle



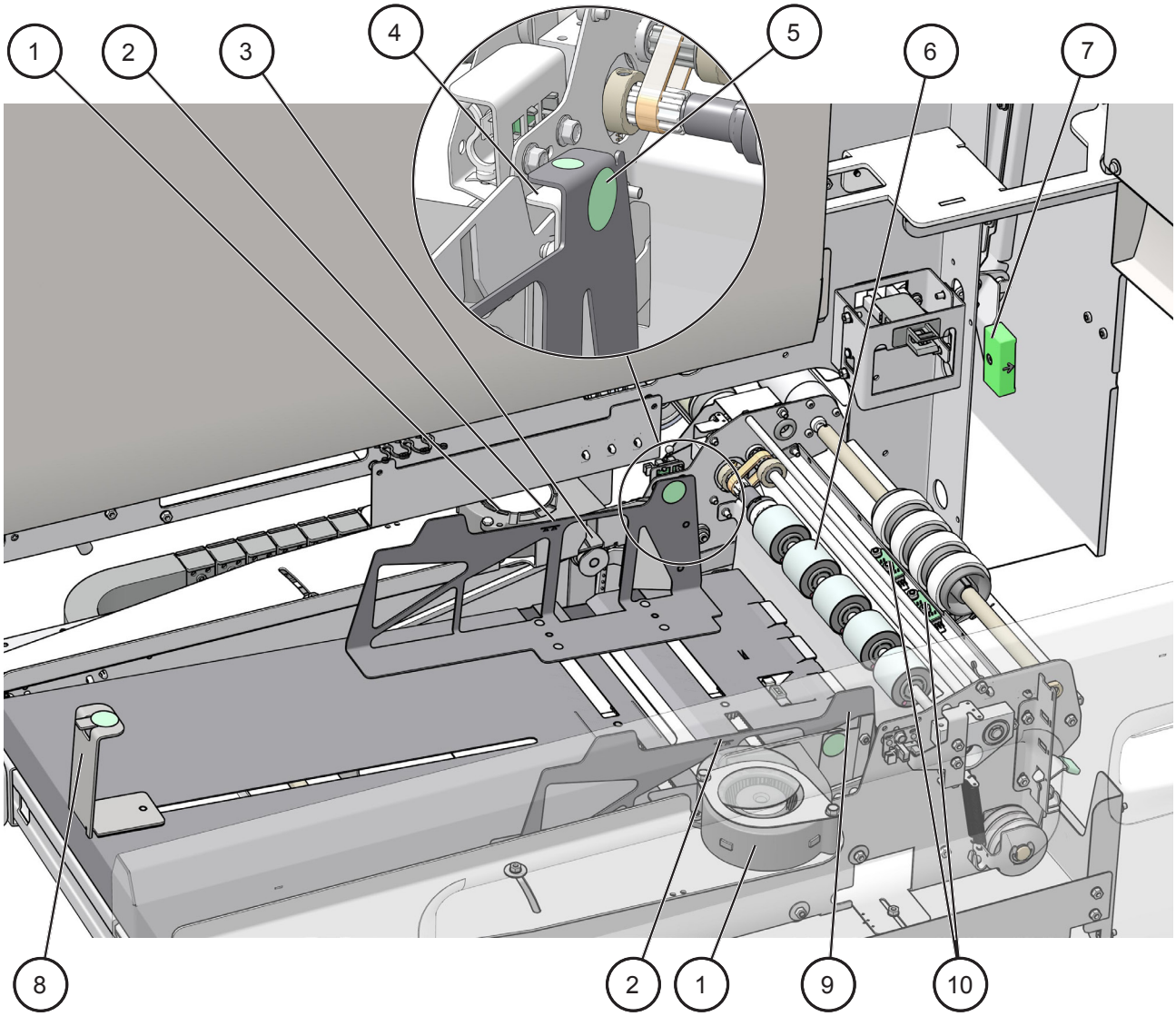
The Convenience Feeder Load Level Indicator is lit when the system is not in power save mode or shut off. Indications are as follows.

4 blue marks - 100-75% loaded
3 blue marks - 75-50% loaded
2 blue marks - 50-25% loaded
1 blue mark (lowest section) - 25-10% loaded
1 yellow mark (lowest section) - 10-0% loaded

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Convenience Feeder, continued

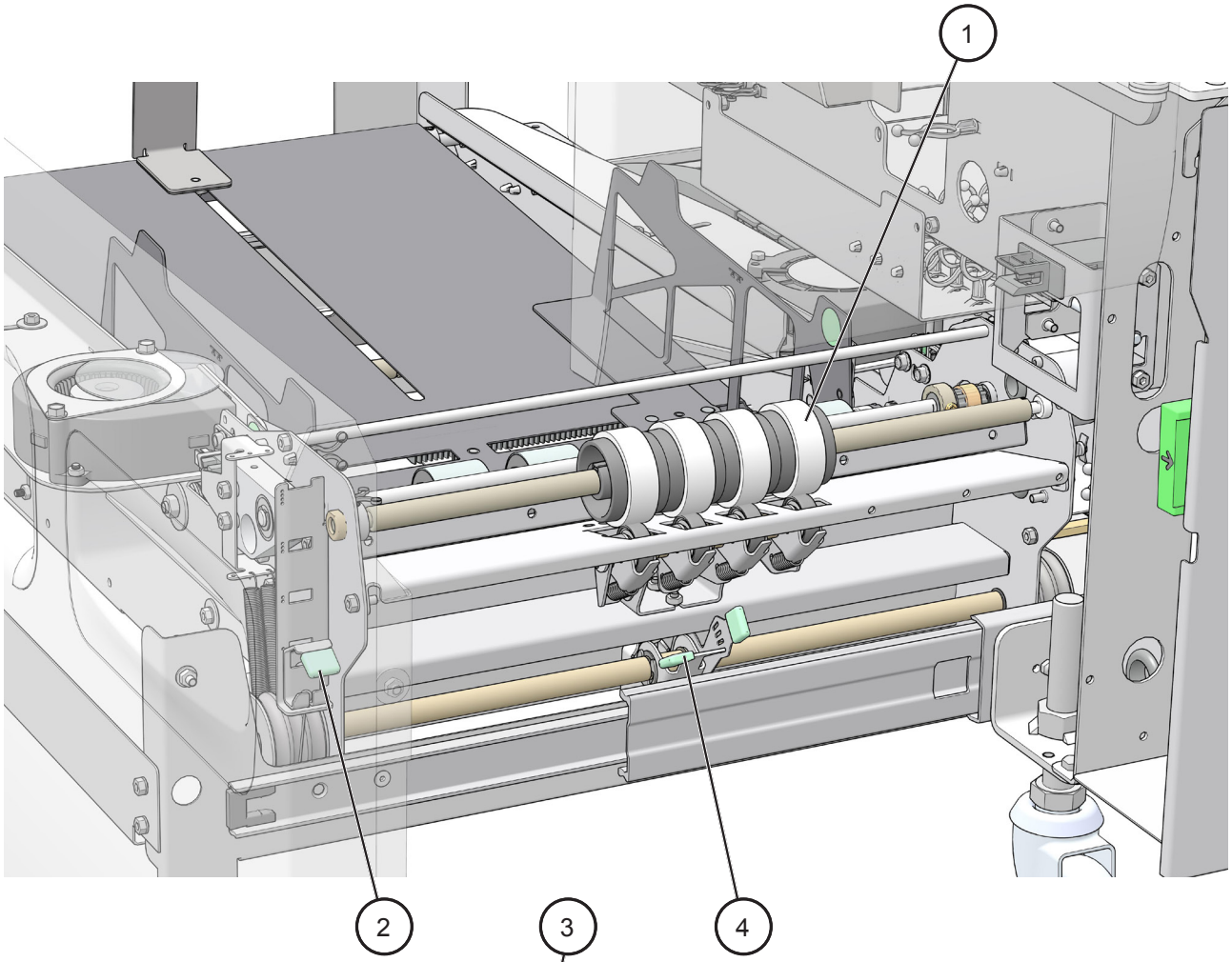
Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.

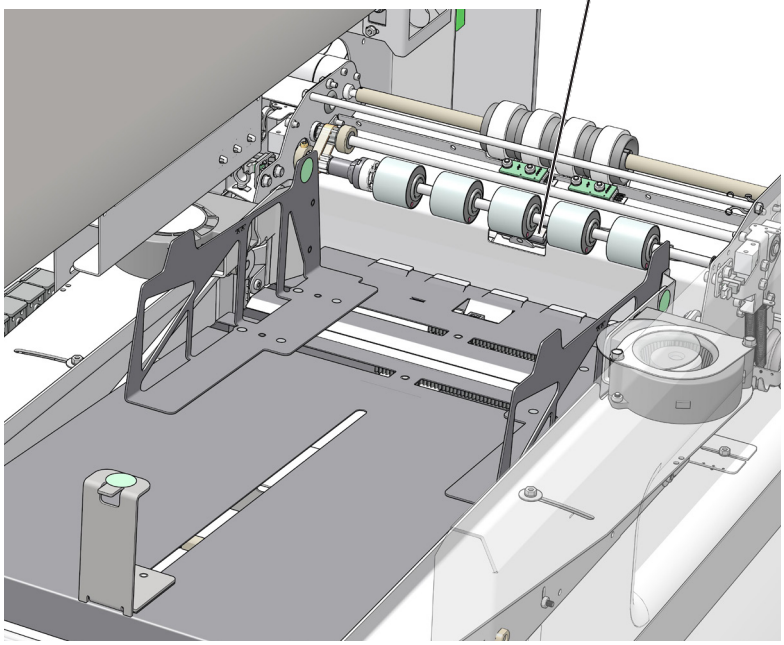


1	Separation Fans (×2)	6	Feed Roller assembly
2	Loading capacity marks	7	Jam Clearance Baffle
3	Air Nozzle (×2)	8	Rear Paper Guide
4	Side Guides Release Lever	9	Front Side guide
5	Rear Side guide	10	DSD sensors

Convenience Feeder, continued

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.



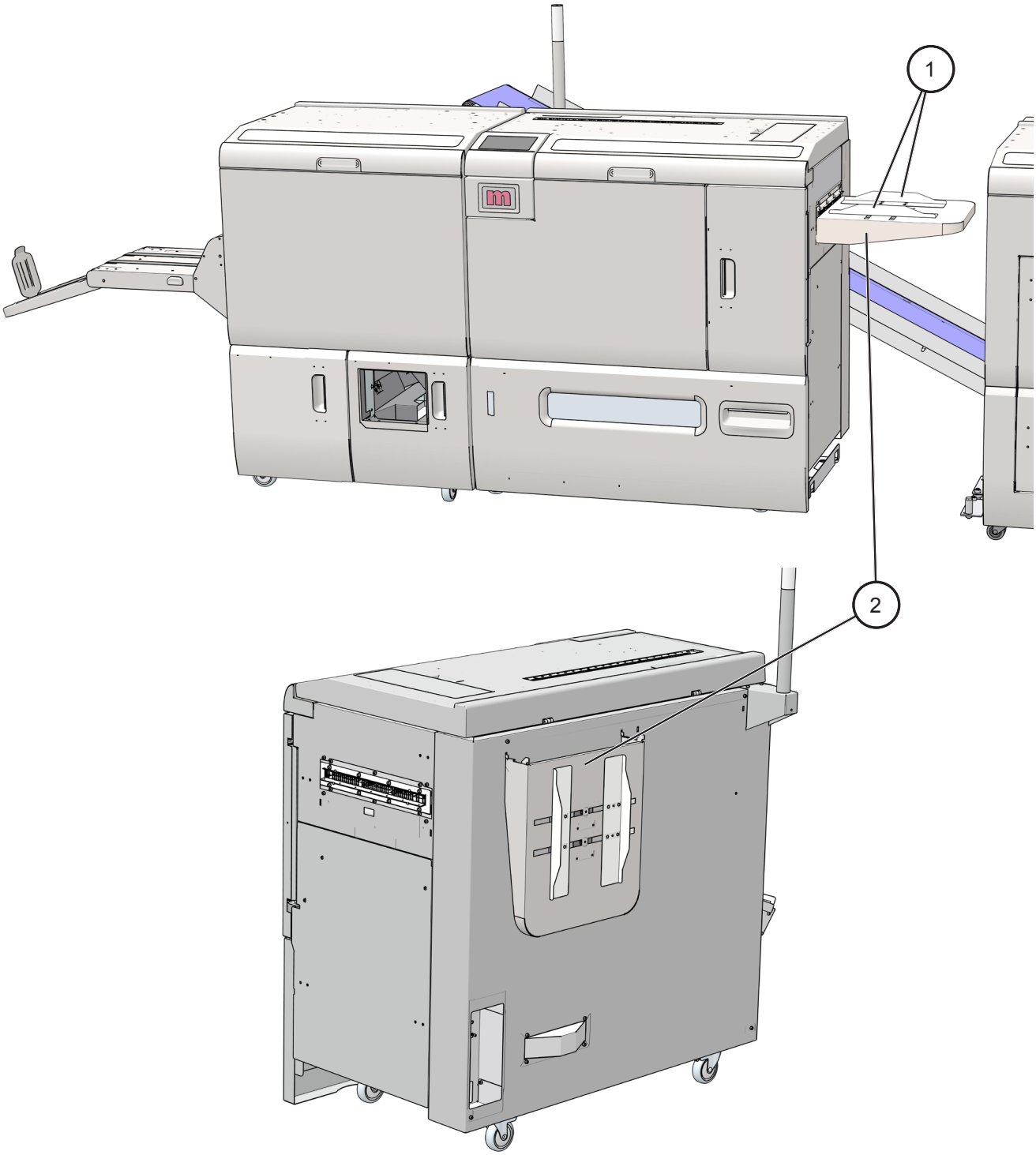


1 Drive Shaft
2 Feed Roller Pressure adjustment
3 Paper Separator Pad
4 Paper Separator Pad Pressure adjustment

continued on next page

Manual Feed Tray

The optional Manual Feed Tray facilitates manual feeding of sets to the Booklet Maker. It can be attached when the Booklet Maker system is undocked. When not in use, the Manual Feed Tray can be stored hanging on the Booklet Maker Rear Cover. Insert the tabs of the Manual Feed Tray into the holes on the upper left of the Booklet Maker Rear Cover.

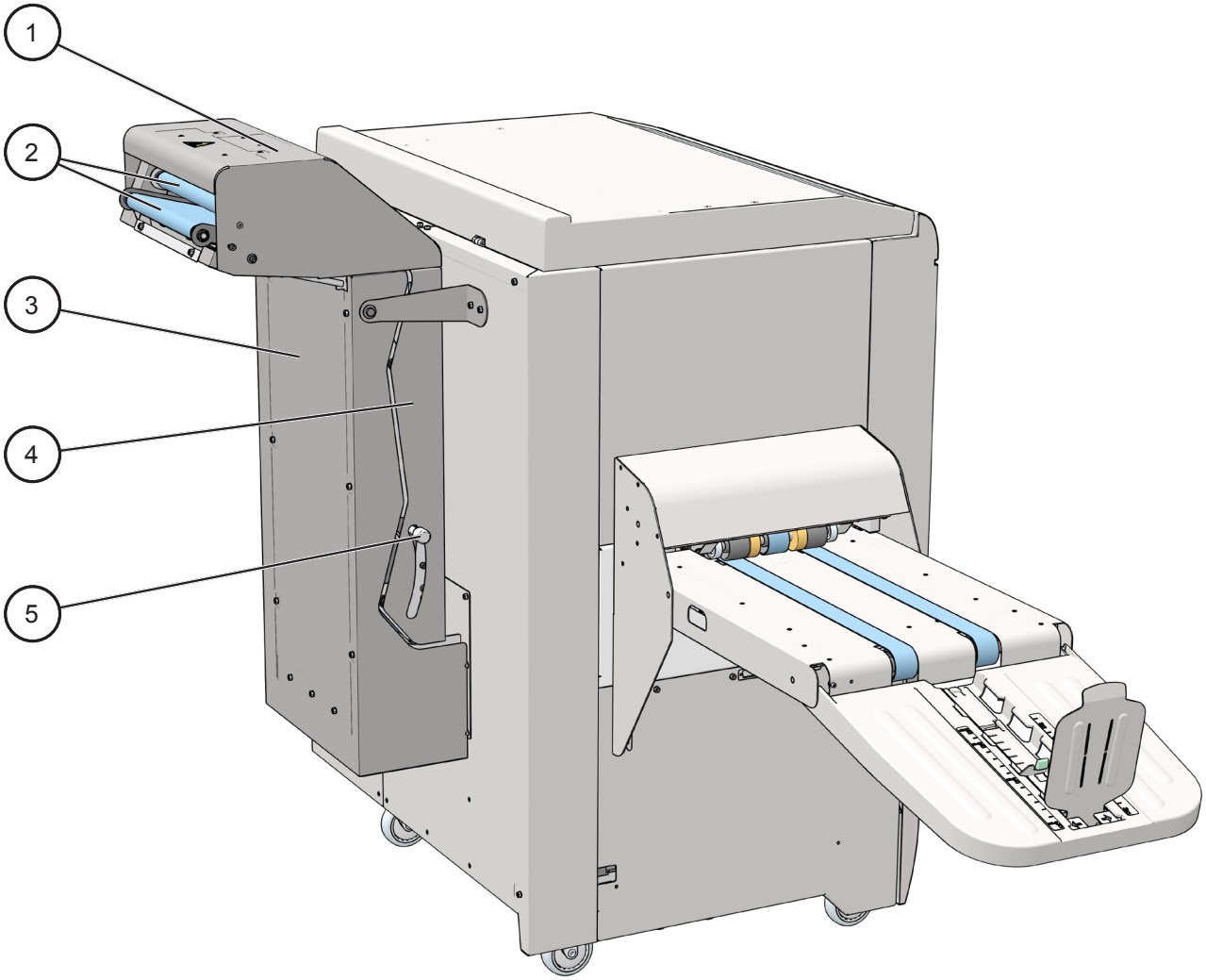


1 Manual Feed Tray Side Guides
2 Manual Feed Tray

Waste Transport to Finishing Module

The Waste Transport installs to the Finishing Module. Instead of using the Trim Waste Bin in the Finishing Module, trim waste is now transported upwards which enables the use of a larger waste bin. This makes long, unattended runs easier than ever before.

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.



1 Top Cover
2 Transport Belts
3 Waste Transport Unit
4 Jam Clearance Cover
5 Lever to Jam Clearance Cover

BST4000-1 Belt Stacker Module

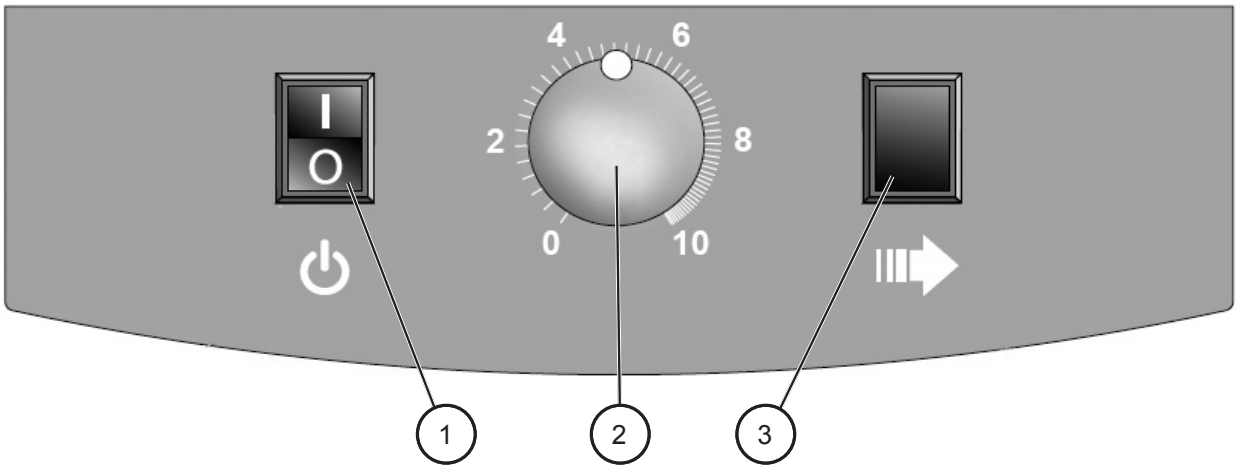
The BST4000-1 High Capacity Belt Stacker Module is an option available for the Plockmatic 5050s or 5035s Booklet Maker System. The stacker can be configured in a straight line after the Booklet Maker system or at a 90 degree angle.

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.



1 Stacking tray
2 Conveyor belt
3 COM-cable
4 Side guides
5 Front end side guide adjustment knobs
6 Leg assembly
7 Control panel box
8 Height adjustment knobs (two on each leg)
9 Rear end side guide adjustment knobs (underneath)

BST4000-1 Belt Stacker Module, continued



1 Main power switch (on/off)
2 Belt speed selector
3 Run-out button (full speed)

BST4000-1 Principle of Operation

The belt is triggered by a signal from the Booklet Maker and will run for a set time.

The belt speed can be adjusted in order to optimize the stacking function for various materials.

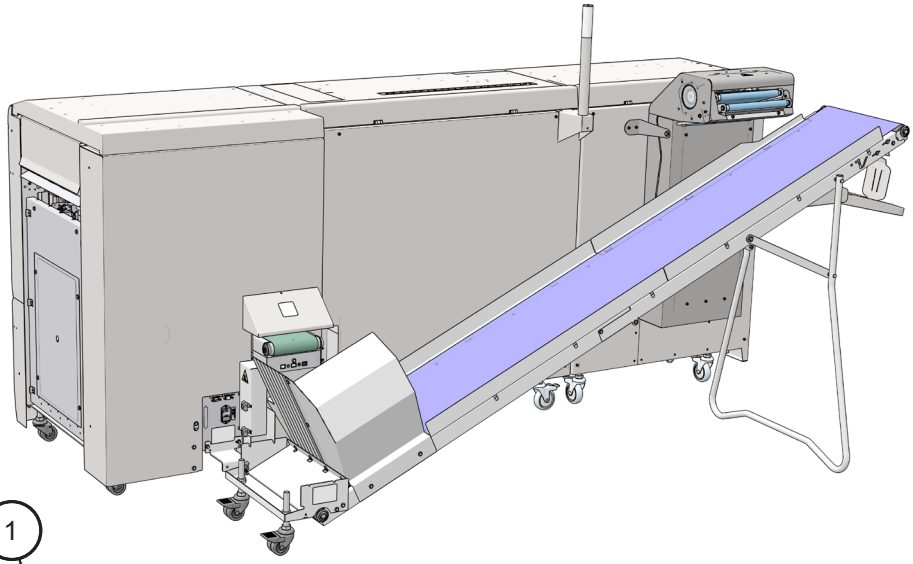
The Run-out button is used to gather the material after a job is finished.
The belt then moves at the highest speed, independent of the speed setting.

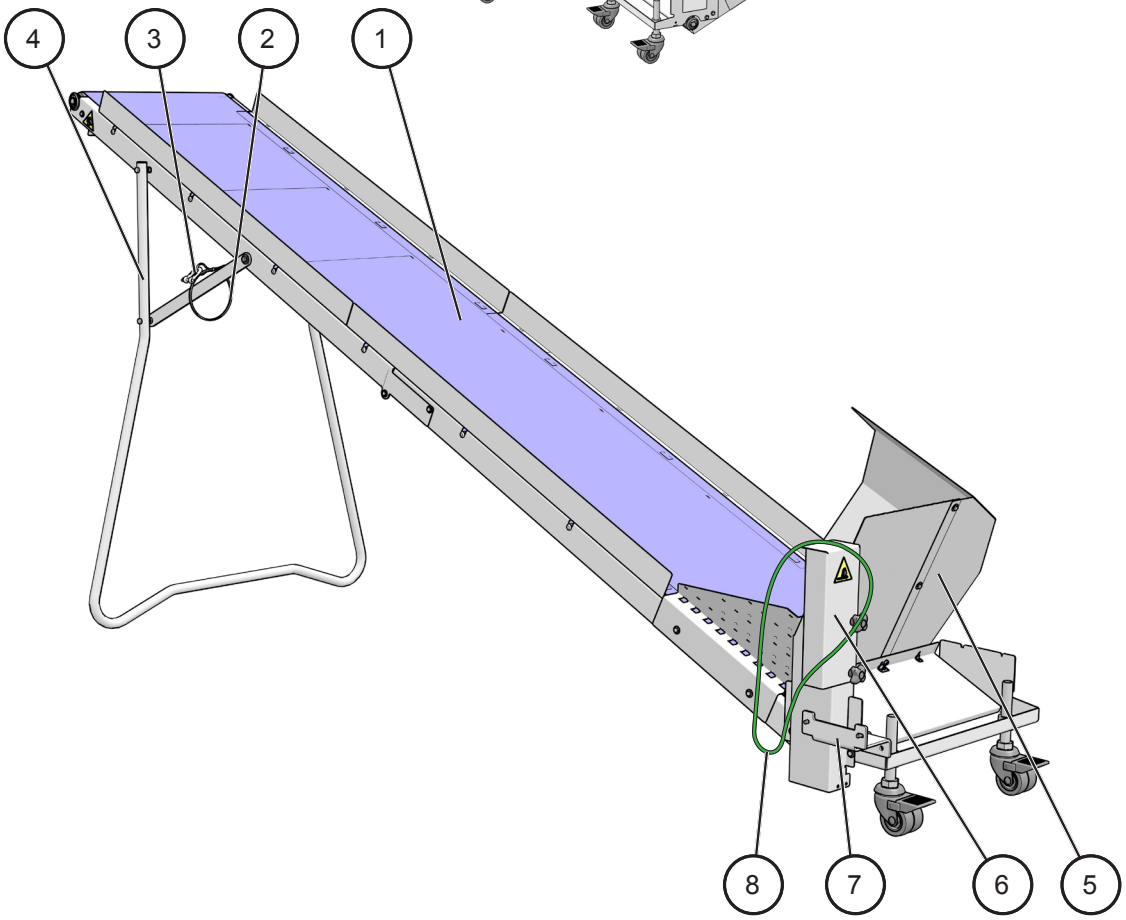
The power switch is also used to reset the unit after an overload situation.

Trim Waste Conveyor

The Trim Waste Conveyor attaches to and is powered from the CST. It transports trim waste upwards which enables the use of a larger waste bin. This makes long, unattended runs easier than ever before.

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.

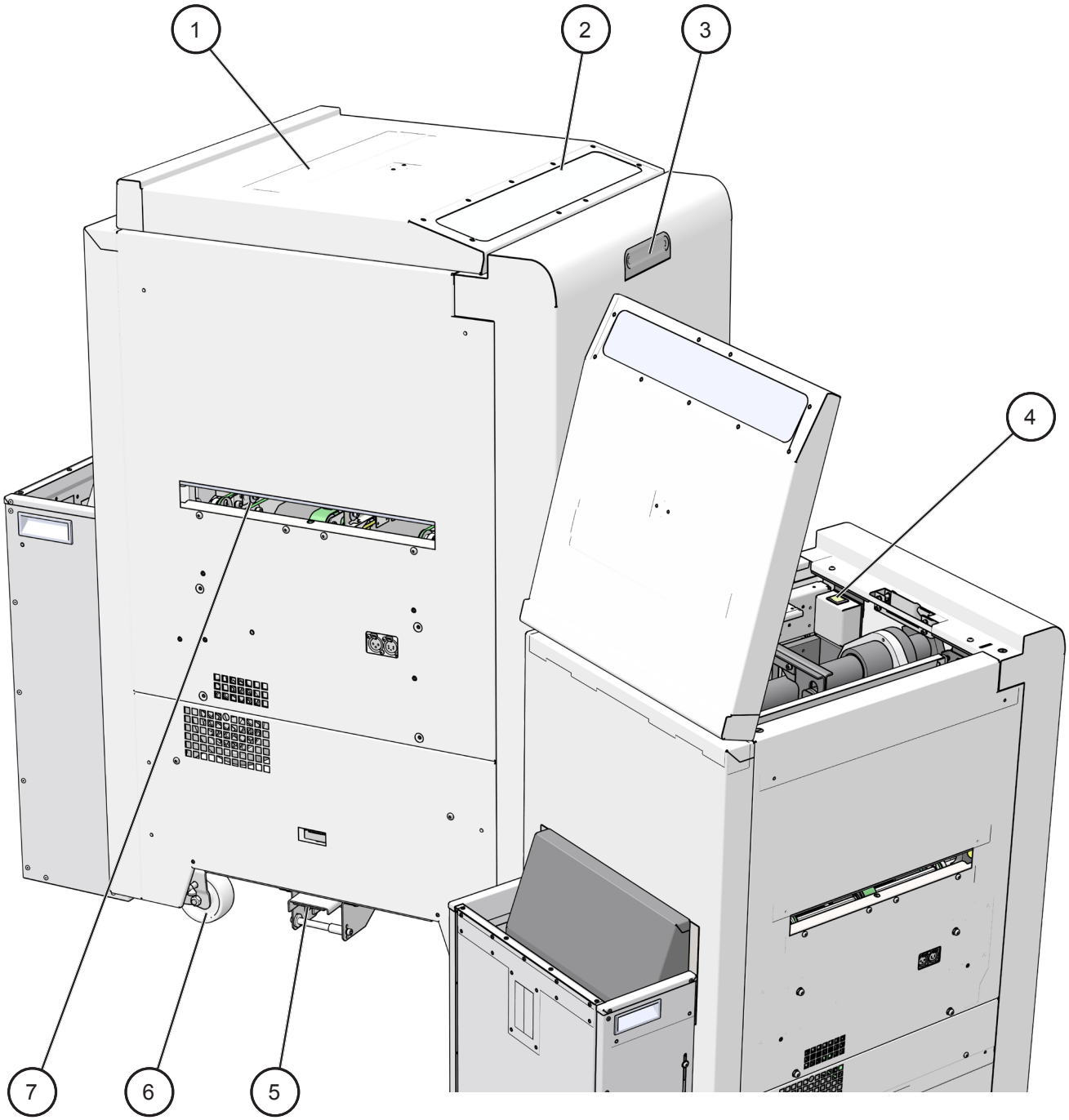




1	Conveyor belt	5	Tray
2	Safety wire	6	Cable protection extension
3	Shackle	7	Docking bracket
4	Support	8	O-ring (drive belt)

ST5000 2 Knife Trimmer

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.

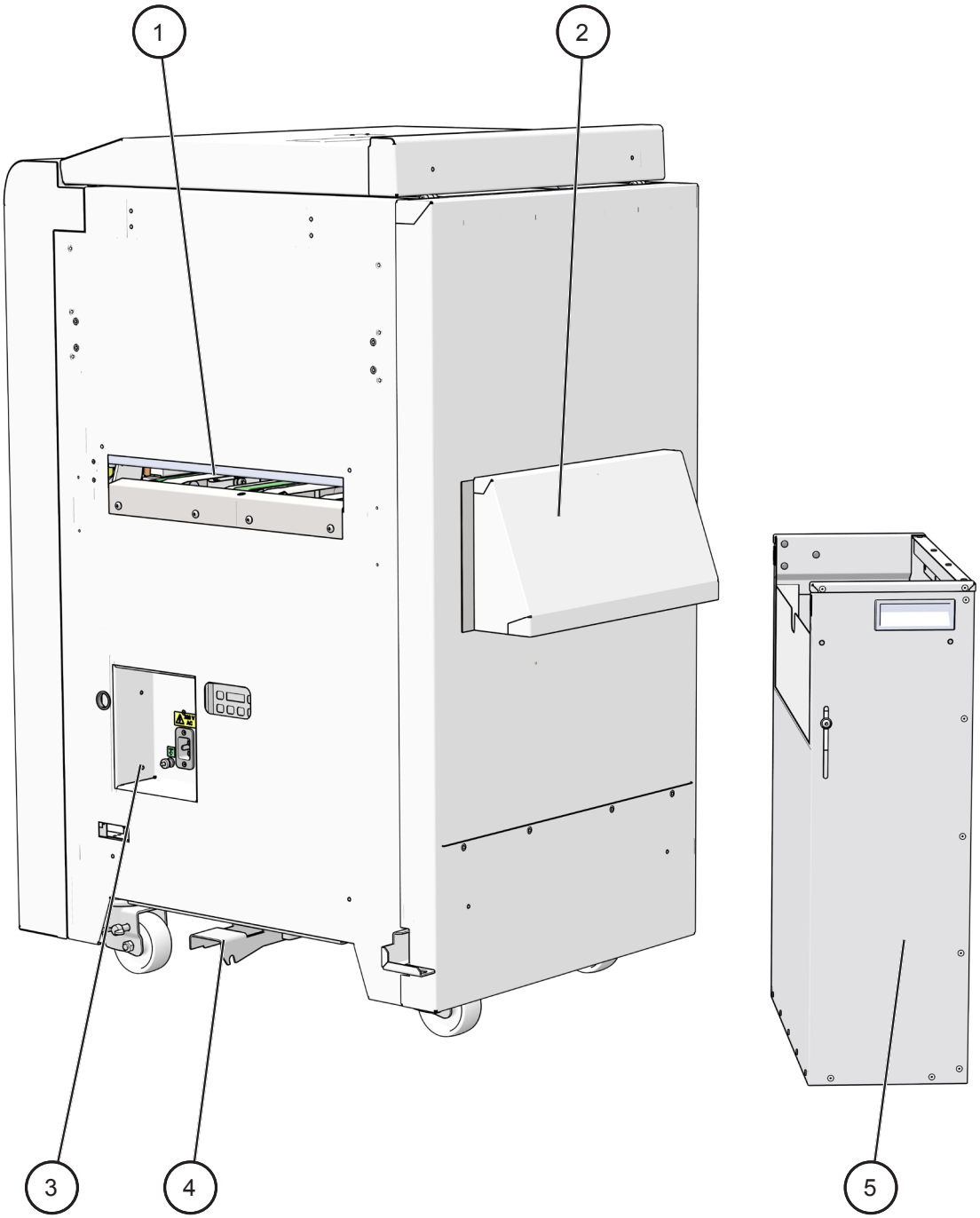


1	Top Cover	5	Docking Latch
2	Top Cover Glass	6	Casters
3	Top Cover Latch Handle	7	Exit Area
4	Main power switch		

continued on next page

ST5000 2 Knife Trimmer, continued

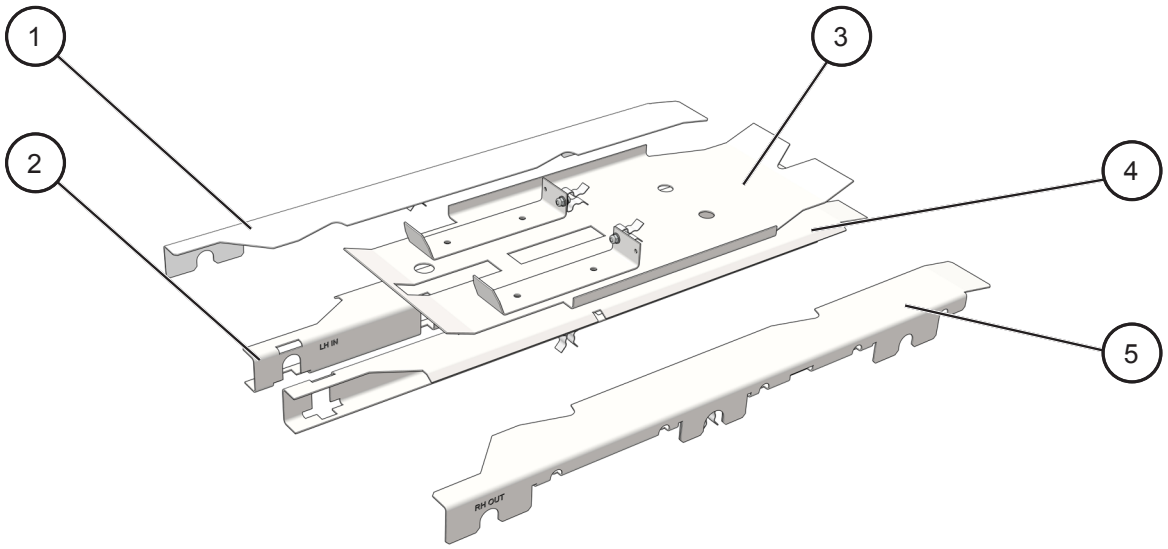
Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.

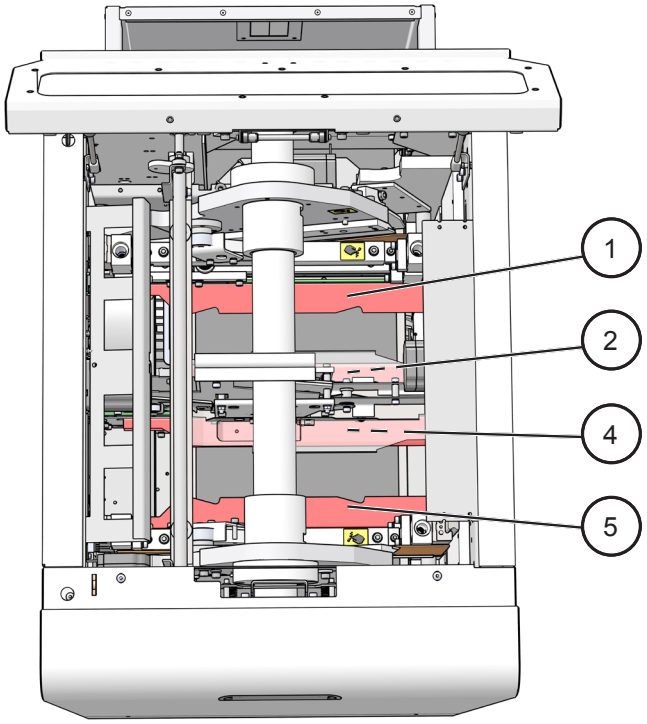


1 Infeed Area
2 Trim Waste Exit
3 Connections and fuses
4 Upstream Docking Bracket
5 Waste Bin

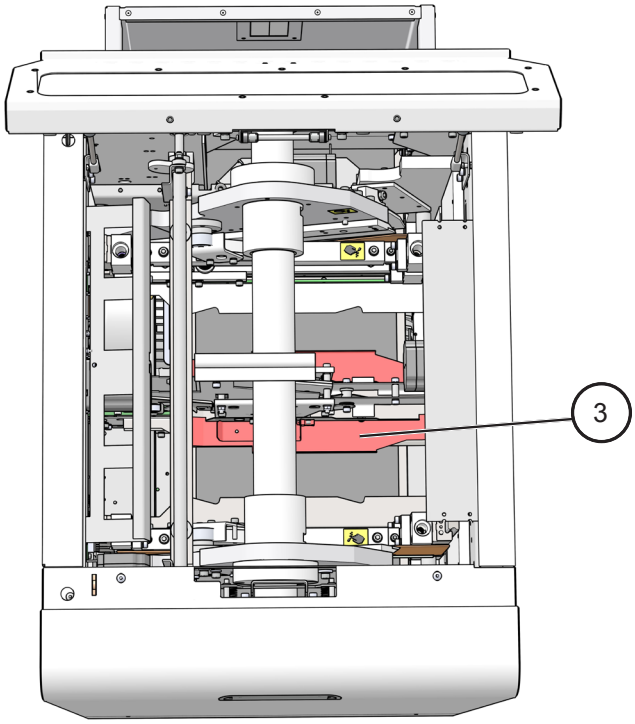
ST5000 2 Knife Trimmer, continued

Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.





Position of Inner and Outer book support inside the ST5000



Position of Centre book support inside the ST5000

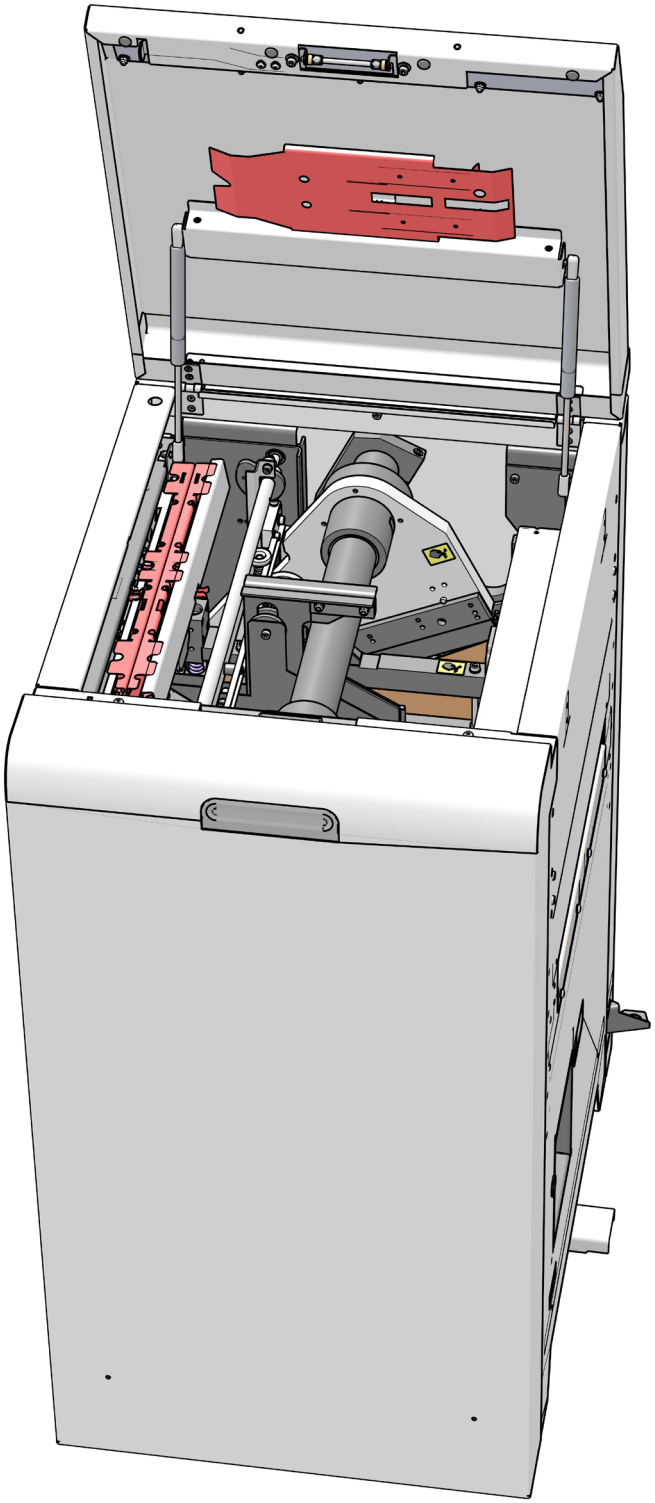
1 Outer book support, left (marked LH OUT)
2 Inner book support, left (marked LH IN)
3 Centre book support
4 Inner book support, right (marked RH IN)
5 Outer book support, right (marked RH OUT)

continued on next page

ST5000 2 Knife Trimmer, continued

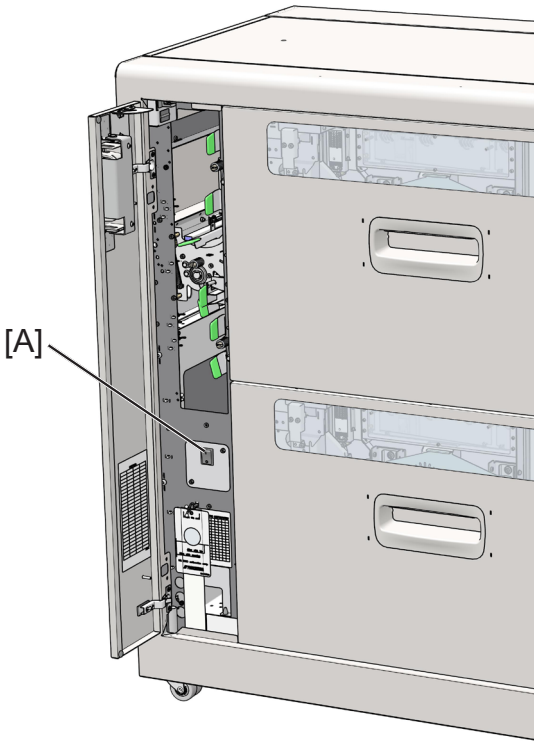
Parts that are important for setup, adjustments, troubleshooting or maintenance are highlighted below.

When not in use, the book supports can be stored inside the ST5000.

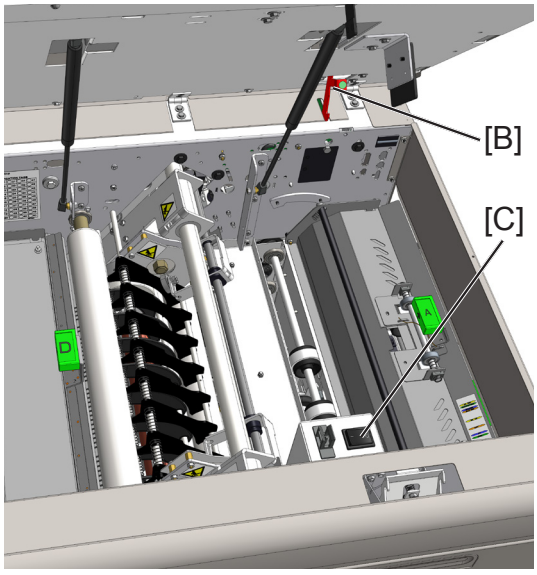


Turning On / Off the Main Power

VFX, CST, Booklet Maker, Finishing Module & BST Module



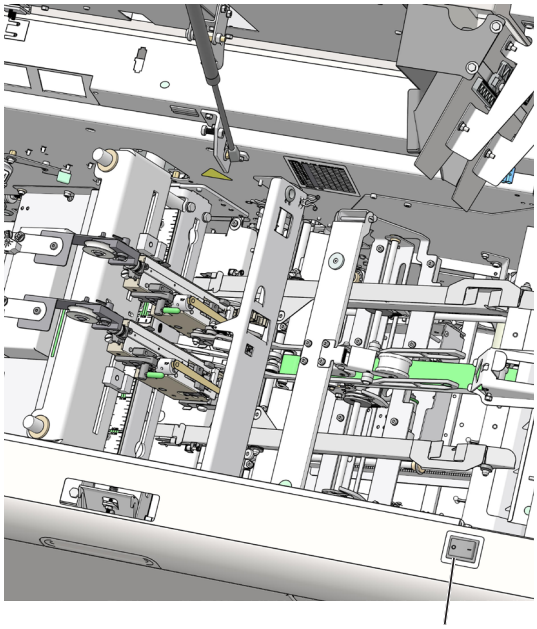
1. Make sure that the power cords to the VFX (optional), CST module (optional), Booklet Maker and BST (optional) are plugged into a live wall outlet.
2. Open the VFX door.
3. Set the main power switch [A] to ON position.
4. Close the VFX door.



5. Open the top cover of the RCT.
6. Slightly push the top cover down and press on the top cover latch [B].
7. Open fully the top cover of the RCT.
8. Set the main power switch [C] to ON position.
9. Close the RCT top cover.

Turning On / Off the Main Power, continued

VFX, CST, Booklet Maker, Finishing Module & BST Module

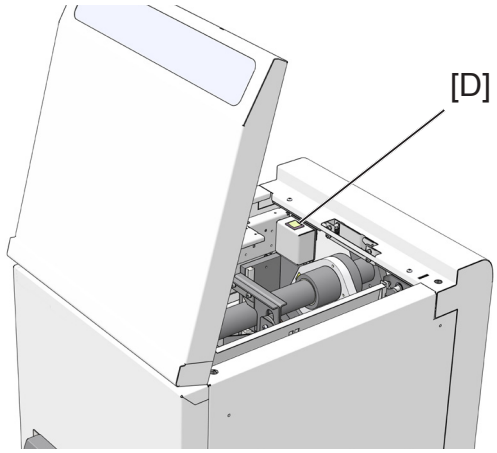


10 Open the Booklet Maker top cover.

11 Set main power switch [C] on Booklet Maker to ON position.

NOTE:
The Finishing Module is powered from the Booklet Maker and does not need to be powered on separately.

12 Close the Booklet Maker top cover.



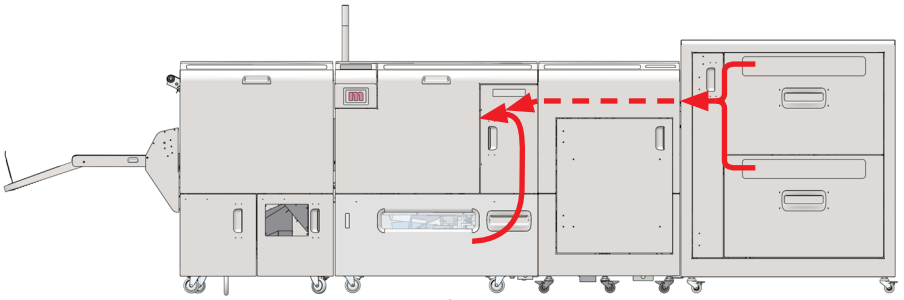
13 Set main power switch [D] on the ST5000 to ON position.



14 Set main power switch [E] on the BST Module to ON position.

How to organize paper stacks for feeding

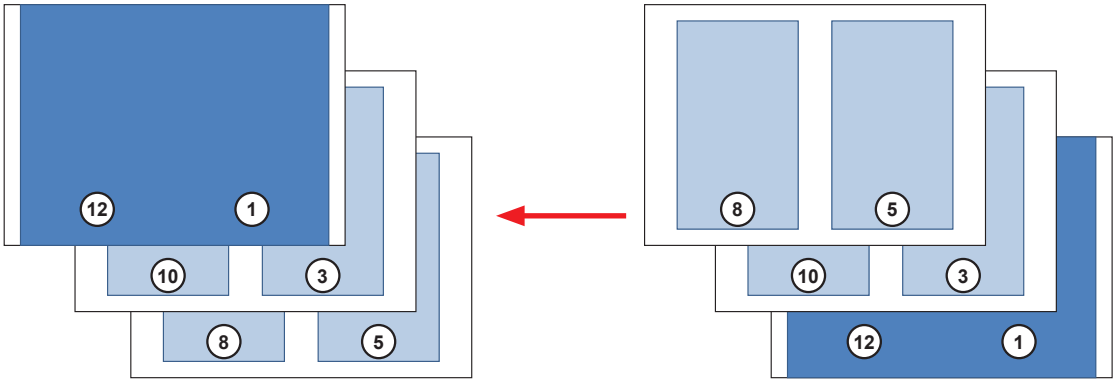
Feeding to the Booklet maker



convenience feeder tray C

Loading sheets when feeding from the VFX

The loaded paper stack should be organized ***face up*** with the centerfold / inner sheet on top of stack and that the cover sheet / last sheet in the set is at the bottom of the stack (N-1).
When fed, the sheets will be transported from the top of the stack in a straight path into the Booklet maker.

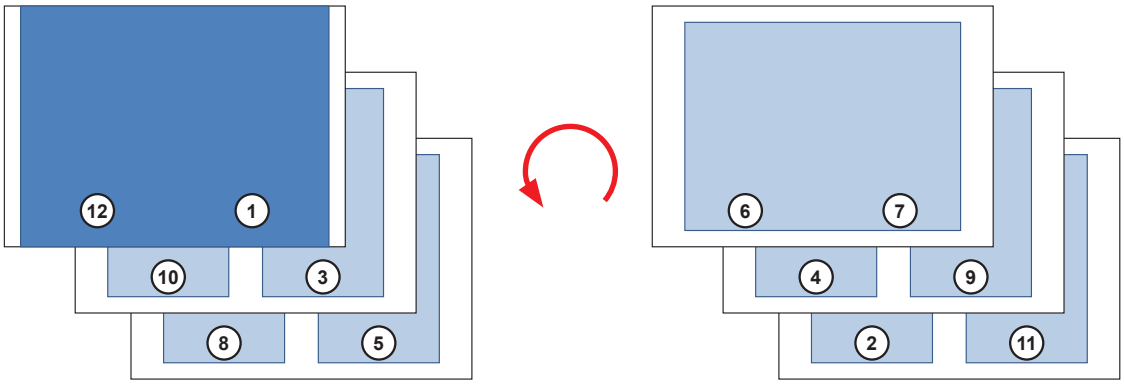


how sheets will end up in the Booklet maker

how sheets must be loaded in the VFX

Loading sheets when feeding from the convenience feeder

The loaded paper stack should be organized ***face down*** with the centerfold / inner sheet on top of stack and that the cover sheet / last sheet in the set is at the bottom of the stack (N-1).
When fed, the sheets will be transported from the top of the stack and flipped over when fed into the Booklet maker.



how sheets will end up in the Booklet maker

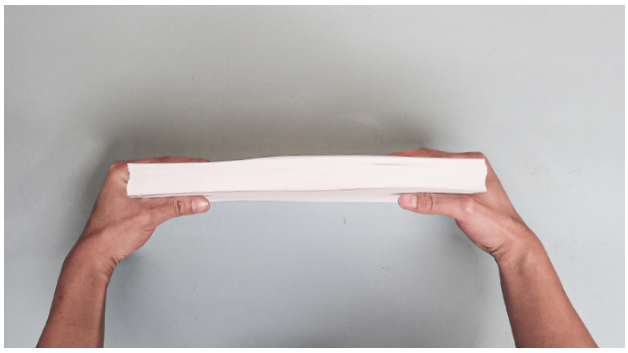
how sheets must be loaded in the convenience feeder

Paper Stack Preparation

General

1

1 Make sure that the ink has completely dried to avoid smearing.



2 Hold the paper stack on a flat surface as shown.



3 Bend the paper stack.



4 Use your fingers and thumbs to pinch the paper stack.

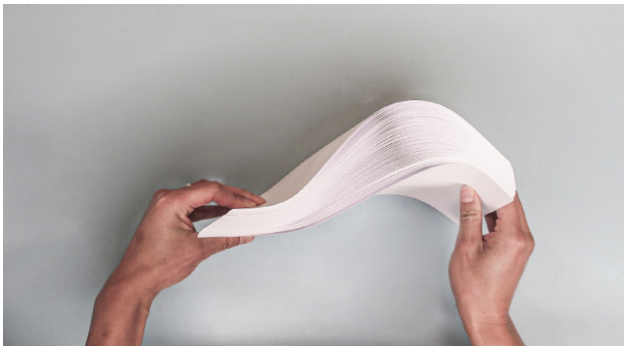


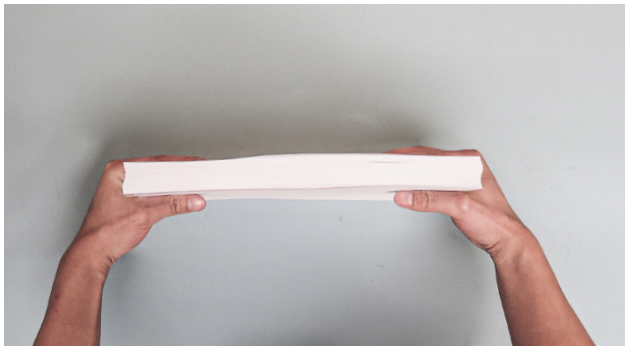
5 With the paper pinched between your fingers, straighten out the paper stack.

General, continued

6 Flex the paper back and forth a couple of times to break surface tension and preseparate the sheets.

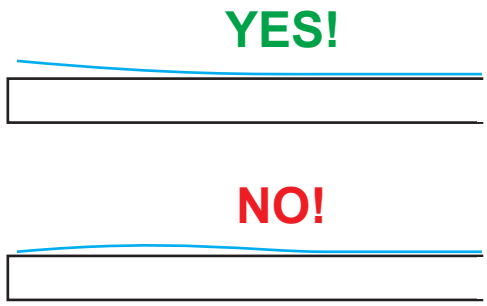






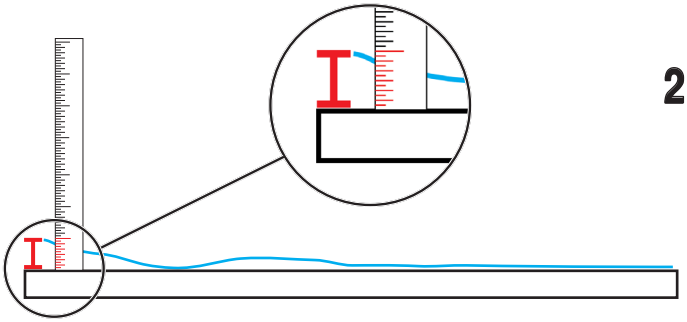
7 Realign the sheets into a stack before putting them into the tray.

Measuring Paper Curl on a single sheet



1 Place the sheet on a flat surface.

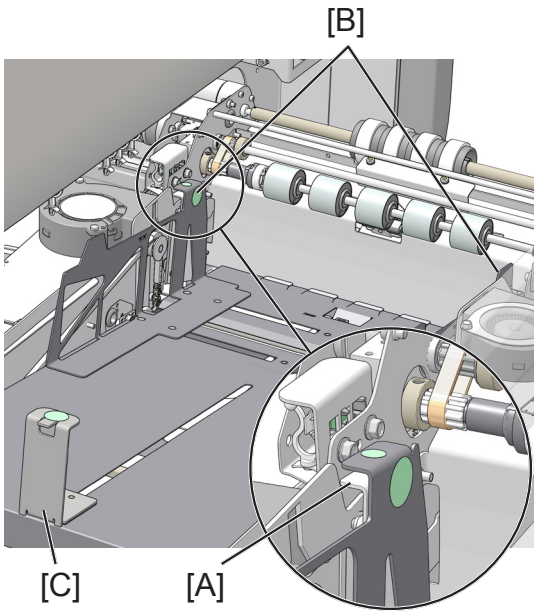
NOTE:
Always measure the positive curl of a sheet, meaning that the leading edge of the sheet should be pointing up as shown in the pictures to the side.

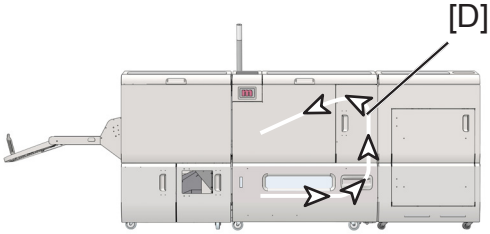


2 Measure the height of the leading edge of the sheet from the surface. Flat curl greater than 10 mm (0.39”) is outside specification.

Convenience Feeder

Loading sheets





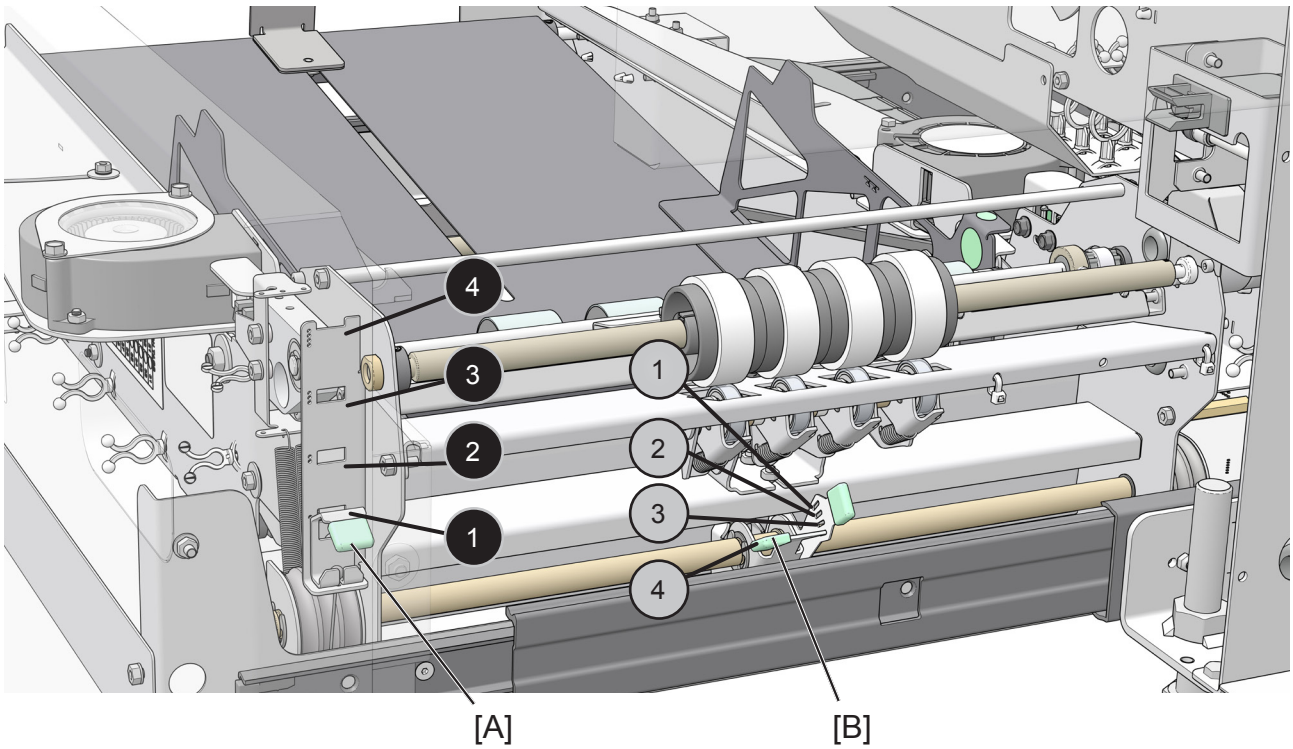
1. Before loading, make sure to follow the General Stack Preparation Procedure described earlier in this section.
2. Lift Release Lever [A] and move Side Guides [B] apart and move Rear Guide [C] outwards.
3. Mind how the sheets travel and are fed on top of the collated set [D] and load the sheets accordingly into the bin.
4. Adjust the side guides [B] and the rear guide [C] up against the sheets until there is no clearance.

NOTE:
Make sure the sheets/covers are same size as sheets fed to Booklet Maker. When using an CST, see Note under "Changing settings, Finished Booklet Size, Custom booklet size".

Convenience Feeder settings

Feeder settings may vary depending on thickness and friction of the media. Start from these suggested settings below and make adjustments until you get a good feed.

According to media run, see table below for approximate settings of Feed Roller pressure and Separation.



Paper weight	Feed Roller [A]	Separation [B]
Thin, 80-120gsm	1	4
Medium, 120-200gsm	2	4
Thick, 200-350gsm	3	3

Convenience Feeder settings guidance table

When experiencing misfeeds:
First reduce Separation and then increase Feed Roller pressure.

When experiencing double-feeds:
First decrease Feed Roller pressure and then increase Separation.

In case of marks on the sheets, decrease both Separation and Feed Roller pressure or one at a time.

There are three types of markings on the sheets that could be tracked to faulty feeder settings.

- markings on the following/second sheet - reduce Feed Roller pressure
- markings on the underside of the sheet being fed - reduce Separation
- Sheet torn around the separation pad - reduce Separation

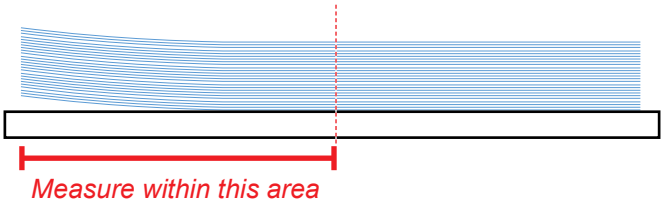
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Preparing the VFX Feeder

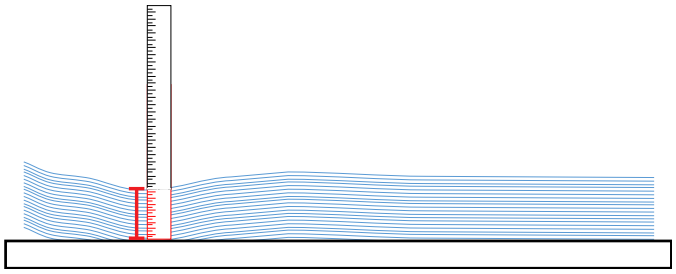
Measuring Paper Curl on a stack of sheets

Take a sample of the stack (about 15 mm / 0.59” high) and place it on a flat surface

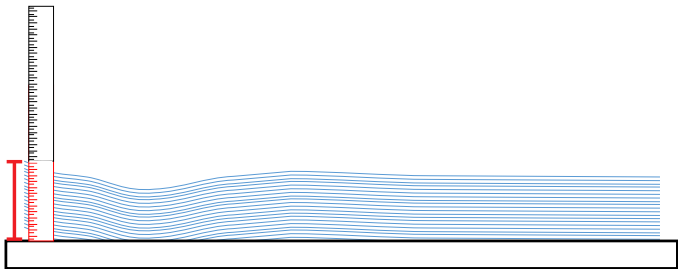
1 Take the midpoint as reference and do all the measurements within the marked area of the picture (from the center to the leading edge in paper feed direction)



2 Measure the lowest point of the stack of paper

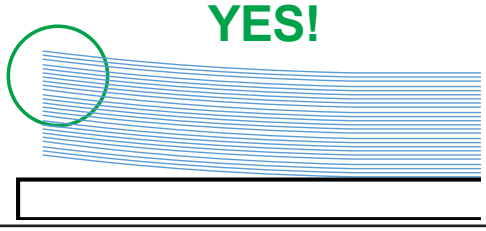


3 Measure the height of the leading edge of stack of paper: the difference between the leading edge and the lowest point is the amount of paper curl

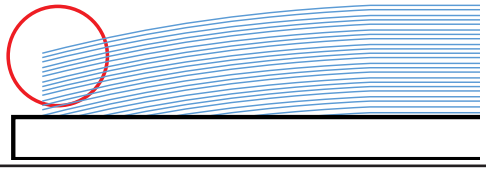


*NOTE: always **measure** the positive curl of a stack of paper, meaning that the leading edge of the stack should be **pointing up** as shown in the pictures below.*

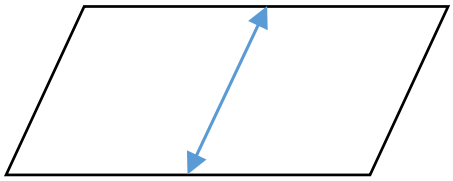
YES!



NO!

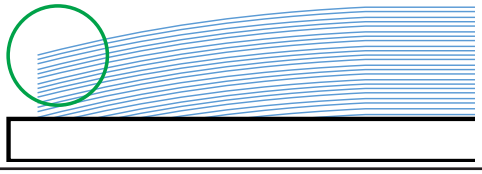


This procedure can also be used to measure the cross process direction curl.

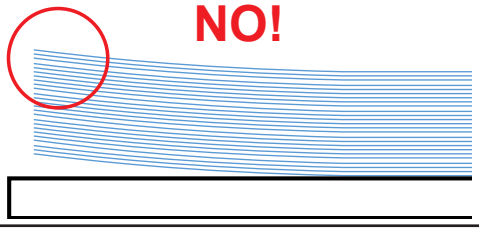


After having measured the curl amount, it is recommended to **load** the vacuum trays with the paper edge **pointing down** (and to insert the negative curl amount in the UI).

YES!

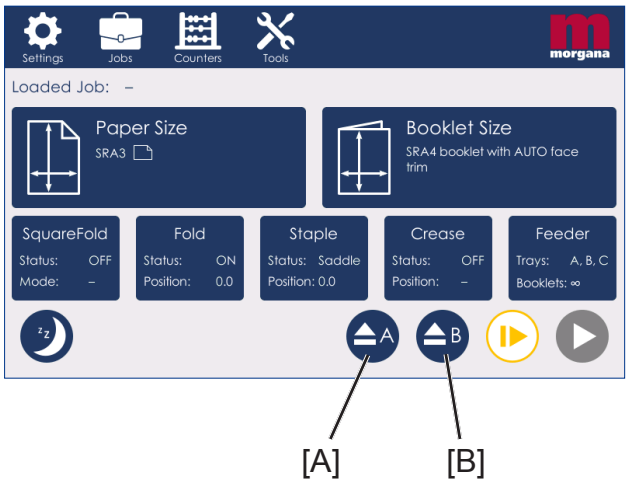


NO!



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Loading paper in the VFX Feeder



1 From the Start screen, press the [A] or [B] button depending on which tray you intend to open and load. Tray A is the upper tray.

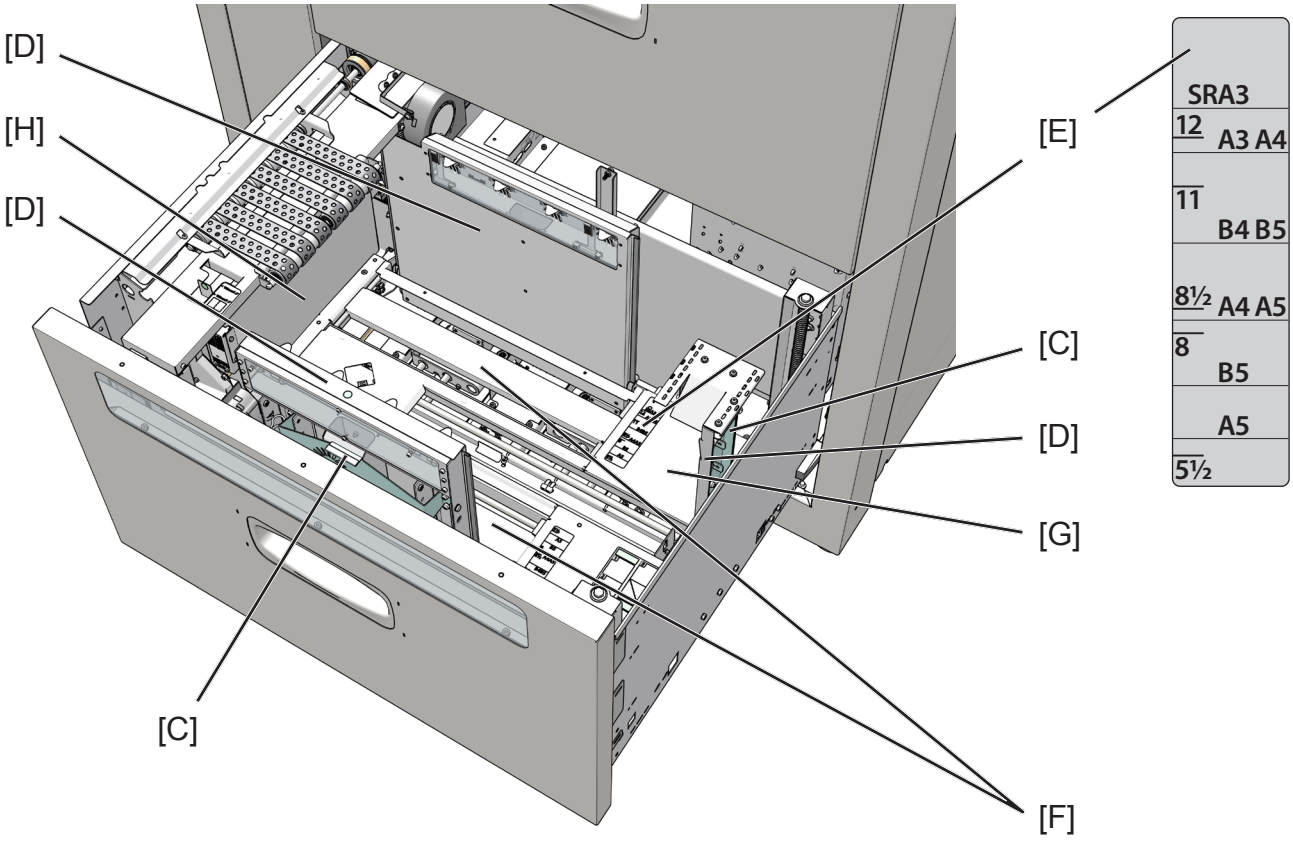
NOTE
If you open both trays, for stability reasons, they cannot be pulled out fully at the same time.

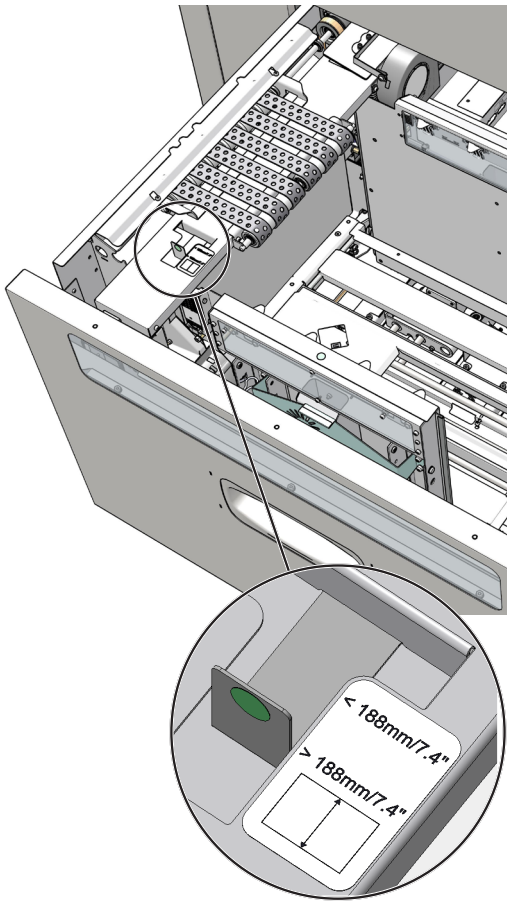
2 Lift the Paper Guide lock release levers [C] and move the Paper Guides [D] inwards and adjust them according to the size of the paper, see label [E]. If paper stack is wider than 260 mm / 10.24" install the Wide Paper Supports [F].

3 Prepare the stack of paper following the General Stack Preparation Procedure described earlier in this section.

4 If running jobs in Auto Feeder Mode, measure the paper curl and insert the value in the UI. See Section 2, "Operation with VFX".

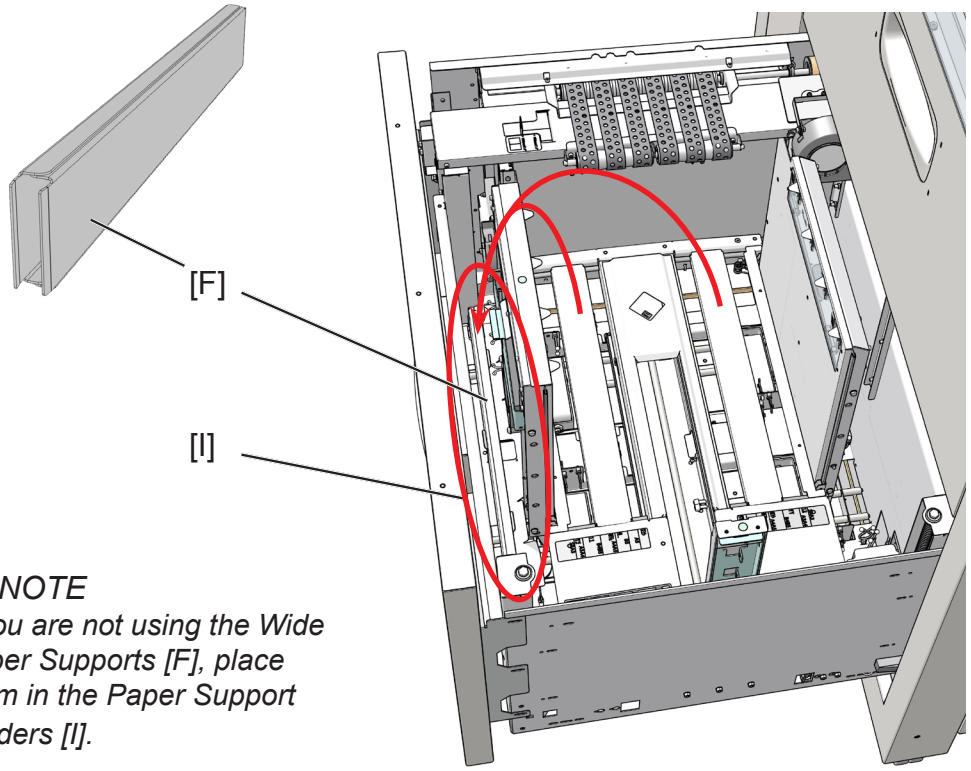
5 Place the sheets on the elevated tray bottom [G]. Place the leading edge of the sheets against the Separation Frame [H], underneath the vacuum belts.





6 The Vacuum Size Valve controls the size of the vacuum suction area on the bottom of the vacuum chamber. The Vacuum Size Valve needs to be manually shifted to the correct position, which depends on paper width. If paper width is greater than 188 mm, the lever needs to be positioned as shown. If paper width is less than 188 mm, the lever needs to be shifted to the corresponding position (<188mm/7.4”).

7 Close tray and repeat procedure on the other tray if required.



NOTE
If you are not using the Wide Paper Supports [F], place them in the Paper Support Holders [I].

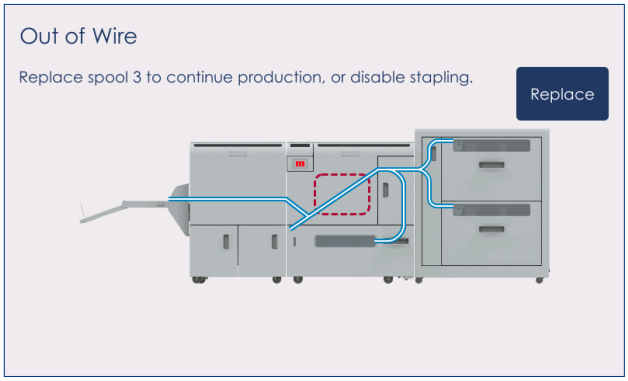
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Stitching heads

The Booklet Maker can be equipped with two or four stitching heads. To match different stapling scenarios, the stitching heads can be moved to different positions and also be disengaged for example when corner stapling.

NOTE:
Edge and corner stapling capability might not be available on all systems.

Out of Wire

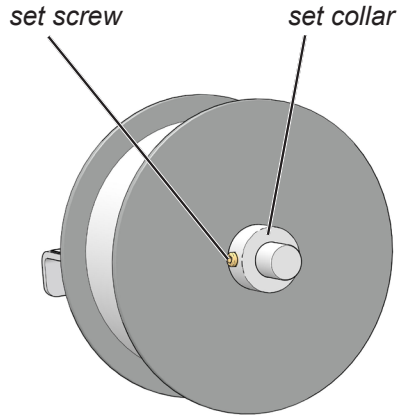


The User Interface will indicate “Out of Wire” and which Spool if the Booklet Maker has performed 5 – 7 staple cycles and if the Wire Spool has stopped rotating. The reason for the Spool to stop rotating could be either that the Wire Spool is empty or that the Wire Spool Spring pressure (brake force) is incorrectly set.

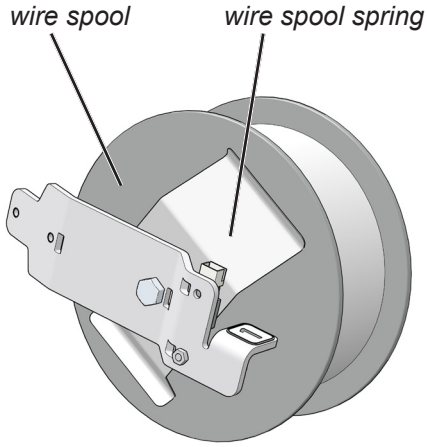
Open the Top Cover to check.

If the Wire Spool is found to be empty, there are approximately 15 staples left in the stitching head. Replace the empty Spool to continue production or disable stapling action for that Stitching Head. See “Replacing Wire Spool(s)” or “Engage/disengage Stitching Head(s)” below.

If the Wire Spool is found ***not*** to be empty, the Wire Spool Spring pressure might be incorrect.



If the spring pressure set too high, the Wire Spool can be obstructed from rotating. This might result in too short staples or that the Wire Spool does not rotate at all.
Setting the spring pressure set too loose can cause the Wire Spool to unwind too much wire at a time instead of slowly unwinding Wire in an even pace.

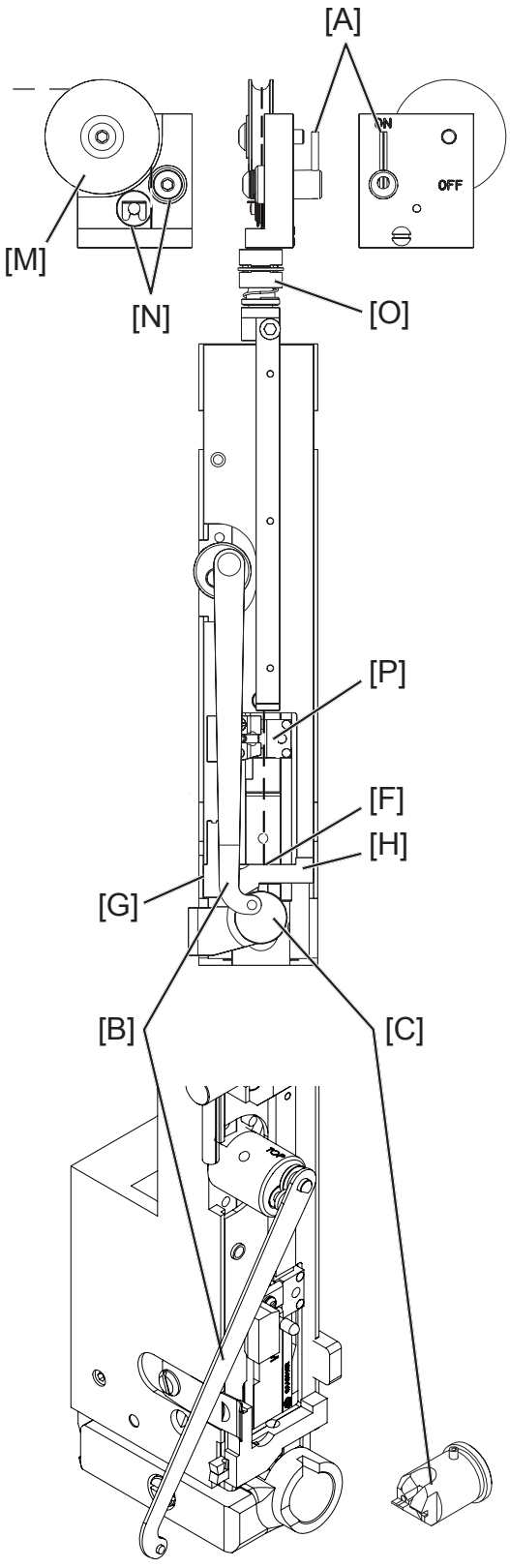


Set the Wire Spool Spring pressure (brake force) as follows:
Loosen the set screw and push in the Set Collar and the Wire Spool so that the Wire Spool Spring compresses approximately 2 mm (5/64″). This to exert the smallest amount force possible on the Wire Spool but still to prevent it from spinning by itself and unwinding the Wire.
Setting the spring pressure (brake force) too high might result in too short staples or that the Booklet Maker will detect “Out of Wire if the spool does not rotate at all.

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Out of Wire, continued

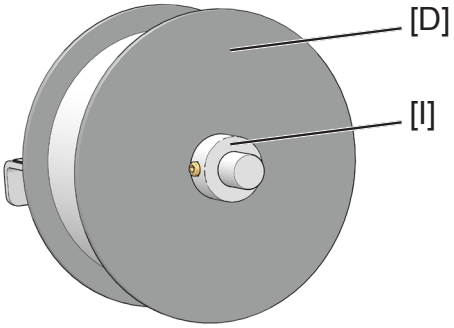
Replacing Wire Spool(s)

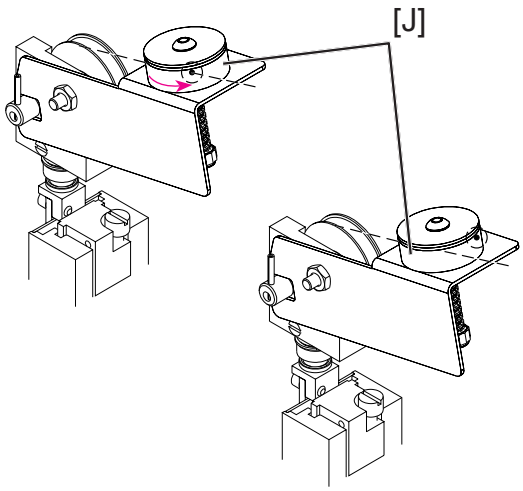


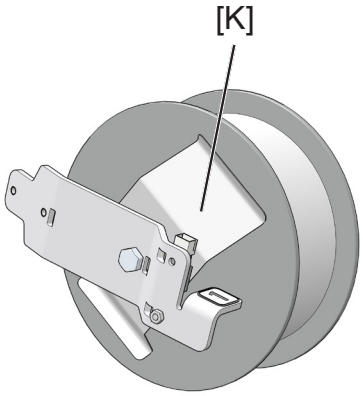
1. Select a large paper size (SRA3 or 11x17”) in order to move the rear jogger assembly away from the stitching heads.
2. Turn off the Booklet Maker.
3. Turn the Wire Threading Lever [A] clockwise to the “Off” position (3 o’clock) to relieve pressure on the Wire.
4. Removing the Rotator Operating Spring [B] and then the Magnetic Rotator [C] is not necessary but will give better access. Remove by lifting the Rotator Operating Spring [B] at the lower end, swing it aside and remove the Magnetic Rotator [C]
5. Use tape or a rubber band to make sure the remaining Wire (if any) on the Wire Spool [D] is stopped from unwinding when the Wire is cut.
6. Cut the Wire between the Spool and the Wire Guide Spring assy [E].
7. Pull the Wire from hole [F] above the Cutter [G] in the Face Plate assy [H] just above the Magnetic Rotator [C] and then pull the Wire downwards to remove it from the Stitching Head.
8. Loosen the set screw in the Set Collar [I] and remove the Set Collar from the Wire Spool Shaft. Remove the Wire Spool [D].
9. Rotate the Felt Pads [J] slightly so that a clean area can be used for cleaning and lubricating the Wire on the new Wire Spool. Dampen the Felt Pads with 3-5 drops of SAE 20W oil, see “Maintaining Your Machines in section 7, “Remarks”.
10. Install the new Wire Spool so that it just touches the Wire Spool Spring [K]. The Spring act as a friction brake and its purpose is to prevent the Spool from spinning by itself and unwinding the Wire when the Stitching head pulls more wire from the spool.

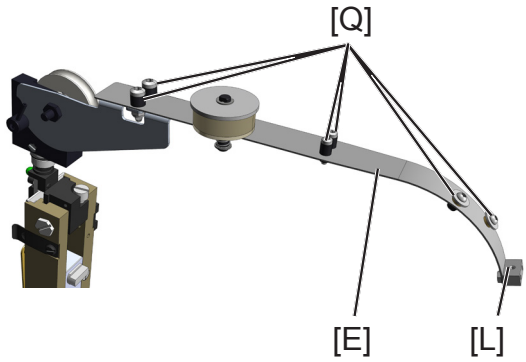
Out of Wire, continued

Replacing Wire Spool(s), continued









11 Install the Set Collar [I] on the Wire Spool Shaft. Push in the Set Collar and the Wire Spool so that the Spring compresses approximately 2 mm (5/64″). This to exert the smallest amount force possible on the Wire Spool but still to prevent it from spinning by itself and unwinding the Wire.

NOTE:
Setting the spring pressure (brake force) too high might result in too short staples or that the Booklet Maker will detect "Out of Wire if the spool does not rotate at all.

12 Use tape or a rubber band to make sure the Wire on the new Wire Spool [D] is stopped from unwinding when the Wire is released.

13 Feed the Wire through the Thread Guide Block [L] and over the Wire Guide Pulley [M], down between the Straightening Rollers [N] and into the hole as indicated.

14 Push down on the Check Pawl Collar [O] to continue feed the Wire. The Collar can be released when Wire gets past the Check Pawl.

15 Continue to feed the Wire, and watch for it to come out past the Gripper [P].

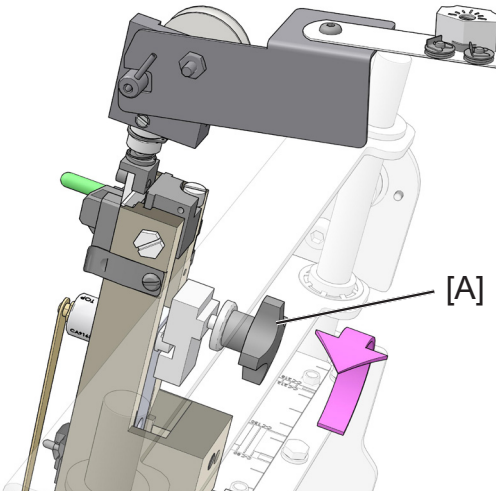
16 Feed a little more Wire and guide it into the hole [F] above the Cutter [G] in the Face Plate assy [H]. Allow the Wire to enter this hole about 3 mm (1/8″).

17 Turn the Wire Threading Lever [A] counter clockwise to the "On" position (12 o'clock).

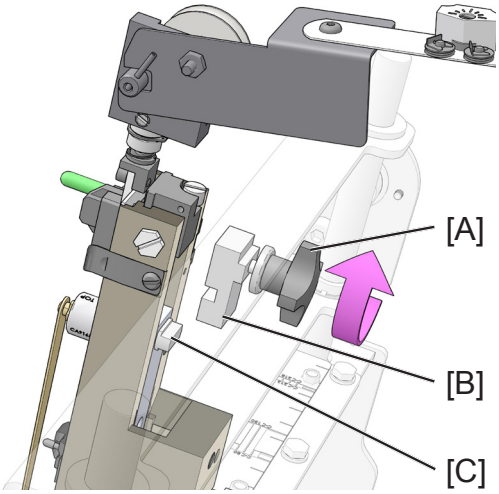
18 Install the Wire between the Wire Guide [Q] and between the thick and thin round Felt Pads [J] in the Wire Guide Spring assy [E].

Engage/disengage Stitching Head(s)

Disengaging Stitching Head(s)

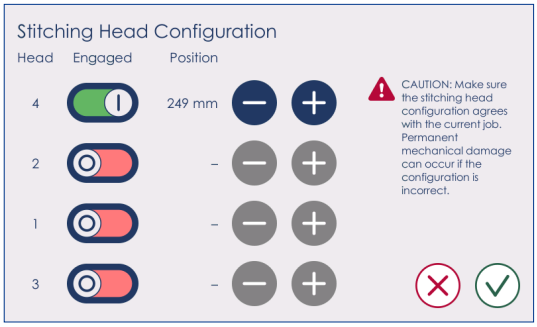


1 Loosen the Knob [A]



2 Move the Knob and the Stitching Head Clutch [B] away from the Stitching Head Driver [C].

3 Tighten the Knob [A] to prevent Stitching Head from being engaged by mistake.
The Stitching Head is now mechanically disengaged.



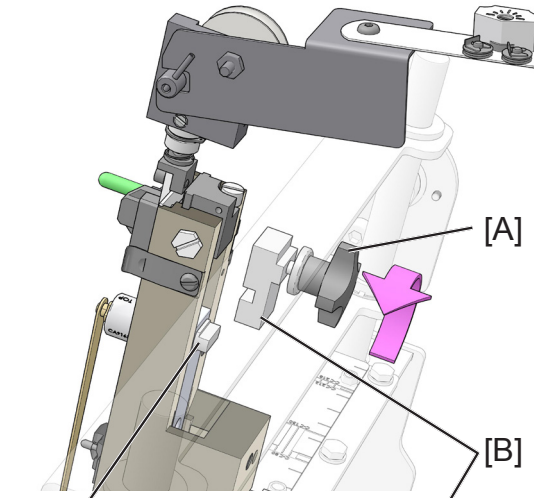
4 Open the Stitching Head Configuration screen and set the disengaged Stitching Head switch to “Disengaged”.

The Stitching Head Configuration screen must reflect wether stitching heads are engaged and where they are positioned. See section 3, “Tools”.

⚠ **CAUTION:**
Make sure that the information about the position of the stitching heads and whether they are engaged is correct. Severe permanent damage to the stitching heads, clinchers and/or the side guides might occur otherwise.

Engage/disengage Stitching Head(s), continued

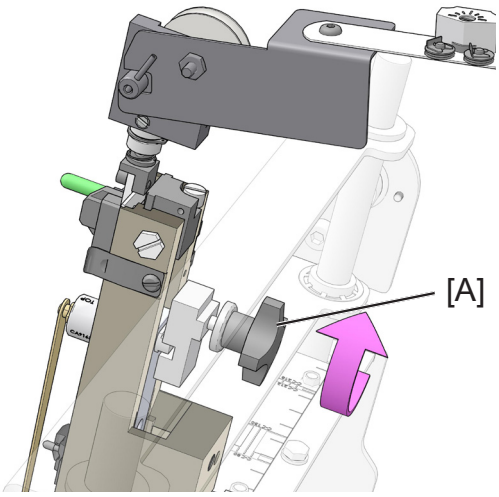
Engaging Stitching Head(s)



1 Loosen the Knob [A]

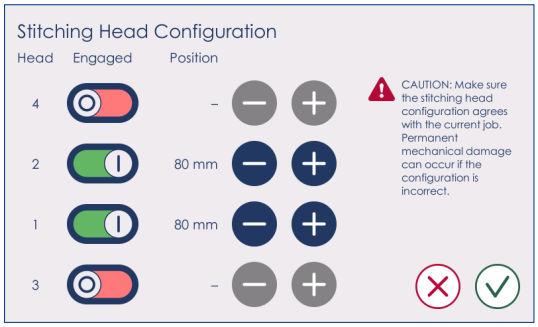
2 Move the Knob and the Stitching Head Clutch [B] towards the Stitching Head Driver [C].

3 Lift the Stitching Head Driver [C] and mate with the Stitching Head Clutch [B].



4 Tighten the Knob [A].

5 Open the Stitching Head Configuration screen and set the disengaged Stitching Head switch to “Disengaged”.

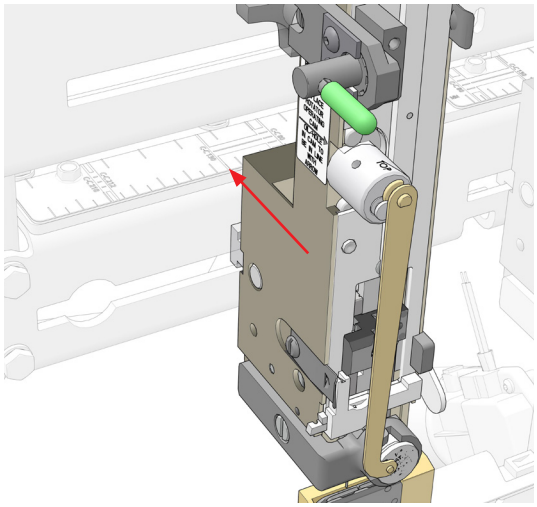


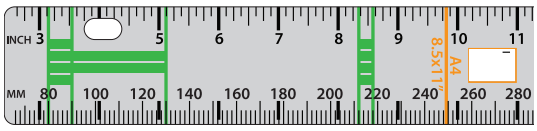
The Stitching Head Configuration screen must reflect wether stitching heads are engaged and where they are positioned. See section 3, “Tools”.

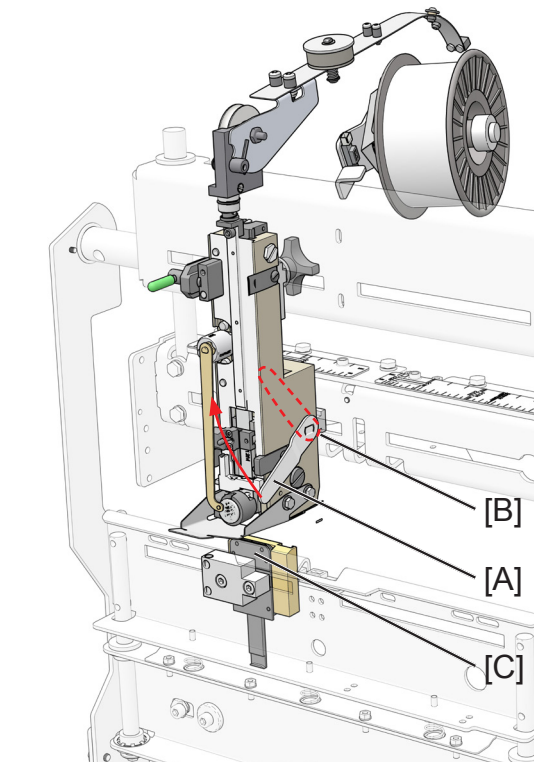
⚠ **CAUTION:**
Make sure that the information about the position of the stitching heads and whether they are engaged is correct. Severe permanent damage to the stitching heads, clinchers and/or the side guides might occur otherwise.

Changing Staple position

Moving Stitching Head(s)







Looking along the left side of any Stitching Head, the actual staple position, center to center, can be read on the scale behind.

The purpose of the scales is to show Stitching Head positions where to avoid skew folding and damaging of the sheets especially when running booklet with few sheets in the set.

When two Stitching Heads are installed - use any positions marked with green lines, two or four.

When four Stitching Heads are installed - use positions with four green lines.

NOTE:
Distances on the scales are center to center.

There is also an orange line that indicates where to position the Stitching Head when using corner stapling.

NOTE:
Edge and corner stapling capability might not be available on all systems.

1. To move a Stitching Head, lift the Bonnet Clamp Eccentric Handle [A] to the approximate position [B]. The Stitching Head can now be moved sideways to another stapling position.
2. In the new position, push down the Bonnet Clamp Eccentric Handle [A] to lock the Stitching Head.
3. If the Stitching head should be engaged in its new position, move the Stitching Clutch so that the Stitching Head Driver will be mechanically engaged. See “Engage/Disengaged Stitching Heads” on the previous page.

⚠ CAUTION:
Make sure to align the Clincher [C] with the Stitching Head. See next page.

4. Open the Stitching Head Configuration screen and enter the proper Stitching Head configuration. See section 3, “Tools”.

The Stitching Head Configuration screen must reflect wether stitching heads are engaged and where they are positioned.

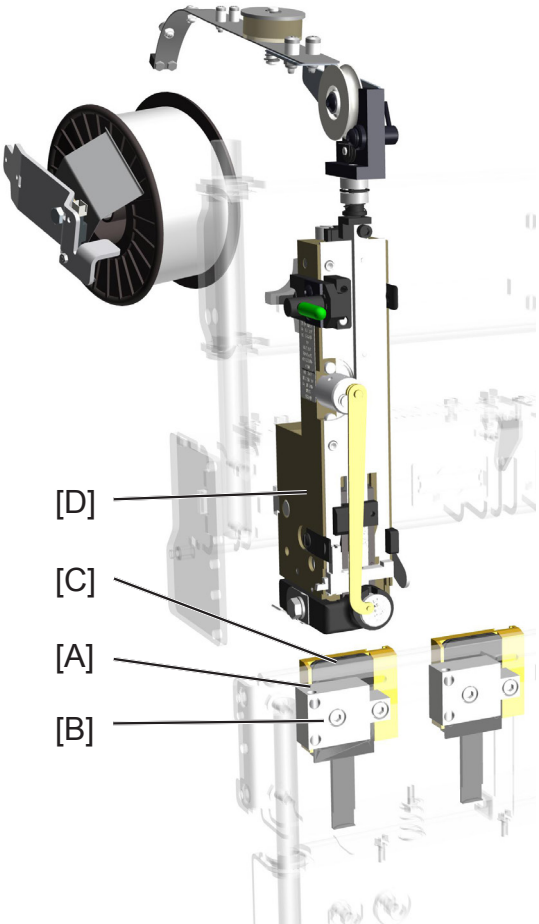
⚠ CAUTION:
Make sure that the information about the position of the stitching heads and whether they are engaged is correct. Severe permanent damage to the stitching heads, clinchers and/or the side guides might occur otherwise.

Changing Staple position, continued

Moving Clincher(s)

The Booklet Maker is delivered with four Clinchers as standard, this in preparation for four stitch head option. This simplifies the clincher positioning.

To move the Clinchers, obtain the 3 mm hex key from the Stitching Tools compartment in the Front Door.

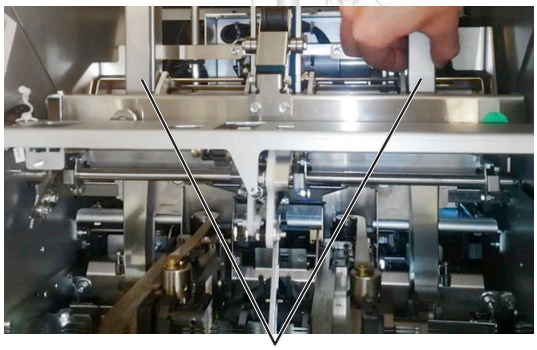


1 Using the 3 mm hex key, loosen the Set Screw [A] in the Clinch Lock [B]. The Clincher [C] can now be moved sideways to align with the Stitching Head [D].

In case the Side Joggers [E] are blocking the Clinch Lock Set Screws, grasp the Side Joggers as indicated and move them aside.

⚠ WARNING
Side Joggers have sharp edges. Grasp as illustrated when moving them aside.

⚠ CAUTION:
Make sure to align the Clincher with the Stitching Head. See below.

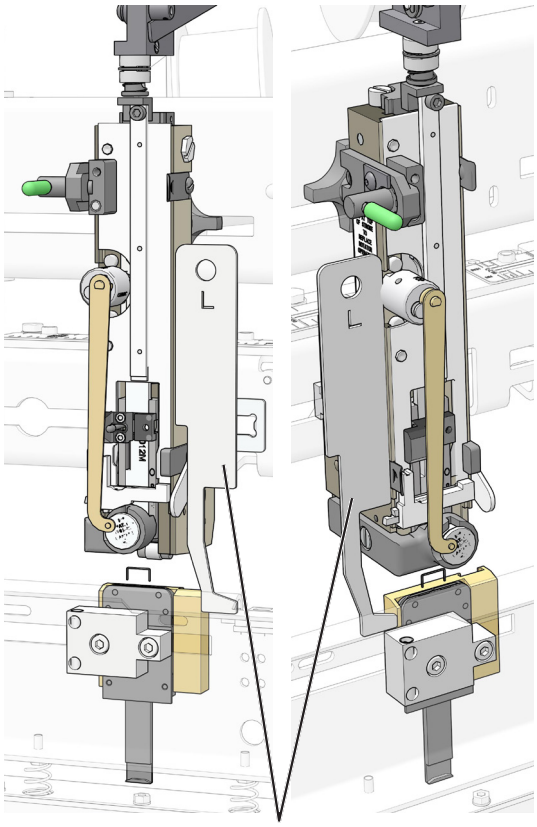


2 Open the Stitching Head Configuration screen and enter the proper Stitching Head configuration. See section 3, “Tools”.

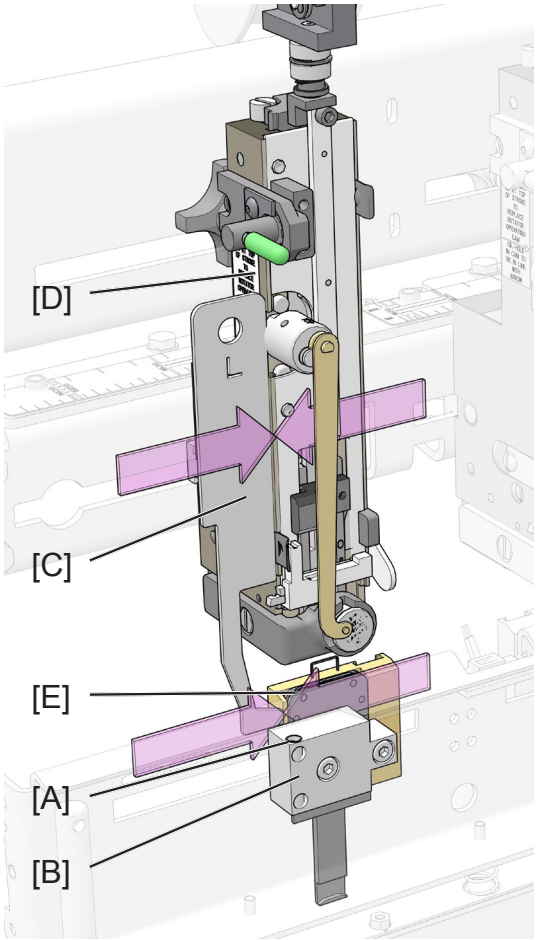
The Stitching Head Configuration screen must reflect wether stitching heads are engaged and where they are positioned.

⚠ CAUTION:
Make sure that the information about the position of the stitching heads and whether they are engaged is correct. Severe permanent damage to the stitching heads, clinchers and/or the side guides might occur otherwise.

Aligning Clincher(s)



Clincher Tool “L”



The clinchers must be properly aligned with the stitching heads to operate without malfunction or damage.

To align a clincher to a stitching head, first obtain the Clincher Alignment Tools from the Stitching Tools compartment in the Front Door.

Use the Clincher Tool marked “L” when aligning number 1 and 3 Clinchers to their Stitching Heads.

Use the Clincher Tool marked “R” when aligning number 2 and 4 Clinchers to their Stitching Heads.

Both Clincher Tools can be used on either side of the Stitching Heads. Choose the side that is most convenient.

This example uses Clincher Tool “L”.

1. Loosen the Set Screw [A] in the Clinch Lock [B].
2. Place the upper part of the Clincher Alignment Tool [C] flush on the side of the Stitching Head [D].
3. Move the Clincher [E] so it touches the lower part of the Clincher Tool.
4. Tighten the Set Screw [A].

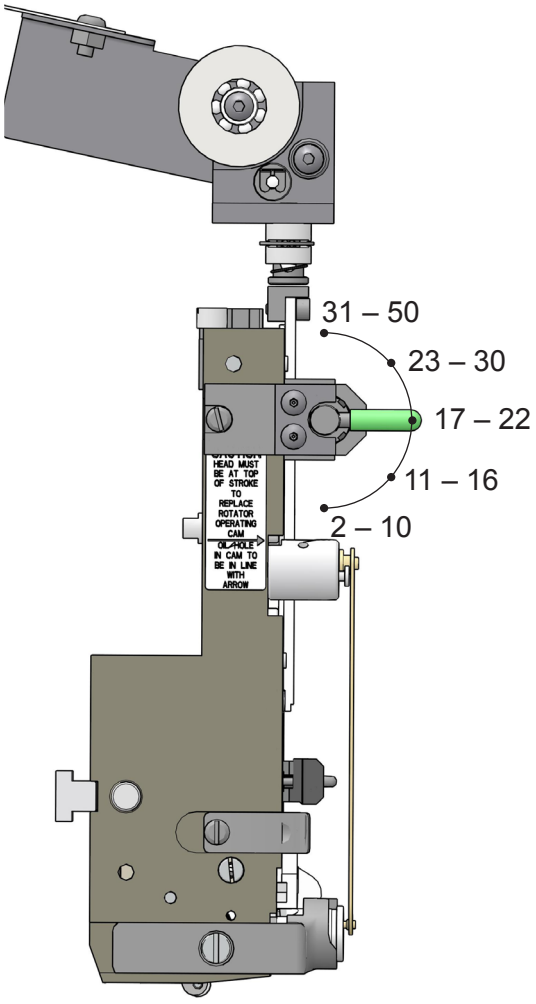
⚠ **CAUTION:**
Do not over tighten the Set Screw.

5. Open the Stitching Head Configuration screen and enter the proper Stitching Head configuration. See section 3, “Tools”.

The Stitching Head Configuration screen must reflect wether stitching heads are engaged and where they are positioned.

⚠ **CAUTION:**
Make sure that the information about the position of the stitching heads and whether they are engaged is correct. Severe permanent damage to the stitching heads, clinchers and/or the side guides might occur otherwise.

Wire Draw Adjustment



The Stitching head is equipped with a 5 position eccentric Adjuster Lever Assembly.This lever changes the length of wire used to staple the booklet.

The down position results in the shortest length of wire for stapling books with 2–10 sheets.

The middle position results in a medium length of wire for stapling books with 17–22 sheets.

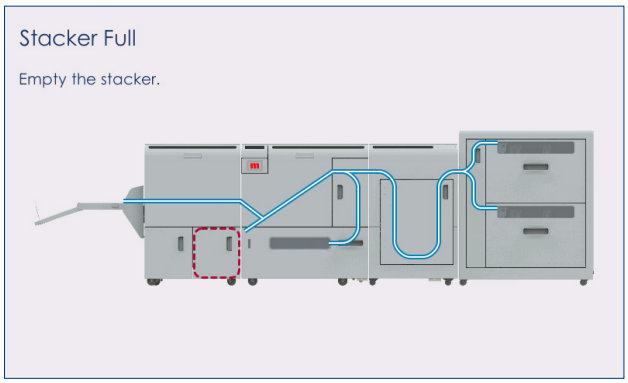
The up position results in the longest length of wire for stapling booklets with 31 or more sheets.

In between positions can be used for stapling books with 11–16 or 23–30 sheets.

3–4 sample booklets should be stitched and inspected to see a change in the wire length inside the booklet.

Emptying the Edge and Corner Staple Stacker

The Edge and Corner Staple Stacker is located in the Finishing Module behind the right door on the front side.

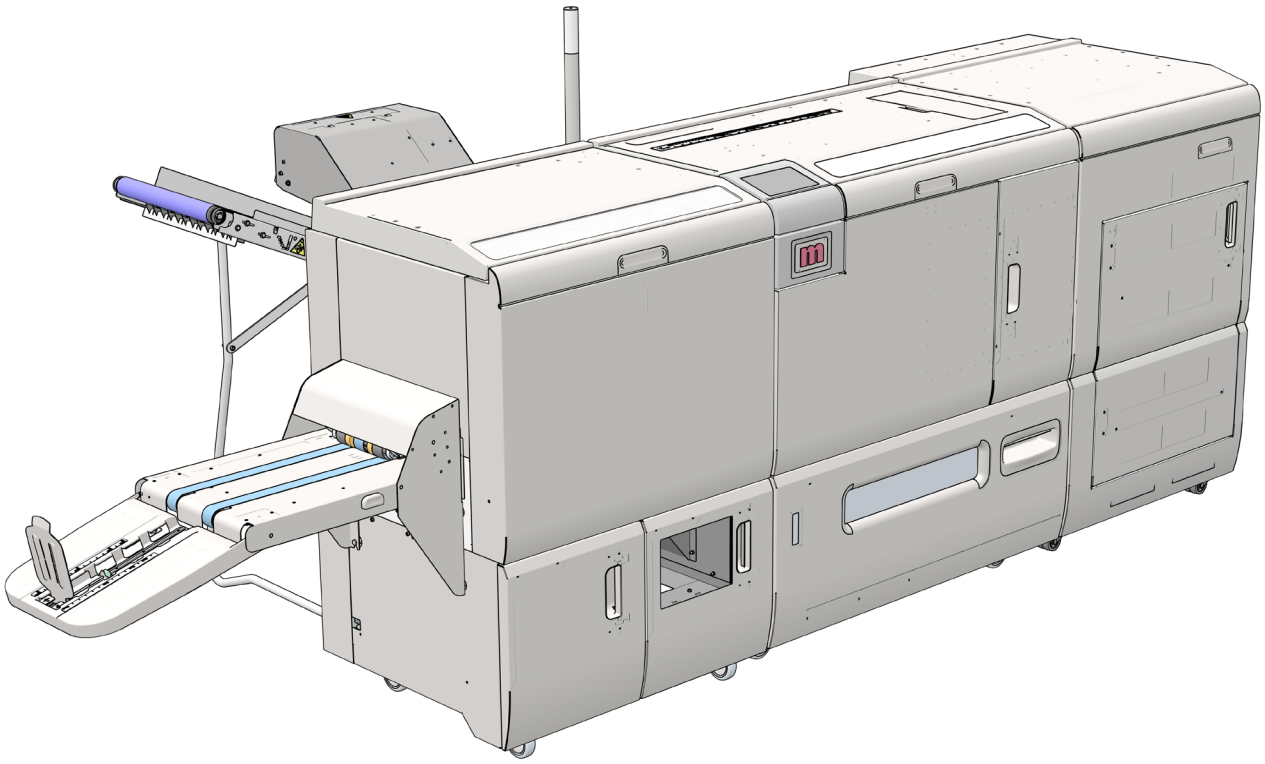


The message “Stacker Full” will be shown on the User Interface when the Edge and Corner Staple Stacker is full. Unload the Stacker by reaching through the opening in the Door.

The Stacker can be unloaded during run.

NOTE:
There is no need to open the Door to unload the Corner and Edge Staple Stacker. The stack can be reached through the opening in the Door.

NOTE:
Edge and corner stapling capability might not be available on all systems.



Emptying the trim waste bins

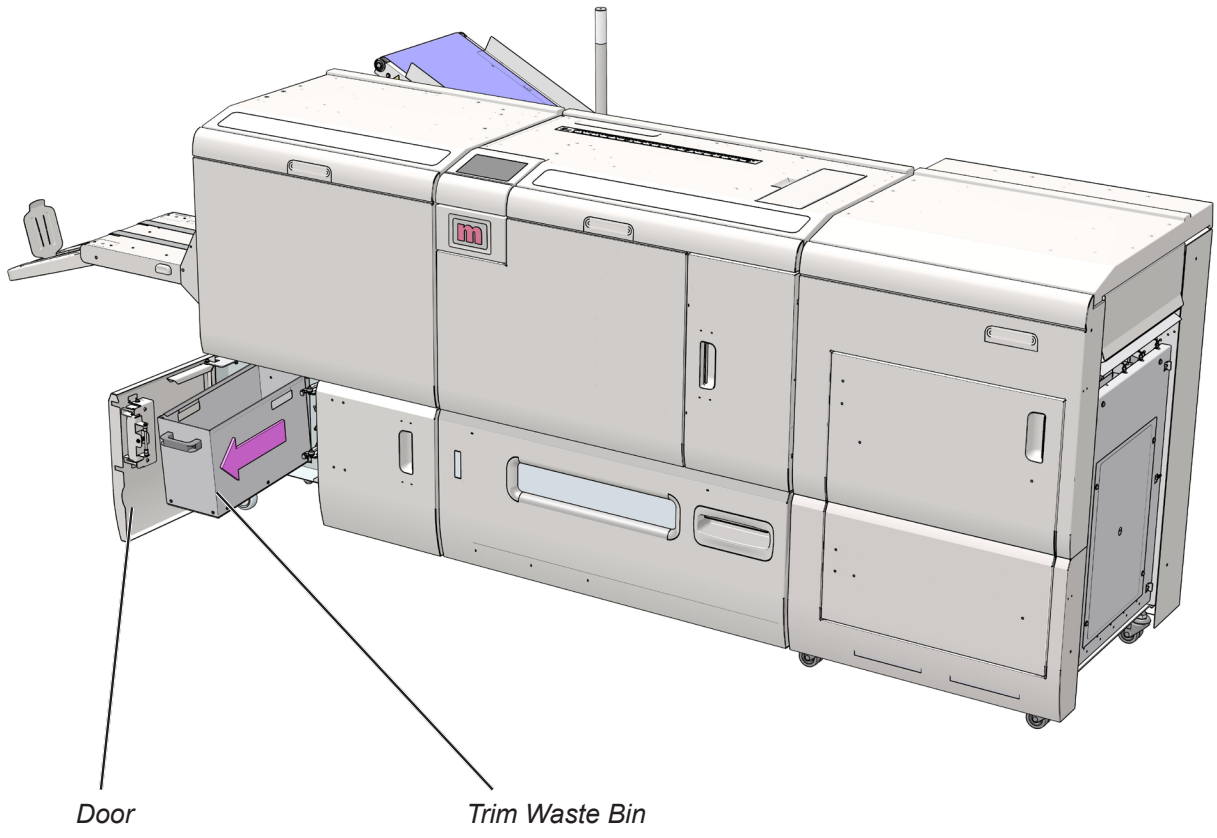
Face Trimmer

The Trim Waste Bin is located in the Finishing Module behind the left door on the front side.



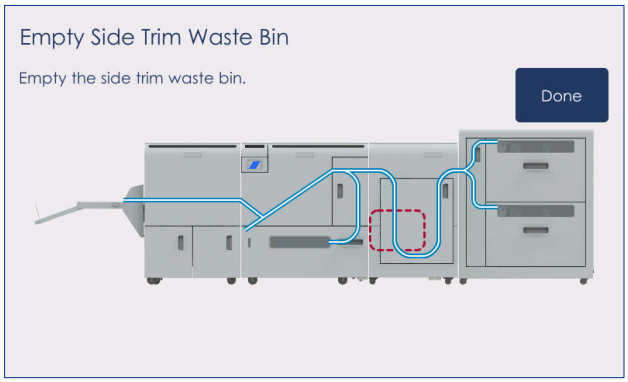
The message “Empty Face Trim Waste Bin” will be shown on the User Interface when the Trim Waste Bin is full. Proceed as follows:

1. Open the Left Door on the Finishing Module.
2. Remove and empty the Trim Waste Bin.
3. Replace the Trim Waste Bin and close the Left Door on the Finishing Module.
4. Press the [Done] button on the User Interface to restart the job.



Crease Side Trimmer

The Waste Bin is located behind the CST.



The message “Empty Side Trim Waste Bin” will be shown on the User Interface when the Trim Waste Bin behind the CST is full. Proceed as follows:

1. Remove and empty the Trim Waste Bin behind the CST.
2. Put the Trim Waste Bin back behind the CST.
3. Press the [Done] button on the User Interface.
4. Restart the job from the Start screen by pressing the green arrow.

2-knife Side Trimmer

The Waste Bin is located behind the ST5000.



The message “Empty Side Trim Waste Bin” will be shown on the User Interface when the Trim Waste Bin behind the ST5000 is full. Proceed as follows:

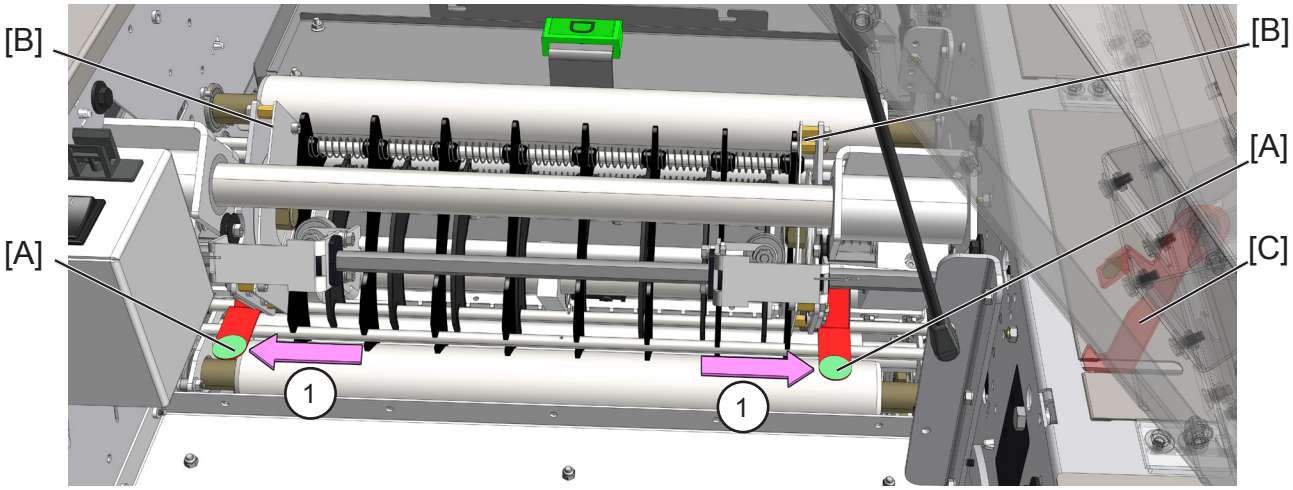
1. Remove and empty the Trim Waste Bin behind the ST5000.
2. Put the Trim Waste Bin back behind the ST5000.
3. Restart the job from the Start screen by pressing the green arrow.

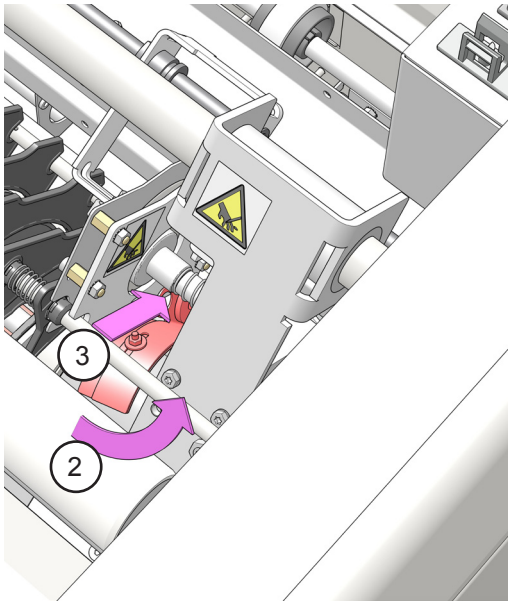
Removing trim waste from trimmer blade area

The purpose of the Trim waste guides [A] is to guide waste material towards the waste chutes. The Trim waste guides are fastened using magnets and can be moved aside or removed completely, should waste material get caught in the trimmer blade area.

⚠ WARNING:
Do not put your fingers within knife protections [B]. Doing so may result in injury.

⚠ CAUTION:
Under no circumstances should jams around the trimmer blades be cleared using metallic tools. The edges are very fragile and easily damaged.



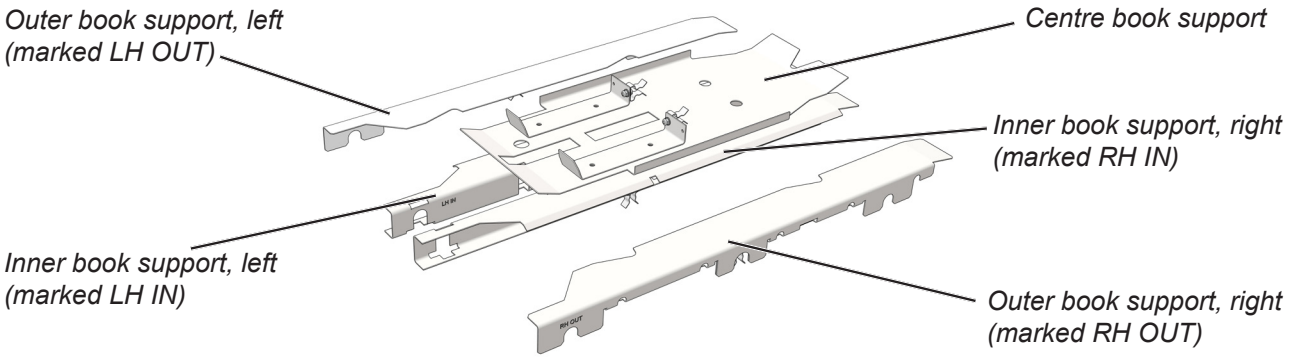


Top cover or the RCT made transparent for clarity

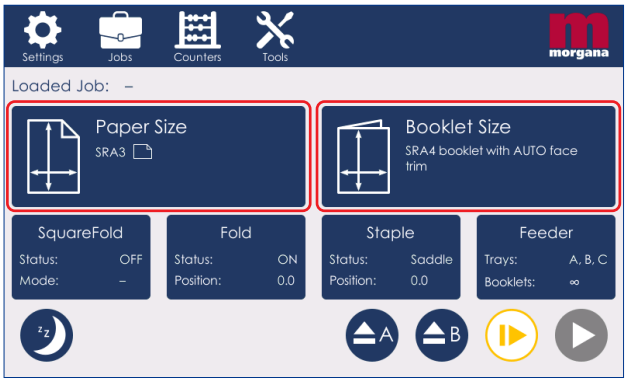
1. Set the Paper Size to A3 or 11x17”. See section 2, “Selecting standard paper sizes”.
2. Set the Width of the Custom Booklet Size to minimum value (max trimming). See section 2, “Custom Booklet Size”.
3. Open the top cover of the RCT.
4. Slightly push the top cover down and press on the top cover latch [C].
5. Open fully the top cover of the RCT.
6. Move the Trim waste guides aside (1) to access and remove waste material gotten caught.
7. For more access, remove the Trim waste guides completely by twisting (2) and wiggling while pulling (3) it towards the infeed area. Ilustration shows the operator side. On the non operator side, twist the Trim waste guide clockwise before wiggling it while pulling it towards the infeed area.
8. After removing waste material, reinstall the Waste material guides to normal position
9. Close the RCT top cover.

ST5000 Book Supports

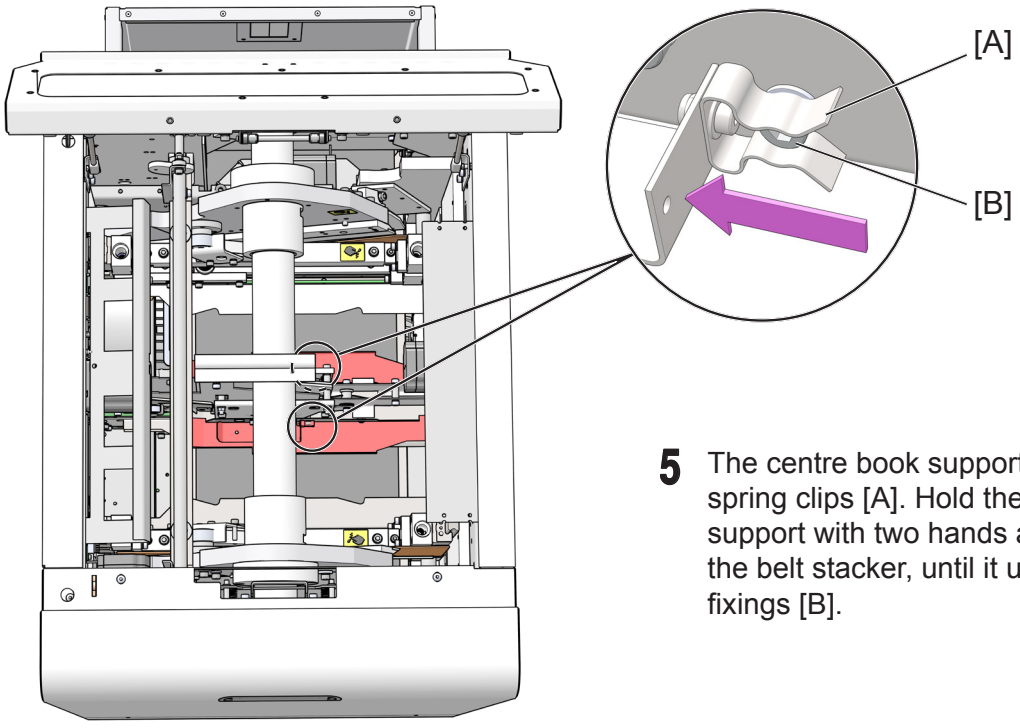
There are five removable metal book supports inside the ST5000 that must be removed when producing booklets with a side-trim dimension of 190 mm / 7.48” or less.
Ensure the book supports are fitted when the side-trim dimension is over 190 mm / 7.48”.



Removal of Book Supports



1. Set Paper Size to the largest paper width possible i.e 320 mm / 12.6”. See section 2, “Making Booklets, Paper Size”.
2. Set Booklet Size to the largest width possible i.e 320 mm / 12.6”. See section 2, “Making Booklets, Booklet Size”.
3. Open the ST5000 top cover.
4. Turn the ST5000 OFF using the mains ON/ OFF switch.

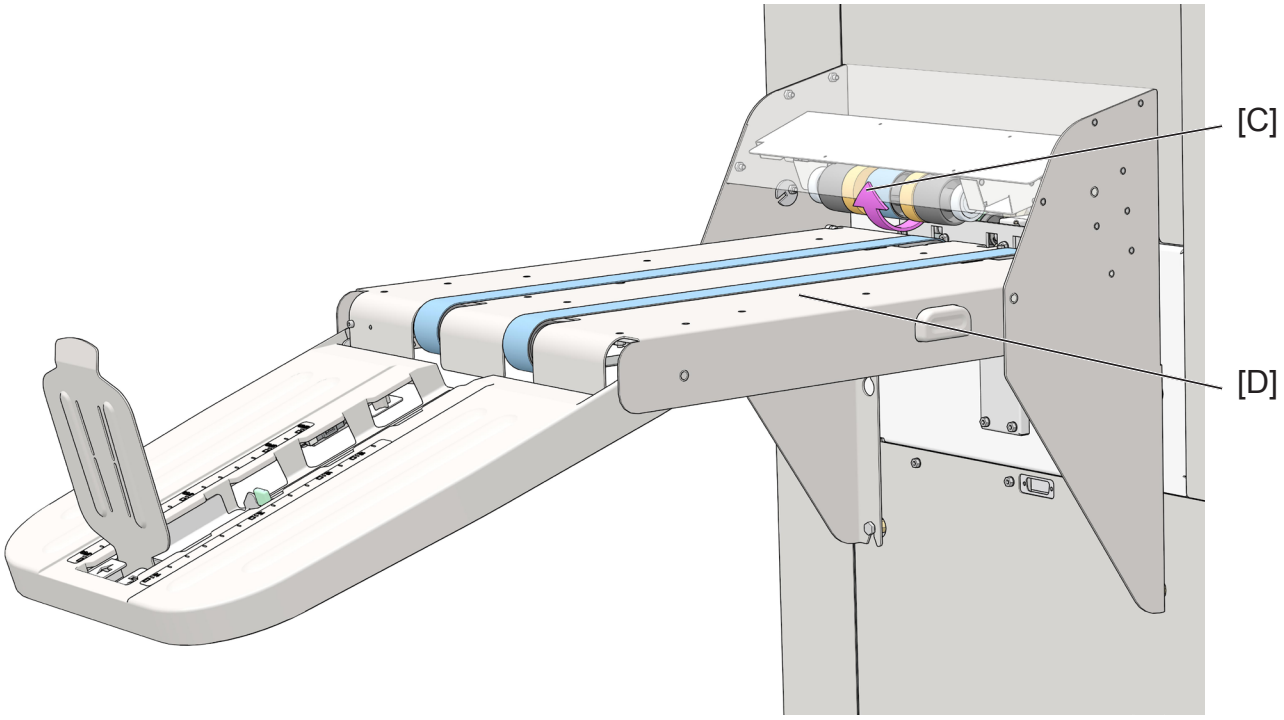


5. The centre book support is secured with two spring clips [A]. Hold the the centre book support with two hands and pull towards the belt stacker, until it unclips from the two fixings [B].

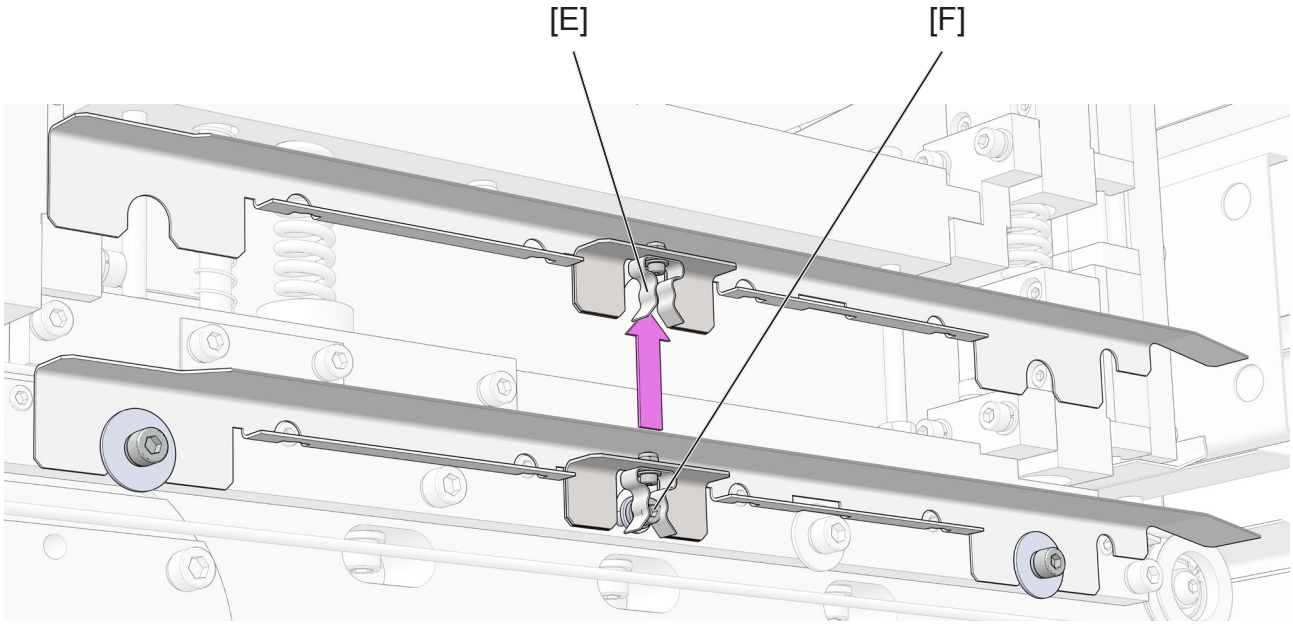
continued on next page

Removal of Book Supports, continued

6 Lift the upper belt unit [C] and remove the centre book support out through the opening in the exit cover towards the belt stacker chassis [D].



7 Each inner and outer book support is secured with a spring clip [E]. The book support is removed by holding each end of the book support and lifting upwards, until it unclips from the fixing [F].



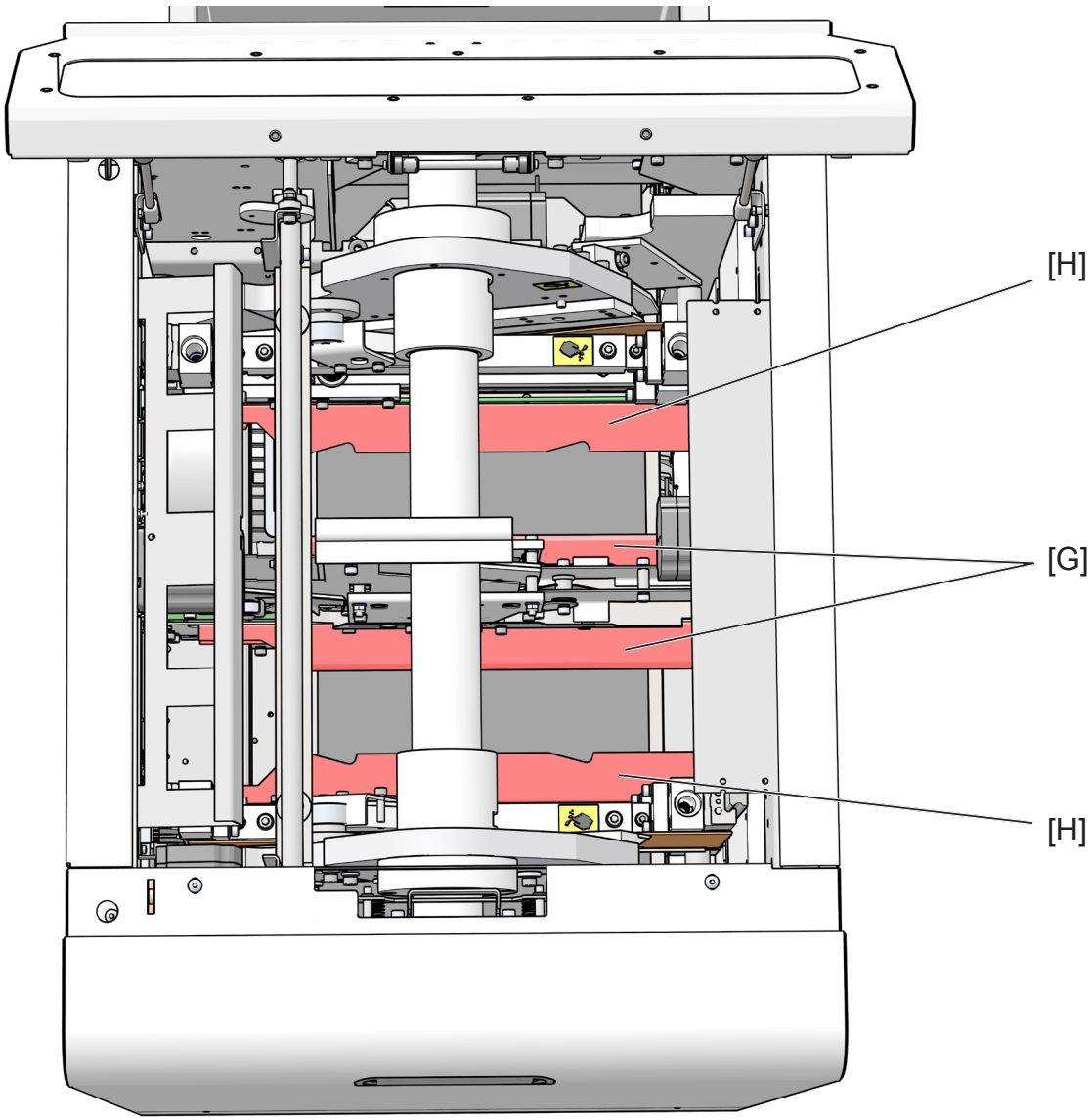
sample illustration showing how to remove the inner and outer book supports

continued on next page

Removal of Book Supports, continued

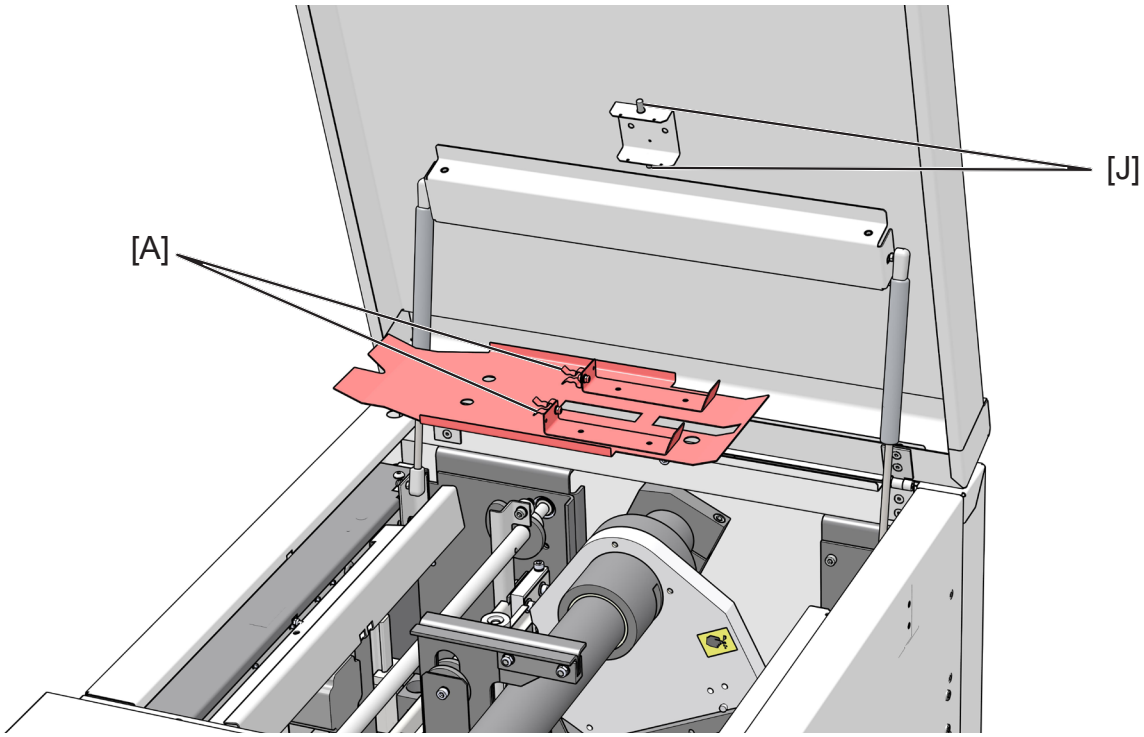
8 Remove the two inner book supports [G] one at a time and lift them out through the top of the machine. Repeat with the other inner book support.

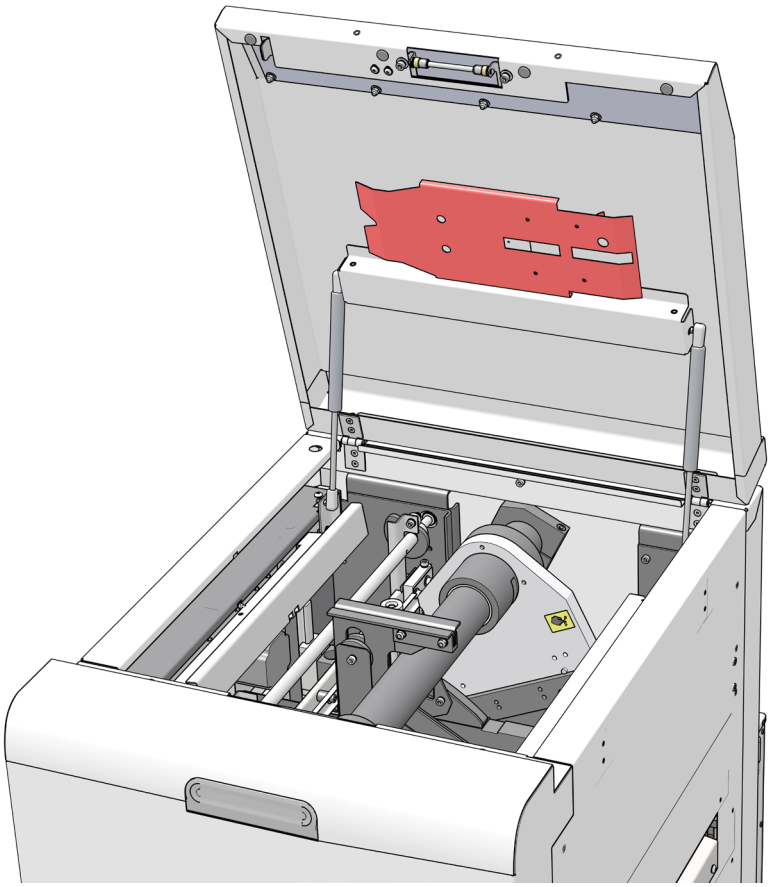
9 Remove the two outer book supports [H] one at a time and lift them out through the top of the machine. Repeat with the other outer book support.



Removal of Book Supports, continued

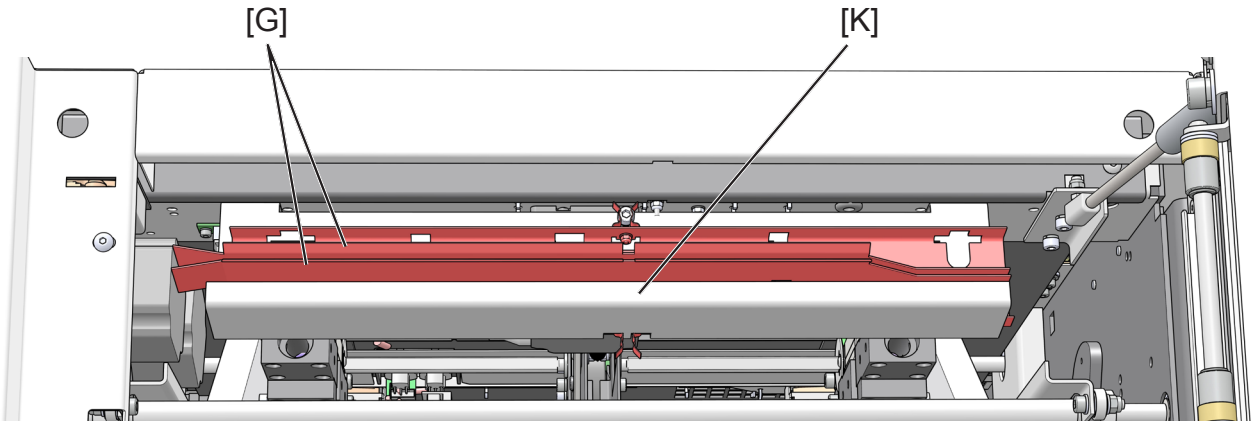
10 When not in use, store the centre book support inside the top cover. Use the two spring clips [A] to secure the centre book support to the fixings [J] inside the top cover.



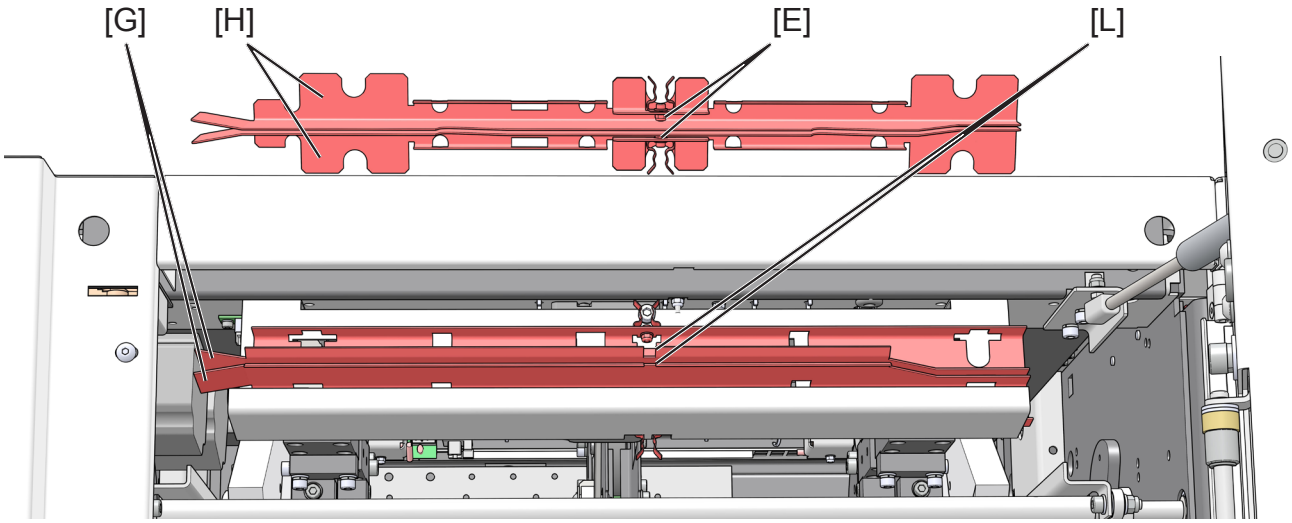


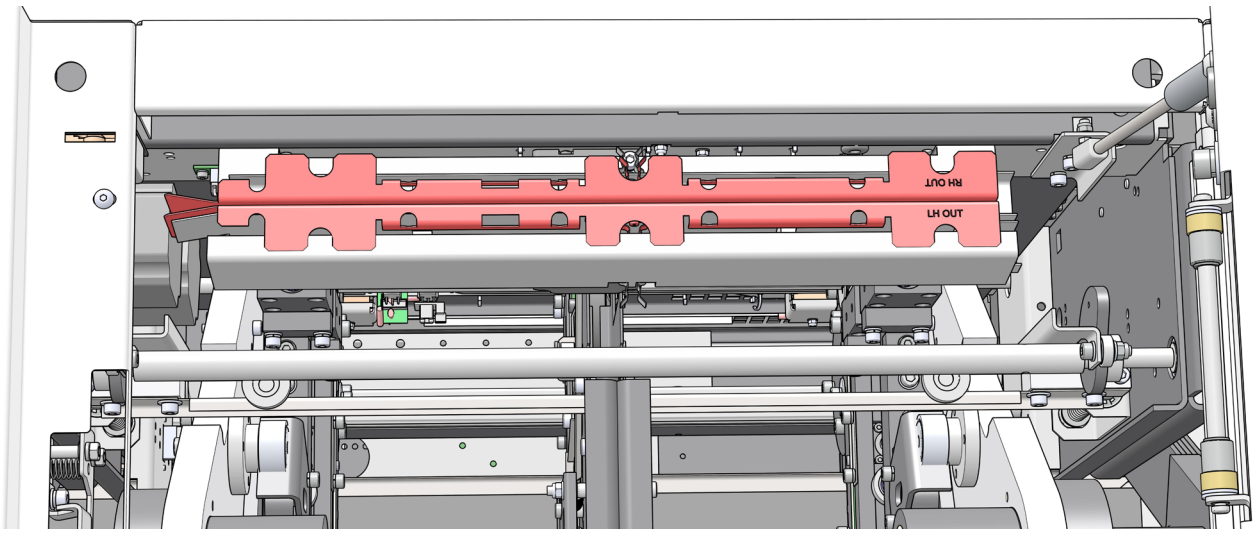
Removal of Book Supports, continued

11 Place the inner book supports [G] inside the store bracket [K] as illustrated.



12 Place the outer book supports [H] on top of the inner book supports [G]. The nuts securing the spring clips [E] on the outer book supports fits in the cut-outs [L] on the inner book supports [G].





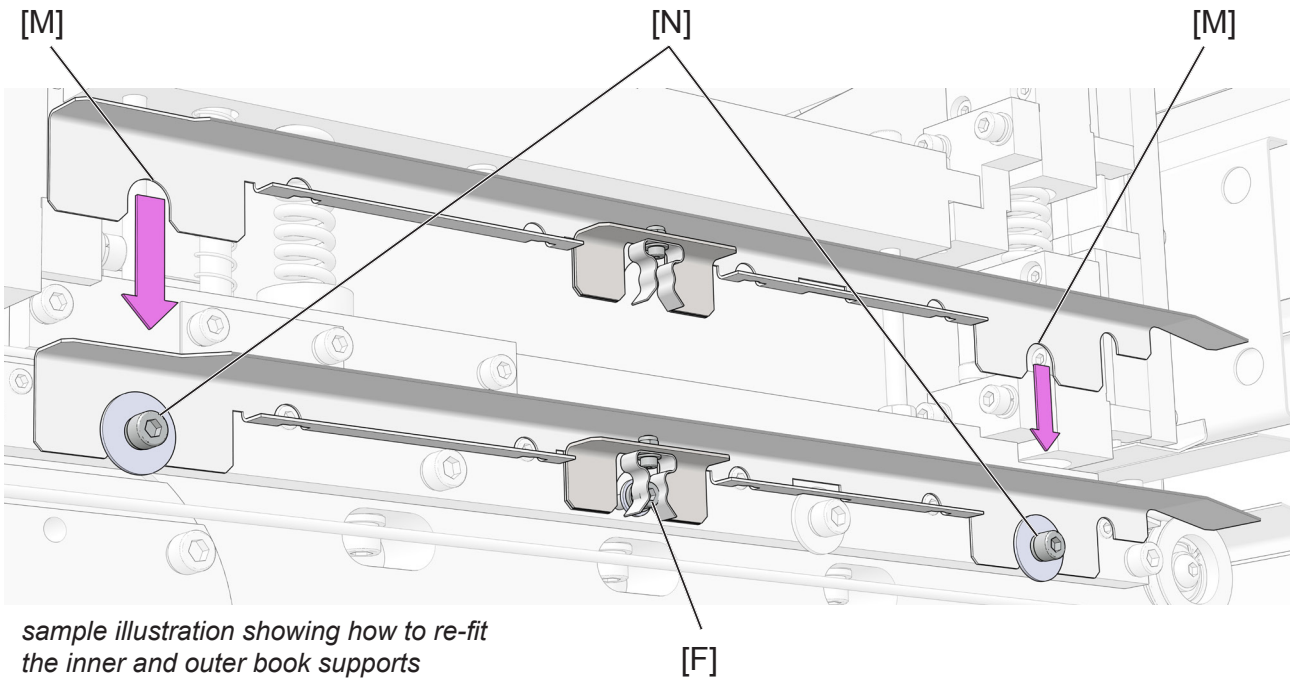
Re-fitting of Book Supports

1 Set Paper Size to the largest paper width possible i.e 320 mm / 12.6”. See section 2, “Making Booklets, Paper Size”.

2 Set Booklet Size to the largest width possible i.e 320 mm / 12.6”. See section 2, “Making Booklets, Booklet Size”.

3 Open the ST5000 top cover.

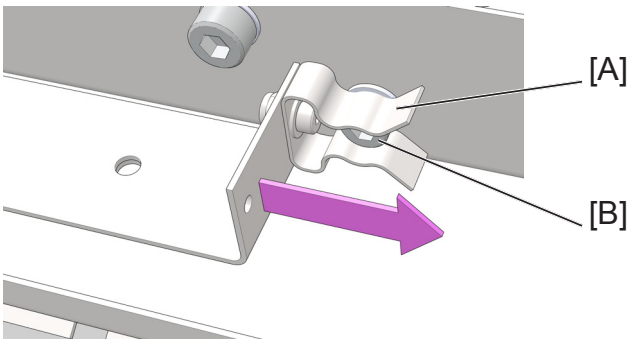
4 Re-fit the two outer and the two inner book supports one at a time. Refer to the illustrations in the removal procedure.
On each book support, there are semicircular cut outs [M] at each end. Position the cut-outs over the fixing points [N]. Press down on the book support, until it clips onto the fixing in the middle [F] and that it fits onto the fixing points at the ends. Repeat with the other book supports.



sample illustration showing how to re-fit the inner and outer book supports

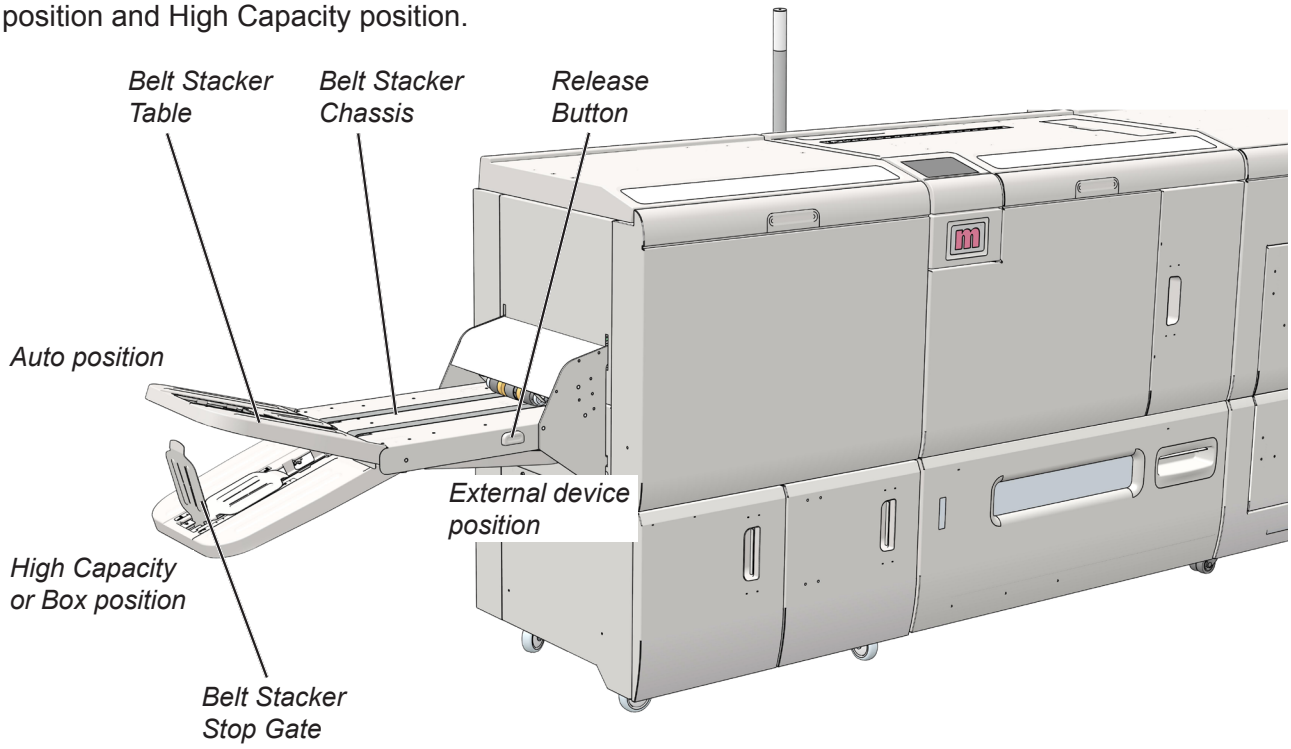
5 Lift the upper belt unit at the belt stacker and slide the centre book support through the opening in the exit cover. Keep holding the book support in the middle of the machine.

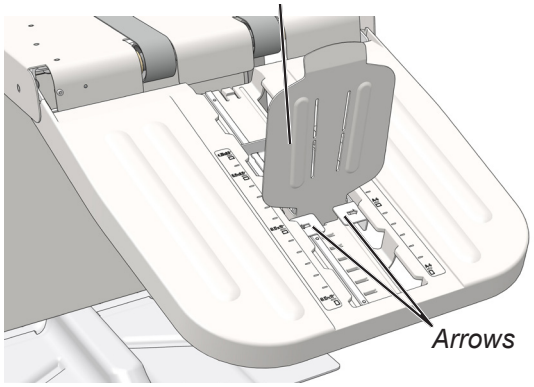
6 The centre book support is secured with two spring clips [A]. Hold the the centre book support with two hands and slide away from the belt stacker, until it clips onto the two fixings [B].

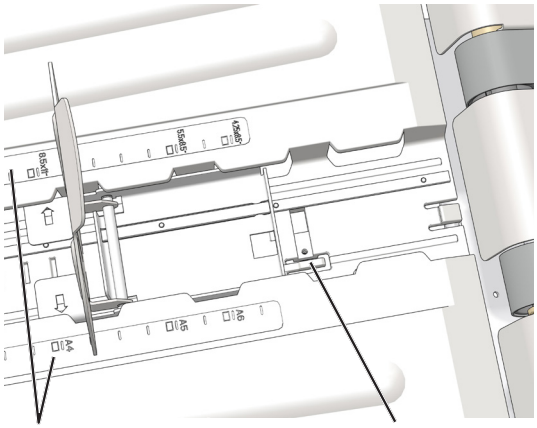


Using the Belt Stacker

The Belt Stacker can be placed in three different positions to suit any stacking needs. Auto position, High Capacity/Box postion or External Device position. The Finishing Module features a load sensor that detects when the Belt Stacker is full. Stacker Full Detection can be used in Auto position and High Capacity position.





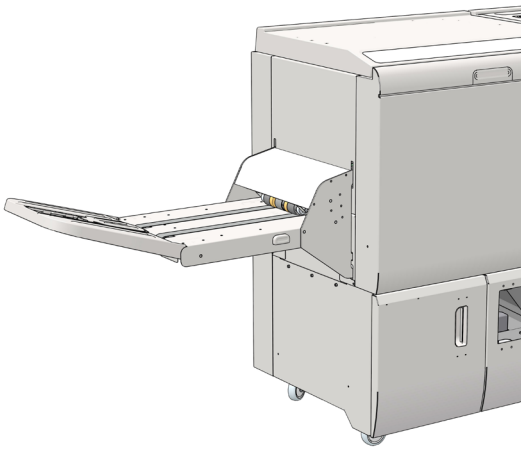


To change position, hold the Belt Stacker Table while pressing the Release Button. Fold the Table down- or upwards while slightly letting go of the Release Button. Keep moving the Table until it clicks into the desired position. Let go of the Release Button.

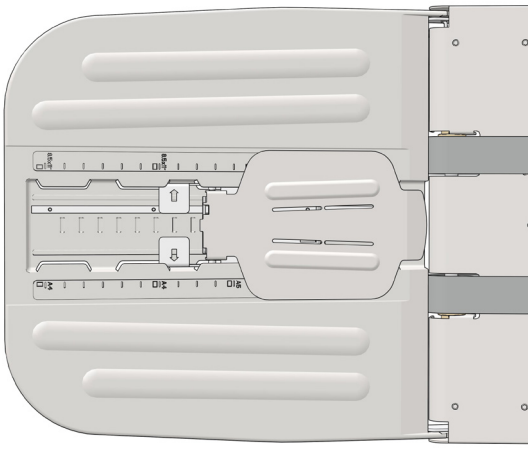
The booklets will exit the Finishing Module onto the Belt Stacker Chassis and will end up on the Belt Stacker Table.
The Belt Stacker detects the weight of the output and will stop the system and cycle down automatically when the Stacker is full. This can be avoided by unloading booklets from the Belt Stacker during run. Also, the limit when detecting Stacker full can be adjusted to operator preference. See 3 “Tools”, Stacker settings for how to adjust the Stacker Full Max Limit.

NOTE:
In order to achieve correct stacker full function and detection in High Capacity mode, make sure to position the Belt Stacker Stop Gate correctly. To do so, fold down the Belt Stacker Stop Gate slightly and position the arrows pointing to the correct booklet size on the scales. Leave the Stop Gate in an upright position.

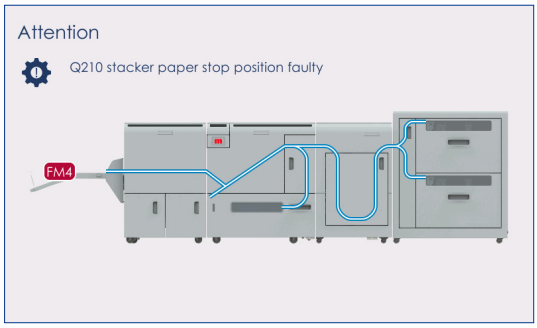
*For booklet sizes smaller than A4/8.5*11”, the Belt Stacker Stop Gate has to be moved past the plastic Bulge in the Belt Stacker Table.*



1 Auto position.
This basic setting suits most types of stacking situations. Except from unloading booklets it needs no action by the operator.



Make sure that the Belt Stacker Stop Gate is placed in its correct resting position not past the plastic Bulge in the Belt Stacker Table.



If this error message is shown, it indicates that the Belt Stacker Stop Gate is in the wrong position.

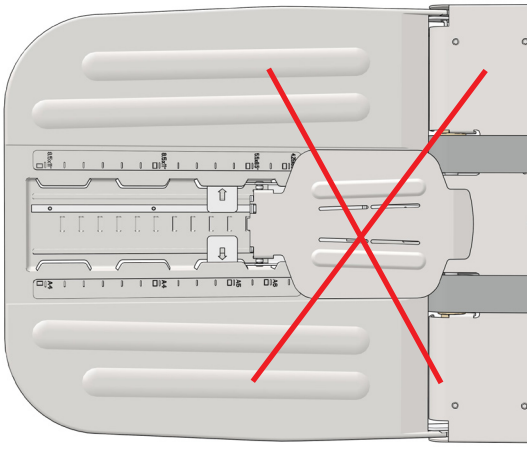
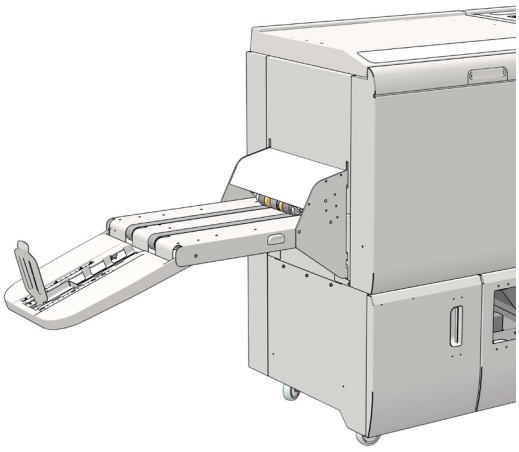


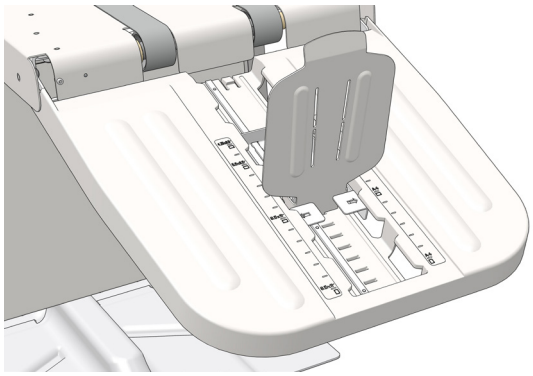
Illustration shows the Belt Stacker Stop Gate in the wrong postion moved past the plastic Bulge in the Belt Stacker Table.

continued on next page

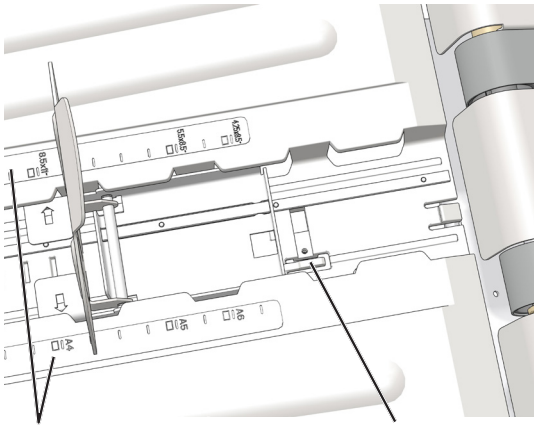
Using the Belt Stacker, continued



2 High Capacity position.
This position is also suitable for the majority of stacking situations but compared to the Auto position it enables a higher stacking capacity.

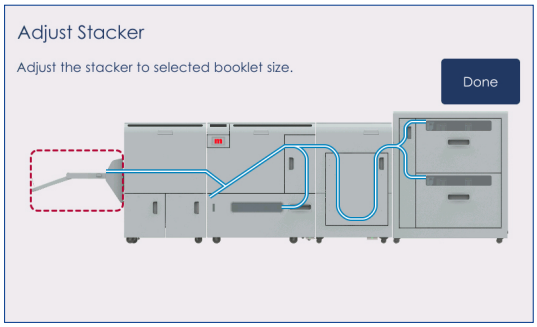


NOTE:
In order to achieve correct stacker full function and detection in High Capacity mode, make sure to position the Belt Stacker Stop Gate correctly. To do so, fold down the Belt Stacker Stop Gate slightly and position the arrows pointing to the correct booklet size on the scales. Leave the Stop Gate in an upright position.

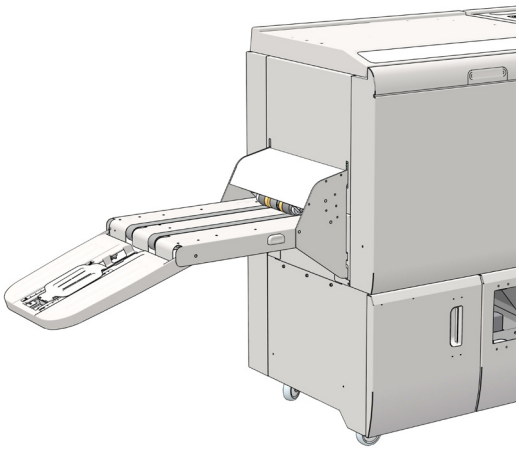


Format scales *Bulge*

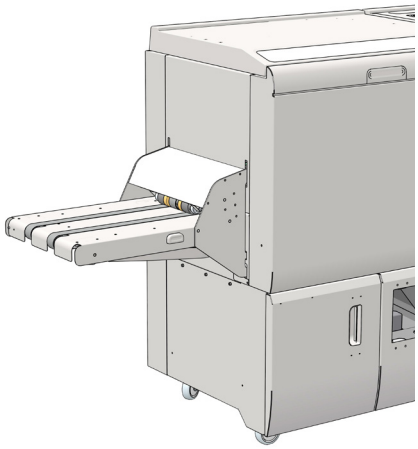
*For booklet sizes smaller than A4/8.5*11", the Belt Stacker Stop Gate has to be moved past the plastic Bulge in the Belt Stacker Table.*



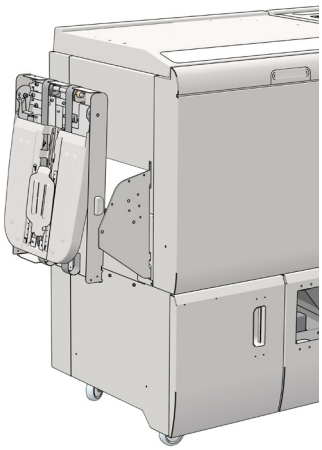
Whenever the Paper Size is changed and the Belt Stacker is placed in High Capacity position, the Stacker Booklet Size Warning will be shown as a reminder to set the Belt Stacker Stop Gate to the correct position. See 3 "Tools", Stacker settings for how to turn this warning off.



3 Box position.
Position the Belt Stacker Table in the High Capacity position but keep the Belt Stacker Stop Gate in a flat position. This allows the booklets to slide off the Belt Stacker Table into a box.



4 External Device position.
To allow for stacking onto an external device, for example such as the The BST4000-1 High Capacity Belt Stacker Module, fold the Belt Stacker Table completely up under the Belt Stacker Chassis.



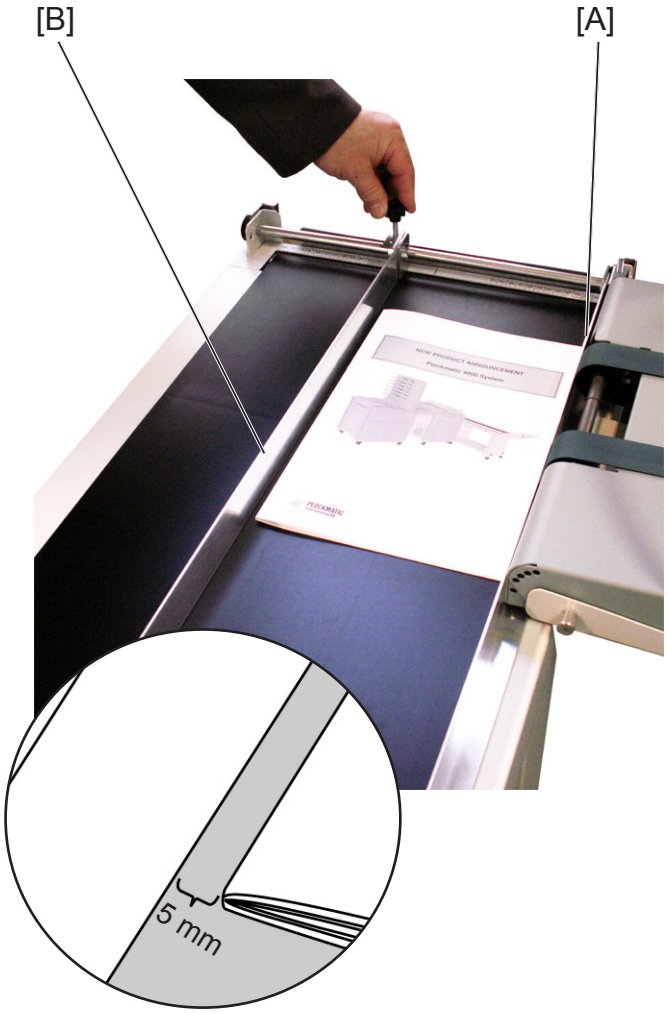
5 To put the Belt Stacker in storage position while not in use, lift up the Belt Stacker Chassis from External Device position.

Belt Stacker BST4000-1

Setting up Belt Stacker for right-angled mode

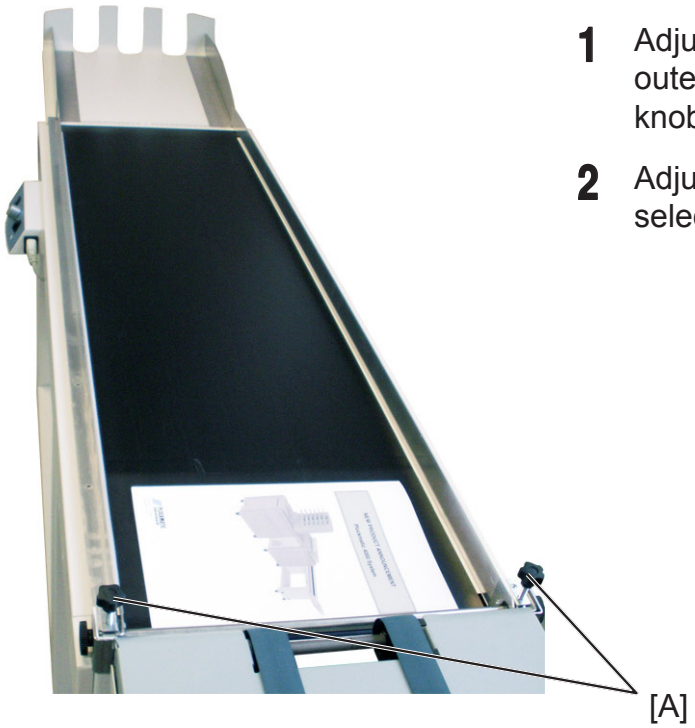
1

Follow these steps to correctly set up the Stacker

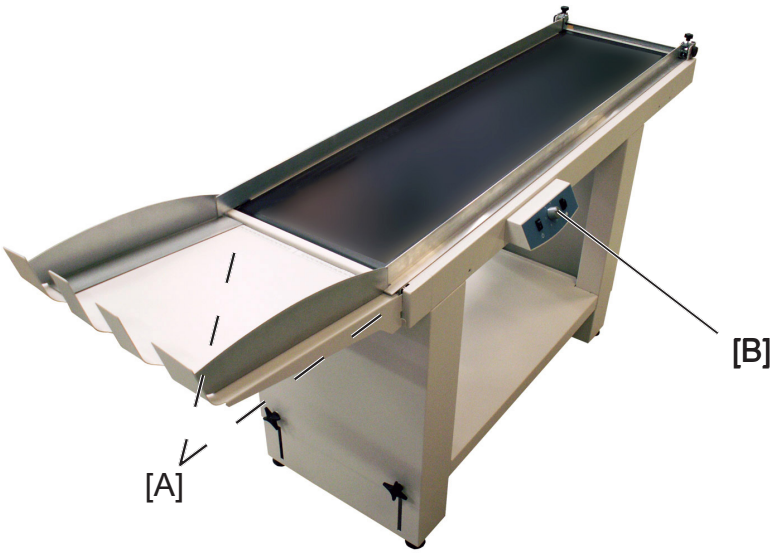


1. Move the inner Side Guide [A] as far as possible towards the Booklet Maker.
2. Adjust the outer Side Guide [B] to give at least 5 mm (1/4″) play. Tighten the Side Guides at both ends.
3. Adjust the stacking with belt speed selector.

Setting up Belt Stacker for straight mode

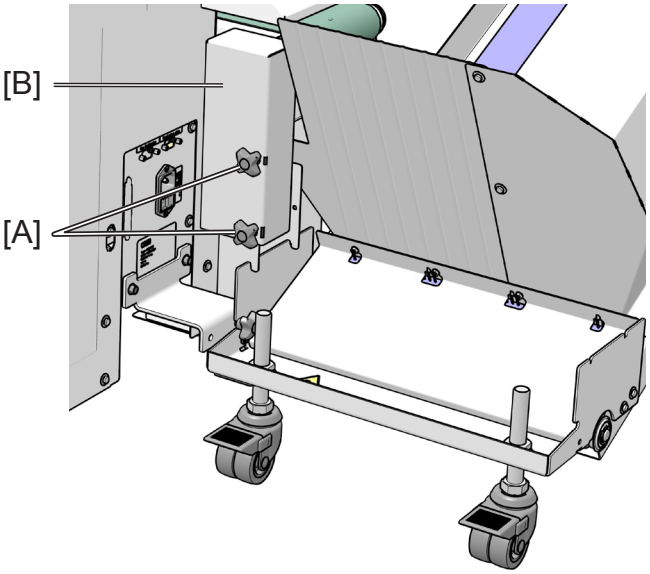


1. Adjust Side Guides to their outermost position by loosening knobs [A].
2. Adjust the stacking with belt speed selector [B].

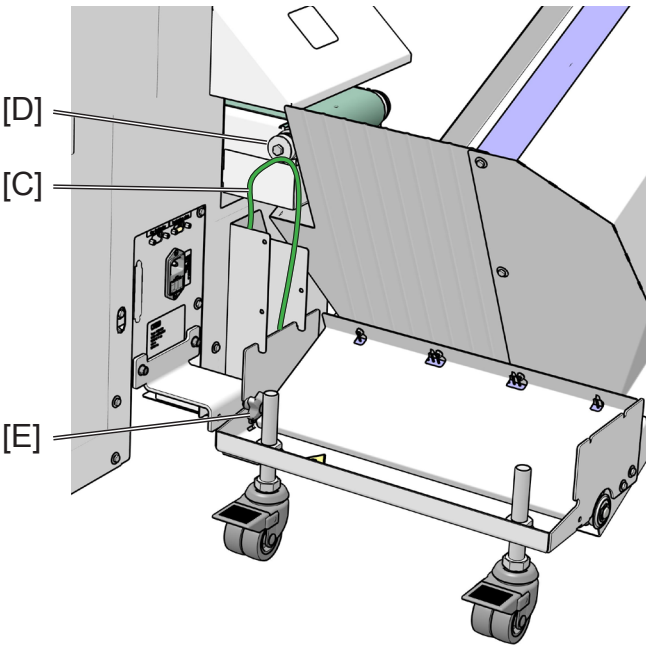


Detaching / Attaching the Trim Waste Conveyor

Detaching the Trim Waste Conveyor



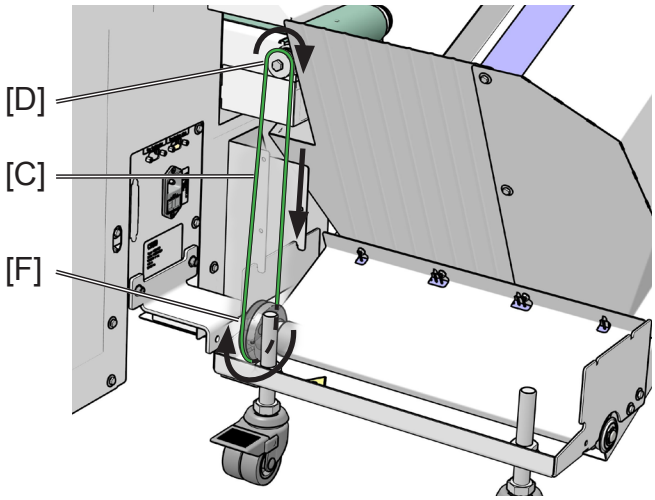
1 Loosen the Knobs [A] (x2) and remove the Cable Protection Extension [B].



2 Unhook the O-ring [C] from the upper Pulley [D]

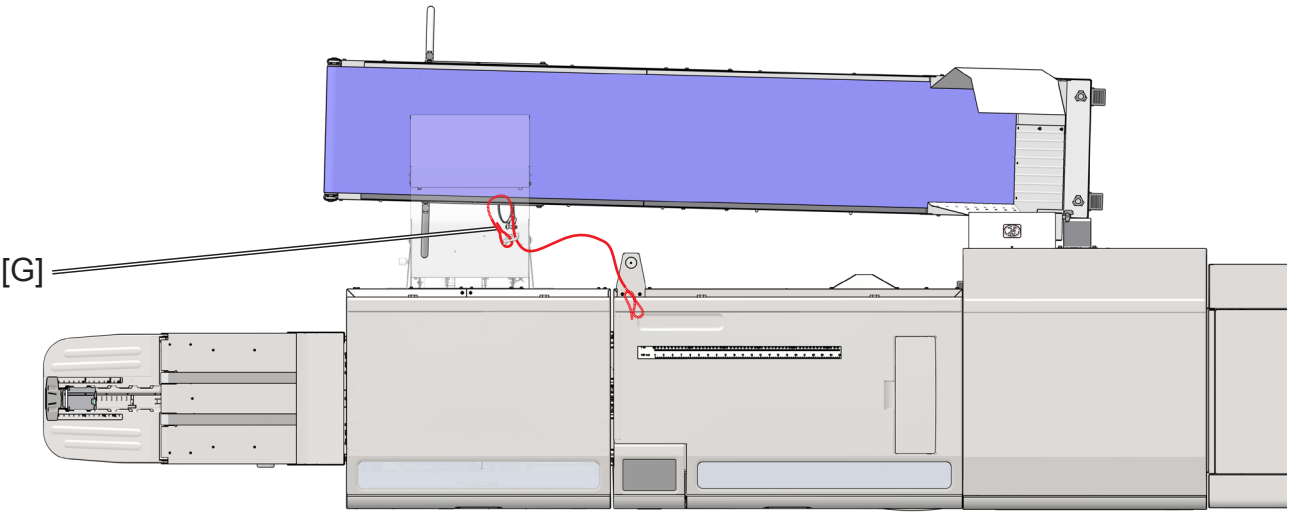
3 Loosen Knob [E]. The TWC is now detached from the CST and can be moved away.

Attaching the Trim Waste Conveyor



1 Attaching the Trim Waste Conveyor is an exact reversal of detaching as described above.

NOTE:
In order to make the conveyor belt travel in the correct direction, make sure to route the O-ring [C] on the Pulleys [D] and [F] as illustrated.

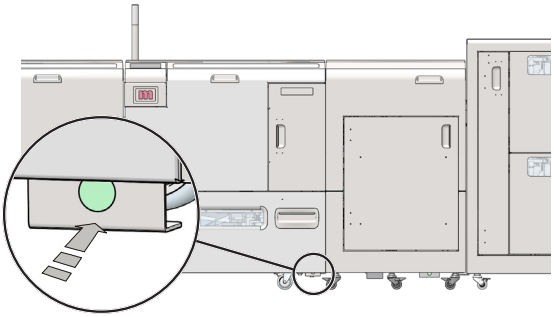


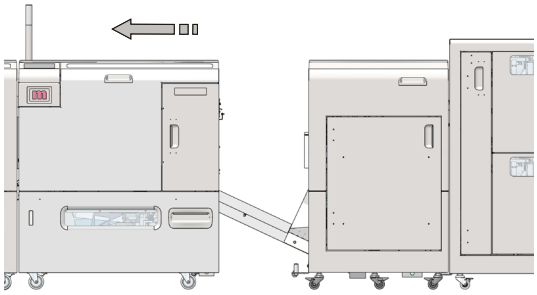
2 Ensure that the Trim Waste Conveyor is close to parallel to the Booklet Making System.

⚠ WARNING
To prevent the Trim Waste Conveyor from falling over, a safety wire [G] must be installed between the Conveyor support and the rear caster spindle on the Booklet Maker on the exit side. Reinstall the Safety Wire [G] if it earlier was removed.

Docking / Undocking the Booklet Maker

Undocking the Booklet Maker



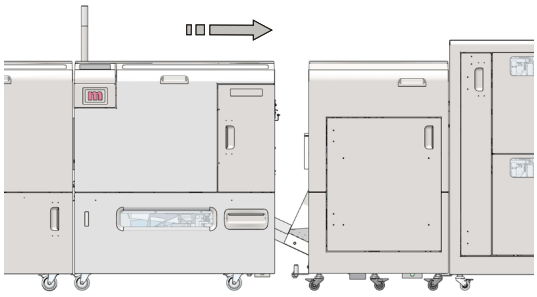


1 Push in the latch on the docking assembly and move the Booklet Maker System away from the CST or the Feeder.

⚠ CAUTION

To avoid damaging the communication cable connecting the Booklet Maker to the Feeder or the Booklet Maker to the CST, do not separate them to far.

Docking the Booklet Maker



1 Move the Booklet Maker System up to the CST or the Feeder and dock it.

2. Making Booklets or Stapled Sets

Changing settings

General procedure

Settings can be changed in one of two ways. “Temporary”, which means that the changes will remain until a new job is loaded or “Permanent”, which means that the changes will be stored as a job. This job can later be recalled.

Procedure for temporary changes:
From the Start screen, select the option you wish to alter and make your changes. Confirm by pressing the green [check] button.

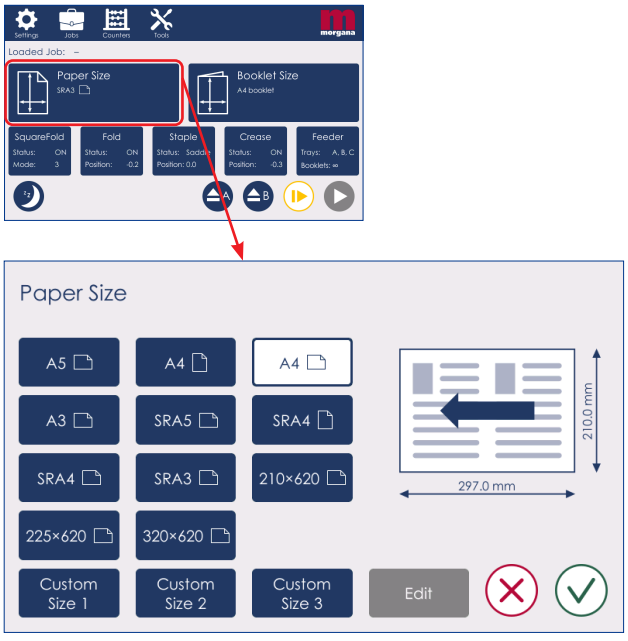
Procedure for permanent changes:
To keep your new settings, press the [Jobs] button. Follow on screen instructions to save your current settings as a new job or to an existing job.

NOTE:
Choose either of the above mentioned procedures when changing size, stapling, trimming, covers or square forming as follows.

Depending on how the system is configured, the number of settings that can be selected varies. The information on the screen and the size of the buttons will adapt to fit the screen. Examples below shows a fully configured system.

Paper Size

Selecting standard paper sizes



From the Start screen, press the [Paper Size] button.

Select any standard paper size by pressing the corresponding button and save choice by pressing the green [check] button.

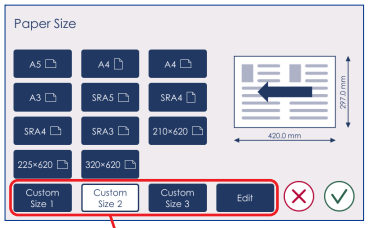
Depending on configuration, available standard paper sizes may differ.

For other paper sizes, see “Custom Paper Size” described on the next page.

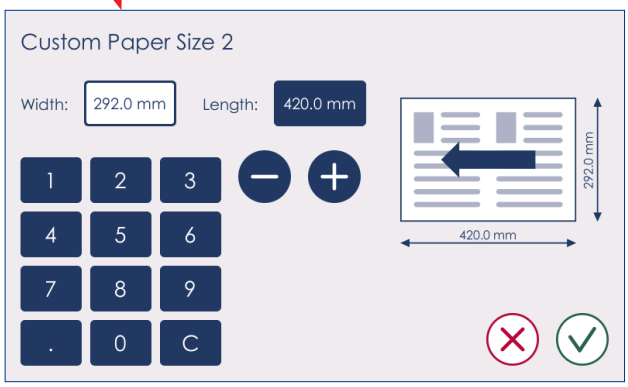
NOTE:
Changing of Paper Size (leaving this screen pressing the green check mark) affects a number of adjustments.
All settings related to the external feeder (trays A and B), except the function Load While Run (Tools) and the current feed sequence, will be reset.
SquareFold will be set to Auto, Fold and Staple position to 0.0 and Crease and Convenience Feeder (tray C) settings are set to off.
Any Fine-tuning that has been done (see section 2, “Making Booklets”, Fine-tuning booklet appearance below) will be reset.

continued on next page

Custom Paper size



Three different custom paper sizes can be stored. From the Paper Size screen, press any of the [Custom size] buttons and then press the [Edit] button.

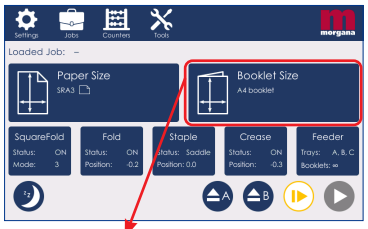


Press the Width and/or Length numbers and enter the desired width and/or length. Also, the [plus] and [minus] buttons can be used to change the numbers. Save the custom size format by pressing the green [check] button.

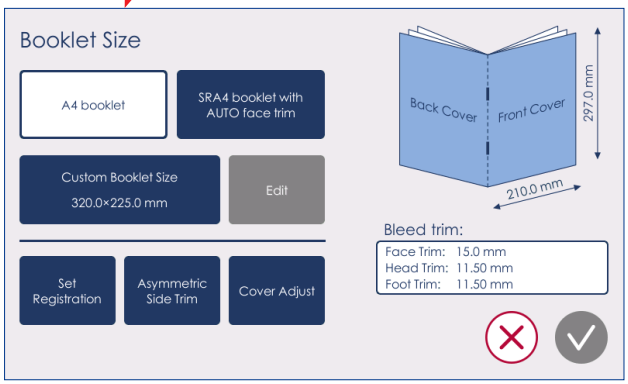
Back at the Paper Size screen (above left) there are two choices.
1. Press the red cross to keep using the paper size that was used when the Paper Size button was pressed from the Start screen.
2. Press the green check mark to use the paper size that is currently selected in the Paper Size screen. Pressing the green check mark will reset a number of adjustments and fine-tunings. See NOTE under “Selecting standard paper sizes” on the previous page.

Booklet Size

General



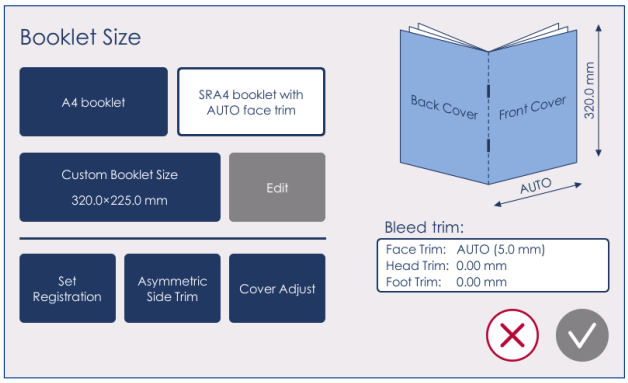
From the Start screen, press the [Booklet Size] button.



Booklet Size can be set to either of two suggested formats or to a Custom Booklet Size. The amount of Bleed trim as well as the size of the finished booklet as a result of the actual Booklet Size choices, is displayed.

The lower three buttons are for fine tuning and will be described later on in this section under “Fine-tuning the booklet appearance” below.

AUTO trimming



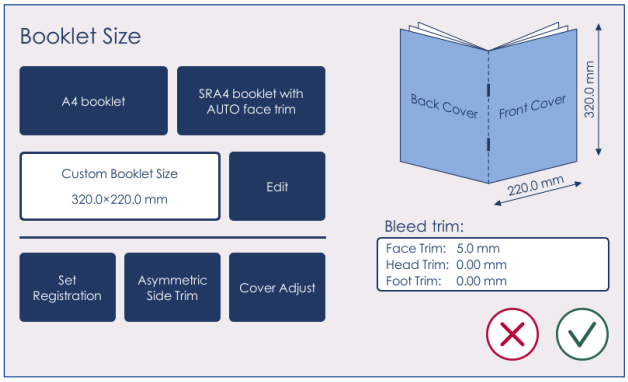
When Booklet Size is set to a format that includes AUTO Face Trim, a minimum trim, based on the information from Set Thickness Sensor, is calculated.

After one booklet have been produced, the amount of Face Trim is displayed within parentheses.

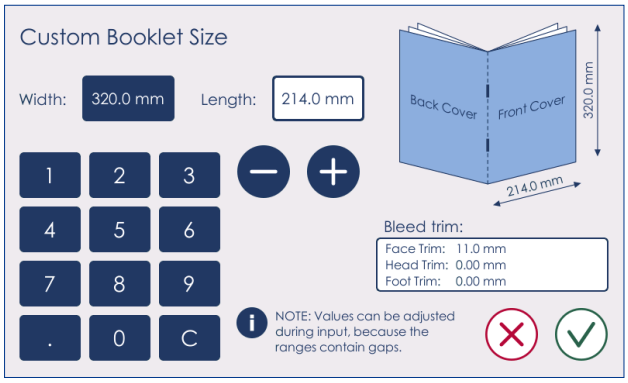
In case Face Trim needs to be changed, press the [Custom Booklet Size] button and then the [Edit button. Follow procedure under “Face Trim” in “Custom Booklet Size below.

Custom Booklet Size

Face Trim



To set the trim manually, press the [Custom Booklet Size] button and then the [Edit] button.



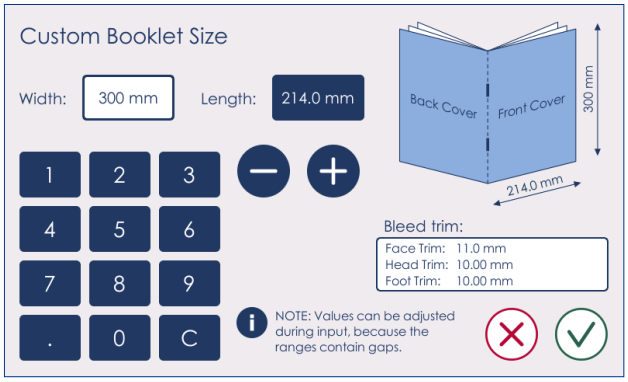
To adjust the amount of Face Trim, press the Length number and enter the desired length of the booklet. Also, the [plus] and [minus] buttons can be used to change the numbers. The amount of Face Trim is displayed in the box.

Press the green [check] button to confirm or continue adjusting the amount of Head and Foot Trim i.e. the amount of Side Trim.

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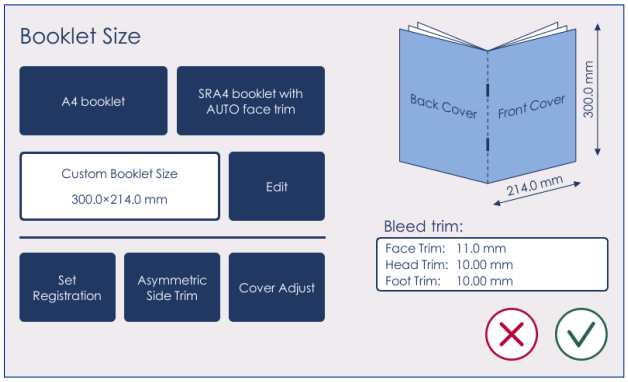
Custom Booklet Size, continued

Side Trim (Head and Foot)



To adjust the amount of Side Trim, press the Width number and enter the desired width of the booklet. Also, the [plus] and [minus] buttons can be used to change the numbers. The amount of Head and Foot Trim is displayed in the box.
To make the Side Trim asymmetric, see section “Asymmetric Side Trim” under “Fine-tuning the booklet appearance” below.

Press the green [check] button to confirm.



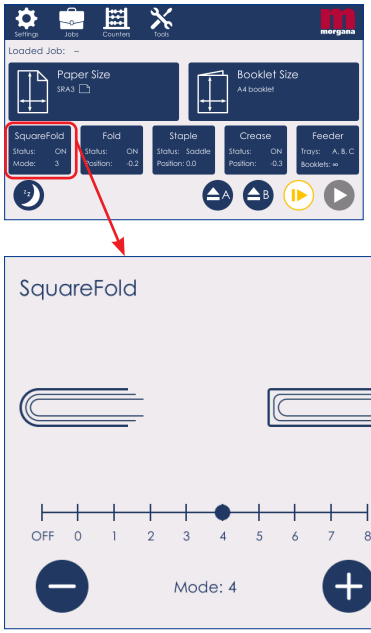
Back in the Booklet Size screen, the size of the finished booklet and the amount of Face, Head and Foot Trim is displayed.

Press the green [check] button to confirm.

NOTE:
When using the Head and Foot Trim function and feeding covers or centerfolds at the same time, make sure covers loaded in the Convenience Feeder are the same size as sheets fed from the CST. According to the example on the left, covers must be 300x450 mm.
Width is 300 mm and Length is 2 × (214 mm + Face Trim 11 mm).

SquareFold

General



The SquareFold in the Finishing Module has three different settings - AUTO, Manual and OFF.
Information on the [SquareFold] button shows the actual Status of the SquareFold and what mode is selected.

Set to AUTO, the Booklet Maker uses information from the set thickness sensor to calculate the most appropriate mode from 1 to 7 or if the SquareFold should be by-passed.

To override the AUTO function, set SquareFold to OFF or any of the Manual modes. In Manual, there are nine different modes of spine forming action to choose from. Eight different modes of square forming pressure and also the possibility to just have a clamping action to enhance the fold.
See guidance table below.

Select OFF to completely bypass the square forming action.

NOTE:
The SquareFold can be set to any status or mode during run. AUTO, all Manual modes or OFF.

When SquareFold is set to AUTO and if the booklet has less than approximately 6 sheets/booklet, the square forming action will bypassed.

Mode 0 will have no square forming action, only an enhancement of the fold. This setting can be used on any number of sheets per booklet but will have less effect the larger the sheet count is. Mode 0 is not included in the Auto setting and therefore must be selected manually.

Mode 8 is a heavy duty setting in case of extra demanding media. Mode 8 is not included in the Auto setting and therefore must be selected manually.

Table below is approximate numbers and is based on 80 gsm / 20 lb Bond sheets.

Mode	Number of sheets in the set
0	No square forming action, just fold enhancement. Use for fewer sheet booklets.
1	Approximately 6 to 10
2	Approximately 11 to 16
3	Approximately 17 to 22

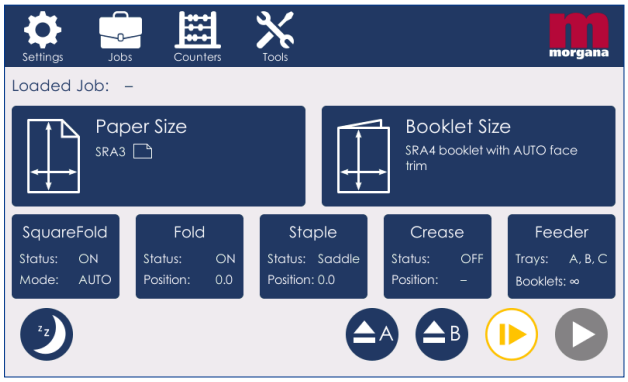
Mode	Number of sheets in the set
4	Approximately 23 to 29
5	Approximately 30 to 35
6	Approximately 36 to 43
7	Approximately 44 to 50
8	Heavy duty setting in case of extra demanding media.

SquareFold pressure settings guidance table.

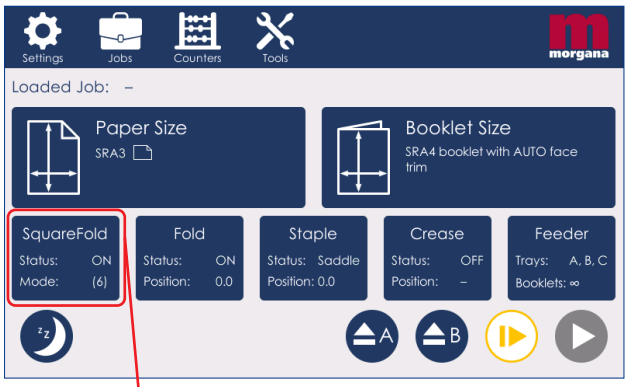
NOTE:
The SquareFold pressure settings for Modes 1 - 8 can be adjusted based on preference or application. See SquareFold Offset in section "Tools".

continued on next page

Selecting SquareFold pressure setting

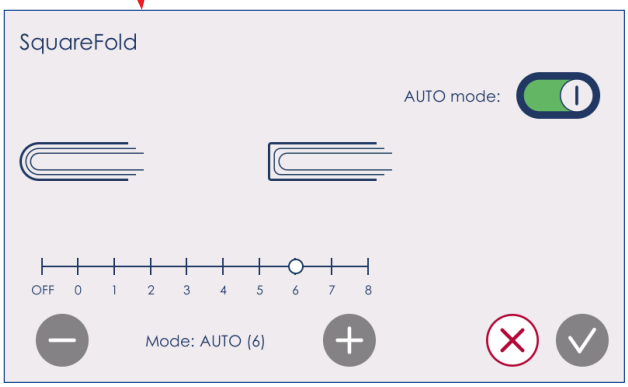


The default status for the SquareFold is ON and the default mode is AUTO.

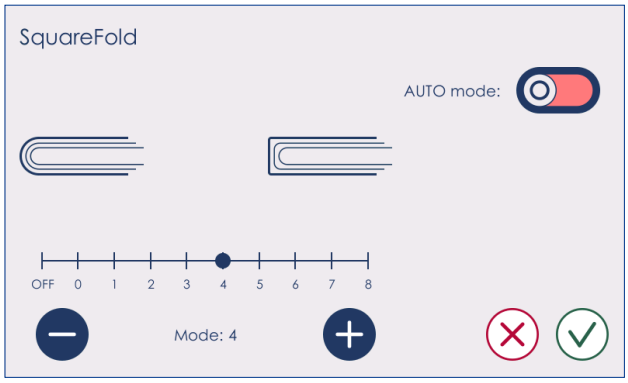


After one booklet has been produced, the Mode info in the [SquareFold] button will change from “AUTO” to show the mode that was calculated to be the most appropriate mode setting. The number will be shown within parentheses.

To alter settings, press the [SquareFold] button from the Start screen.



To change from the AUTO mode, start by setting the green AUTO mode switch to Off.

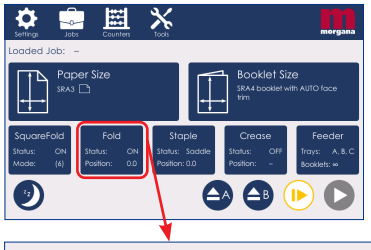


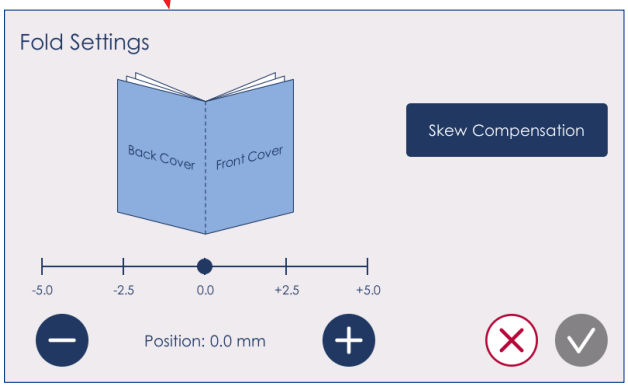
For Manual mode, with the AUTO mode switch in the Off position, select the desired amount of square forming pressure or set to off to by-pass the square forming action.
Use the [+] and [-] buttons or just point/drag at the scale .

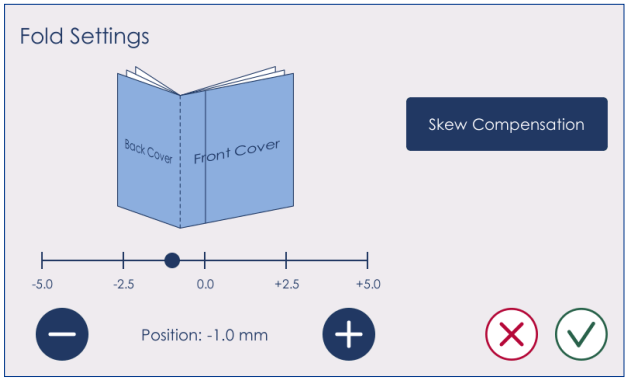
Save setting by pressing the green [check] button.

Fold

Adjusting fold position







Information on the [Fold] button shows the actual Fold status and position. To alter the Fold settings, press the [Fold] button from the Start screen.

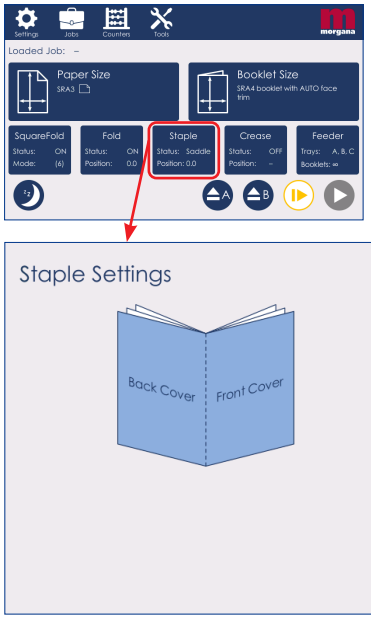
The Booklet Maker uses information from the set thickness sensor to calculate and adjust the correct fold position.
However, the operator can adjust the position of the fold up to 5 mm (0.2″) on either side of the center of the set. Press the [+] button move position closer to the lead edge and press the [-] button move position closer to the trail edge. Save setting by pressing the green [check] button.

Skew Compensation will be described later on in this section under “Fine-tuning the booklet appearance” below.

NOTE:
This adjustment, as well as Skew Compensation, can be performed during run. You may want to turn off trimming to see the result more clearly when you move the fold position.

Staple

General



Information on the [Staple] button shows the actual staple status and position. To alter the staple settings, press the [Staple] button from the Start screen.

Staple status can be set to either Saddle Stapling, Edge Stapling, Corner Stapling or being disabled by pressing the corresponding button. The screen to the left shows that stapling will be disabled when the green [check] button is pressed.

NOTE:
*Enabling or disabling of stapling **cannot** be performed during run.*

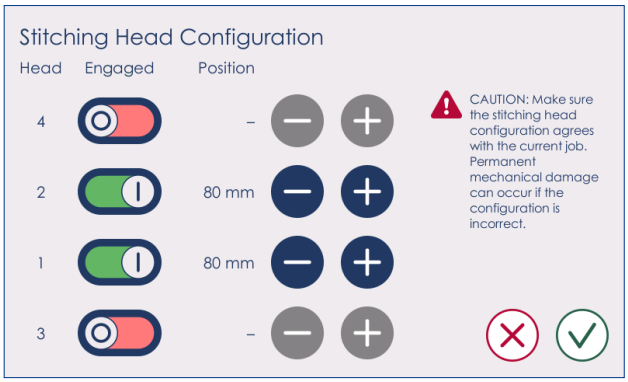
NOTE:
Edge and corner stapling capability might not be available on all systems.



Enabling any staple setting and pressing the green [check] button in the Staple Settings menu above will present this question.
Any mechanical changes to the stitching head configuration that already has been done or that will be done due to a change of status must be entered in the Stitching Head Configuration screen.

Press the red [cross] button if no mechanical changes has been made.

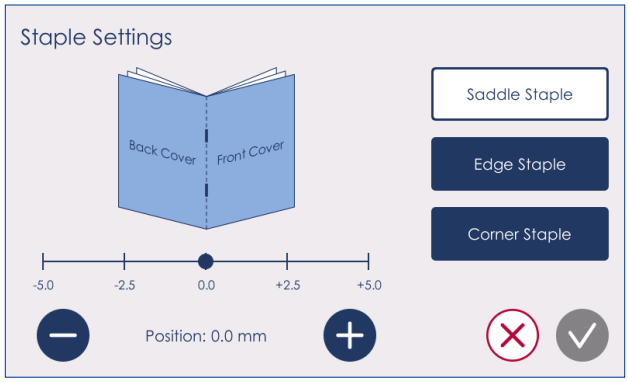
Press the green [check] button to open the Stitching Head Configuration screen in order to enter any mechanical changes.



The Stitching Head Configuration screen must reflect wether stitching heads are engaged and where they are positioned.
Mechanical changes in the stitching head configuration are described in section 1, “Basics”.
How changes in the stitching head configuration are entered in the user interface, is described in section 3, “Tools”.

⚠ CAUTION:
Make sure that the information about the position of the stitching heads and whether they are engaged is correct. Severe permanent damage to the stitching heads, clinchers and/or the side guides might occur otherwise.

Saddle Staple

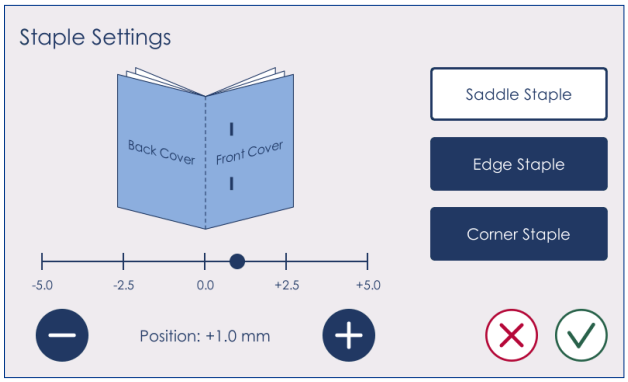


In the Staple Settings screen, enable saddle stapling by pressing the [Saddle Staple] button. Confirm by pressing the green [check] button.

The Booklet Maker uses the information from the set thickness sensor to calculate and adjust the correct staple position.

2

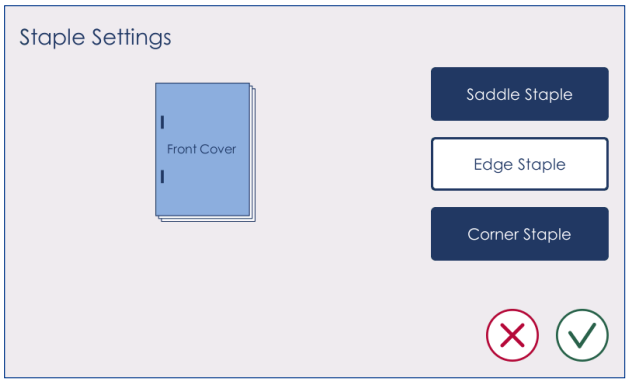
Adjusting saddle staple position



The operator can adjust the staple position up to 5 mm (0.2″) on either side of the fold. Press the [+] button move position closer to the lead edge and press the [-] button move position closer to the trail edge.
Save the setting by pressing the green [check] button.

NOTE:
This adjustment can be performed during run.

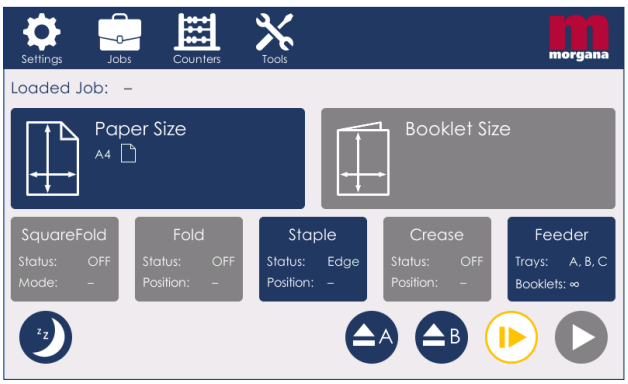
Edge Staple



NOTE:
Edge and corner stapling capability might not be available on all systems.

In the Staple Settings screen, enable edge stapling by pressing the [Edge Staple] button. Confirm by pressing the green [check] button.

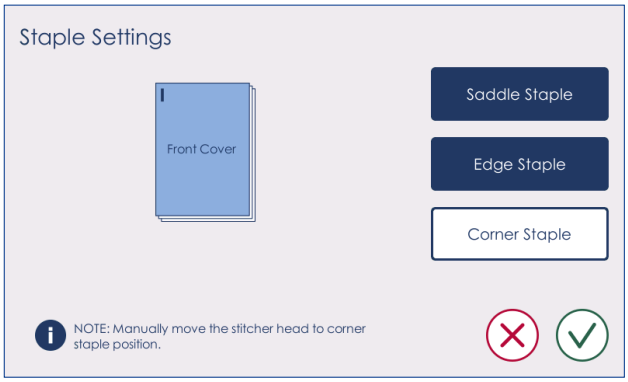
NOTE:
Edge Staple is only possible on paper sizes A4 or 8.5x11”.



The [Staple] button will show that the Booklet Maker is set to Edge Staple.

The Edge Stapled sets will then be delivered to the built-in Edge and Corner Staple Stacker in the Finishing Module.

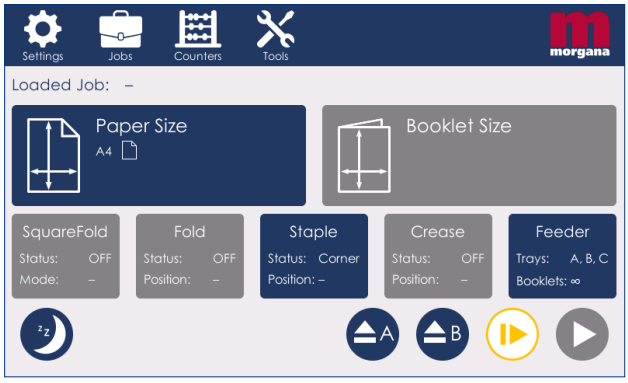
Corner Staple



NOTE:
Edge and corner stapling capability might not be available on all systems.

In the Staple Settings screen, enable corner stapling by pressing the [Corner Staple] button. Confirm by pressing the green [check] button.

NOTE:
Corner Staple is only possible on paper sizes A4 or 8.5x11".



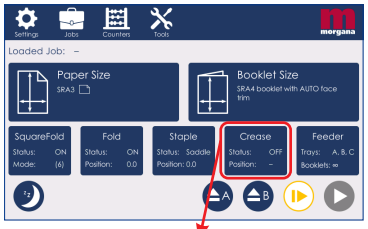
The [Staple] button will show that the Booklet Maker is set to Corner Staple.

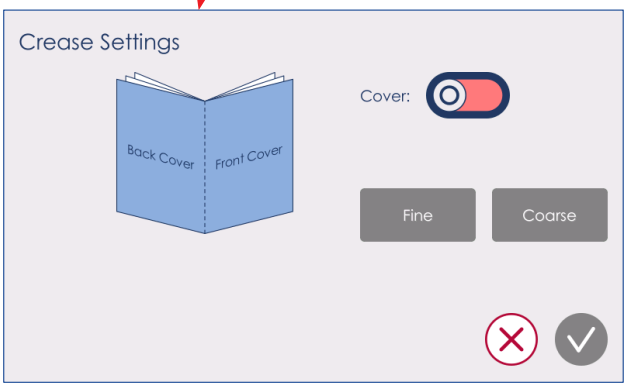
The Corner Stapled sets will then be delivered to the built-in Edge and Corner Staple Stacker in the Finishing Module.

Crease

The Crease function makes it possible to crease the cover sheet and/or the centre sheet of the booklet in order to avoid toner cracking or flaking at the fold.

Crease Mode





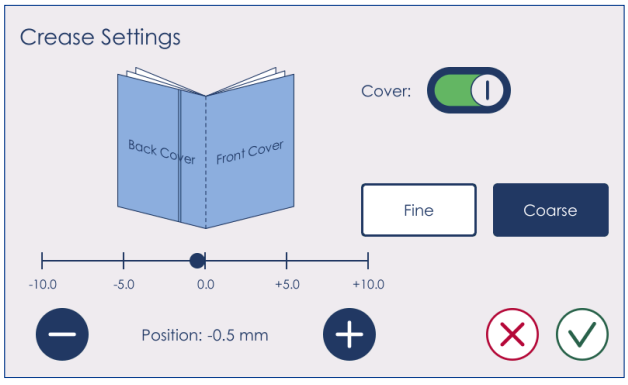
Information on the [Crease] button shows the actual Crease status and position. To alter the Crease settings, press the [Crease] button from the Start screen.

In the Crease Settings screen, press the Cover switch symbol to set the desired state, On or Off.
When the Cover switch is on, you can select which creaser tools to use by pressing the [Fine] or the [Coarse] button.

Normally the Fine setting is recommended for sheets less than 120 gsm / 32 lb Bond.
For sheets heavier than that, select the Coarse setting.

Press the green [check] button to confirm.

Crease position



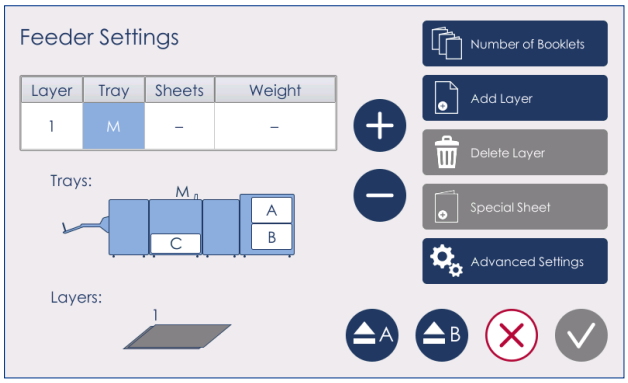
The positions of the crease is initially set to the center of the sheet. Operators have the option to offset the position of the crease using the [+] or [-] buttons. Press the [+] button move position closer to the trail edge and press the [-] button move position closer to the lead edge. Regardless if you chose Fine or Coarse creasing, each press of a button will move the crease 0.1 mm / 0.004″.

When done, press the green [check] button to confirm.

The illustration shows that the crease is offset 0.5 mm towards the lead edge.

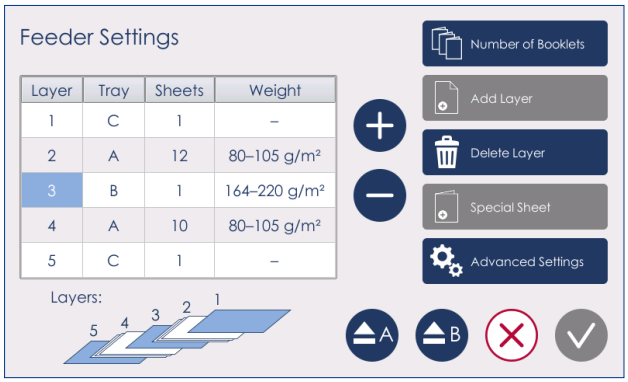
Feeder

General



In a fully configured system, the Booklet Maker can be feed sheets from trays A and B in the optional VFX Vacuum Feeder, tray C, the optional Convenience Feeder in the Booklet Maker or manually.

Select “Layer”, “Tray”, “Sheets” or “Weight” and use any of the buttons that are not greyed out to change settings.



The order of the layers reflects how the booklet will be compiled in the Booklet Maker. Subsequently, the layer with the highest number will be fed first and so on.

NOTE:
When feeding multiple sheets from a tray, they must be organized N-1 and face up. See Section 2, “How to organize paper stacks for feeding”, “Loading sheets when feeding from the VFX”.

For combinations and order of trays, see table below.

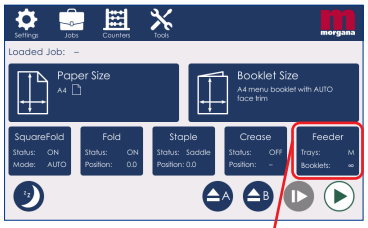
Possible feed sequences in a fully configured system i.e. with trays: M, C, A and B

Handfeeding of sets of 1 - 50 sheets. Sets can be fed either by opening the Manual Feed Cover in the Top Cover or by using the Manual Feed Tray.
Feeding from tray C only, 1 - 50 sheets.
Mixed feeding of handfed sets from tray M and then tray C using 2 layers. Max 50 sheets in total. Limitations: Max 1 sheet from tray C.
Mixed feeding from trays A and B in any order and combination up to 5 layers. Max 50 sheets in total.
Mixed feeding from trays A and B in any combination and tray C in up to 5 layers. Max 50 sheets in total. Limitations: Max 1 sheet from tray C. Tray C have to be in the first layer, the last layer or the first and the last layer.

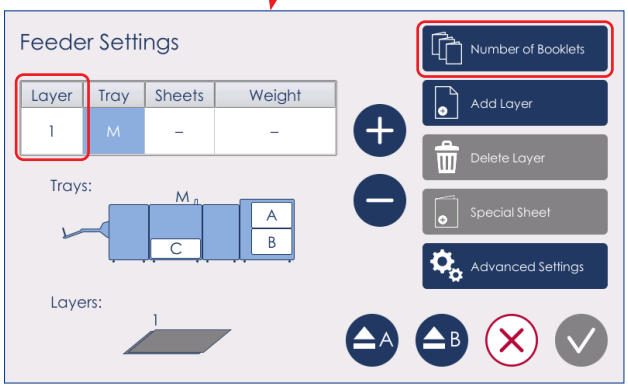
Not allowed feeding sequences

Feeding order first from tray C and then tray M is **not** allowed.
Mixed feeding from M and A and/or B is **not** allowed.

Setting up a feeder job



Press the [Feeder] button from the Start Screen.



Number of Booklets

To produce a certain number of booklets, press the [Numbler of Booklets] button and enter a number. That number will be shown on the [Feeder] button on the Start Screen.

Layers

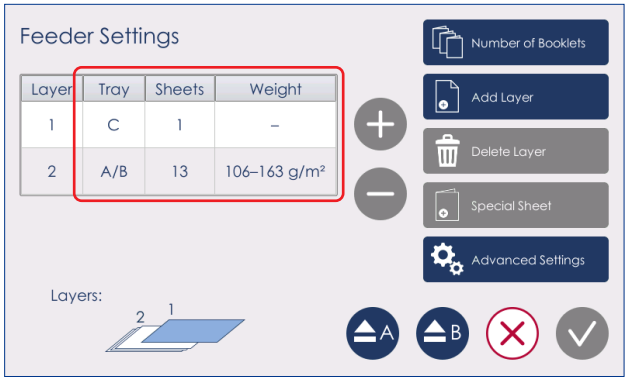
To add a layer, select the layer you want to add a layer on top of and press the [Add Layer] button. Unwanted layers can be deleted by marking that layer and pressing the [Delete Layer] button.

Trays

Select Tray and set to feed from A, B or C by pressing the [+] and [-] buttons.

To feed manually, set Tray to M. Sheets or sets can be fed either by opening the Manual Feed Cover in the Top Cover or by using the Manual Feed Tray.

Tray can also be set to A/B. This means that tray A and B are linked together and the loading capacity now is doubled. The Feeder will automatically switch to tray B when tray A is empty.



NOTE:
Linked trays A/B can be selected to extend the capacity when you have the exact same sheet size in both trays. To further extend the capacity, enable the tool [Load While Run], see section 3, "Tools", Load While Run.

Sheets

Select Sheets and set to desired number of sheets to be fed by pressing the [+] and [-] buttons.

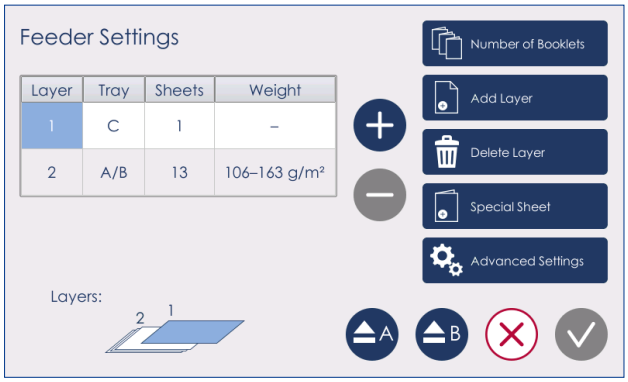
Weight

For tray A and B, select Weight and set to the correct paper weight by pressing the [+] and [-] buttons. When running mixed media, for example thinner body sheets and thicker cover sheets, set weight to the thinner body sheets.

NOTE:
Also see "Media Properties" under "Advanced Feeder Settings" below.

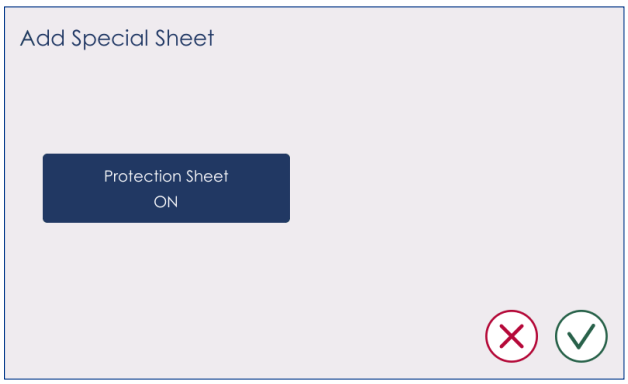
continued on next page

Setting up a feeder job, continues

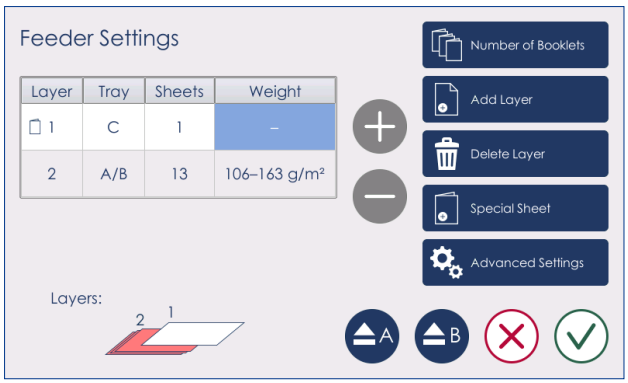


Special Sheet - Protection Sheet
In case you are running sensitive media you can use tray C to feed a protection sheet.

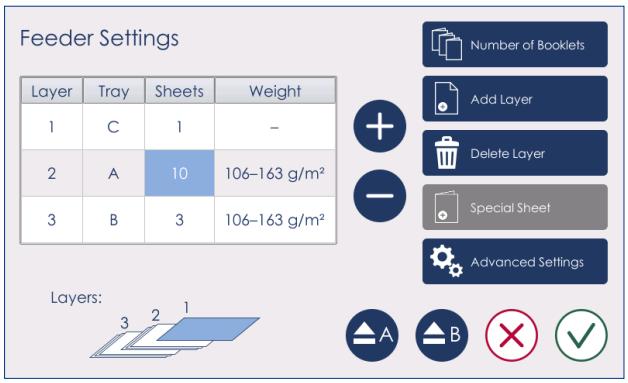
To enable the [Special Sheet] button, make sure the top layer is set to feed 1 sheet from tray C and that layer is marked. Pressing the [Special Sheet] button will then open the Add Special Sheet screen.



Press the [Protection Sheet] button and set to on to add a protective sheet to the set. Then press the green [check] button to confirm.
The sheets in the set will be jogged and stapled before the protection sheet is fed.
The set and the protections sheet will then be folded together. Protective Sheet ON is shown by a red triangle next to the layer number.



Example 1
The job consists of 13 body sheets and one cover sheet.
13 sheets will be fed from tray A. The Feeder will automatically switch to tray B when tray A is empty.
1 sheet will be fed from tray C.
The folded sheet symbol next to the layer number shows that the sheet from tray C is a protection sheet.



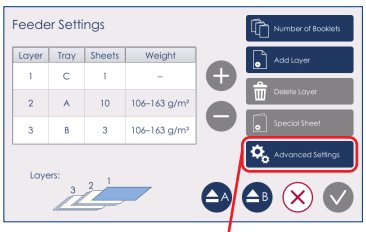
Example 2
The job consists of 13 body sheets and one cover sheet.
Cover sheets are placed in tray C.
Black and white body sheets are placed in tray A.
Colored body sheets are placed in tray B.

When the setup is completed, confirm by pressing the green [check] button.

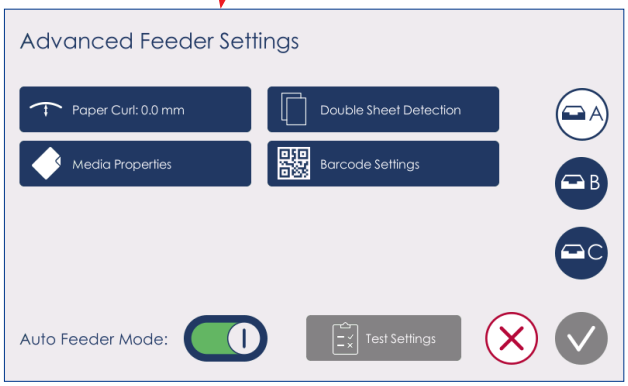
Advanced Settings

General

In the Advanced Feeder Settings screen you can modify tray settings, paper loading settings, double sheet detection (DSD) settings and also test the settings.



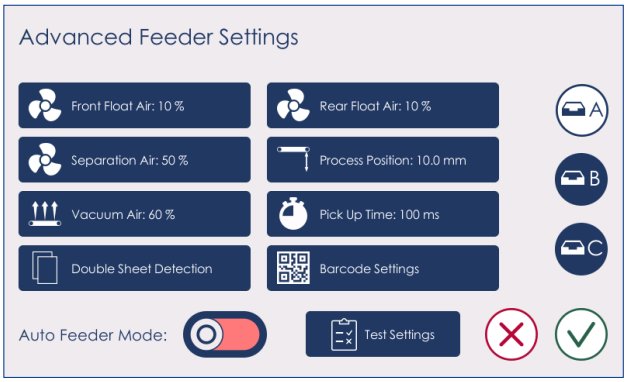
To reach Advanced Feeder Settings, press the [Advanced Settings] button from the Feeder Settings Screen.



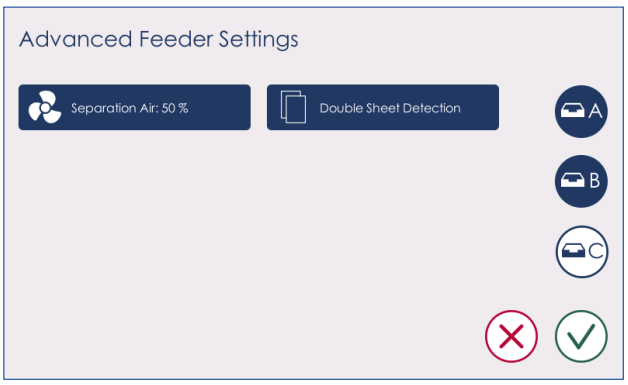
The two trays A and B of the VFX can be set independently. Just select Tray A or B and then any setting to modify.

Settings that can be modified in Auto Feeder Mode are: Paper Curl, Double Sheet Detection, Media Properties and Barcode Settings.

NOTE:
It is recommended, at least initially, to use Auto Feeder Mode.



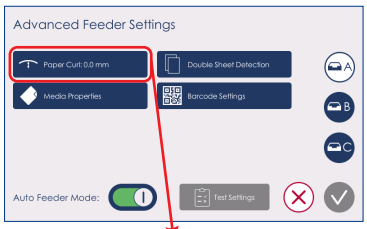
If Auto Feeder Mode provides unsatisfactory results, it can be turned off so that the fan settings can be adjusted individually. It is recommended to adjust only one setting at a time. If adjusting that setting does not provide satisfactory results, set it back to the original value prior to adjusting another setting.



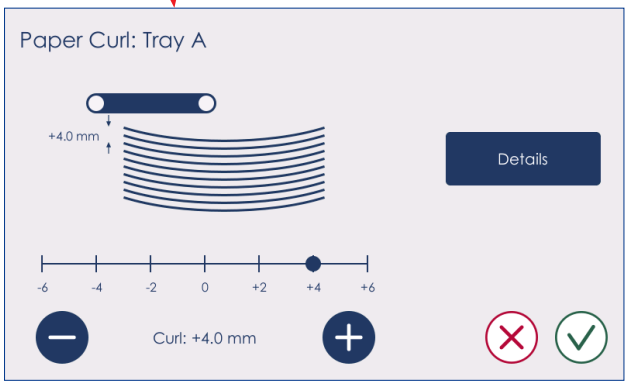
Tray C, the Convenience Feeder, offers less settings to modify. Just Separtion Air and Double Sheet Detection.

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode on

Paper Curl



To reach Paper Curl settings, press the [Paper Curl] button from the Advanced Feeder Settings Screen when in Auto Feeder Mode.

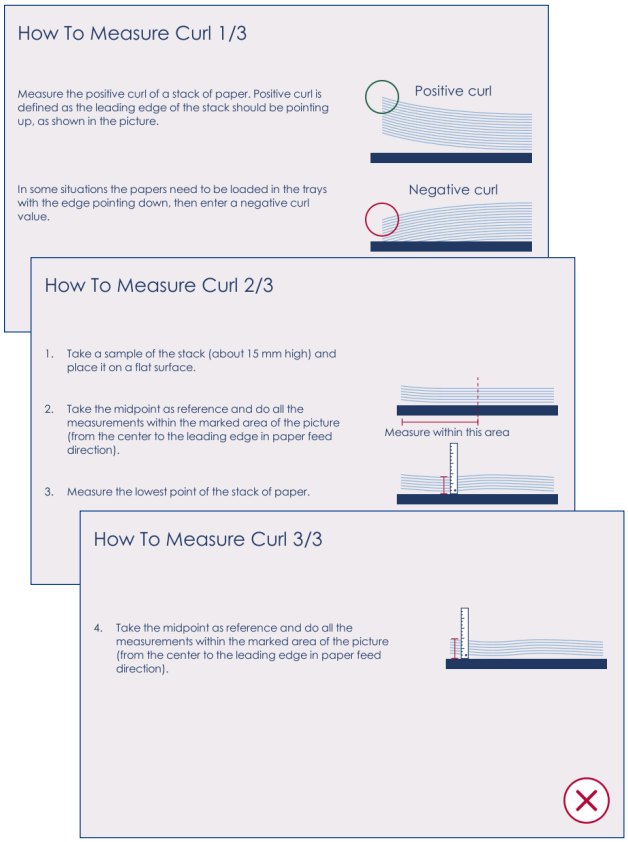


This parameter allows the user to select the curl amount of the loaded paper.
The user can choose between six different amounts that should be selected as follows:

6 mm / 0.24” for 6 mm / 0.24” curls and over;
4 mm / 0.16” for 4 / 0.16” and 5 mm / 0.20” curls;
2 mm / 0.08” for 2 / 0.08” and 3 mm / 0.12” curls;
-2 mm / -0.08” for -2 / -0.08” and -3 mm / -0.12” curls;
-4 mm / -0.16” for -4 / -0.16” and -5 mm / -0.20” curls;
-6 mm / -0.24” for -6 mm / -0.24 curls and under.
Save setting by pressing the green [check] button.

NOTE:
It is strongly advised not to select a curl amount greater or smaller than what is defined in the machine specs. (process direction curl ± 5 mm / ± 0.20” and cross process direction curl ± 2 mm / ± 0.08”).

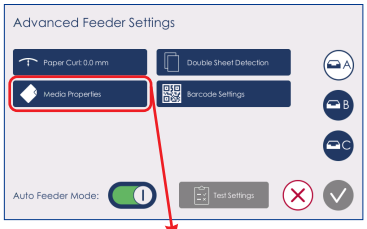
NOTE:
Always load the trays with paper that has negative curl. If this is not possible, it is very important to compensate for the positive curl with the Paper Curl function.

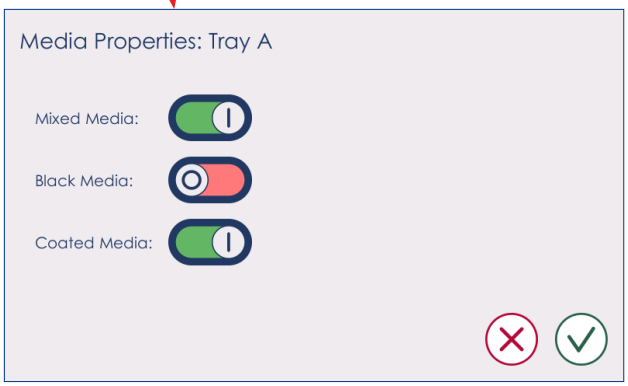


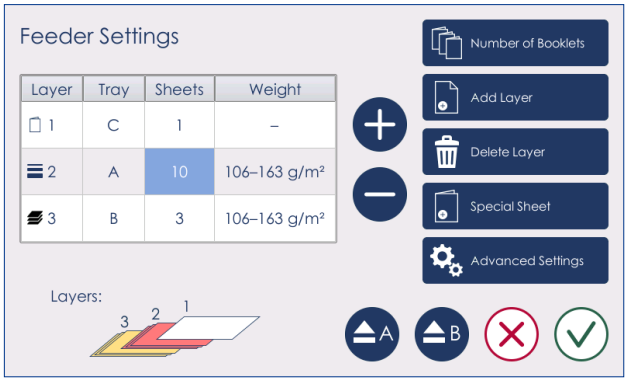
Pressing the [Details] button in the Paper Curl screen will present a step by step instruction how to measure curl.

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode on, continues

Media Properties







To reach Media Properties settings, press the [Media Properties] button from the Advanced Feeder Settings Screen when in Auto Feeder Mode.

Mixed Media

Set Mixed Media to on when running media of various paper weight. Mixed Media setting will be indicated by an icon showing three lines of different thickness next to the layer number. See layer 2 below.

NOTE:
Also see "Weight" under "Setting up a feeder job" above.

Black Media

Set [Black Media] to off when running light colored paper and to on when running dark colored paper (e.g. dark blue paper). Black Media setting is indicated by an icon showing a stack of black sheets next to the layer number. See layer 3.

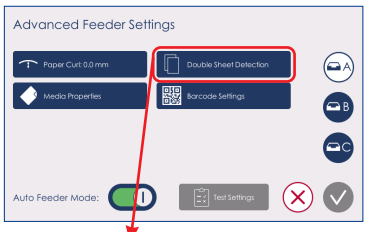
NOTE:
This setting is only about the paper color. The ink color and the print job does not affect this choice.

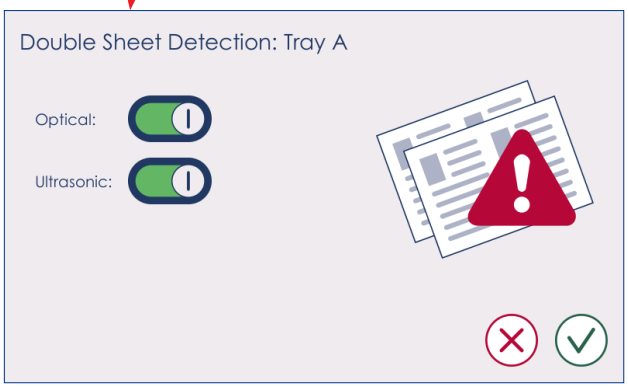
Coated Media

Set [Coated Media] on or off depending on whether the loaded media is coated or not.

Save setting by pressing the green [check] button.

Double Sheet Detection





To reach Double Sheet Detection setting, press the [Double Sheet Detection] button from the Advanced Feeder Settings Screen when in Auto Feeder Mode.

Double Sheet Detection will allow the user to view and control which DSD Sensors are active. The VFX Vacuum Feeder is equipped with two independent double sheet detection systems, both optical and ultrasonic. One in each tray. The Ultrasonic Double Sheet Detection is active by default. If one of them should cause problems with a specific material, it can be turned off. This setting is stored with the active job.

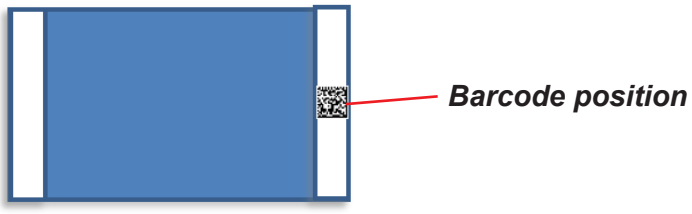
Save setting by pressing the green [check] button.

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode on, continues

Barcode readers

If your VFX is equipped with the optional barcode readers, you can monitor every sheet fed from both trays.

Barcode characteristics
The barcode generation on the sheets is responsibility of the user.
The barcode size has to be of 5x5mm or larger (10x10mm is the optimal size).
The barcode must be placed in the centre on the trail edge of the sheet as shown in the picture below. This area can be trimmed off during the booklet production.



Supported codes:

1D and 2D BARCODES

Types:	Max number of characters:
Code-39	24
DataMatrix	24
QR	24
PDF417	24

The reader can handle 10mil resolution on barcode

The following control codes are supported:

Control codes	Cover	Set ID	Job ID	Sequential	Page number	Page Count	Stop
Number of characters that can be allocated	1 digit (0-9)	1-20 digits (0-9)	1-20 digits (0-9)	1-5 digits (0-9)	Must be 2 digits (0-9)	Must be 2 digits (0-9)	1 digit (0-9)

NOTE:
Number of characters should not exceed 24. Only digits are allowed.

See the “definition of control codes” on the following page for further information.

continued on next page

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode on, continues

Barcode Readers, continued

Definitions of the control codes:

Name	No. of character	Content
Cover	1 digit (0-9)	This function is used to feed covers from Tray B. If the Cover position in the barcode is equal to 0, this means that cover will not be fed. For any other number VFX will feed the cover as the last sheet.
Set ID	1-20 digits (0-9)	The Set Identification Code function is used for security purposes. All the sheets of the same document/set must have the same ID, while the following set must differ.
Job ID	1-20 digits (0-9)	The Job ID function is used for security purposes. All the sets in the same job must have the same ID, which is defined on the first page.
Sequential	1-5 digits (0-9)	The Sequential function is used for security purposes. Sequential numbering runs through the whole job counting up or down and it is determined by the first two pages.
Page Count	Must be 2 digits (0-9)	The Page Count function is used to control the total number of sheets in the set.
Page Number	Must be 2 digits (0-9)	The Page Number function is used both for control and security purposes. When used together with Page Count, this function counts the sheets' number within a set. It can count up or down and it is determined by the first set that has two sheets.
Stop	1 digit (0-9)	Soft stops the machine. When a stop mark is read, the machine finishes that set and then stops the cycle. If the Stop position in the barcode is 0, this means that the machine will run. For any other number the machine will stop.

If a control code is set to "–", that means the control code/function is turned off/disabled.

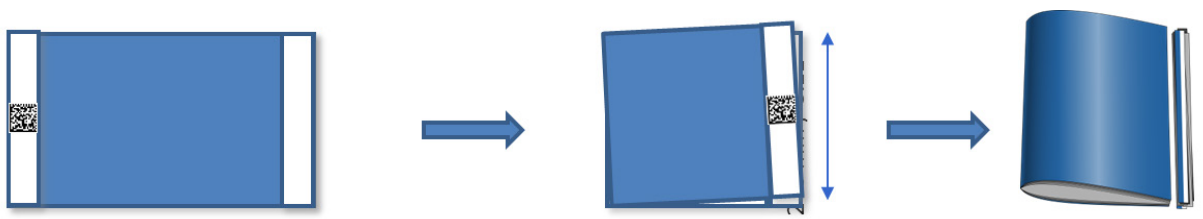
NOTE:

- *Page Number and Page Count are the only two control codes that always have to be specified to run a job. Every other code adds additional features but is not mandatory.*
- *Control codes needs to be grouped together on adjacent rows.*

Functional description:

- Feed either from tray A or from B or from both the trays

  NOTE:
  If feeding from both trays, the "Sequential" option must be enabled;
- Count within set;
- Set break;
- Set size definition.



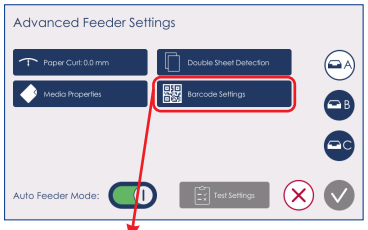
Sheet with barcode ***After folding*** ***After trimming***

continued on next page

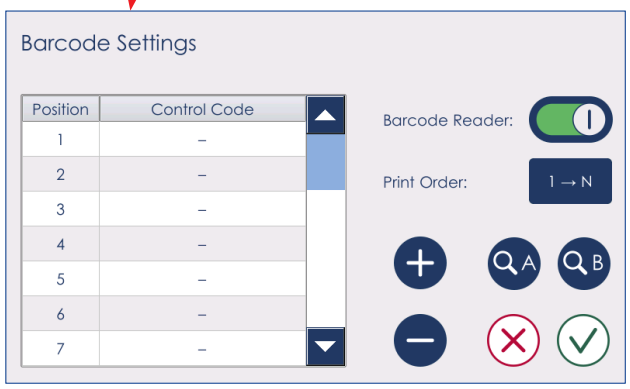
Advanced Settings in the VFX, trays A and B, Auto Feeder Mode on, continues

Barcode Settings

This section will guide the user through the Barcode job setup.



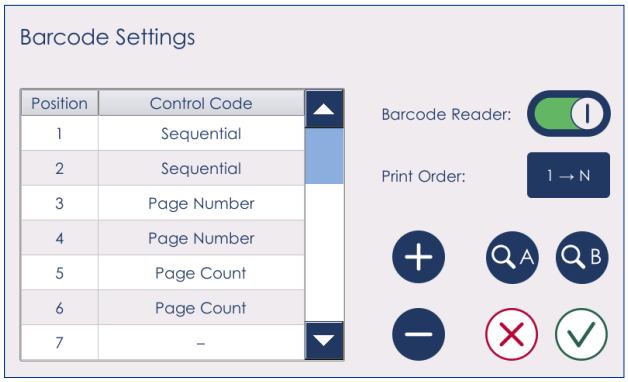
Select [Barcode Settings] from the Advanced Feeder Settings menu to open the Barcode Settings screen.



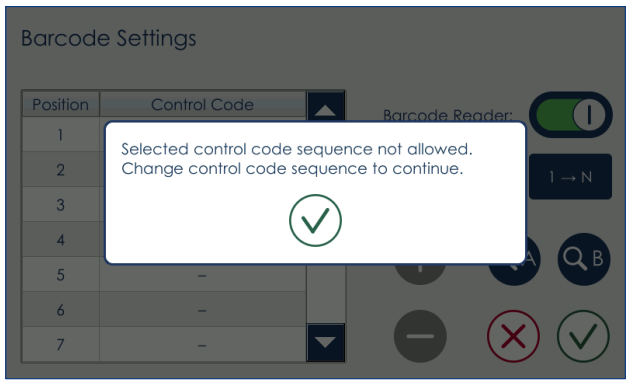
Switch on the Barcode Reader and choose a print order

Switch on the Barcode Reader by pressing on [Barcode: ON] and choose the correct print order for the code by pressing the [Print Order] button: ascending: 1→N; or descending: N→1.

NOTE:
This will not change the actual print order of the job.



When the control code sequence is entered, press the green checkmark to confirm.



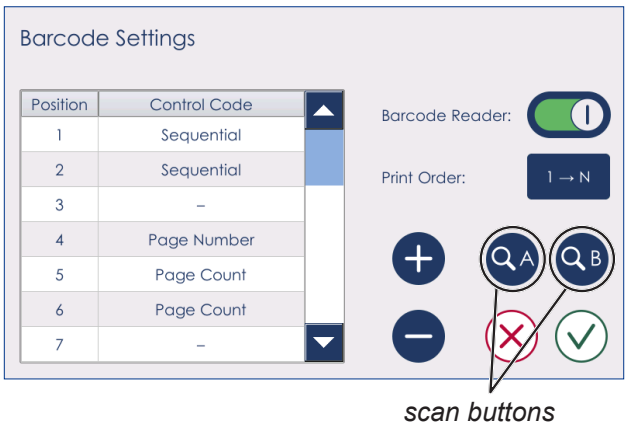
If the entered control code sequence is not allowed, the message to the left will be shown when the green checkmark is pressed to confirm.

Press the green check mark in the dialog box and correct the control code sequence.

continued on next page

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode on, continues

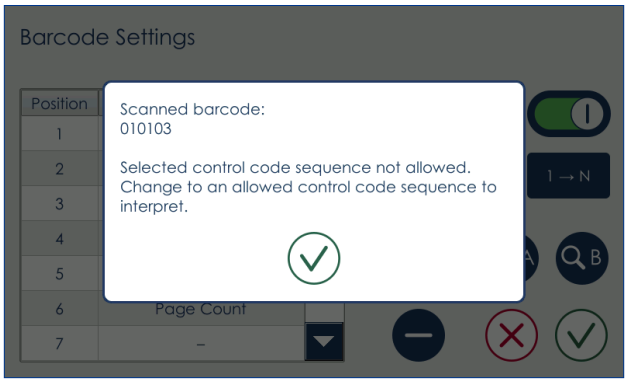
Barcode Settings, continues



scan buttons

The Barcode cameras can scan the Barcode on the loaded stack at any point during the programming if the actual Scan button is pressed.

When the control code sequence is entered, press the green checkmark to confirm.



If the entered control code sequence is not allowed, the message to the left will be shown when the green checkmark is pressed to confirm.
Also the control code interpreted from scanning the barcode from the paper stack is displayed.

Press the green check mark in the dialog box and correct the control code sequence.

continued on next page

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode on, continues

Barcode Settings, continues

Examples:
The following examples show how the machine reads the barcode and interprets the control codes.

Example 1

2

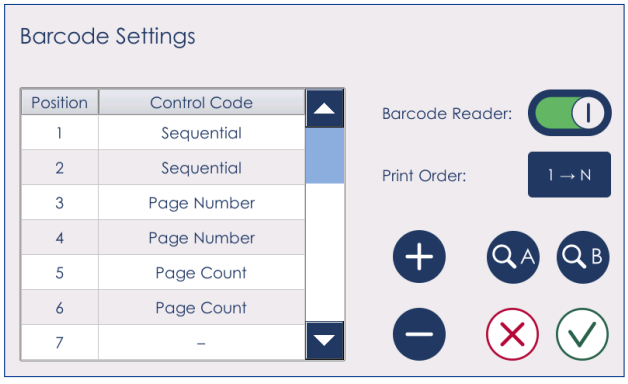
Barcode:

Data processed by the Barcode reader:

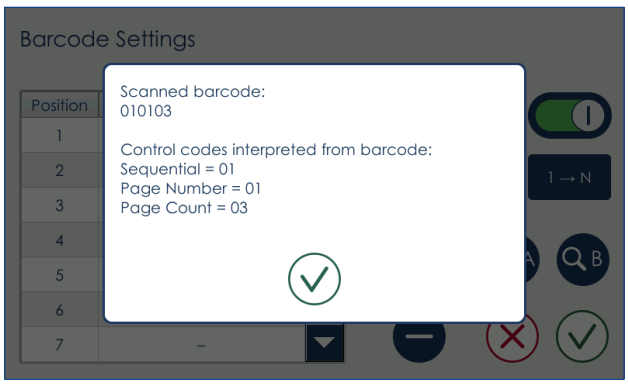
cover:	*Cover function is off*
setid:	*Set ID function is off*
jobid:	*Job ID function is off*
seq: 01	*Number of sheet in sequence*
pagenr: 01	*Number of current page in the set*
pagecount: 03	*Total number of pages in the set*
stop:	*Stop function not enabled*
code: 010103	*String of numbers*

In this case, the first sheet of the stack reads: 010103.
This means that the first two characters are for the Sequental function, the 3rd and the 4th characters are the Page Number and the 5th and the 6th characters are the Page Count function.

Code:	0	1	0	1	0	3
Control Code:	Sequential		Page Number		Page Count	
Position:	1	2	3	4	5	6



This screenshot shows the correctly entered control code sequence.



This screenshot confirms that the entered barcode settings are correct and also shows the control codes interpreted from scanning the barcode on the loaded paper stack.

continued on next page

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode on, continues

Barcode Settings, continues

Example 2

Barcode:

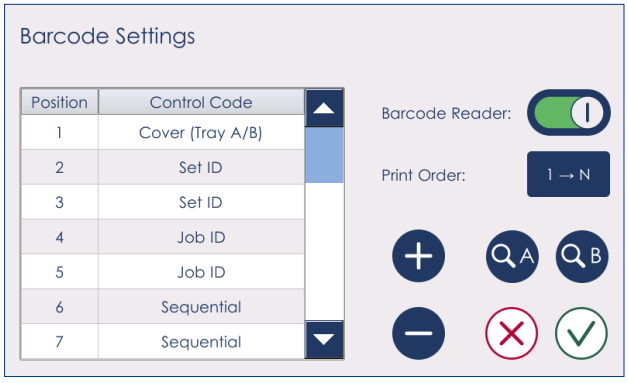
Data processed by the Barcode reader:

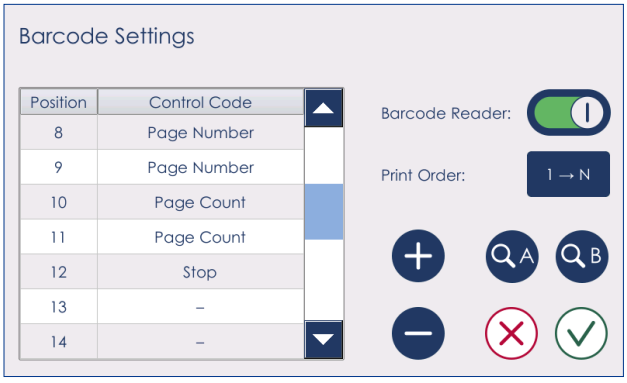
cover: 1	*Cover function is on and a cover will be fed*
setid: 03	*Set ID function is on and the setID is 03*
jobid: 01	*Job ID function is on and the jobID is 01*
seq: 06	*Number of sheet in sequence*
pagenr: 01	*Number of current page in the set*
pagecount: 05	*Total number of pages in the set*
stop: 0	*Stop function is enabled but not active for this sheet*
code: 103010601050	*String of numbers*

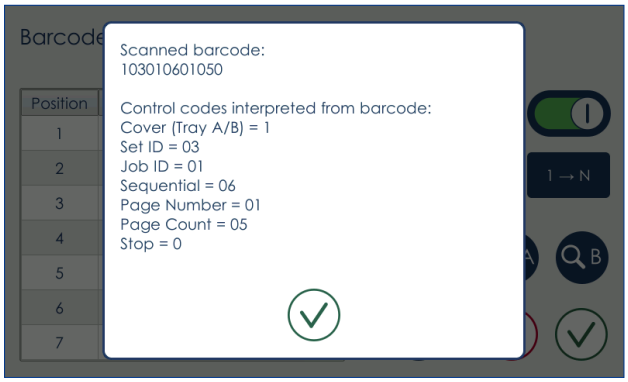
In this case, the sixth sheet of the stack reads: 103010601050.

This means that the first character is for the cover function, the following two characters are for the set ID function, the 4th and the 5th characters are for the job ID, the 6th and the 7th are for the Sequental function, the 8th and the 9th characters are the Page Number, the 10th and the 11th characters are the Page Count function and the last character is for the stop function.

Code:	1	0	3	0	1	0	6	0	1	0	5	0
Control Code:	Cover	Set ID		Job ID		Sequential		Page Number		Page Count		Stop
Position:	1	2	3	4	5	6	7	8	9	10	11	12







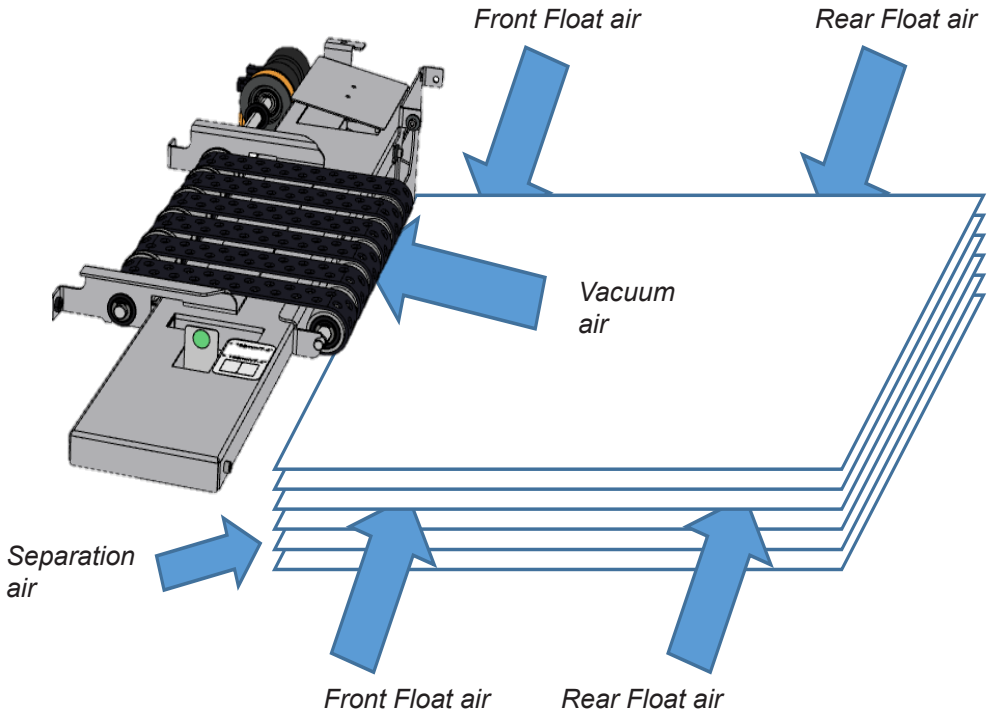
The two upper screenshots shows the correctly entered control code sequence.

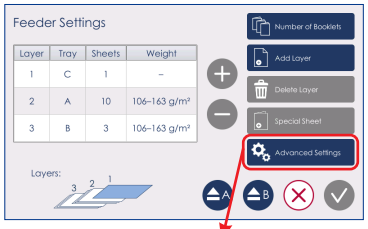
The lower screenshot confirms that the entered barcode settings are correct and also shows the control codes interpreted from scanning the barcode on the loaded paper stack.

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode off

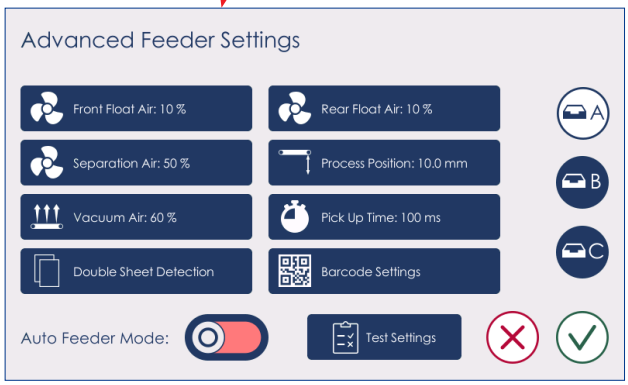
A number of different fans are used to create paper suction and separation between the sheets. If Auto Feeder Mode provide unsatisfactory results, it can be turned off so that the fan settings can be adjusted individually. It is recommended to adjust only one setting at a time. If adjusting that setting does not provide satisfactory results, set it back to the original value prior to adjusting another setting. As a rule of thumb, heavier paper typically requires more air flow.

NOTE:
It is recommended, at least initially, to use Auto Feeder Mode.





To reach Advanced Feeder Settings, press the [Advanced Settings] button from the Feeder Settings Screen.

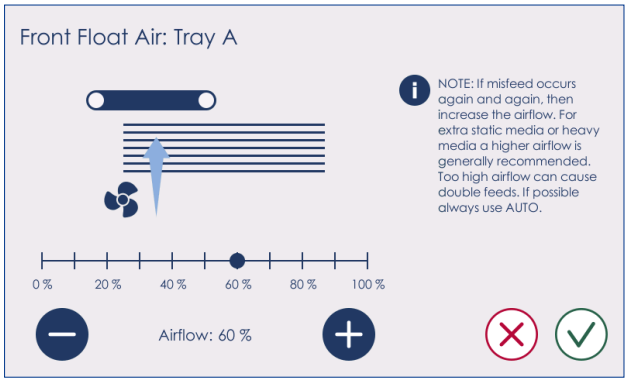


The two trays A and B of the VFX can be set independently. Just select Tray A or B and then any setting to modify.

Settings that can be modified when Auto Feeder Mode is turned off are: Front Float Air, Rear Float Air, Separation Air, Process Position, Vacuum Air and Pick Up Time.
Double Sheet Detection and Barcode Settings are already describe above under Advanced Feeder Settings, Auto Feeder Mode On.

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode off, continues

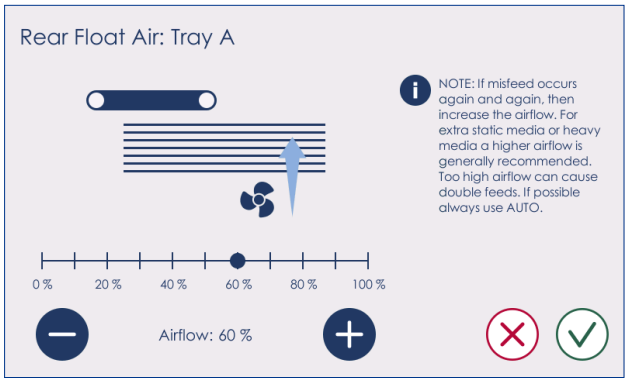
Front Float Air



This parameter controls the flow of the two front fans (closest to the transportation belt). Float air blows into the paper stack from the sides to create separation between sheets.
Press the green [check] button to confirm the changes or the red [cross] button to discard them and to go back.

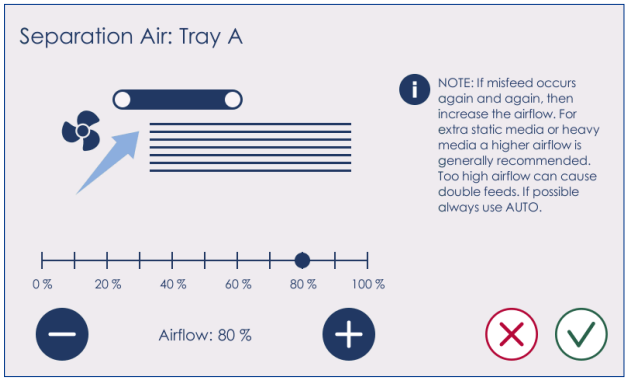
2

Rear Float Air



This parameter controls the flow of the two rear fans. Float air blows into the paper stack from the sides to create separation between sheets.
Press the green [check] button to confirm the changes or the red [cross] button to discard them and to go back.

Separation Air

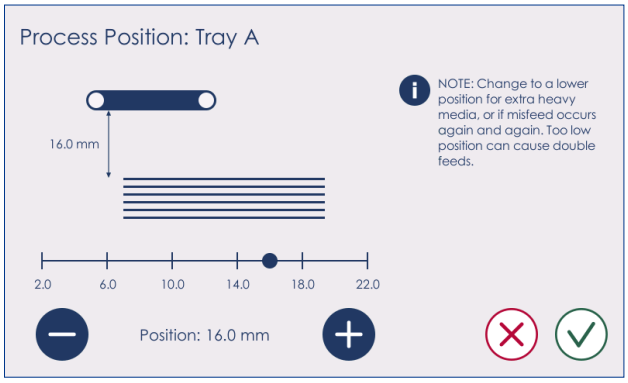


The Separation Air Fan blows air underneath the transportation belts at the leading edge of the paper stack to maintain paper separation during feeding.
Press the green [check] button to confirm the changes or the red [cross] button to discard them and to go back.

continued on next page

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode off, continues

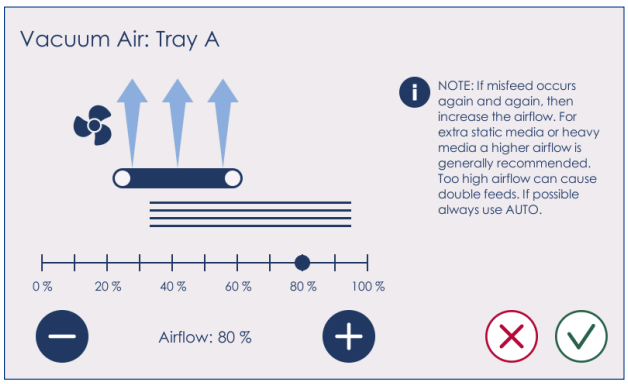
Process Position



This parameter controls the position of the top of the unseparated paper stack. The Process Position value corresponds to a position on the SP Sensor, which the operator can see via a label on the case of the SP Sensor.
Press the green [check] button to confirm the changes or the red [cross] button to discard them and to go back.



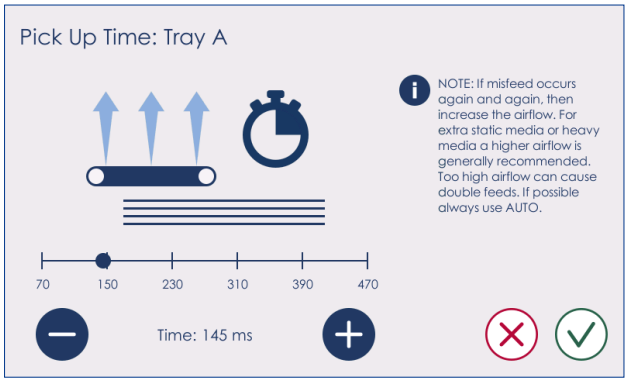
Vacuum Air



This parameter controls the vacuum fan, which pulls paper towards the transportation belt during feeding.
Press the green [check] button to confirm the changes or the red [cross] button to discard them and to go back.

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode off, continues

Pick Up Time

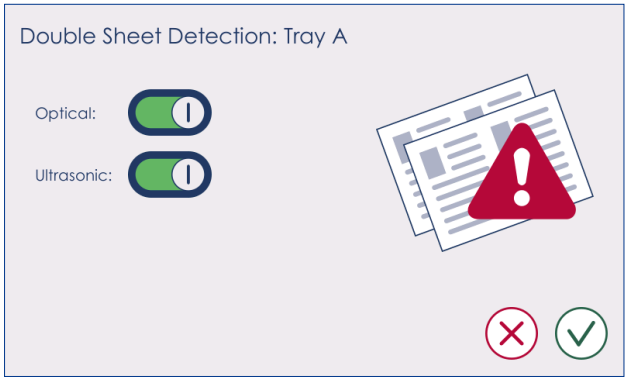


The Pick up Time is the amount of time the vacuum is activated to feed each sheet. This value can be adjusted between 75 ms and 500 ms. Press [+] or the [-] button to adjust this value. A higher Pick up Time will slow the process down since it will take more time for the VFX to feed each sheet but it might also help to solve jam problems.

NOTE:
This value should be adjusted when performing the "jam recovery manual setting" procedure described in section 6.

Press the green [check] button to confirm the changes or the red [cross] button to discard them and to go back.

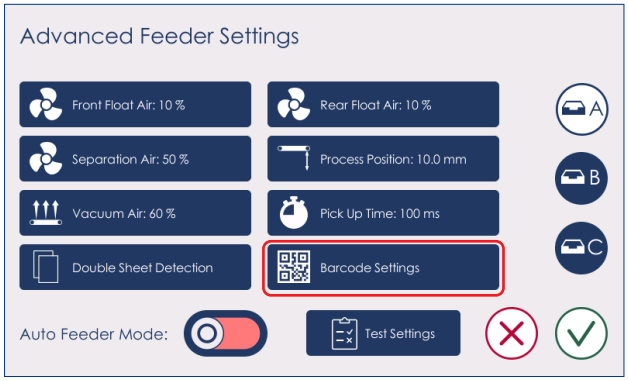
Double Sheet Detection



Double Sheet Detection will allow the user to view and control which DSD Sensors are active. The VFX Vacuum Feeder is equipped with two independent double sheet detection systems, both optical and ultrasonic. One in each tray. They are both active by default. If one of them should cause problems with a specific material, it can be turned off. This setting is stored with the active job.

Save setting by pressing the green [check] button.

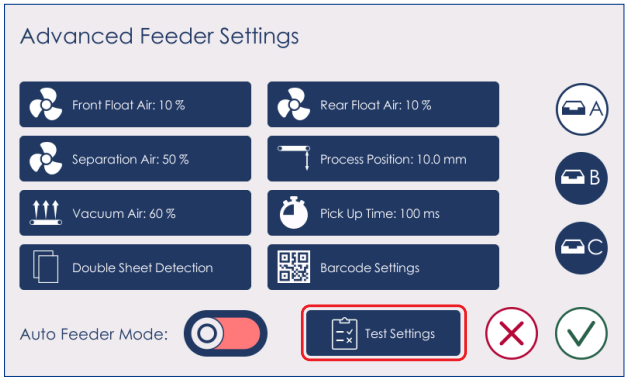
Barcode Settings



See "Barcode Readers" and "Barcode Settings" earlier in this section under "Advanced Settings in the VFX, Trays A and B, Auto Feeder mode ***on***".

Advanced Settings in the VFX, trays A and B, Auto Feeder Mode off, continues

Test Settings



Test Settings
The [Test Settings] button is used to check the manual settings.
Press this button once and then [ON] to activate all the fans and move the elevator to process position according to your settings.
The sheets will continue to float until you push [OFF] to stop the test mode: the fans will switch off and the elevator will move down.

NOTE:
This function is disabled when the VFX is set to Auto Feeder Mode On.

As a rule of thumb, there should be from 10 to 20 sheets floating over the stack of unseparated paper.

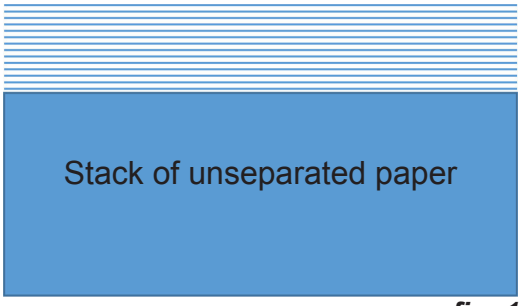


fig. 1

If the VFX is set correctly, the sheets will be floating horizontally with equal amounts of separation between sheets as shown in figure 1.



fig. 2

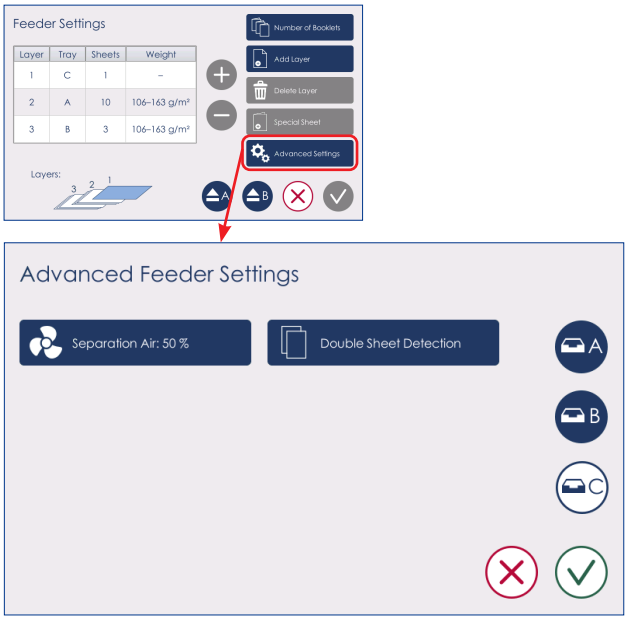
If sheets are floating with the leading edge pointing up, the process position value should be increased while the separation air value should be decreased, in order to get the paper floating as in figure 2.



fig. 3

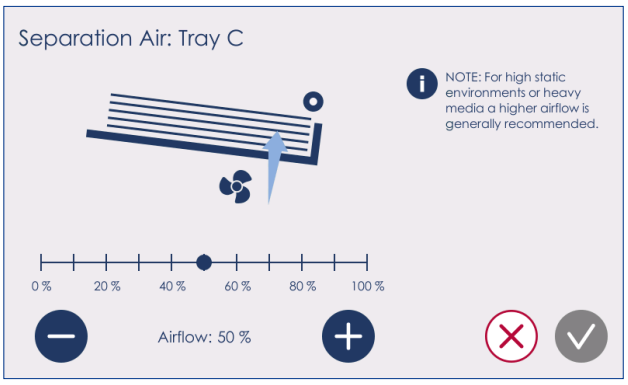
If sheets are floating with the leading edge pointing down, the process position value should be decreased while the separation air value should be increased, in order to get the paper floating as in figure 3.

Advanced Settings in the Convenience Feeder, tray C



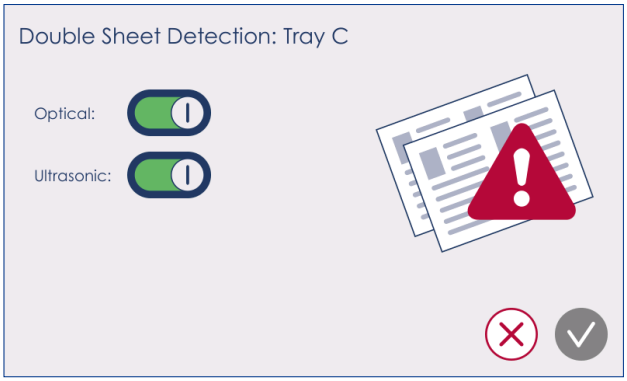
To reach Advanced Feeder Settings, press the [Advanced Settings] button from the Feeder Settings Screen.

Separation Air



You may want to increase the Air flow when running thick, heavy sheets. From the Advanced Feeder Settings screen, press the [Separation Air] button.
Set the desired amount of air flow by pressing the corresponding button and save setting by pressing the green [check] button. Default setting is 10%.

Double Sheet Detection



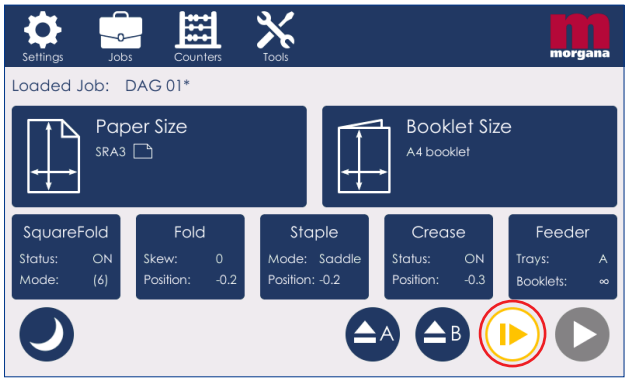
From the Advanced Feeder Settings screen, press the [Double Sheet Detection] button.

Press the appropriate switch symbol to set Optical and/or Ultrasonic (optional) double sheet detection to On or Off. Then press the green [check] button to confirm.

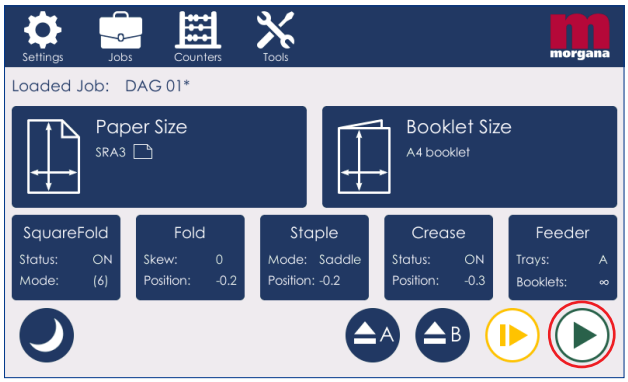
Normally, both Optical and Ultrasonic (optional) double sheet detection should be set to On when you are feeding covers. However, if you experience “false double sheet feeds”, for example when running covers that are thick, with dark print or with mixed prints on the covers, begin with setting the Optical double sheet detection to Off.

NOTE:
Misfeed detection will work regardless of how Double Sheet detection is set.

Operation with VFX



Proof
After loading sheets, set up a job as described earlier in this section.
Press the yellow [Proof] button. The VFX will then feed one set into the Booklet Maker.
This allows the user to check the first booklet before starting production and when necessary change the job set up.



Play
When the proof booklet is found to be good, press the green [Play] button to start production.

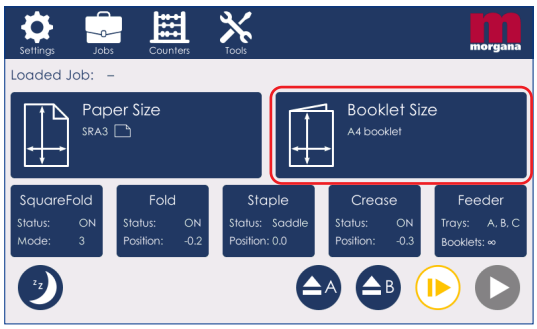


Stop
If no specific number of booklets to produce was set, press the red [Stop] button to abort production at will.

Fine-tuning the booklet appearance

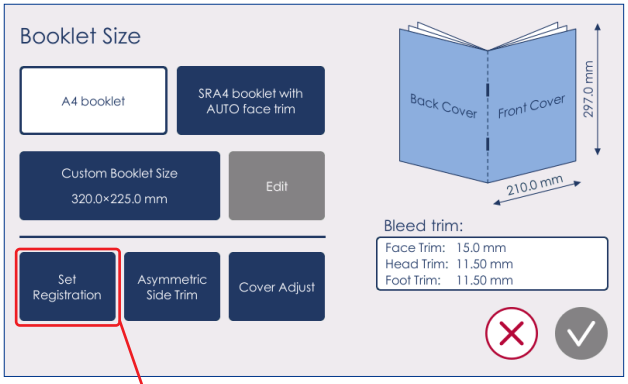
There are a number of adjustments you can perform to fine-tune the appearance of the booklets and compensate for variations in paper or print.

NOTE:
All these adjustments are specific and will be reset to zero if the Paper Size is changed.

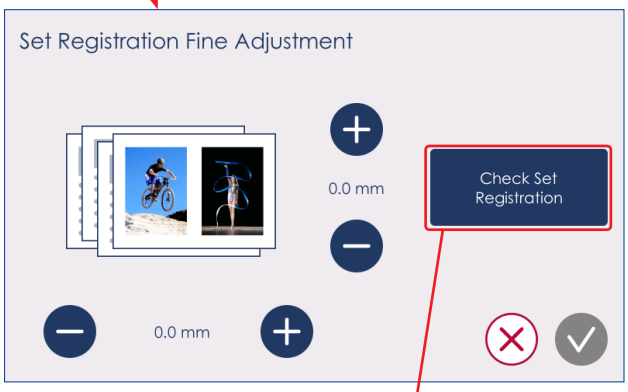


For all adjustments on this spread, start by pressing the [Booklet Size] button from the Start screen in order to reach the Booklet Size screen.

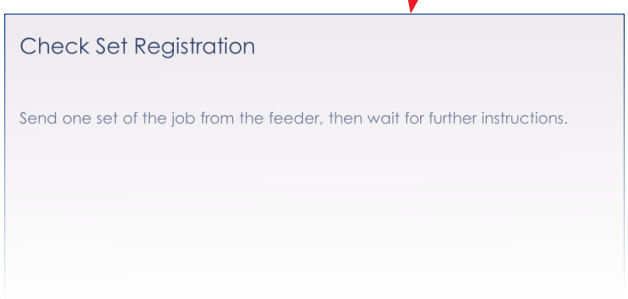
Set registration, Fine Adjustment



From the Booklet size screen, press the [Set registration] button.

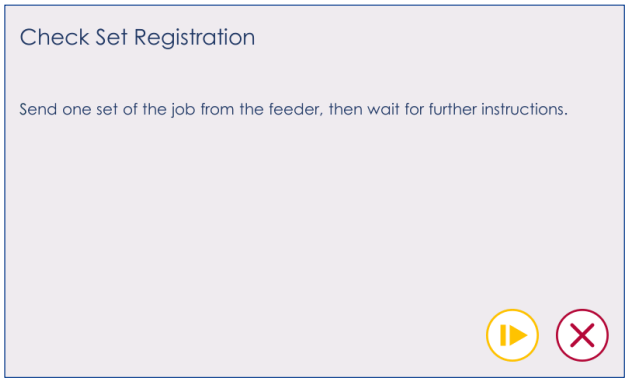


From the Set Registration Fine Adjustment screen, press the [Check Set Registration] button to start the Check Set Registration procedure.

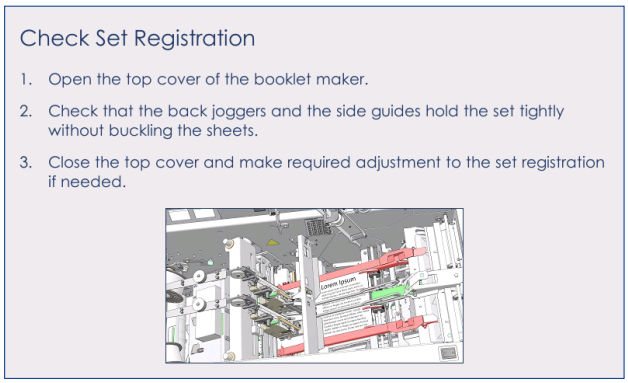


continued on next page

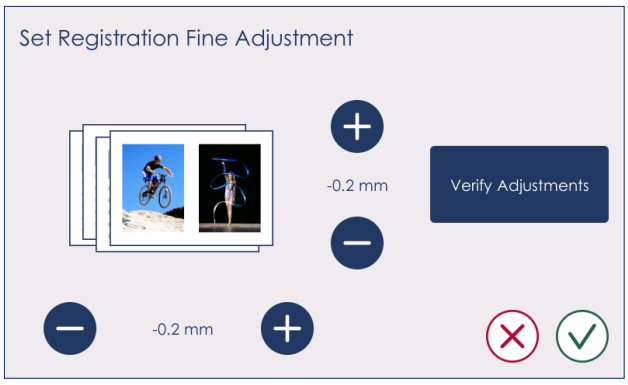
Fine-tuning the booklet appearance, continued



Send one set of the job from the feeder and follow instructions on screen.



When the set has stopped in the compiler area, follow instructions on screen to check the registration of the set.



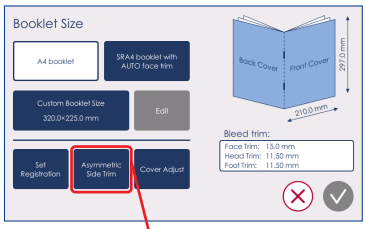
After the Top Cover is closed, press the [-] and [+] buttons from the [Set Registration Fine Adjustment] screen to change either or both registration values.
A negative value means a tighter registration of the Booklet.

NOTE:
Too tight of a setting may worsen the result.

After setting registration values, press the [Verify Adjustments] button.

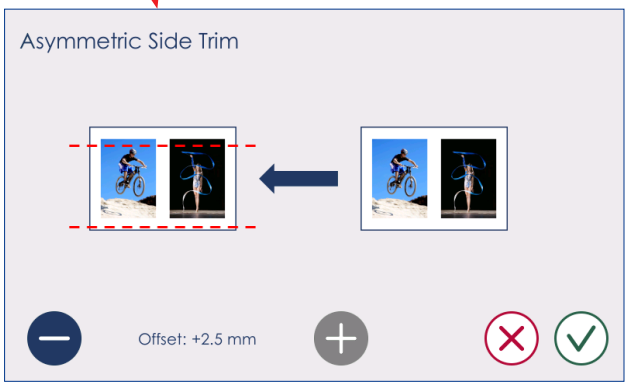
Repeat this procedure till a desired registration is achieved. Then, press the green [check] button.

Side Trimmer - Asymmetric Side Trim



Change value of the Asymmetric Side Trim if you want to offset the Side Trim from the center.

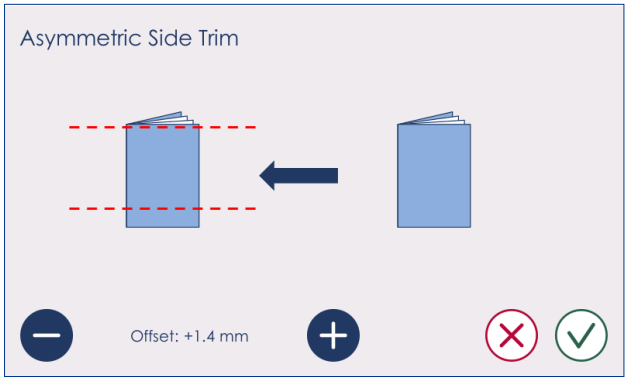
From the Booklet size screen, press the [Asymmetric Side Trim] button.



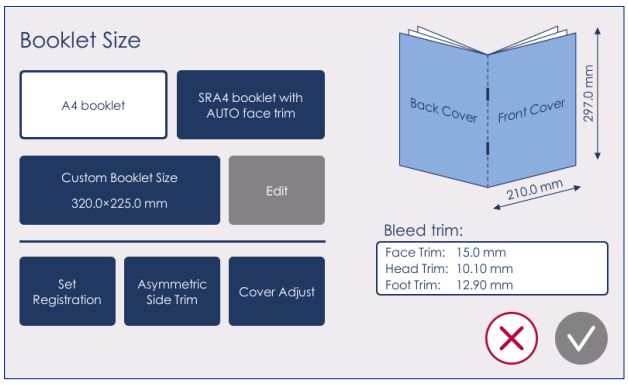
Asymmetric Side Trim using a CST

Move the Side Trim to either side, Head or Foot, by using the [+] and [-] buttons and then press the green [check] button to save the setting. The width of the Booklet will remain but the amount of Head and Foot Trim will not be equal.

NOTE:
Asymmetric Side Trim is displayed differently in the UI depending on what side trimmer that is used. See screenshots to the left.



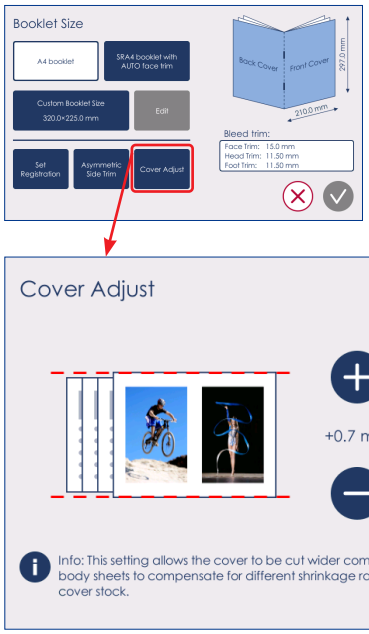
Asymmetric Side Trim using an ST5000



Changing settings as in the example above would result in a booklet with bleed trim settings as shown in the image to the left.

continued on next page

Side Trimmer - Cover Adjust



Use Cover Adjust to compensate for differences in shrinkage of body- and cover stock.

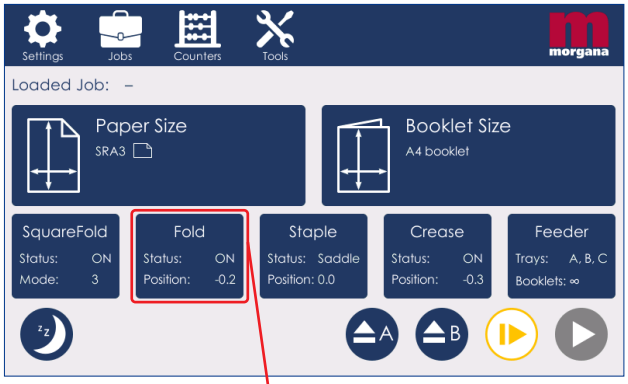
From the Booklet size screen, press the [Cover Adjust] button.

Variations in shrinkage between different paper stocks can occur under some conditions such as the heat and pressure of the fusing process. Changing the Cover Adjust value can improve booklet appearance, especially if the cover is dark and the body sheets are bright.

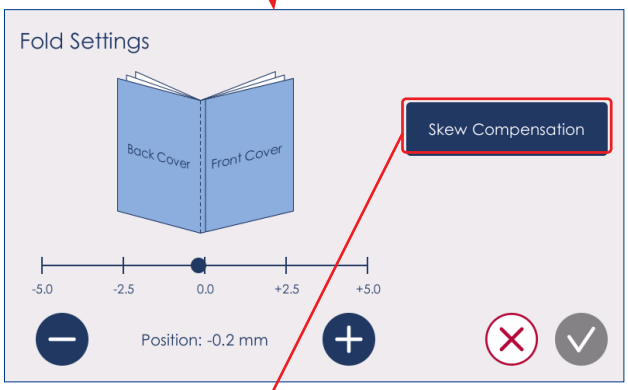
Settings in the example to the left will make the cover sheet 0.7 mm wider than the body stock.

NOTE:
The Cover Adjust feature is not available when using an ST5000 Side Trimmer.

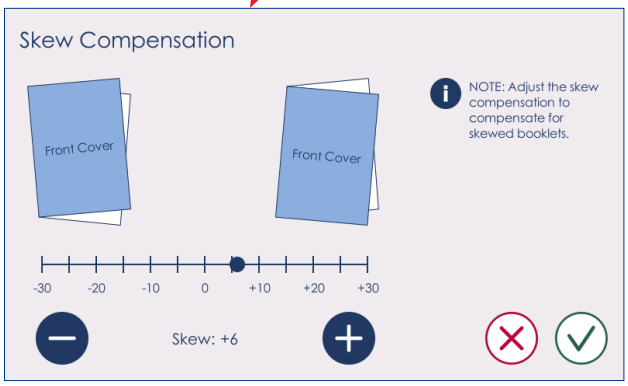
Skew Compensation



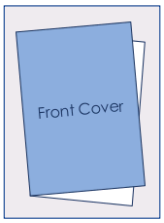
There is a number of reasons why finished booklets could come out skewed. One being that the sheets might not have been cut in perfect angle. The folder can be set up to compensate for that. From the Start screen, press the [Fold Settings] button.



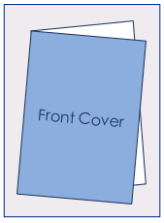
From the Fold Settings screen, press the [Skew Compensation] button.



Compare the booklet with the example on the screen and select an amount of skew you want to compensate towards. Press the green [check] button to confirm.



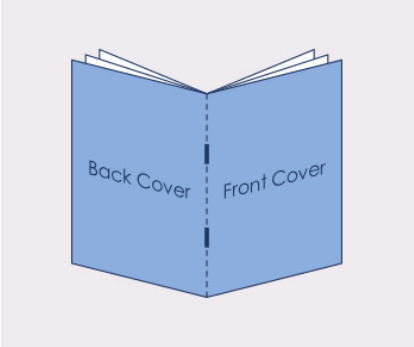
If your booklets come out skewed like this, then press the [+] button to compensate.



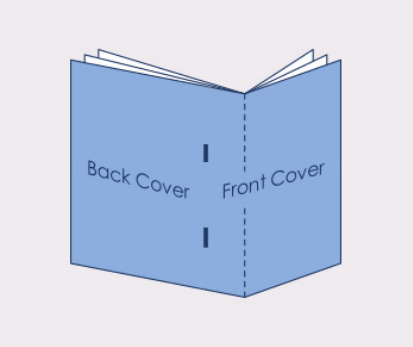
If your booklets come out skewed like this, then press the [-] button to compensate.

Fold Stop Pocket adjustment

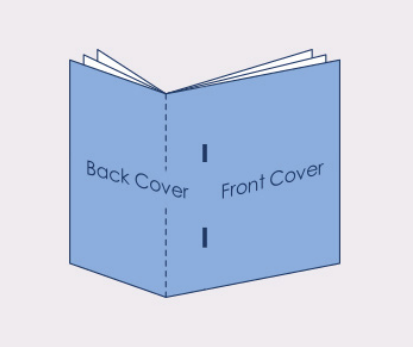
Normally, setting the Fold Stop Pocket adjustment knob so that the indicator is pointing to the number one position (leftmost position) should be suitable for most combinations of paper weights, sheet lengths and set sizes within the specifications. However, if the fold line is consistently not aligned with the staple line, tightening the Fold Stop Pocket might help to correct this phenomenon. One reason for this misalignment could be that a less sturdy set containing few, long sheets of low paper weight, possibly curled at the leading edge, travels too far down the Fold Stop Pocket. Another reason could be that a sturdier, heavier and thicker, set of sheets bounces back after reaching the fold stop or that the set does not reach the fold stop at all cause the Fold Stop Pocket is adjusted too tight.



Staple line and fold line aligned



Stapled set travelling too far

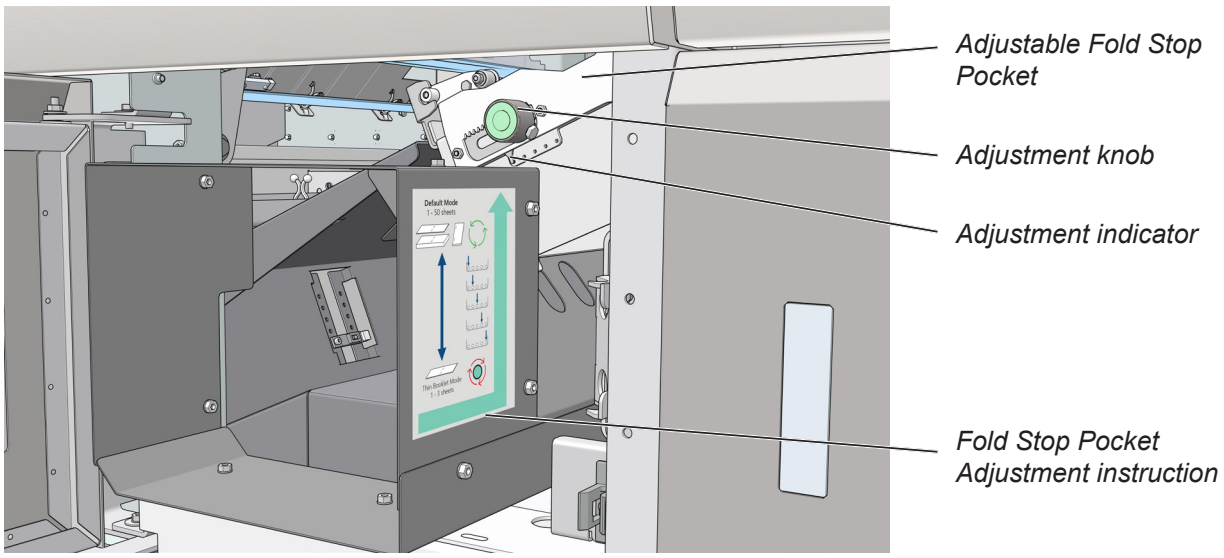


Stapled set bouncing back after reaching the fold stop or not reaching the fold stop at all

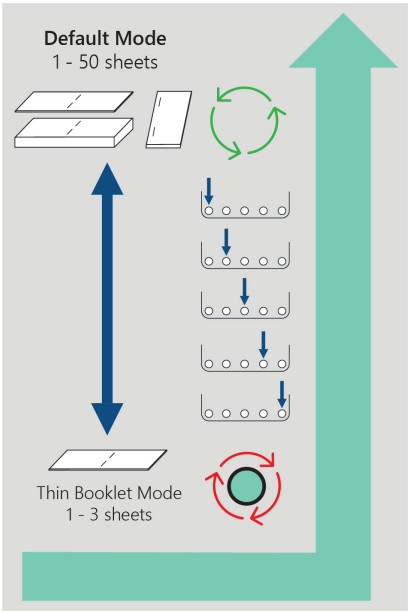
Before performing this adjustment

- Make sure that the fold position and saddle staple position is correctly adjusted. See “Adjusting fold position” and “Adjusting saddle staple position” earlier in this section.
- Check that the paper curl, if any, is inside specifications. See section 1,“Measuring paper curl”.
- Check if the printer features a decurling function. If so, turn it on.
- Perform adjustment to the fold pocket according to instructions and table below.

NOTE:
This adjustment should only be performed as a last option.



The adjustable Fold Stop Pocket is located on the Booklet Maker and can be reached by opening the right door on the Finishing Module



Normal setting is position 1 where the Fold Stop Pocket is fully opened. This setting is suitable for corner, edge and saddle stapling.
Increasing the setting will tighten the Fold Stop Pocket and is used when saddle stapling sets of various thickness and length and when a misalignment between the staple line and the fold line is experienced.

The table below shows maximum thickness of stacked sets in millimetres and (inches). The recommended position of the knob is based on both sheet length and set thickness.

Use the table as a guidance to find a suitable setting for your specific situation.

NOTE:
Edge and corner stapling capability might not be available on all systems.

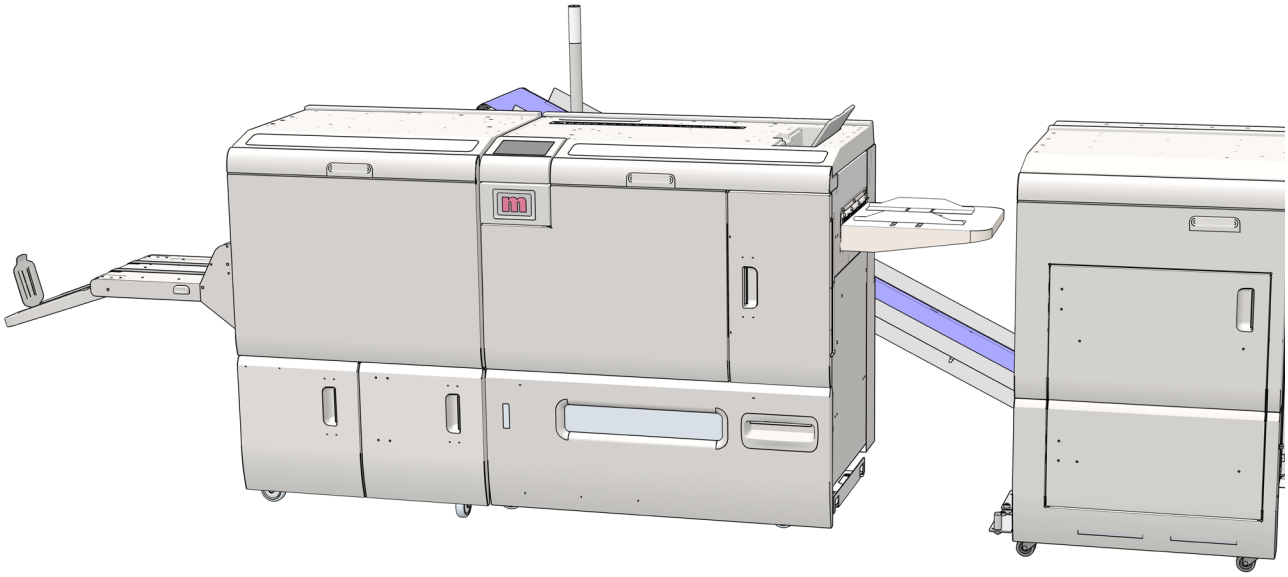
	Sheet length							
Position of knob	**210-270**	**270-320**	**320-420**	**370-420**	**420-470**	**470-520**	**520-570**	**570-620**
1	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)
1,5	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)
2	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	4,7 mm (0.185”)	4,2 mm (0.165”)	3,8 mm (0.150”)	3,3 mm (0.130”)
2,5	5 mm (0.197”)	5 mm (0.197”)	5 mm (0.197”)	4 mm (0.157”)	3,3 mm (0.130”)	2,5 mm (0.098”)	1,8 mm (0.071”)	1 mm (0.039”)
3	5 mm (0.197”)	5 mm (0.197”)	4,2 mm (0.165”)	3,3 mm (0.130”)	2,3 mm (0.091”)	1,5 mm (0.059”)	0,5 mm (0.020”)	
3,5	5 mm (0.197”)	4 mm (0.157”)	3,2 mm (0.126”)	2,5 mm (0.098”)	1,7 mm (0.067”)	1 mm (0.039”)	0,2 mm (0.008”)	
4	3,3 mm (0.130”)	2,7 mm (0.106”)	2,2 mm (0.087”)	1,6 mm (0.063”)	1 mm (0.039”)	0,5 mm (0.020”)		
4,5	1,8 mm (0,071”)	1,5 mm (0.059”)	1,1 mm (0.043”)	0,8 mm (0.031”)	0,5 mm (0.020”)			
5	0,6 mm (0,024”)	0,5 mm (0.020”)	0,3 mm (0.012”)	0,1 mm (0.004”)				

NOTE:
The adjustment knob for the Adjustable Fold Stop Pocket must be set to position 1 (one) when corner or edge stapled sets are produced.

NOTE:
Edge and corner stapling capability might not be available on all systems.

Manual Feed

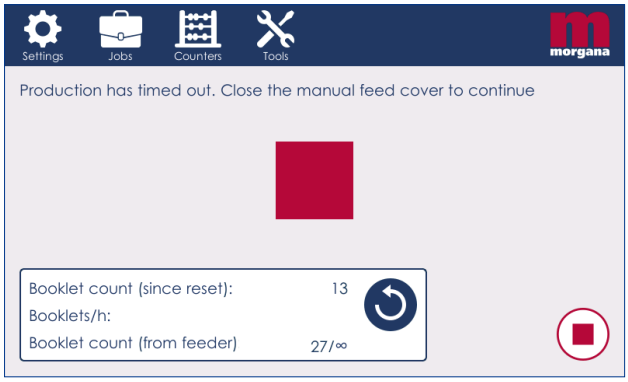
There are two ways you can feed sets into the Booklet Maker manually. Either by opening the Manual Feed Cover in the Top Cover or by using the more convenient and ergonomic optional Manual Feed Tray when the Booklet maker is undocked.



General

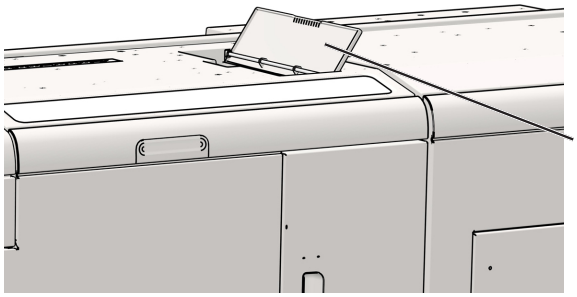


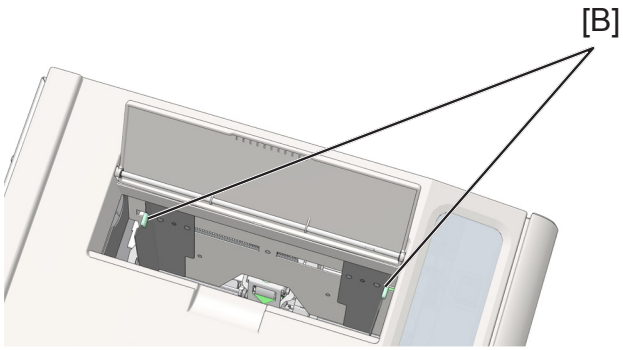
Manual Feed Mode is initiated either by opening the Manual Feed Cover in the Top Cover or by setting the Convenience Feeder to feed from Tray M and then pressing the green [Start] button from the Start screen. The later alternative will free up space on the Top Cover since the Manual Feed Cover can remain closed. Use that space for placing the pre-collated sets waiting to be manuallly fed.
In either case, the User Interface will display a green hand when the Booklet Maker is ready to receive manually fed sets.
Close the Manual Feed Cover or press the red [Stop] button to stop Manual Feed Mode.



In Manual Feed Mode, after approximately 2 minutes of inactivity, the Booklet Maker will cycle down and the time out message to the left will be shown. Close the Manual Feed Cover or press the red [Stop] button to continue.

Using the built-in Manual Feed Slot

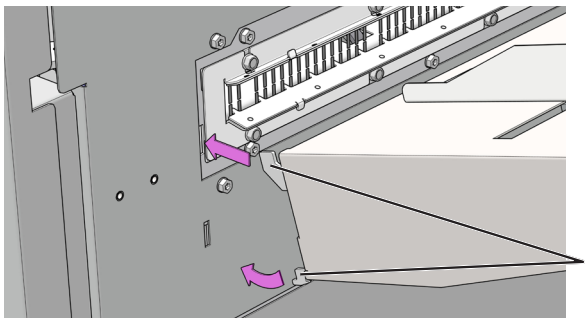




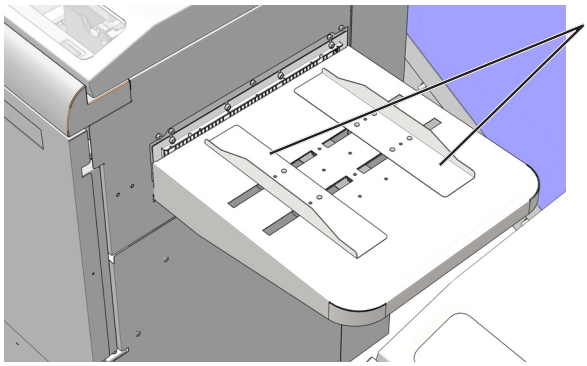
1. Open the Manual Feed Cover [A] in the Booklet Maker Top Cover to initiate Manual Feed Mode. The User Interface will display a green hand when the Booklet Maker is ready to receive manually fed sets.
2. Adjust the Manual Feed Side Guides [B] to the correct paper size.
3. The booklet making process will start automatically when a set is fed into the Booklet Maker.

If the manual feeding process needs to be aborted or interrupted, just close the Manual Feed Cover.

Using the optional Manual Feed Tray



1. Follow “Undocking the Booklet maker” in section 1, “Basics”.
2. Hang the Manual Feed Tray onto the Booklet Maker by inserting the tabs [C] in the slots in the Infeed Cover.
3. Initiate Manual Feed Mode by setting the Convenience Feeder to feed from Tray M and then pressing the green [Start] button from the Start screen. The User Interface will display a green hand when the Booklet Maker is ready to receive manually fed sets.



4. Adjust the Manual Feed Side Guides [D] to the correct paper size.
5. The booklet making process will start automatically when a set is fed into the Booklet Maker.

If the manual feeding process needs to be aborted or interrupted, press the red [Stop] button in the User Interface.

When not in use, the Manual Feed Tray can be stored hanging on the Booklet Maker Rear Cover. See “Options”, Manual Feed Tray.

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3. Tools

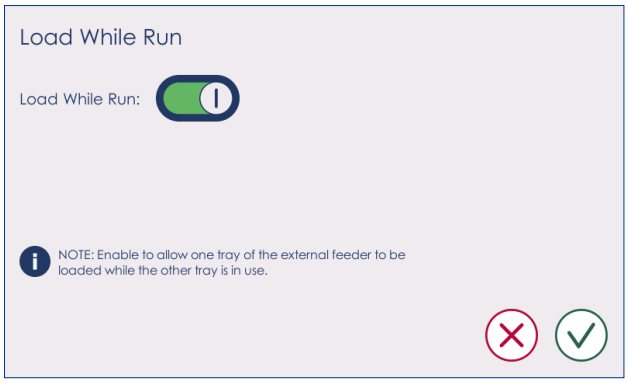
The Tools screen



Press the [Tools] button to get to the Tools screen. Select the setting you want to change by pressing the corresponding button.

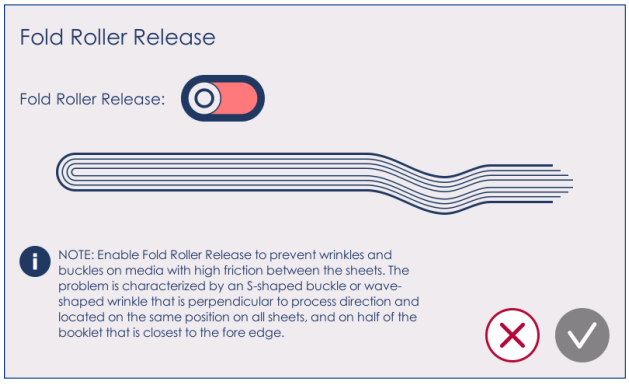
After changing setting in the sub screen, press the green [check] button to save your changes and return to the Tools screen.

Load While Run



When using linked trays, A/B, the capacity can be extended even further by enabling the tool [Load While Run]. The Feeder will automatically switch from tray A to tray B and vice versa when one tray becomes empty. Then the empty tray can be reloaded while the other tray is in use. For setting up linked bins, see section 2, “Making Booklets, Setting up a feeder job in the VFX”.

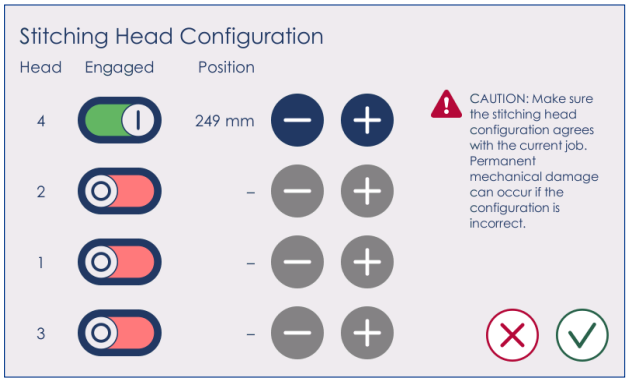
Fold Roller Release



Enable Fold Roller Release to prevent cross process wrinkles and buckles on media with high friction between the sheets.

Stitching Head Configuration

The Stitching Head Configuration screen must reflect wether stitching heads are engaged and where they are positioned.

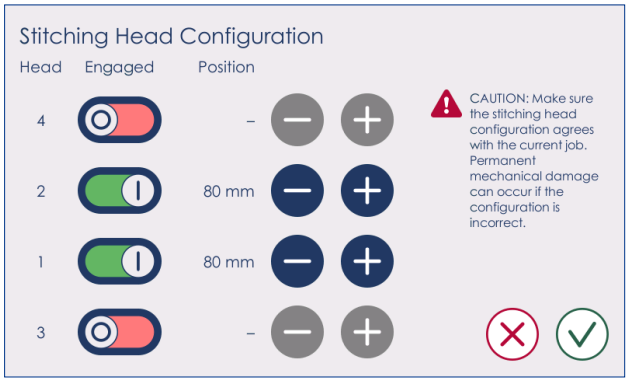


⚠ CAUTION:
Make sure that the information about the position of the stitching heads and whether they are engaged is correct. Severe permanent damage to the stitching heads, clinchers and/or the side guides might occur otherwise.

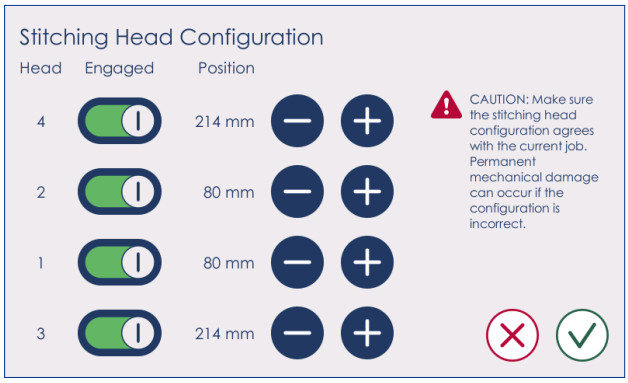
This screen shows a typical corner stapling configuration.

NOTE:
Edge and corner stapling capability might not be available on all systems.

When stitching heads are moved and/or are engaged or disengaged, the actual status and position must be entered in the Stitching Head Configuration screen.

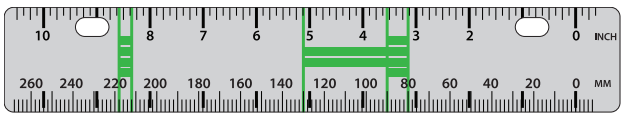


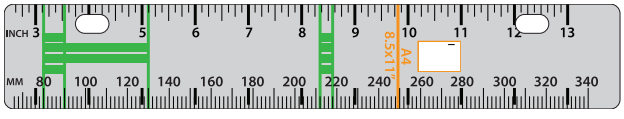
This screen shows a configuration where two stitching heads are used and the center to center distance is 80 mm.
Since stitching heads 3 and 4 are set to “not engaged”, it means they are either not installed or that they are mechanically disengaged.



This screen shows a configuration with four stitching heads. The innermost, number 1 and 2 are set at a center to center distance of 80 mm. The outermost stitching heads are set to a center to center distance of 214 mm.

⚠ CAUTION:
Make sure that the information about the position of the stitching heads and whether they are engaged is correct. Severe permanent damage to the stitching heads, clinchers and/or the side guides might occur otherwise.





The purpose of the scales is to show Stitching Head positions where to avoid skew folding and damaging of the sheets especially when running booklet with few sheets in the set.
Two green lines show positions when two Stitching Heads are installed. Four green lines show positions when four Stitching Heads are installed.

NOTE:
Distances on the scales are center to center.

Production Priority



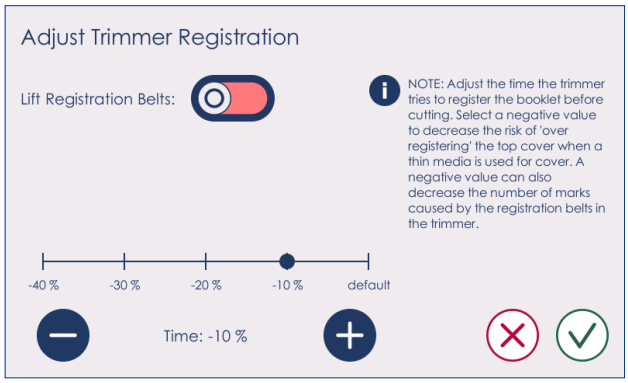
Precision is the default operation mode and ensures optimal performance on the widest range of applications.

Use Productivity mode if the application allows for it. The productivity will be higher, but the system will get more demanding for high quality media.

Thin media (below 120 gsm for coated media) or media that has a slight curl will generally run better in Precision mode.

If the application does not run well in Productivity mode, change to Precision mode.

Adjust Trimmer registration



Adjust the time the trimmer tries to register the booklet before trimming. Select a negative value to decrease the risk of “over registering” the top cover when a thin media is used for cover. A negative value can also decrease the number of marks caused by the registration belts in the Trimmer.

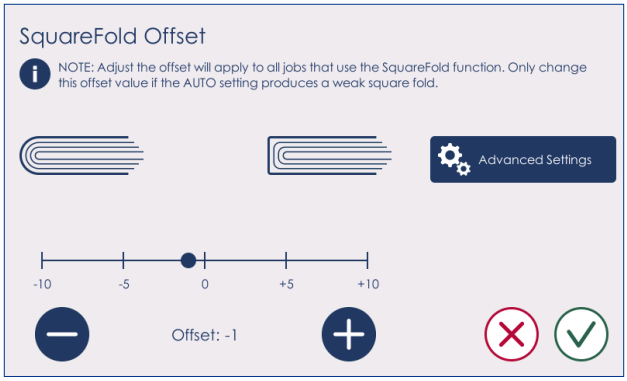
When adjusting this value we recommend to reduce by 10% and to check the result. Caution: reducing too much can lead to skewed booklets

Set Lift Trimmer Belts to [On] to relieve the trimmer belt pressure on the top page of the cover. This may help the top cover to retake its original flat shape if it should have been curled while registering. The default setting for Lift trimmer belts is [On].

Unless the job is saved, the Booklet Maker will return to the default setting when the power is turned off. How to save jobs is described in section 4, “Jobs”.

SquareFold Offset

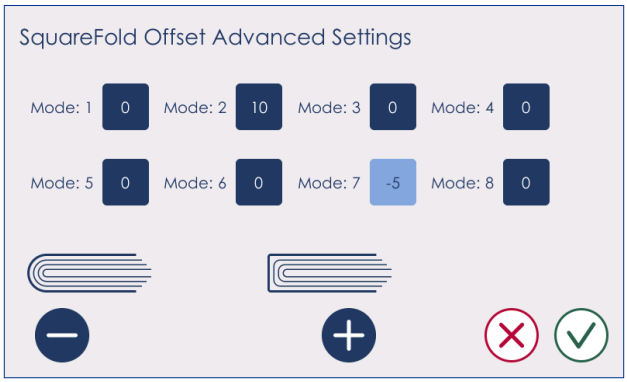
The SquareFold pressure setting is set to a standard that should suit most applications. Operators have the option of sharpening or softening the square edges based on application or preference.



Select sharper edges by pressing the [+] button or softer edges by pressing the [-] button.

Press the [Advanced Settings] button to be able to fine adjust each SquareFold mode individually.

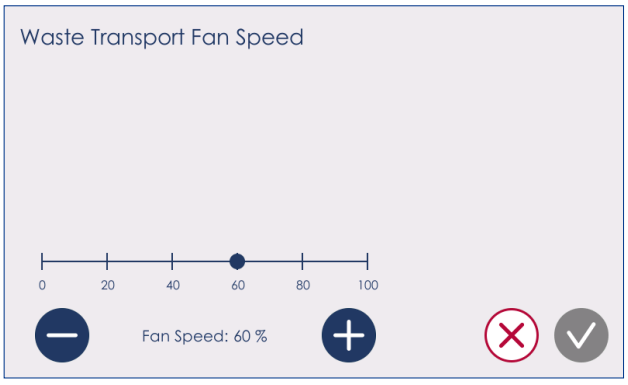
See SquareFold in section 2, “Making Booklets or Stapled Sets”, for how to select SquareFold Modes.



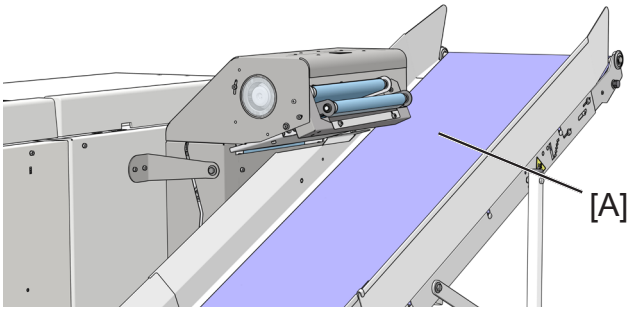
Select which of the 8 modes to fine adjust by pressing the square next to the Mode text. Then use the [+] and [-] buttons to sharpen or soften the square edges based on application or preference. Increase the value to sharpen and decrease the value to soften the square edges.

NOTE:
SquareFold Offset Advanced Settings will apply also when AUTO mode is selected.

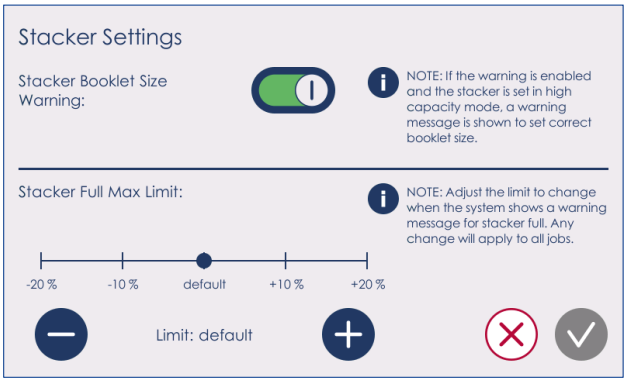
Waste Transport Fan



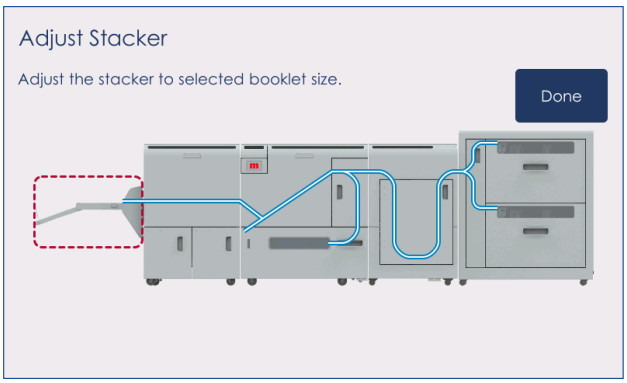
Set the Waste Transport Fan Speed so that the trim waste is delivered at the center of the conveyor belt [A] of the Trim Waste Conveyor.



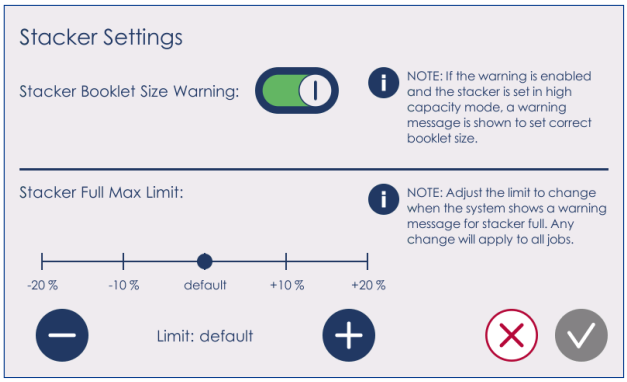
Stacker Settings



Whenever the Paper Size is changed and the Belt Stacker is in High Capacity position, the Stacker Booklet Size Warning will be shown as reminder to set the Belt Stacker Stop Gate to the correct position.
See section 1, “Basics”, for how to use the Belt Stacker and position the Belt Stacker Stop Gate.



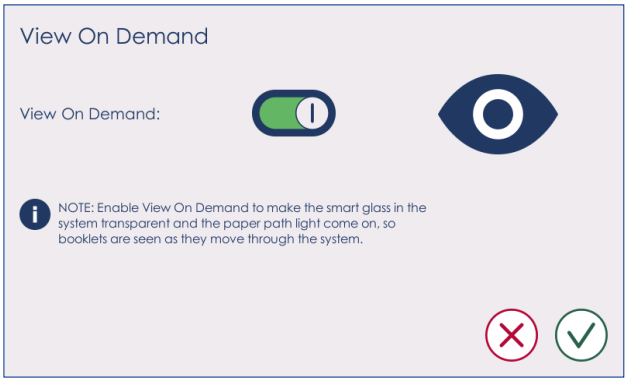
Turn Stacker Booklet Size Warning off if you do not want to have this warning.



The Stacker Full Max Limit default setting should suit most types of stacking situations. However, the limit can be adjusted ± 20 % to better suit the actual situation.

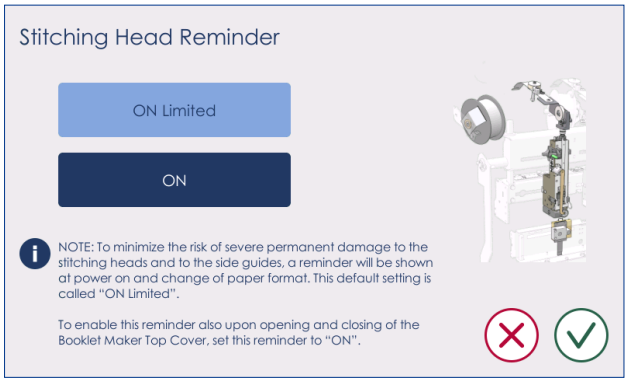
NOTE:
Stacker Full Detection is only available when the Belt Stacker is installed to the FM Module.

View On Demand



By enabling View On Demand, the Paper Path Light can be turned on. The booklet making process can now be viewed through the Smart Glass when the eye icon is pressed. Press the eye icon again to turn off the light.

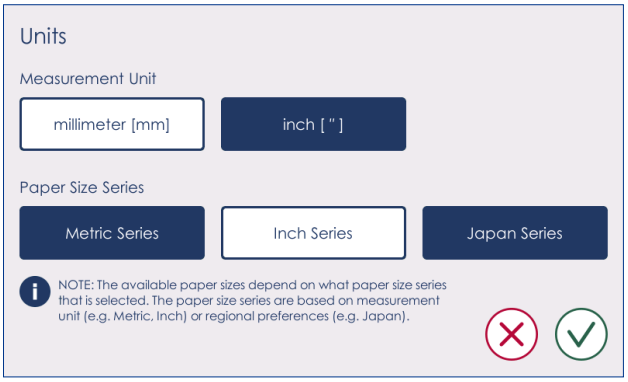
Stitch Reminder



To minimize the risk of severe permanent damage to the stitching heads and to the side guides, a reminder will be shown at power on and change of paper format. This default setting is called “ON Limited”.

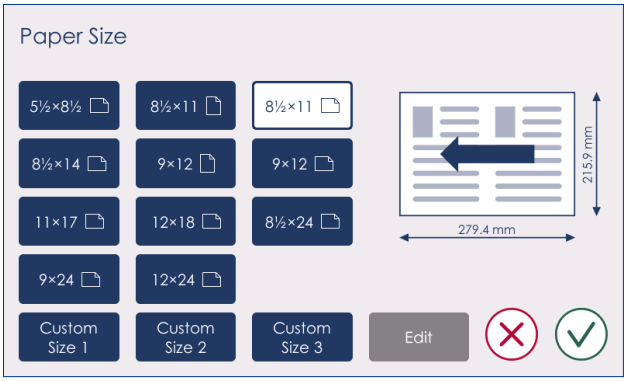
To enable this reminder also upon opening and closing of the Booklet Maker Top Cover, set this reminder to “ON”.

Units



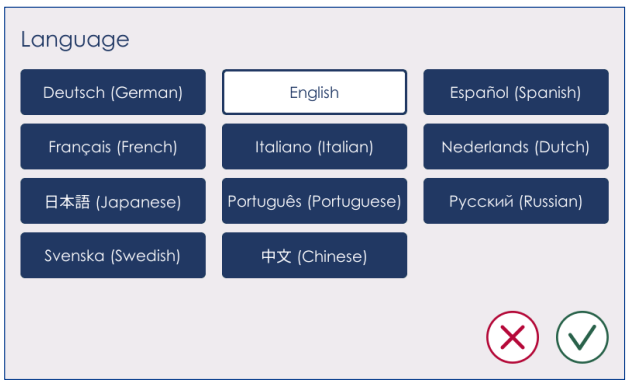
Select the desired units by pressing the [millimeter] or [inch] button.

By selecting Metric, Inch or Japan Series, the corresponding common paper sizes will be shown when pressing the [Paper Size] button on the Start Screen.



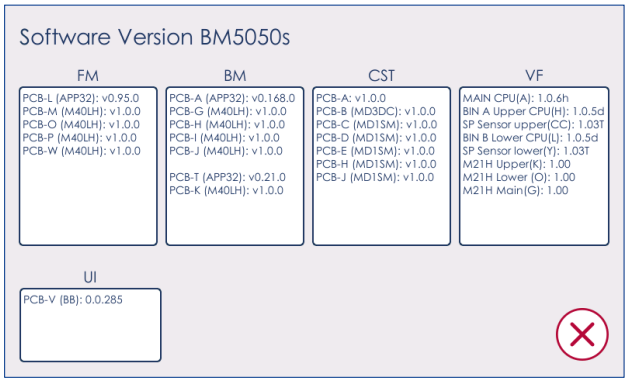
By selecting millimeter [mm] and Inch Series, common inch formats are shown and will also be expressed in millmeters. Combine as you prefer.

Language



Select desired language by pressing the corresponding button.

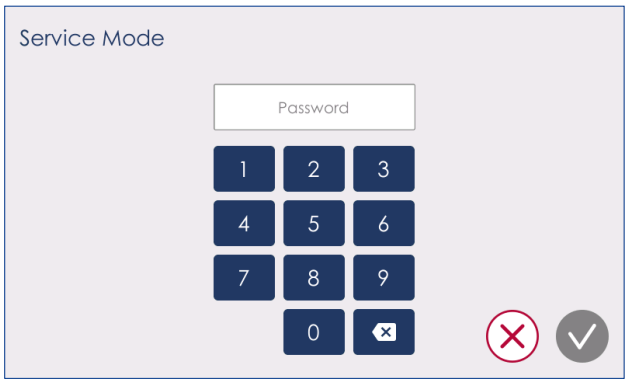
Software version



Shows the software version of all modules in the booklet making system. Press the red [X] button to go back to the Tools screen.

3

Service mode



This function is for authorized service personnel only and is password protected.

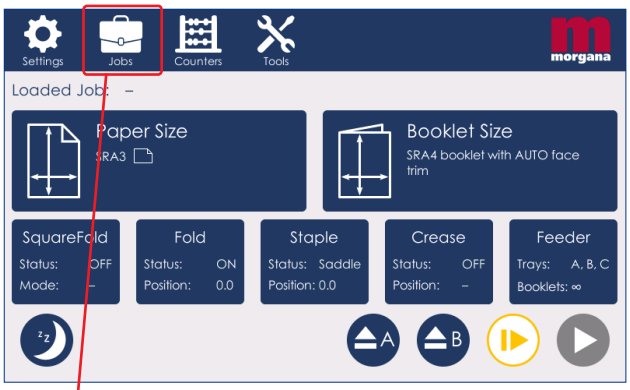
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4. Jobs

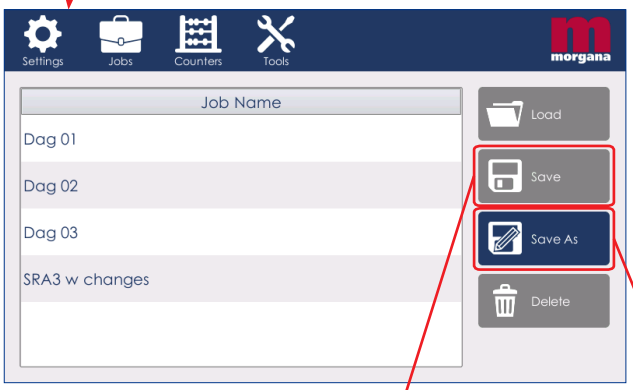
Handling jobs

The Booklet Maker has a maximum storage capacity of 100 different jobs. To make temporary changes in the actual job settings or temporary changes of a stored job, see section 2, “Making Booklets”.
From the Start screen, press the [Jobs] button to be able to store, change or delete jobs.

Saving a Job

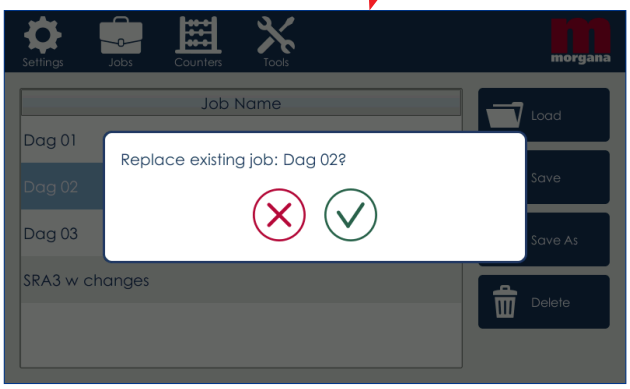


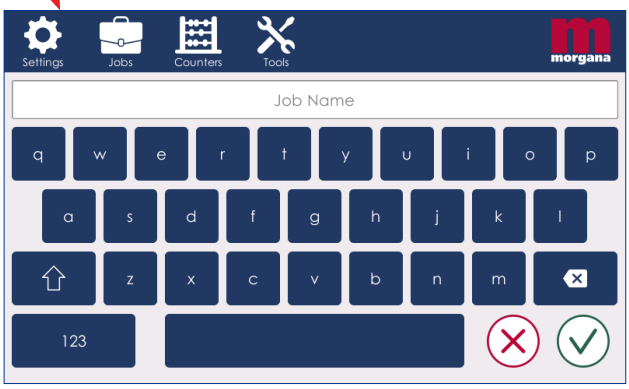
From the Start Screen, press [Jobs] button.



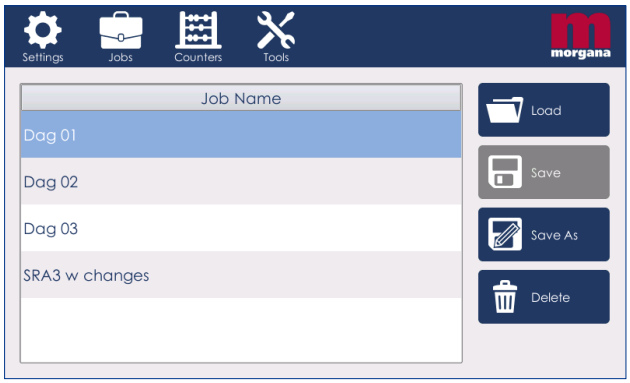
Current settings can be saved to the currently loaded job, any of the other saved jobs or as a new job.

Press the [Save] button to overwrite currently loaded job
or
Select any of the other saved jobs and press the [Save] button
or
Press the [Save as] button to save as a new job with a new name.

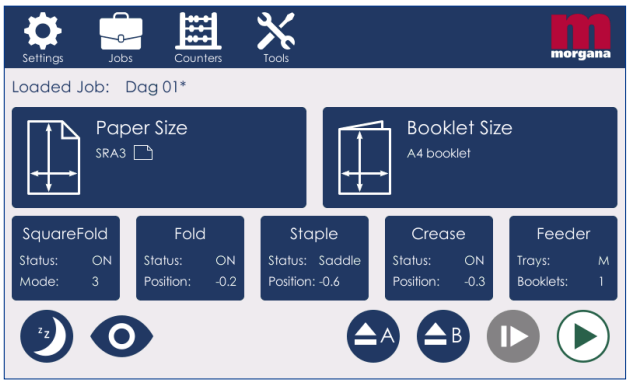




Loading Jobs

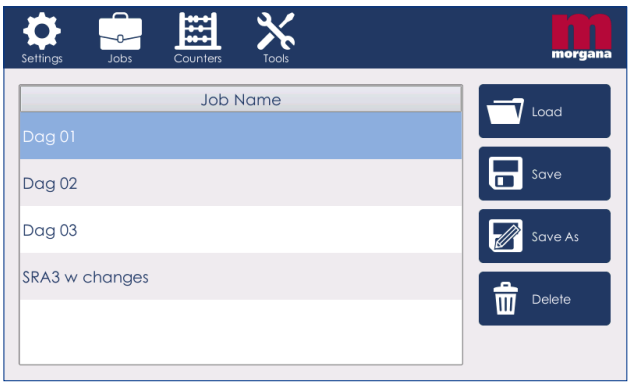


Open (load) any stored job by selecting the job and confirm by pressing the [Load] button.



The name of the currently loaded job is shown in the upper left corner. When there is an asterisk next to the name, it indicates that changes to the job have been made after the job was loaded and that the changes have not yet been saved.

Deleting Jobs



Delete any stored job by selecting the job from the list and confirm by pressing the [Delete] button.

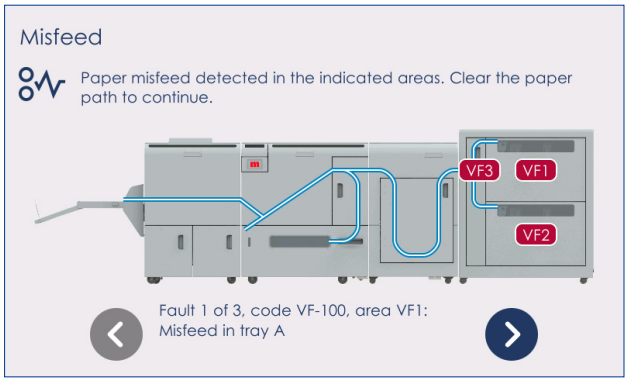
NOTE:
The currently loaded job cannot be deleted.

5. Clearing Misfeed(s)

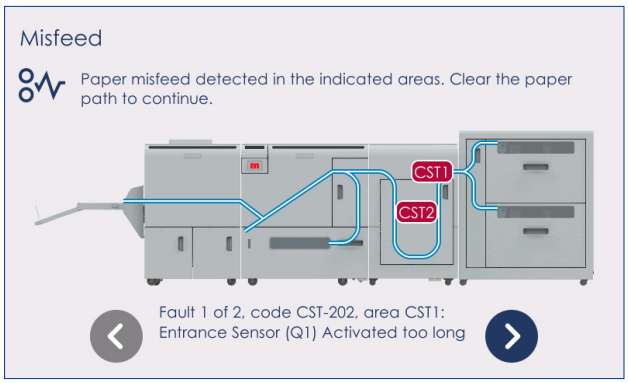
Clearing misfeed(s)

General

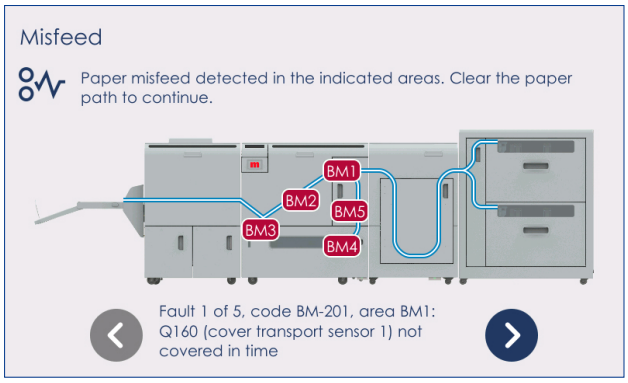
If a misfeed condition should occur, it is indicated on the Booklet Maker User Interface. See examples below.



Misfeeds in the VFX Vacuum Feeder are indicated visually where in the VFX the misfeed occurred (area VFX1 to VFX3), by an error code VF-XXX and by a component description.
If there should be multiple error codes, press the blue arrow buttons to scroll.



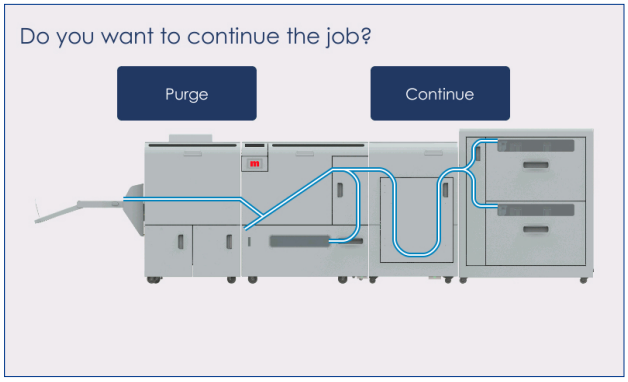
Misfeeds in the Crease Side Trim Module are indicated visually where in the CST the misfeed occurred (area CST1 or CST2), by an error code CST-XXX and by a component description.
If there should be multiple error codes, press the blue arrow buttons to scroll.



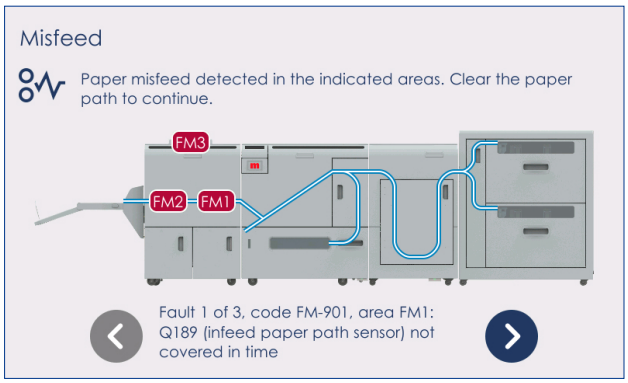
Misfeeds in the Booklet Maker are indicated visually where in the Booklet Maker the misfeed occurred (area BM1 to BM5), by an error code BM-XXX and by a component description.
If there should be multiple error codes, press the blue arrow buttons to scroll.

continued on next page

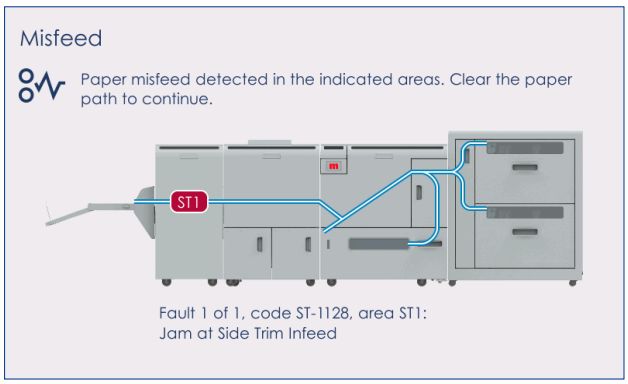
General, continued



A misfeed or an empty tray in the VFX vacuum feeder or convenience feeder can cause the system to stop. The operator then has the option to check the set and possibly continue the job or to purge the system and restart the job.



Misfeeds in the Finishing Module and on the Belt Stacker are indicated visually where in the Finishing Module the misfeed occurred (area FM1 to FM5), by an error code FM-XXX and by a component description.
If there should be multiple error codes, press the blue arrow buttons to scroll.

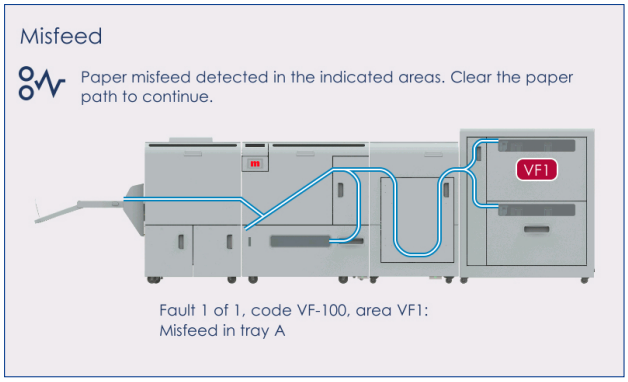


Misfeeds in the 2-Knife Side Trimmer are indicated visually (area ST1), by an error code ST-XXXX and by a component description.
If there should be multiple error codes, press the blue arrow buttons to scroll.

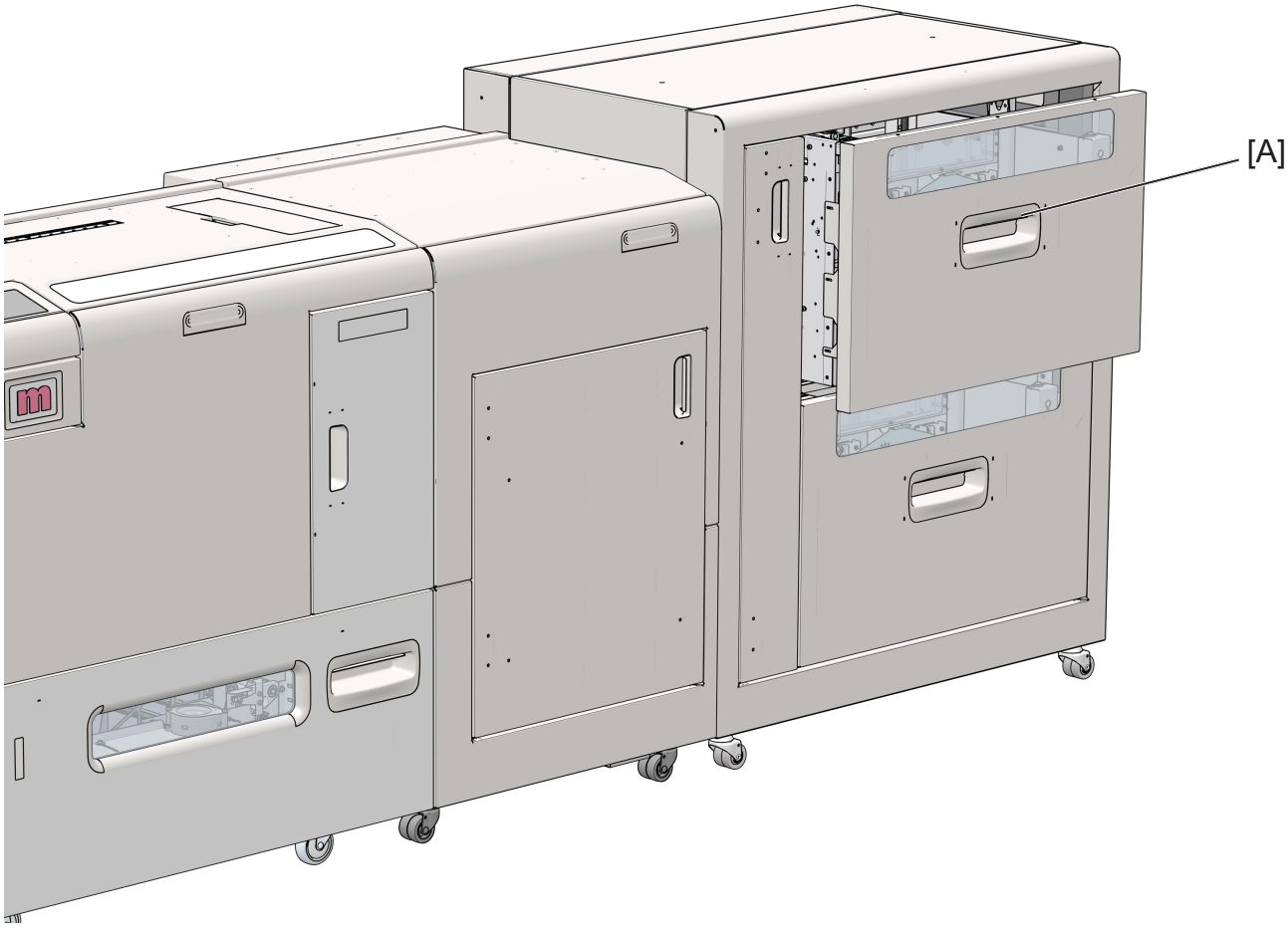
VFX Vacuum Feeder

Clearing misfeed(s) inside the VFX

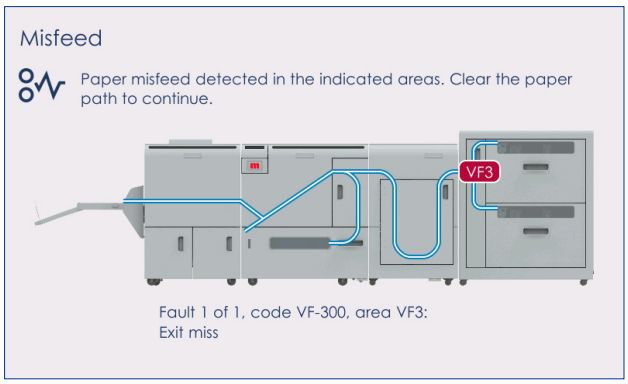
Misfeed/Jam in vacuum tray



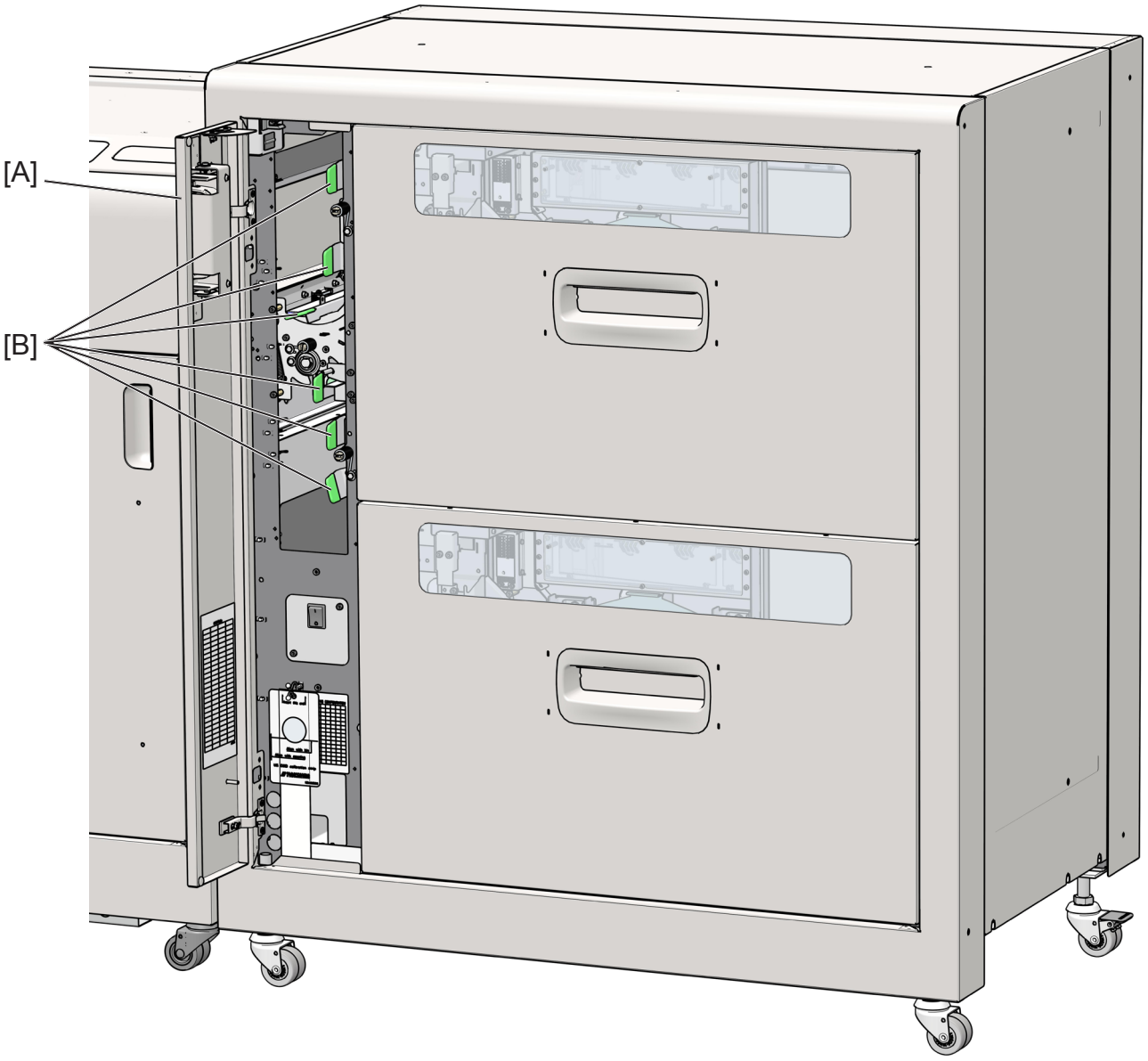
1. The affected tray will unlock
2. Pull out the tray [A].
3. If the sheet has been misfed and is not damaged, re-position and re-start.
   If the sheet is damaged, remove the complete set and the next booklet will be correct.



Misfeed/Jam in paper transport area



1. Open the VFX door [A].
2. Lift the green handles [B] to the baffles.
3. Remove the damaged sheet(s).

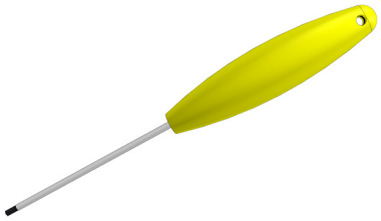


Clearing misfeed(s) inside the VFX, continued

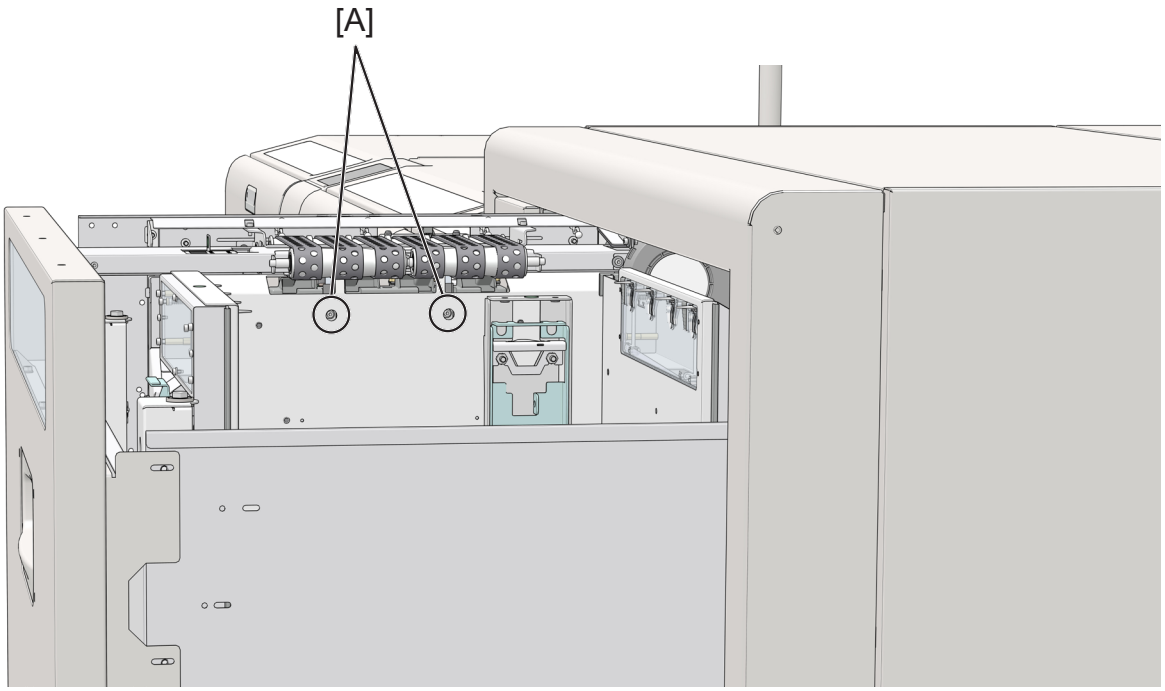
Misfeed/Jam in vacuum tray when feeding thick media

If you experience frequent misfeeds when feeding thick media (above 300 gsm / 111 lb Cover) from the vacuum trays and you are feeding thick media from tray B (the lower tray), try using tray A (the upper tray) instead. If changing from from tray B to tray A does not make any difference or if you are already feeding from tray A, make sure that the paper path is clean, nothing is obstructing the sheets in the trays and that proper maintenance has been performed on the machine - see section 7 of this manual. If the problem is still not solved after having perfomed these checks and you are sure that media thickness is the causing misfeeds or jams, follow this procedure.

A 3 mm allen key / hexagonal key is needed to perform the adjustment described.



1. Open the relevant tray and remove any misfed paper.
2. Turn off the main power and disconnect the power cord.
3. Pull out the tray.
4. Locate the screws [A] (2x) in the tray: these screws hold the separation pads.



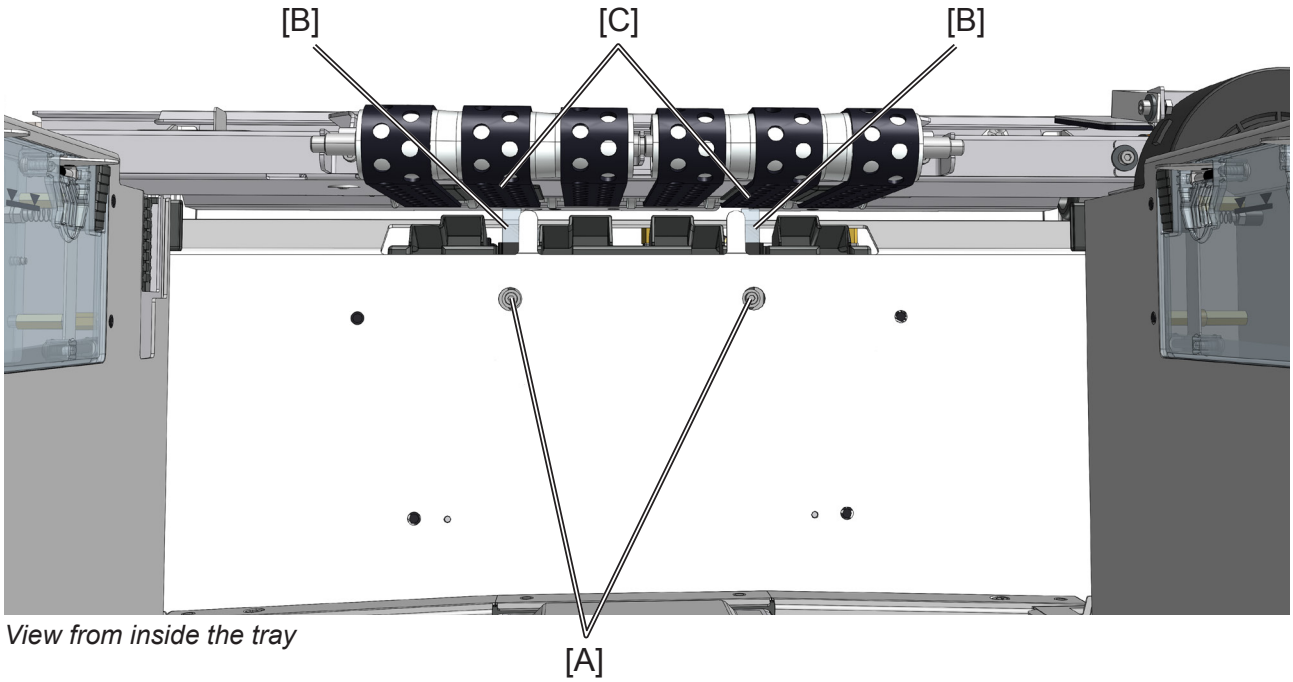
5

5 Locate the separation pads [B] (2x) and the vacuum belts [C].

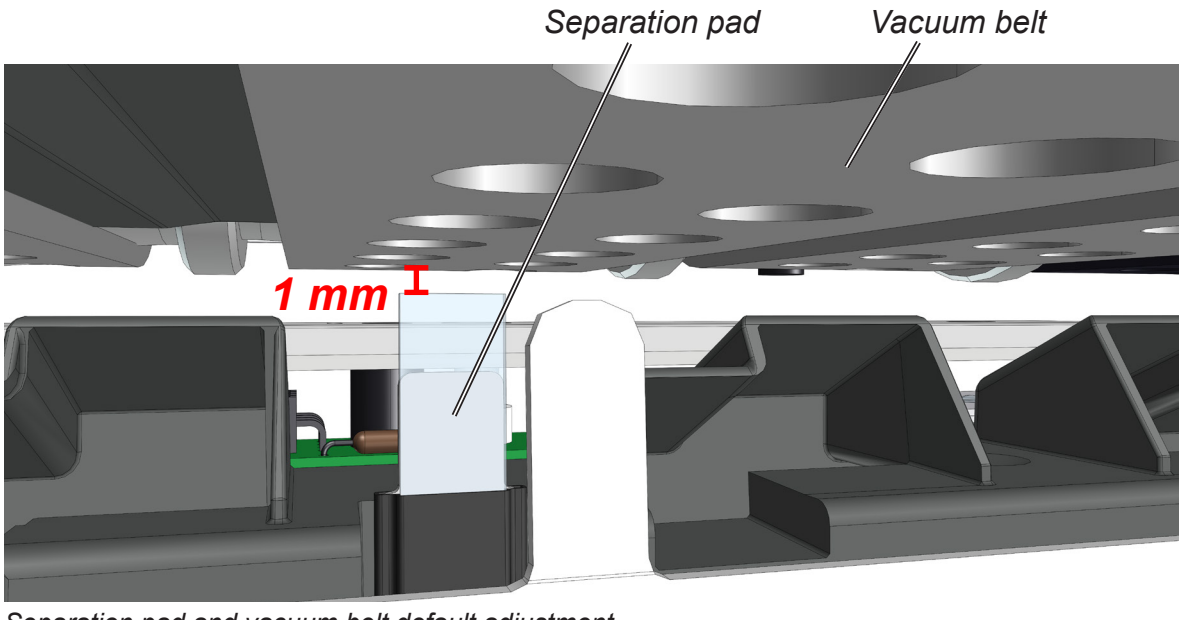
6 The separation pads are factory adjusted so that the distance between the top edge of the separation pads and the vacuum belts is equal to 1 mm. If feeding thick media (above 300 gsm / 111 lb Cover), this distance can be increased to avoid jams or misfeeds.

7 Loosen the screws [A] (2x) to move the separation pads [B] (2x) slightly downwards then tighten the screws [A] again. Run the job again and, if necessary, move the pads downwards again.

8 Once done with the job, reset the pads to their default distance as shown in the pictures below (1 mm from vacuum belts and top of the separation pads).



View from inside the tray

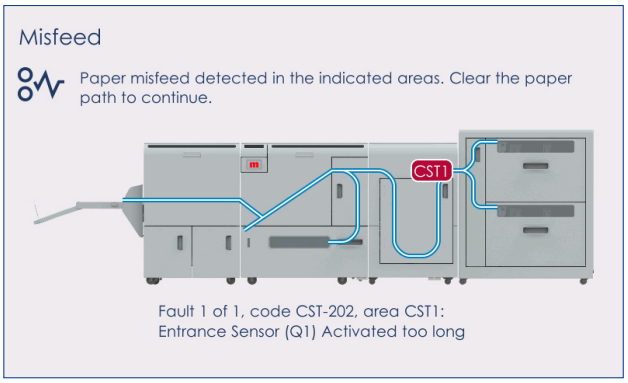


Separation pad and vacuum belt default adjustment

CST module

Clearing misfeed(s) in the paper path

Infeed “A” area and exit “D” area - CST1

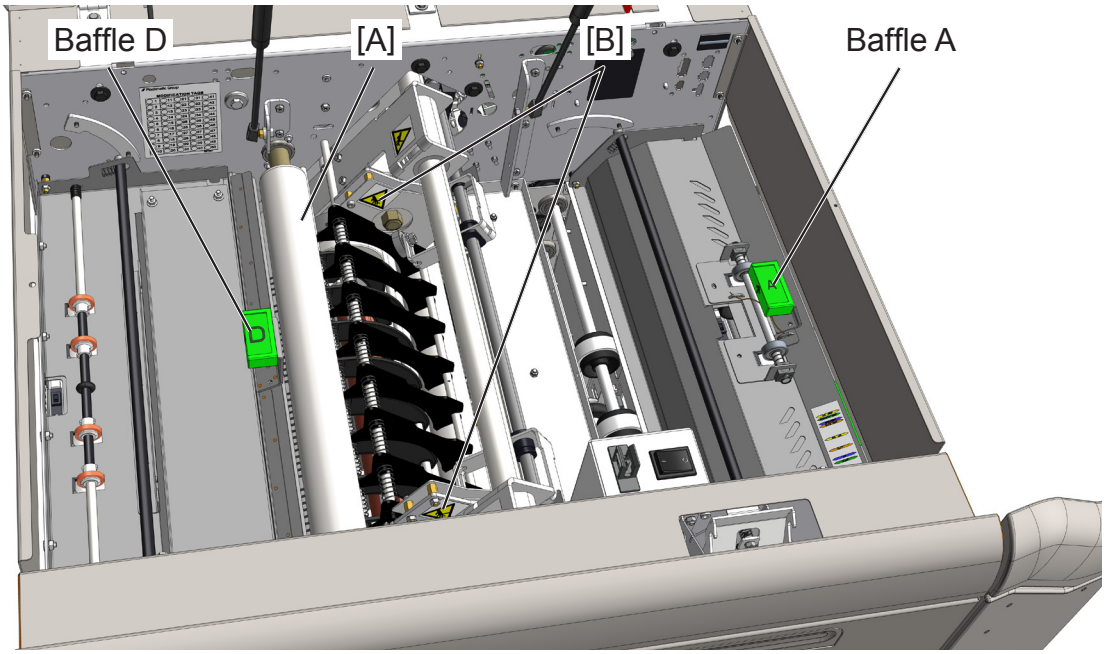


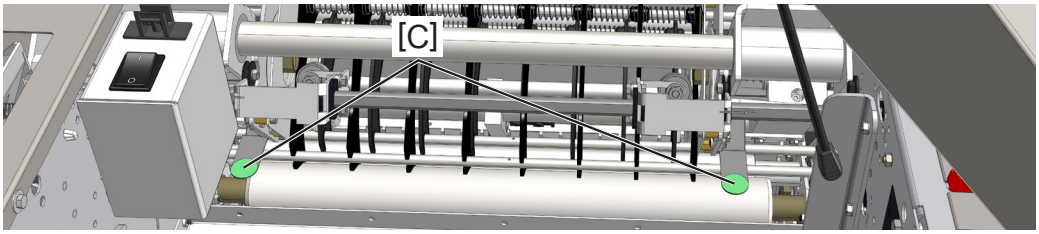
1. Open the top cover.
2. Lift up the baffles marked “A” and “D” if needed.
3. Remove any jammed/misfeed sheets.
4. Lower the baffles “A” and “D” to normal position
5. Missfeed(s) in the trimmer areas are rolled out by rotating the rubber surfaced pinch roller [A].
6. When necessary, remove Trim waste guides [C]. See section 1, “Basics”.
7. Close the top cover.

5

⚠ WARNING:
Do not put your fingers within knife protections (B). Doing so may result in injury.

⚠ CAUTION:
Under no circumstances should jams around the trimmer blades be cleared using metallic tools. The edges are very fragile and easily damaged.

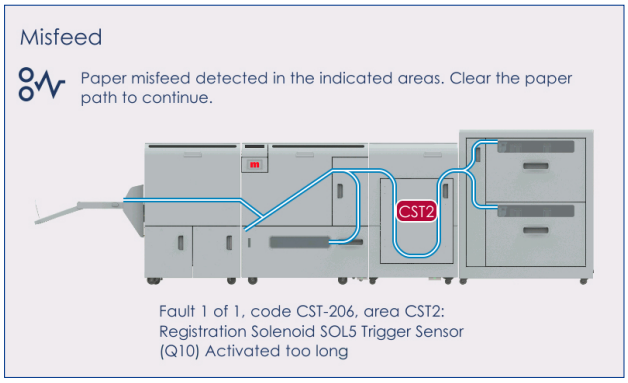




continued on next page

Clearing misfeed(s) in the paper path, continued

Registration and creaser area - CST2



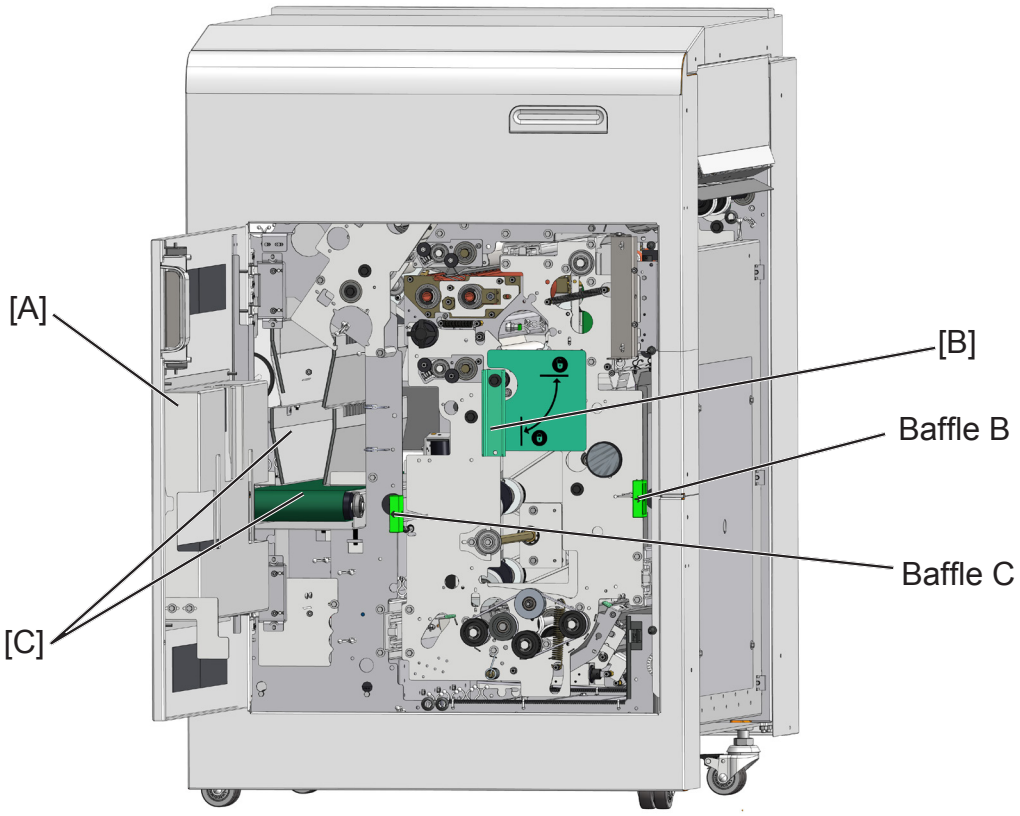
1. Open the slide door [A].
2. Unlatch and pull out the slide [B].
3. Open the baffles marked “B” and “C” if needed.
4. Remove any jammed/misfeed sheets.
5. Push in and latch the slide.
6. Always remove any residual waste from waste channel and waste belt [C] before closing the slide door.
7. Close the slide door.

5

Clearing jams in the waste transport

The waste transport is easily accessible through the slide door. Shreds jammed in or wrapped around the knife assembly are also accessible through the slide door.

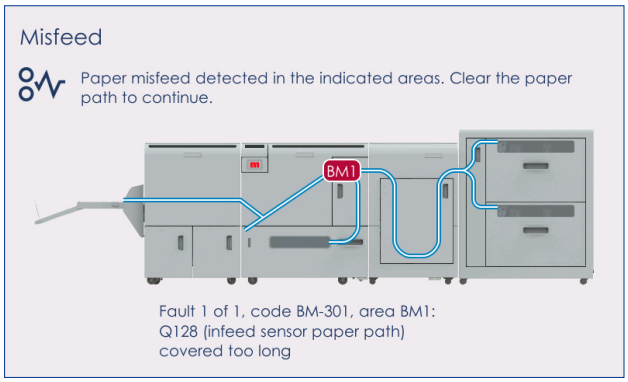
⚠ **CAUTION:**
Under no circumstances should jams around the trimmer blades be cleared using metallic tools. The edges are very fragile and easily damaged.



Booklet Maker

Clearing misfeed(s) inside the Booklet Maker

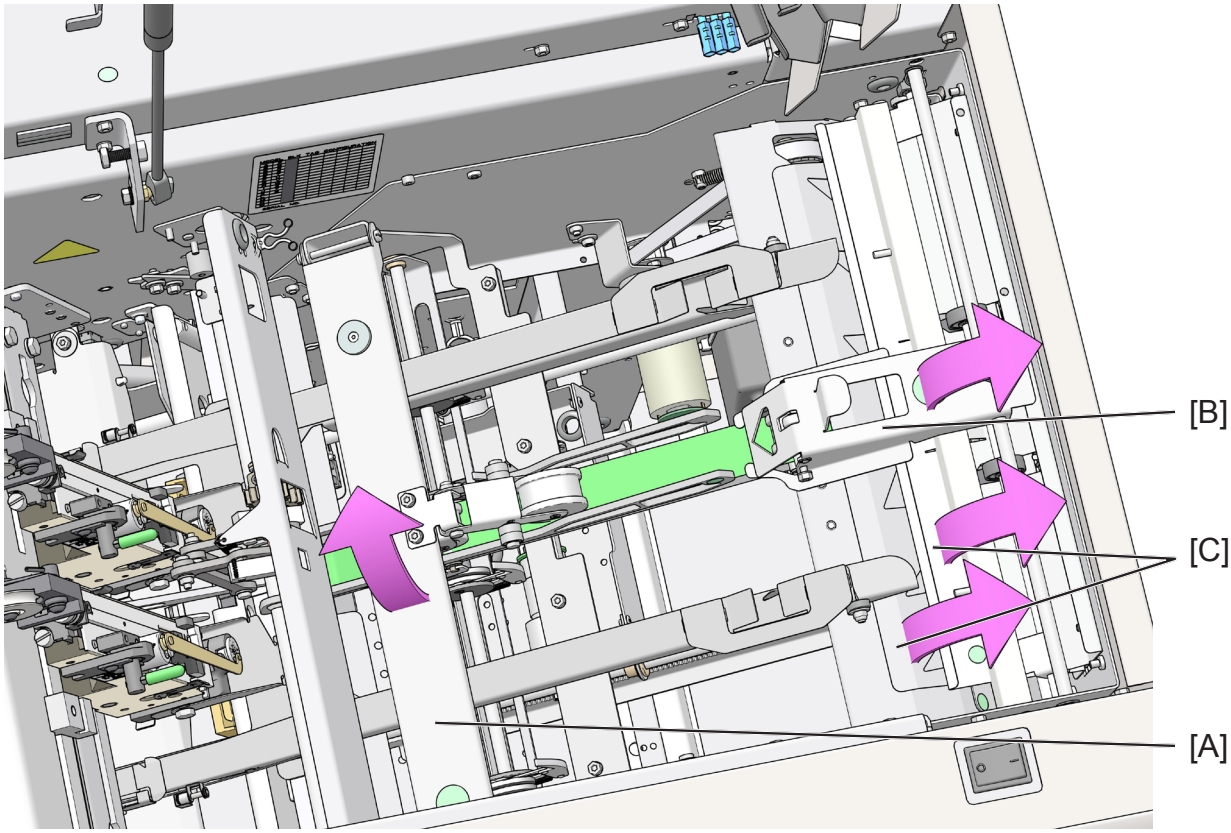
Clearing misfeed in the Infeed area - BM1



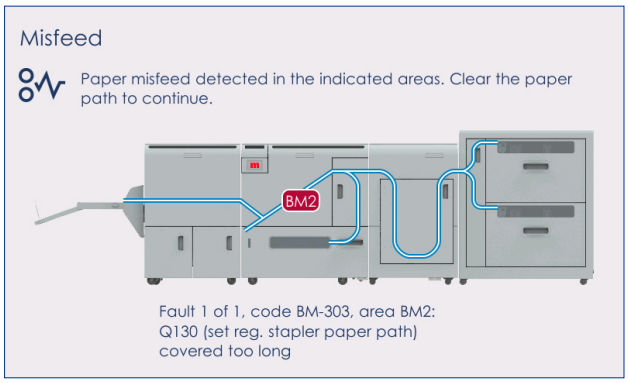
To clear a misfeed indicated in Area BM1

Follow the procedure below.

1. Open the Booklet Maker Top Cover.
2. Lift the Back Jogger Beam [A], lift the Infeed Roller assembly [B] and the Upper Infeed Paper path [C].
3. Remove any jammed/misfeed sheets.
4. In reversed manner, place the Upper Infeed Paper path [C], the Infeed Roller assembly [B] and the Back Jogger Beam back [A] in operating position.
5. Close the Booklet Maker Top Cover.



Clearing misfeed in Stapler area - BM2

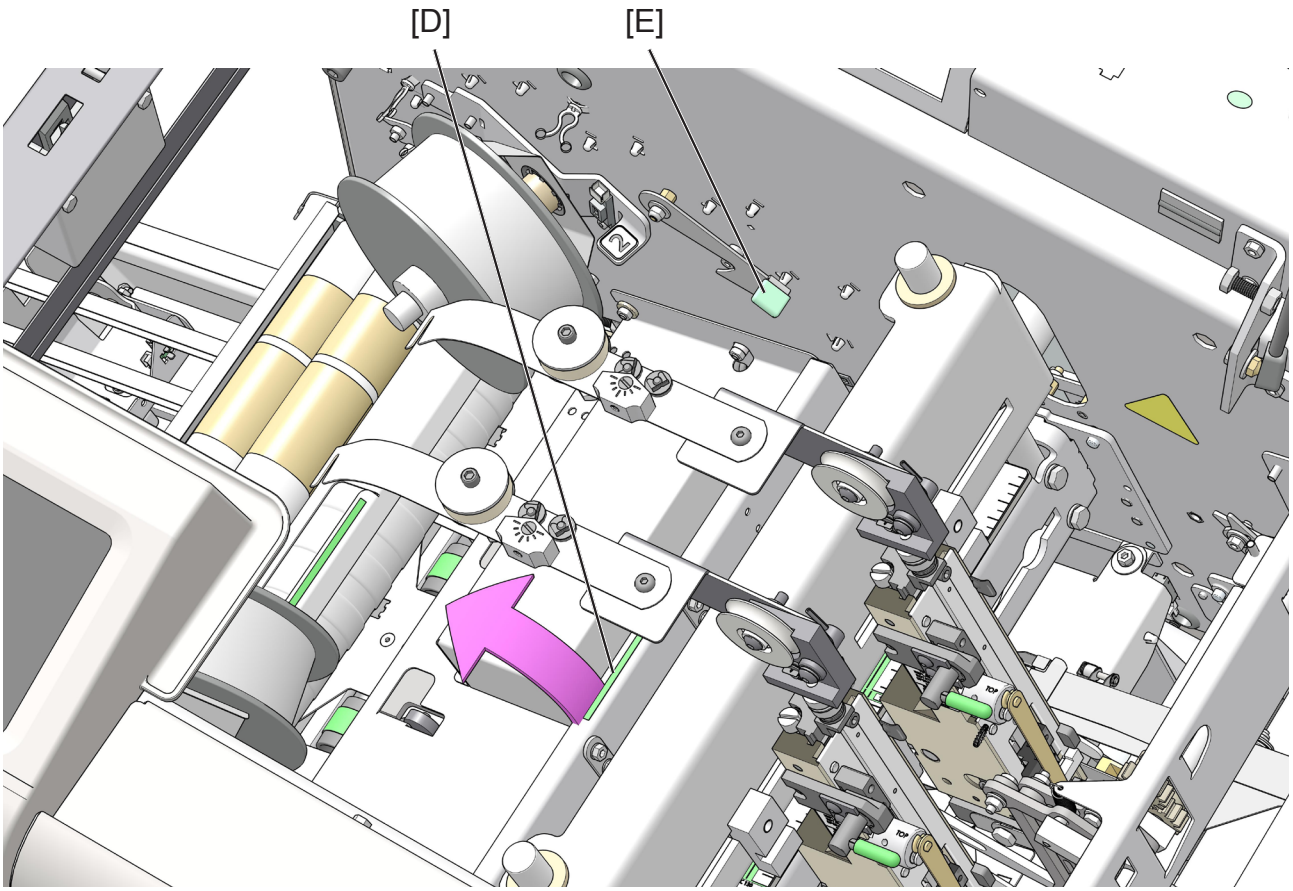


To clear a misfeed indicated in Area BM2

Open and then close the top cover.

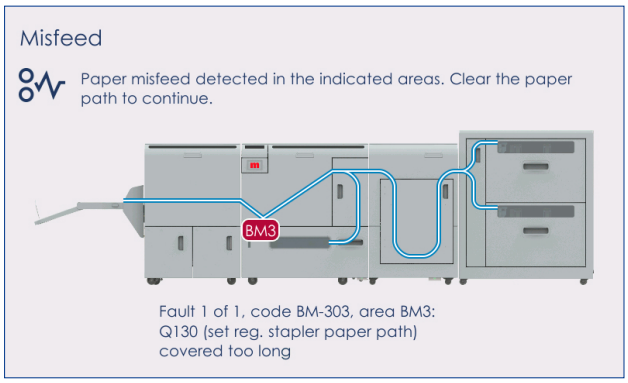
If system does not purge, remove misfed sheets manually following the procedure below.

1. Open the Booklet Maker Top Cover.
2. Lift the Paper Transport [D] until it latches.
3. Remove any jammed/misfeed sheets/sets.
4. Lift Latch [E] and place the Paper Transport [D] back in operating position.
5. Close the Booklet Maker Top Cover.



continued on next page

Clearing misfeed in Folder area - BM3



To clear a misfeed indicated in Area BM3

Open and then close the top cover.

If system does not purge or if misfeed condition persists, power off and then power on the system.

If needed, remove misfed sheets manually following the procedure below.

If necessary, check procedure on next page, Clearing misfeed in Fold Stop area.

1 Open the Booklet Maker Top Cover.

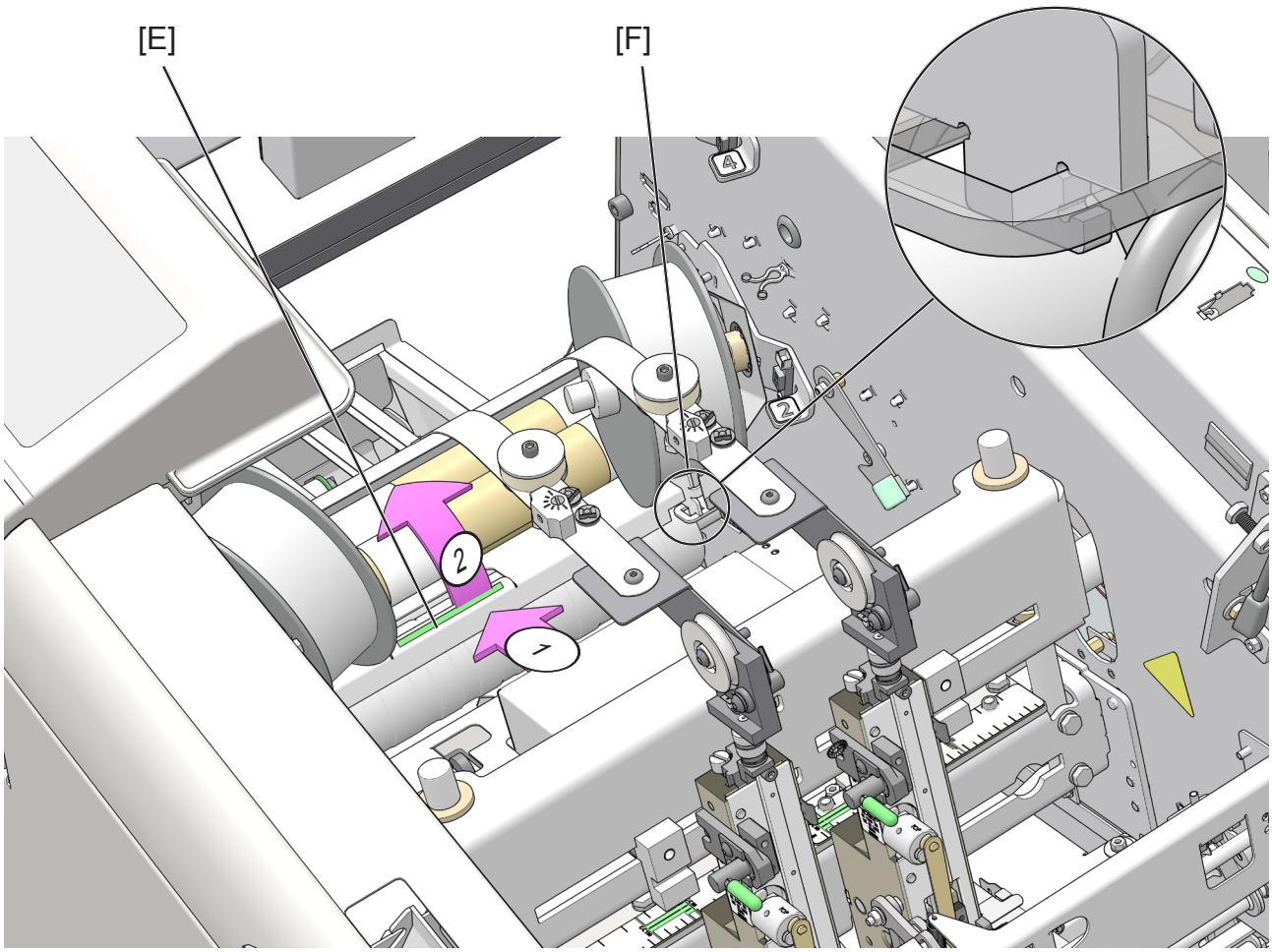
2 Lift the Fold Roller Paper Guide [E].

3 Remove any jammed/misfeed sheets/sets.

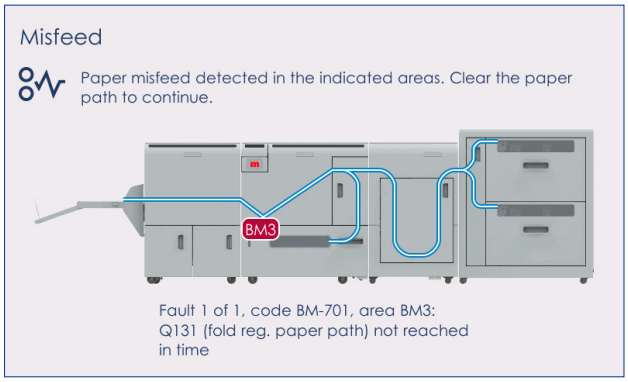
4 Place the Fold Roller Paper Guide back in operating position.

NOTE:
Make sure the Fold Roller Paper Guide is locked in operating position [F] at both sides.

5 Close the Booklet Maker Top Cover.



Clearing misfeed in the Fold Stop area - BM3



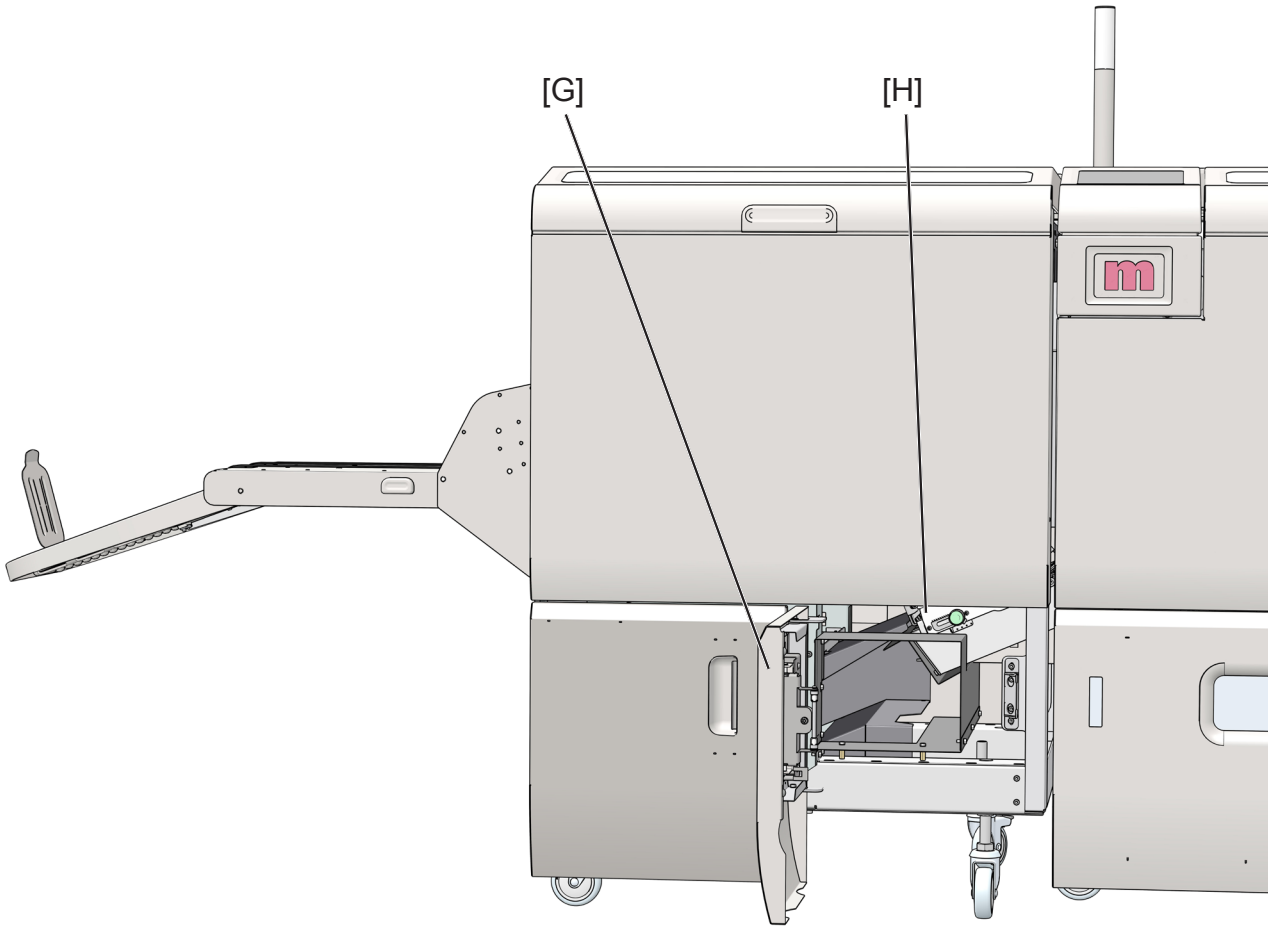
To clear a misfeed indicated in Area FM5

Follow the procedure below.

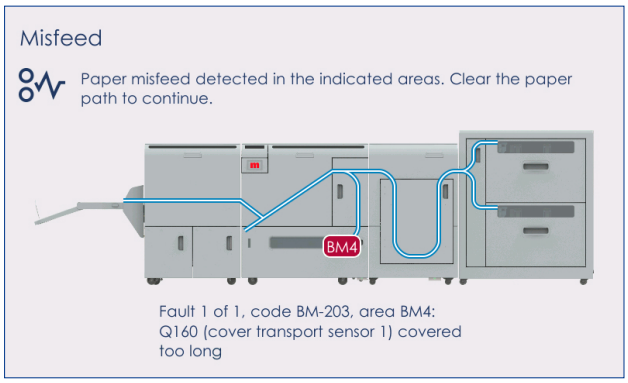
If necessary, check procedure on previous page, Clearing misfeed in Folder area.

5

1. Open the Jam Clearance Door [G].
2. Lift the Fold Stop Paper Guide [H]
3. Remove any jammed/misfed sets/booklets.
4. Close the Jam Clearance Door [G].

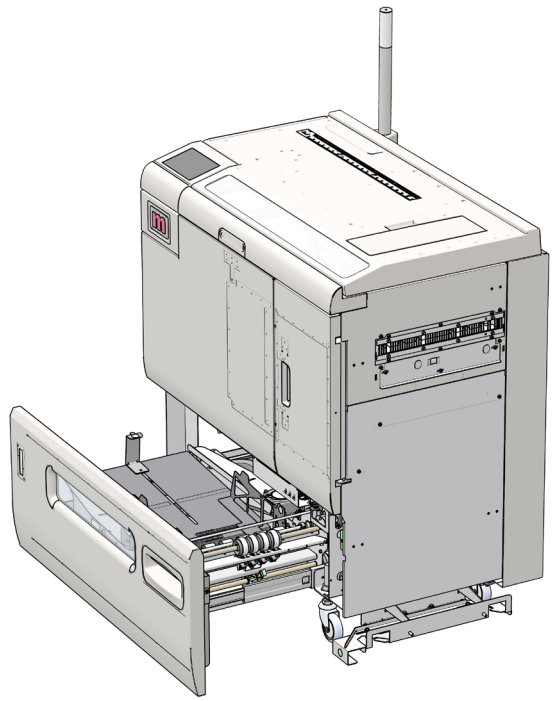


Clearing misfeed in Convenience Feeder area - BM4

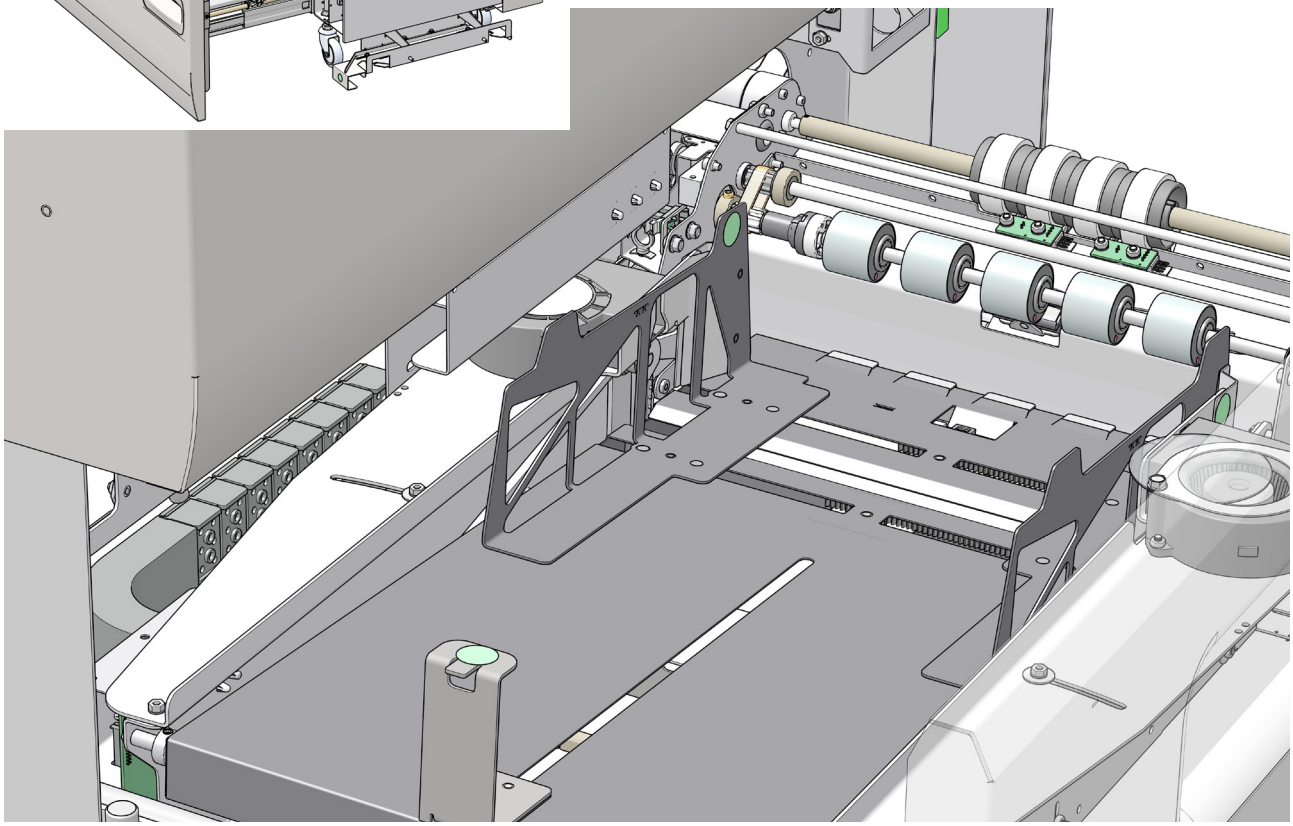


To clear a misfeed indicated in Area BM4

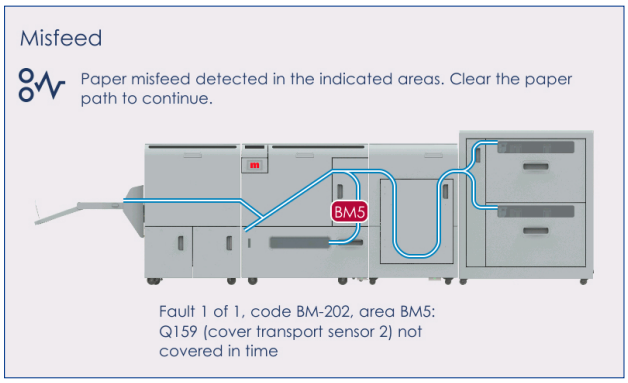
Follow the procedure below.



1. Open the Convenience Feeder Cover.
2. Remove any jammed/misfeed sheets from the Convenience Feeder.
3. Close the Convenience Feeder Cover.

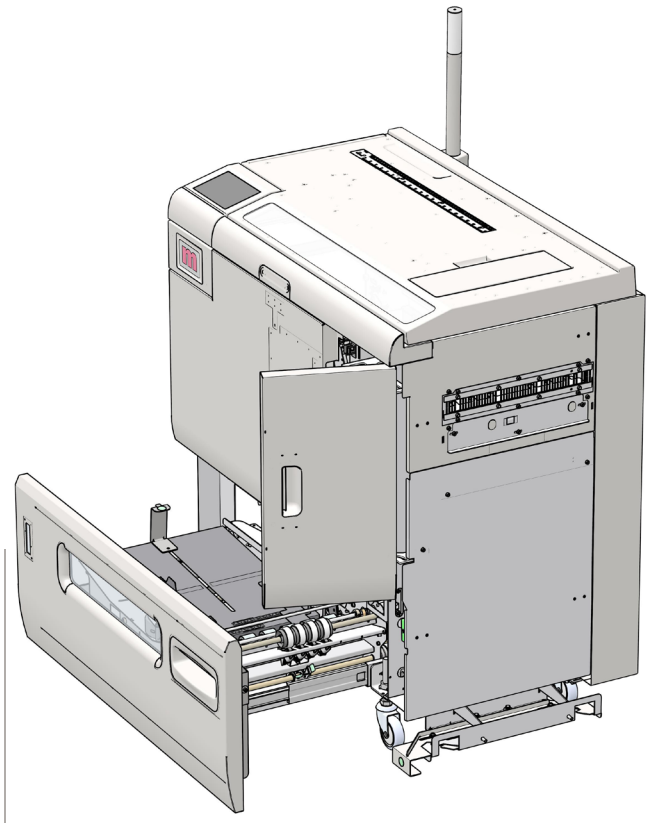


Clearing misfeed in Convenience Feeder area - BM5

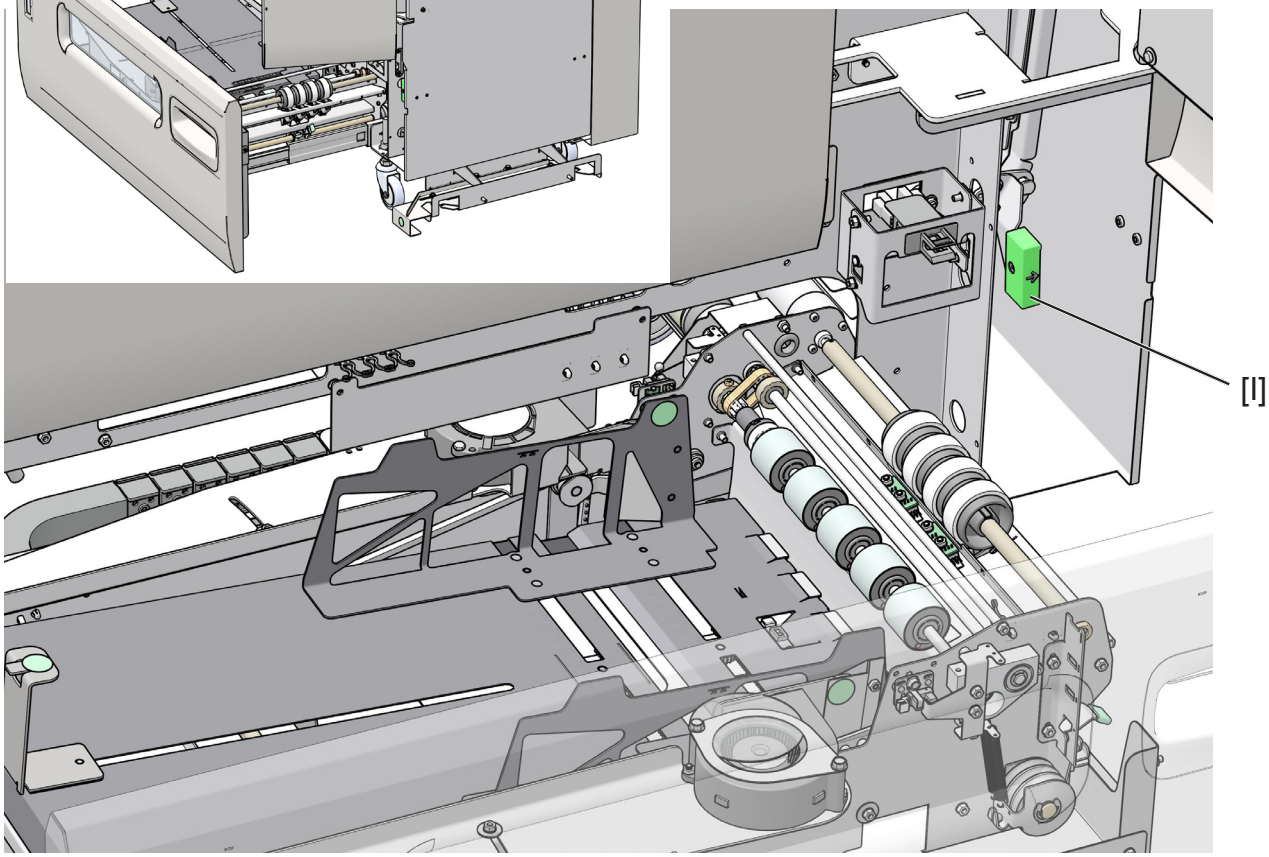


To clear a misfeed indicated in Area BM5

Follow the procedure below.



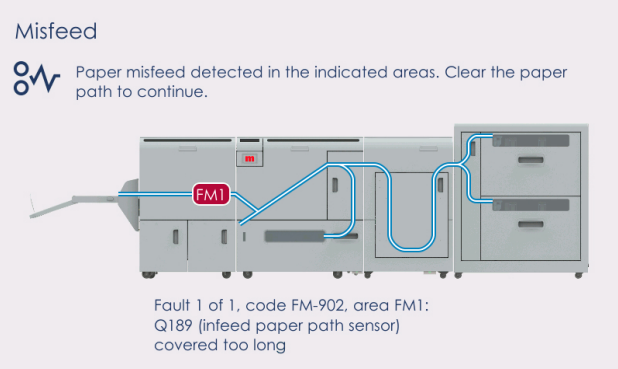
1. Open the Convenience Feeder Front Cover and the Front Door.
2. Open the Jam Clearance Baffle [I].
3. Remove any jammed/misfeed sheets.
4. Close the Jam Clearance Baffle, the Convenience Feeder Front Cover and the Front Door.



Finishing Module

Clearing misfeed(s) in the Finishing Module

Inside the SquareFold area - FM1



To clear a misfeed indicated in Area FM1

Follow the procedure below.

1 Open the Finishing ModuleTop Cover.

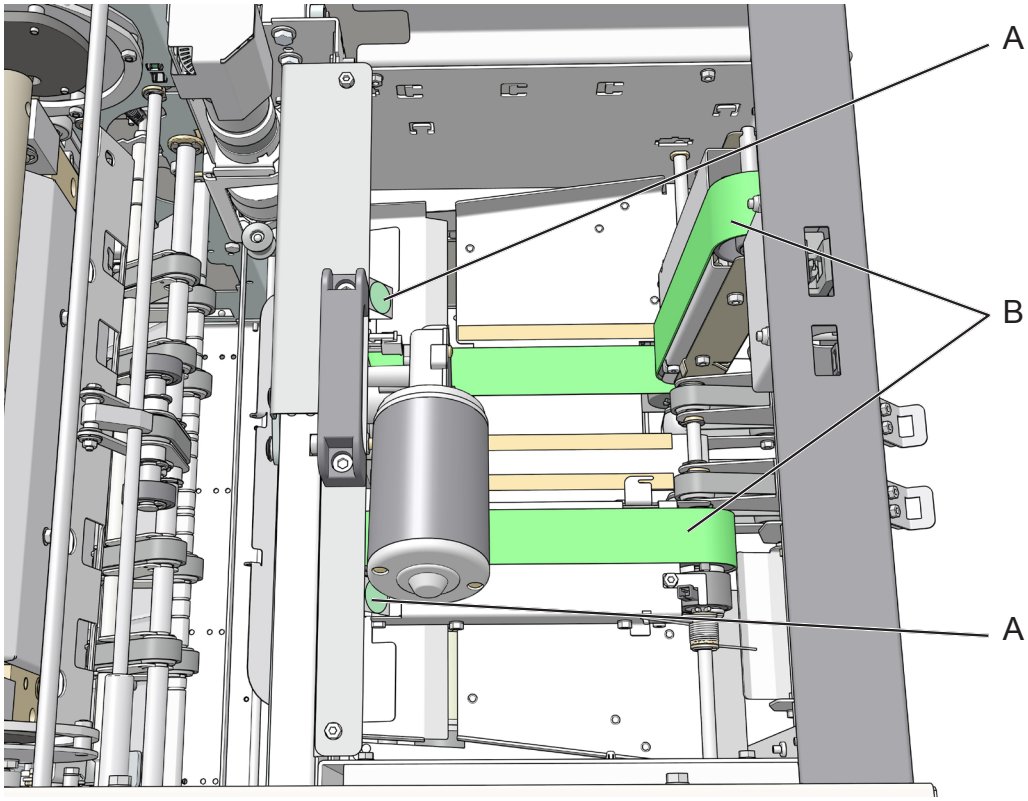
2 Press the Green Dots [A] on the Release Latches and lift up Upper Feed Belts (B).

NOTE:
The upper feed belt on the operator side sided cannot be lifted fully.

3 Remove any jammed/misfed sets/booklets.

4 Place the Upper Feed Belts in normal position.

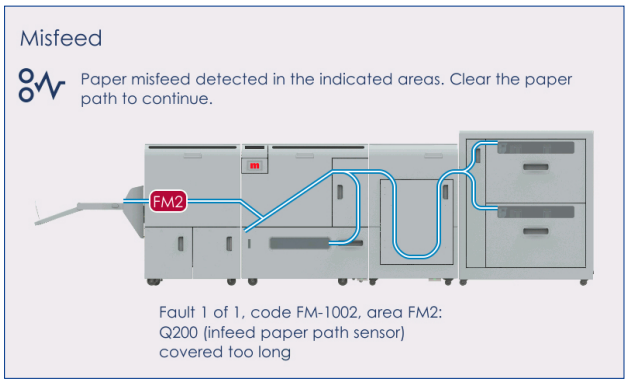
5 Close the Finishing Module Top Cover.



The upper trimmer blade on the trimmer is protected by a knife protection plate that moves away during the cutting stroke.

⚠ **WARNING:**
Never put fingers or other parts of the body between the upper and lower trimmer knives.

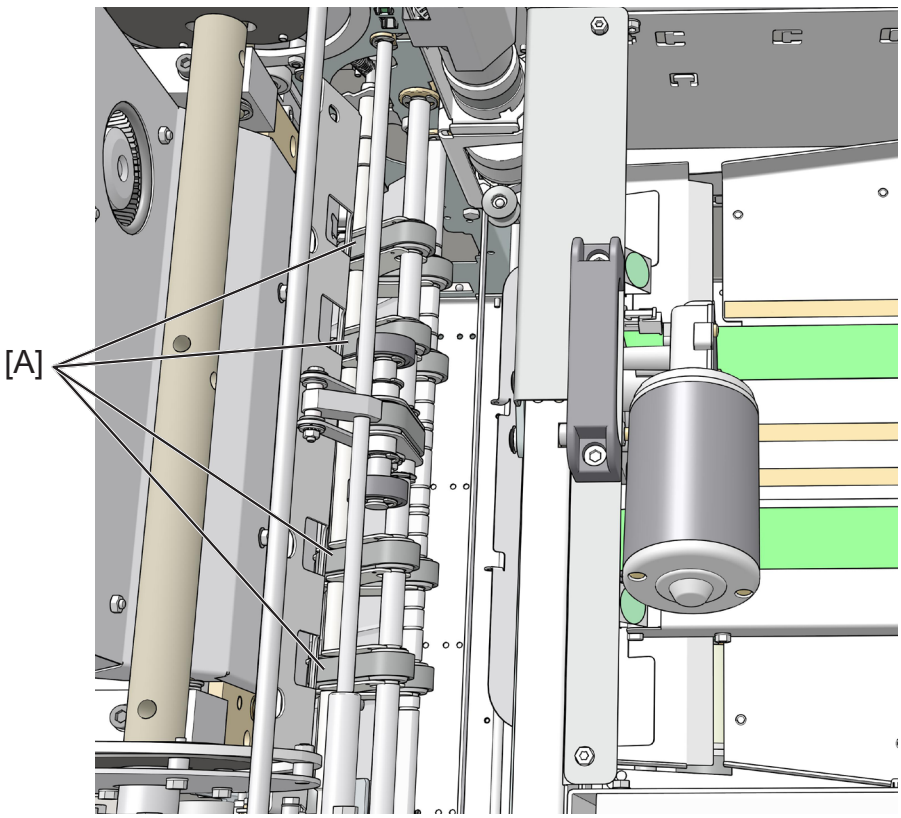
Clearing misfeed in the Trimmer infeed area - FM2



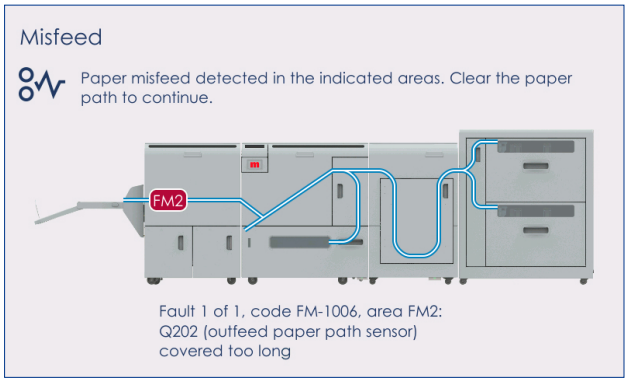
To clear a misfeed indicated in Area FM2

Follow the procedure below.

1. Open the Finishing ModuleTop Cover.
2. Remove any jammed/misfeed sets/booklets by pulling them towards the SquareFold.
3. The leftmost side of the infeed roller shaft assembly [A] can be lifted slightly to ease removing any jammed/misfeed sets/booklets.
4. Place the infeed roller shaft assembly back into operating position.
5. Close the Finishing Module Top Cover.



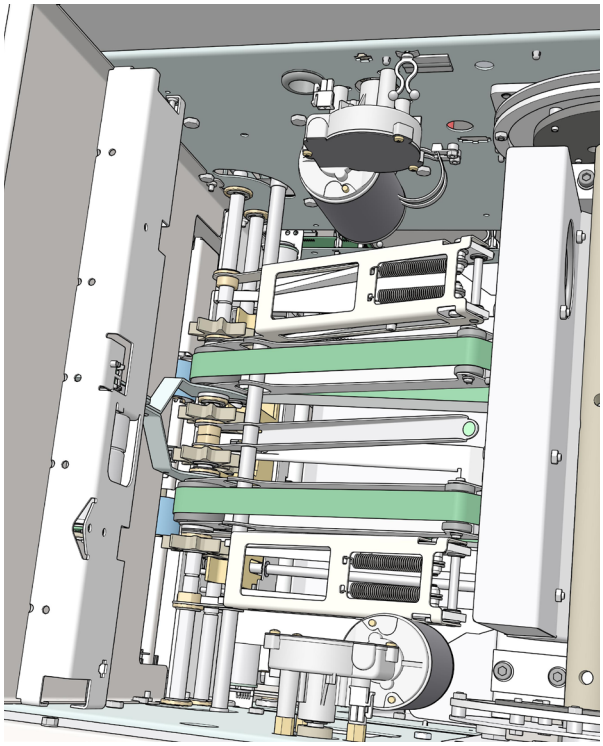
Clearing misfeed in the Trimmer exit area - FM2



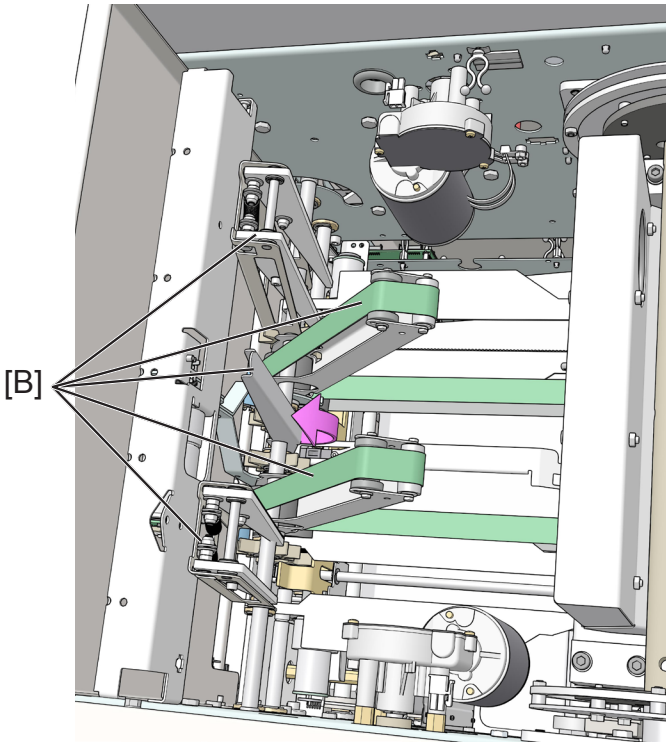
To clear a misfeed indicated in Area FM2

Follow the procedure below.

1. Open the Finishing ModuleTop Cover.
2. Lift the exit compressing brackets and transport belts [B].
3. Remove any jammed/misfeed sets/booklets.
4. Place the exit compressing brackets in operating position.
5. Close the Finishing Module Top Cover.

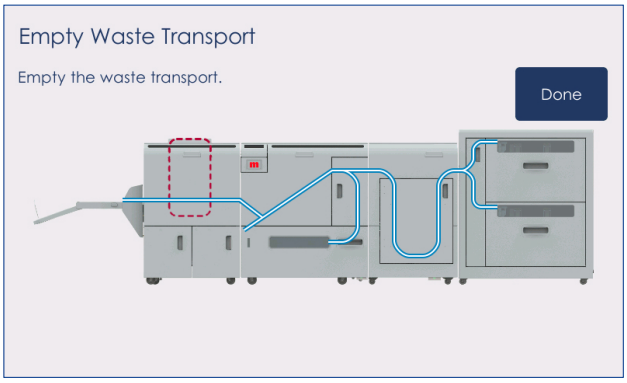


Exit compressing brackets and transport belts in normal position



Exit compressing brackets and transport belts lifted

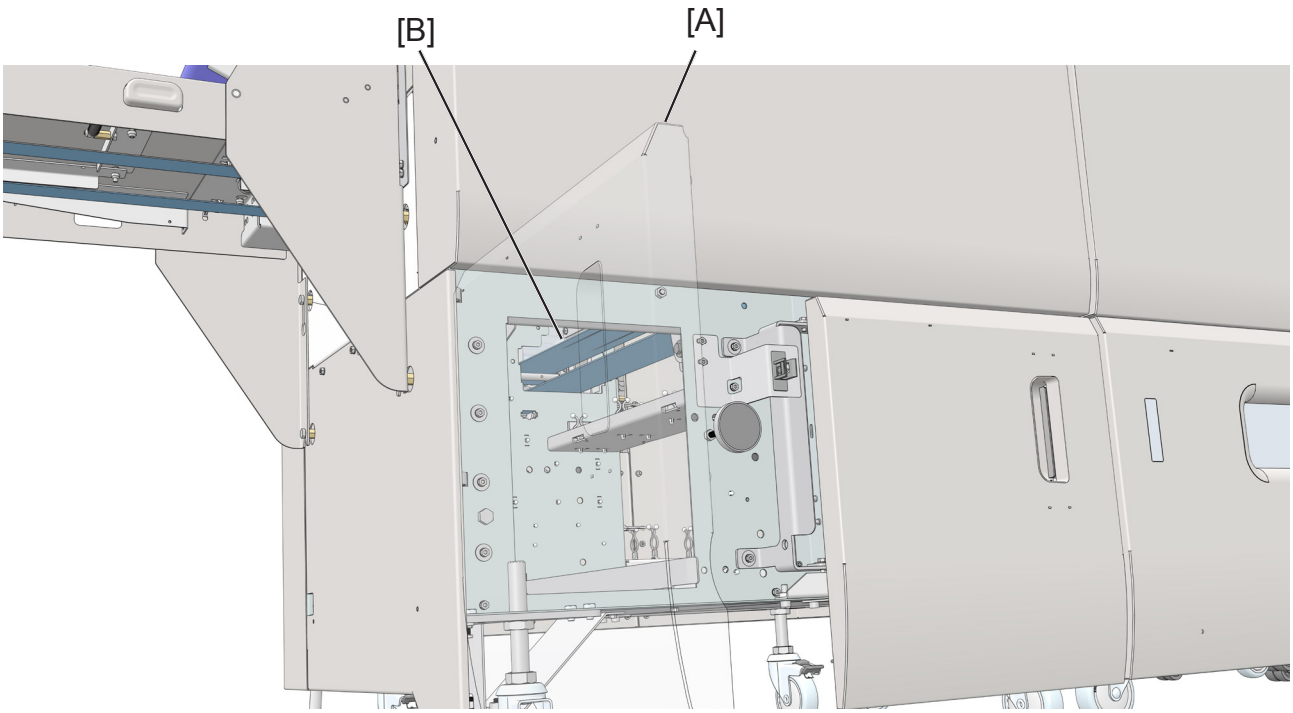
Clearing misfeed in the Waste Transport



The message “Empty Waste Transport” will be shown on the User Interface when trim strips are getting stuck in the waste transport areas. Proceed as follows:

1 Open the Left Door [A] on the Finishing Module.

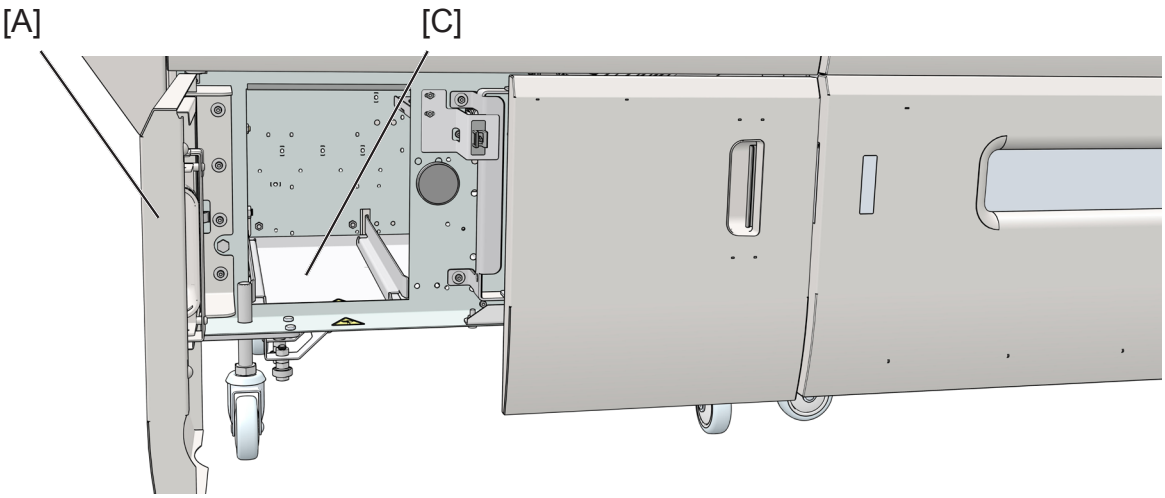
2 Pull the upper part of the Transport Belt [B] downwards and remove any trim waste strips.



Left door made transparent for clarity

3 Also remove any trim waste strips from the bottom area [C] inside the Finishing Module.

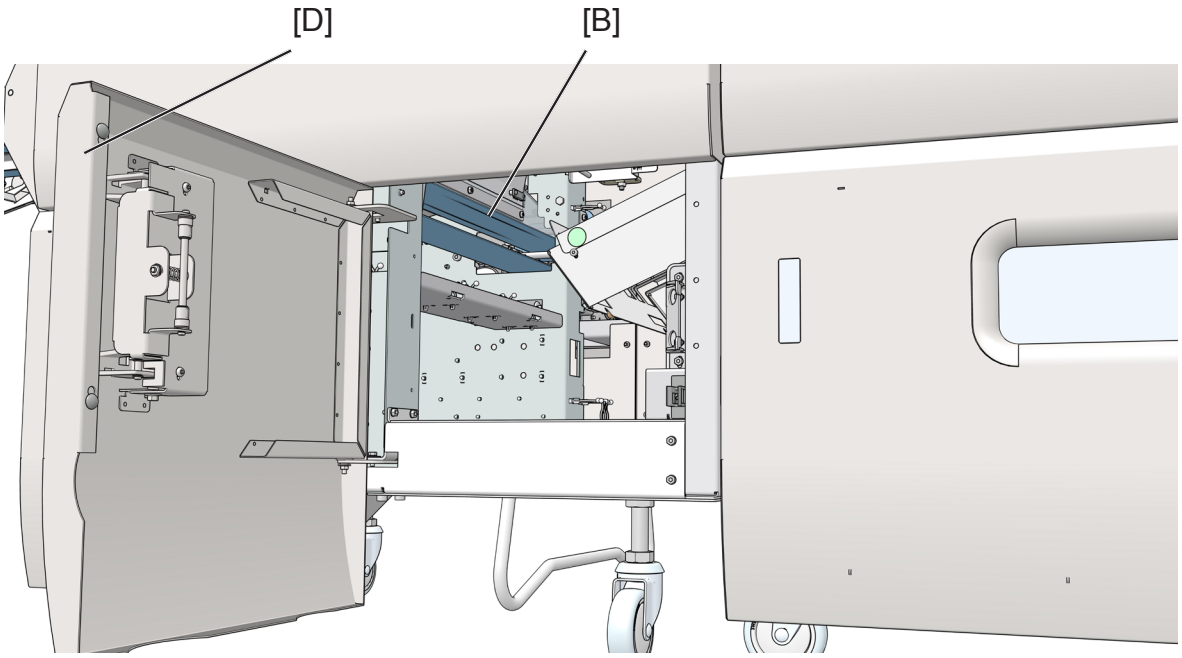
4 Close the Left Door [A] on the Finishing Module.



Clearing misfeed in the Waste Transport, continued

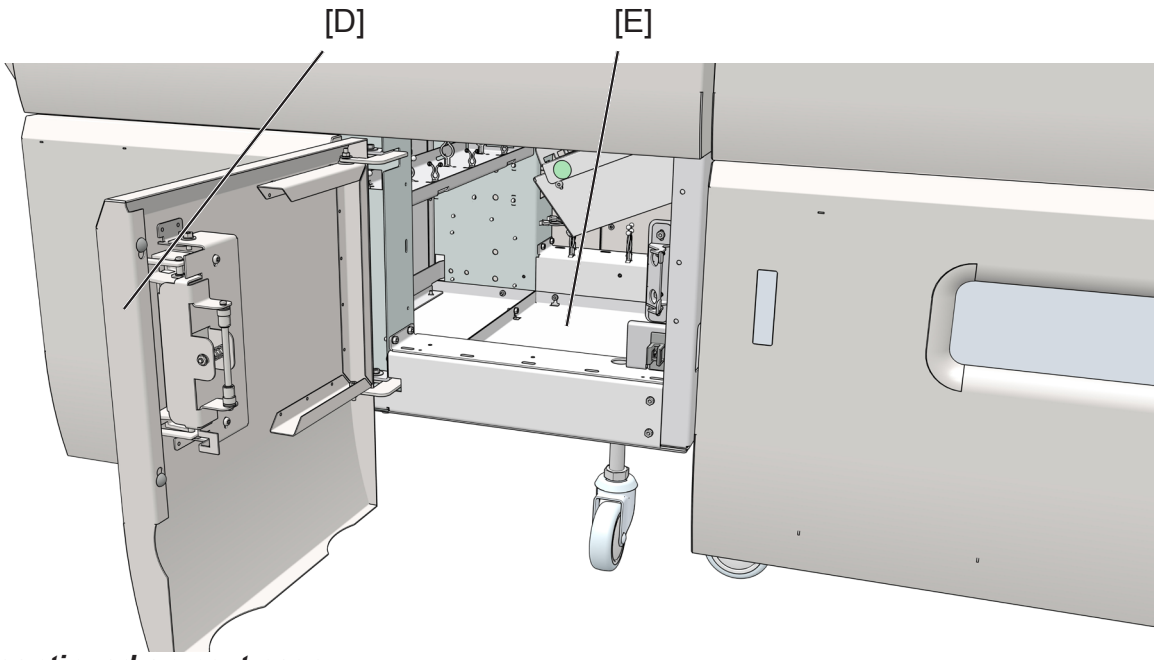
5 Open the Right Door [D].

6 Pull the upper part of the Transport Belt [B] downwards and remove any trim waste strips.



7 Also remove any trim waste strips from the bottom area [E] inside the Finishing Module.

8 Close the Right Door [D] on the Finishing Module.



continued on next page

Clearing misfeed in the Waste Transport, continued

9 Open the Waste Transport Top Cover [F].

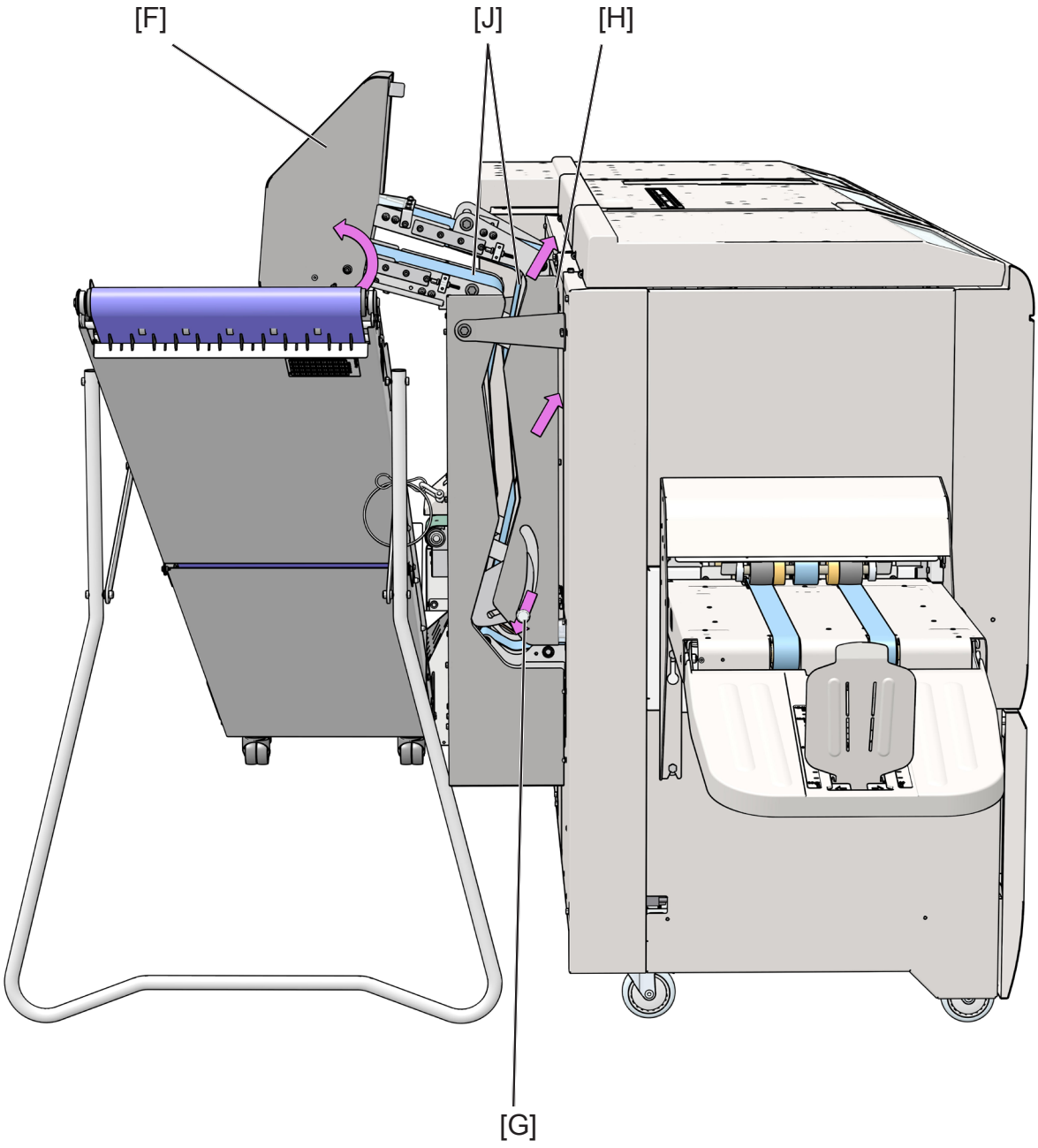
10 Push down the Lever [G] to release the Jam Clearance Cover [H].

11 Remove any trim waste strips from between the transport belts [J].

12 Lift the Lever [G] to restore the Jam Clearance Cover to operating position.

13 Close the Top Cover [F].

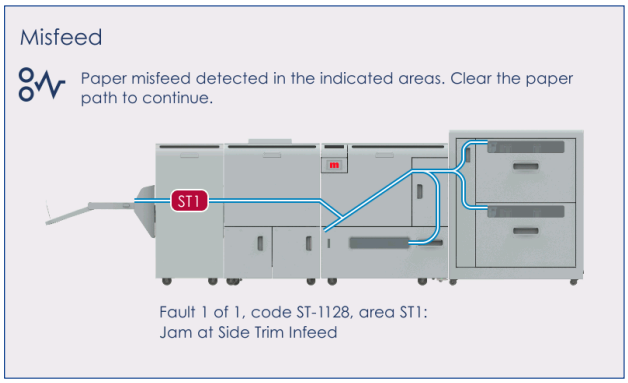
14 Press the [Done] button on the User Interface to restart the job.



ST5000

Clearing misfeed(s)

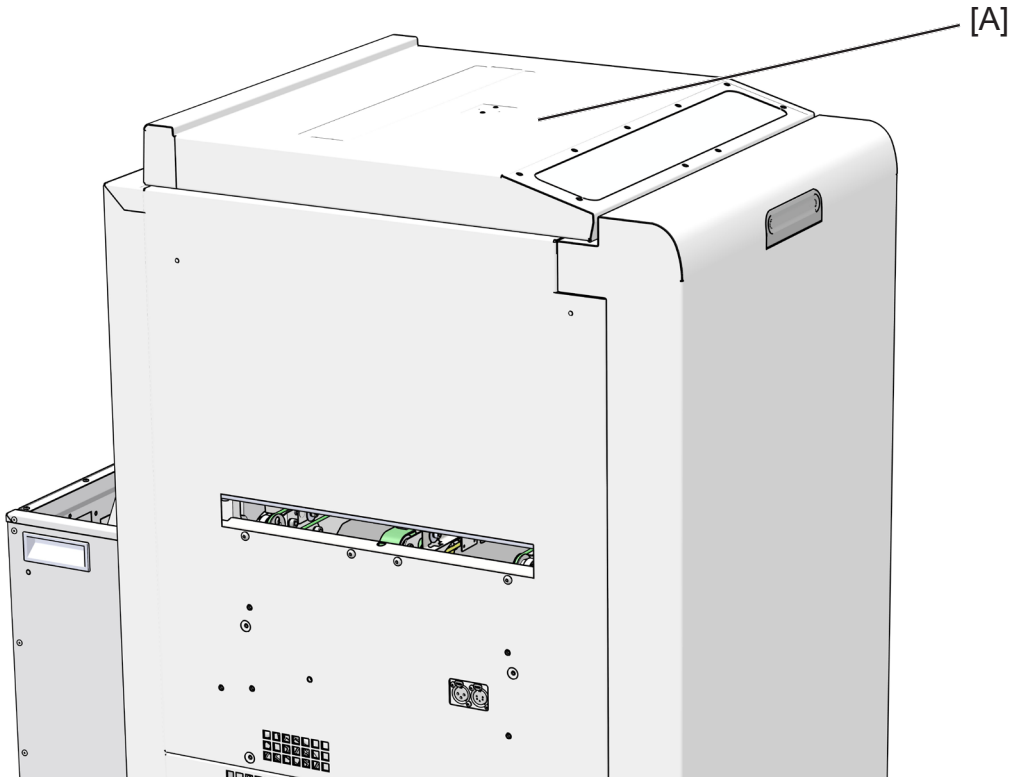
Clearing misfeed in the ST5000



To clear a misfeed indicated in Area ST1

Follow the procedure below.

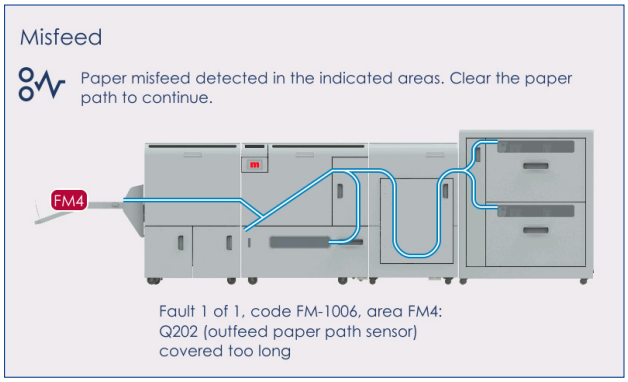
1. Open and then close the Side Trimmer Top Cover [A].
2. Then, if necessary, open the Side Trimmer Top Cover and check for paper trimmings or obstructions. Close the Side Trimmer Top Cover.
3. If the message still does not clear, open the Side Trimmer Top Cover [A], turn the Side Trimmer OFF using the mains ON/OFF switch, wait at least 5 seconds and then turn the Side Trimmer ON.
4. If misfeed(s) continue, then clean the book supports. See section 7, “Maintaining Your Machines”, for how to clean the book supports.



Belt stacker

Clearing misfeed(s)

Clearing misfeed in the belt stacker

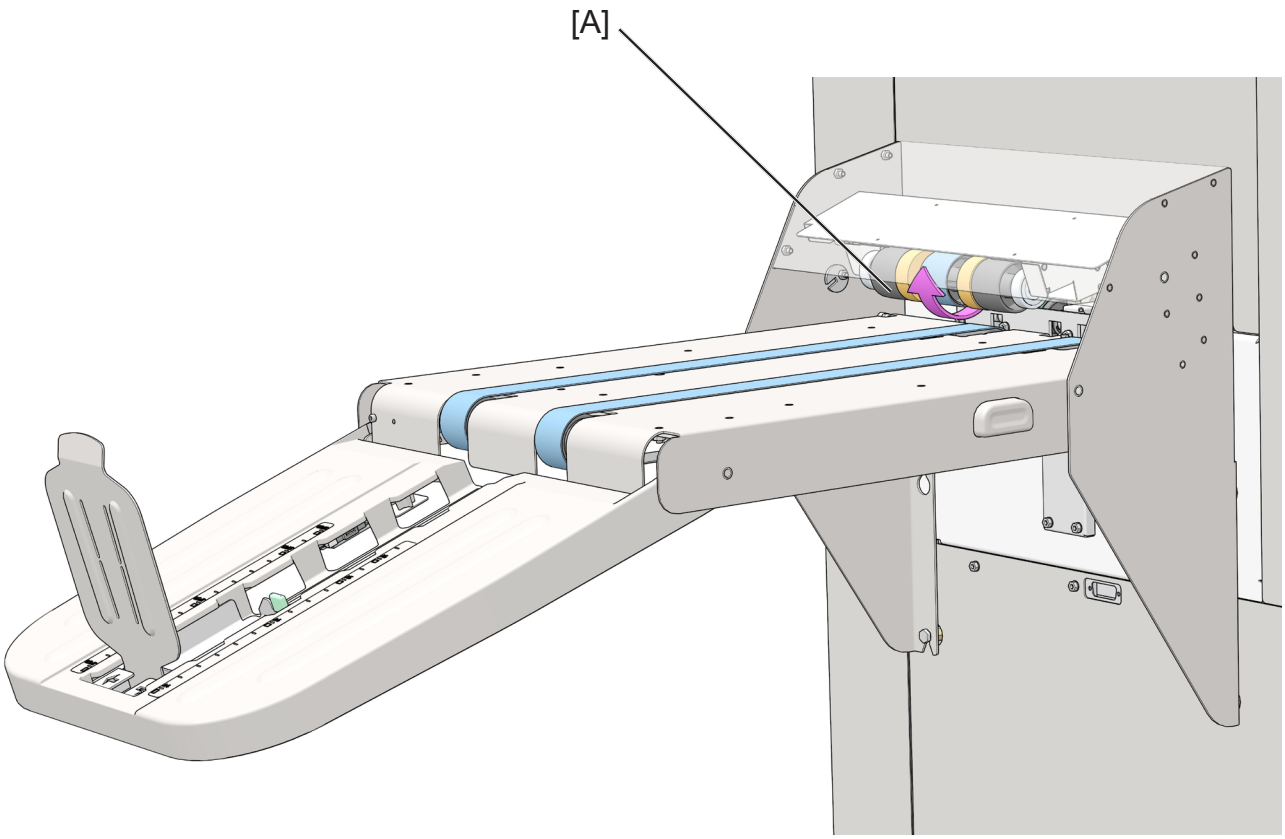


To clear a misfeed indicated in Area FM4

Follow the procedure below.

1 Lift the upper belt unit [A].

2 Remove any jammed/misfed sets/booklets.



6. Troubleshooting

Fault codes

General Procedure

When there is a misfeed or a fault condition in the Booklet Maker system, a code and/or a message will be displayed on the User Interface. Follow this general procedure to clear a jam condition:

- open and close the top covers: this might trigger an automatic purge, depending on where the misfed set / booklet is located.
- see section 5 of this manual, “Clearing Misfeed(s)” for how to clear misfeed(s), then remove any paper in the paper path and power Off and On the system. Note that if a job is cancelled or if there is a jam, there might be an incomplete set inside another module of the system. The incomplete set will also have to be removed manually.
- see the detailed description of the fault code in the following pages to check if further action is needed.

If frequent jams are experienced:

- check that paper curl is not outside specifications,
- check for misfed sheets in the system and remove them,
- check for debris or obstructions on the paper path and remove them,
- check that booklets on the stacker do not block the path of exiting booklets,
- check that paper size is set correctly (both in the upstream device and in the Booklet Maker system),
- perform preventative maintenance as per section 7 of this manual.

When the message “Close Cover(s)” is displayed, one or several of the interlock switches are actuated. Check that all covers are closed.

To address codes other than those specified in this section, remove any paper in the paper path, then power off and on the system.

NOTE:
If procedures in this manual do not rectify the problem an authorized technician will be needed.

NOTE:
For components locations, refer to the section Guide to Components of this manual.

Vacuum Feeder (VFX) fault codes

NOTE:
As a general rule, any code beginning with VFX-1 (VFX-1XX) refers to tray A (the upper tray), while any code beginning with VFX-2 (VFX-2XX) refers to tray B (the lower tray).

Code / message	Explanation / action
VF100 / VF200 Misfeed in tray A/B	Misfeed is a paper flow error detection. Misfeed checks if a sheet is moved correctly from paper pile to optical DSD sensor. Time is measured from the start of the drive roller (used to feed and separate a sheet from the paper pile) until the optical DSD sensor can see the leading paper edge. A Misfeed condition is generated if this measured time is too long. • Ensure that DSD sensor Q101/201 is clean, refer to the maintenance section of this manual for more information about this matter; • Check that there are no obstructions in the paper path; • Turn off Optical DSD sensor from the Settings page.
VF101 / VF201 Jam in tray A/B	Jam is a paper flow error detection. Jam checks if a sheet is moved past the optical DSD sensor correctly. Time is measured from when the optical DSD sensor sees the leading paper edge until the optical DSD sensor sees the trailing paper edge. A Jam condition is generated if this measured time is too long. • Ensure that DSD sensor Q101/201 is clean, refer to the maintenance section of this manual for more information about this matter; • Check that there are no obstructions in the paper path; • Turn off Optical DSD sensor from the Settings page.
VF102 / VF202 Too long in tray A/B	Too Long is a paper length error detection. Too long checks if a sheet is too long when it passes the optical DSD sensor Q101/201. Time is measured from when the optical DSD sensor sees the leading paper edge until the optical DSD sensor sees the trailing paper edge. A Too Long condition is generated if the measured time is too long, but not long enough to generate a Jam. The sheet will be held in subsequent unit. • Open subsequent unit and remove sheet; • Ensure that DSD sensor Q101/201 is clean, refer to the maintenance section of this manual for more information about this matter; • Check that there are no obstructions in the paper path; • Turn off Optical DSD sensor from the Settings page.

continued on next page

Vacuum Feeder (VFX) fault codes (continued)

NOTE:
For components locations, refer to the **Guide to Components** section of this manual.

Code / message	Explanation / action
VF103 / VF203 Too short in tray A/B	Too Short is a paper length error detection. Too Short checks if a sheet is too short when it passes the optical DSD sensor Q101/201. Time is measured from the situation when the optical DSD sensor sees the leading paper edge until the optical DSD sensor sees the trailing paper edge. A Too Short condition is generated if the measured time is too short. The sheet will be held in subsequent unit. • Open subsequent unit and remove sheet; • Ensure that DSD sensor Q101/201 is clean, refer to the maintenance section of this manual for more information about this matter; • Check that there are no obstructions in the paper path; • Turn off Optical DSD sensor from the Settings page.
VF104 / VF204 Too thick in tray A/B	Too Thick is a paper thickness error detection. Too Thick checks if a sheet is too thick when it passes the optical DSD sensor Q101/201. When the optical DSD sensor sees the leading paper edge, thickness is measured. A Too Thick condition is generated if the measured thickness on a sheet is too thick compared to the calibration sheet. The sheet will be held in subsequent unit. • Open subsequent unit and remove sheet; • Ensure that DSD sensor Q101/201 is clean, refer to the maintenance section of this manual for more information about this matter; • Check that there are no obstructions in the paper path; • Turn off Optical DSD sensor from the Settings page.
VF105 / VF205 DSD (optical sensor) functionality uncertain in tray A/B	DSD functionality uncertain is a warning that can be generated at calibration. DSD functionality uncertain checks if the sheet thickness is within reading range for the optical DSD sensor Q101/201. • Ensure that DSD sensor Q101/201 is clean, refer to the maintenance section of this manual for more information about this matter; • Check that there are no obstructions in the paper path; • Turn off Optical DSD sensor from the Settings page.
VF106 / VF206 Too thick USDSD in tray A/B	Too thick US DSD is a paper thickness error detection. Too thick US DSD checks if a sheet is too thick when it passes the ultrasonic DSD sensor Q102/202. When the ultrasonic DSD sensor sees the leading paper edge, thickness is measured. A Too Thick condition is generated if the measured thickness on a sheet is too thick. • Ensure that DSD sensor Q101/201 is clean, refer to the maintenance section of this manual for more information about this matter; • Check that there are no obstructions in the paper path.

continued on next page

Vacuum Feeder (VFX) fault codes (continued)

NOTE:
For components locations, refer to the **Guide to Components** section of this manual.

Code / message	Explanation / action
VF107 / VF207 Tray empty in tray A/B	Tray Empty is a paper present detection. Tray Empty checks if sheets are present in the activated tray during process. A Tray Empty condition is generated if sensor Q105/205 cannot see any paper. • Refill paper; • If there is paper in the tray, remove paper and clean the tray empty sensor (Q105/205).
VF108 / VF208 Too thin in tray A/B	Too Thin is a paper thickness error detection. Too Thin checks if a sheet is too thin when it passes the optical DSD sensor Q101/201. When the optical DSD sensor sees the leading paper edge, thickness is measured. A Too Thin condition is generated if the measured thickness on a sheet is too thin compared to the calibration sheet. The sheet will be held in subsequent unit. • Open subsequent unit and remove sheet; • Ensure that DSD sensor Q101/201 is clean, refer to the maintenance section of this manual for more information about this matter; • Check that there are no obstructions in the paper path; • Turn off Optical DSD sensor from the Settings page.
VF109 / VF209 Set side guides in process position tray A/B	This error code is displayed if the SP Sensor cannot see the stack of paper. If the operator forgets to set side guides properly (inwards, touching the sides of the paper stack), this fault code will be displayed and the tray will open automatically. • Move the Side Guides inwards so they touch the sides of the paper stack.
VF110 / VF210 Overloaded tray A/B	This error code is displayed if the Optical Sensor (Q301/Q302) senses that there are too many sheets in the tray. Note that sensor Q301/Q302 is accessible when the upper/lower tray is open and is installed on the chassis of the machine. It is installed upsidedown so that it can detect the center of the paper stack from above. • Remove the extra paper from the tray; • Ensure that the sensor is clean; • Check that there are no obstructions between the sensor and the stack of paper.

continued on next page

Vacuum Feeder (VFX) fault codes (continued)

NOTE:
For components locations, refer to the **Guide to Components** section of this manual.

Code / message	Explanation / action
VF300 Exit miss	Exit Miss is a paper flow error detection. Exit Miss checks if a sheet gets stuck between optical DSD sensor Q101/201 and Exit sensor Q303 (this sensor is placed in the exit area of the machine, where the antistatic brushes are). Time is measured from when the optical DSD sensor sees the trailing paper edge until the Exit sensor sees the trailing paper edge. An Exit Miss condition is generated if this measured time is too long. • Open the door/baffle(s) and remove sheet(s); • Make sure that the optical DSD sensors Q101/201 are clean.
VF301 Exit error	Exit Error is a paper flow error detection. Exit Error checks if a sheet has moved past the Exit sensor Q303 correctly (this sensor is placed in the exit area of the machine, where the antistatic brushes are). Time is measured from when the Exit sensor sees the leading paper edge until the Exit sensor sees the trailing paper edge. An Exit Error is generated if this measured time is too long. • Ensure that the Exit sensor is clean; • Check that there are not obstructions in the paper path.
VF400 No feed sequence	No feed sequence is a startup detection error. No feed sequence checks if a feeding sequence has been programmed. No feed sequence is generated if the machine is started without a programmed feeding sequence. • Please insert a feeding sequence and restart the job.

Barcode Reader fault codes

Code / message	Explanation / action
VF50 Wrong Page Number	The Barcode reader has successfully read the barcode on the current sheet, but it is not as expected. Specifically, the page number specified in the barcode is wrong. Make sure that the set loaded in the tray matches what has been programmed on the UI. Please refer to the section named “Definitions of the control codes” in this manual for more information.
VF51 Wrong Sequence Number	The Barcode reader has successfully read the barcode on the current sheet, but it is not as expected. Specifically, the page sequence specified in the barcode is wrong. Make sure that the set loaded in the tray matches what has been programmed on the UI. Please refer to the section named “Definitions of the control codes” in this manual for more information.

continued on next page

Barcode Reader fault codes (continued)

VF52 Wrong Set ID	The Barcode reader has successfully read the barcode on the current sheet, but it is not as expected. Specifically, the Set ID specified in the barcode is wrong. Make sure that the set loaded in the tray matches what has been programmed on the UI. Please refer to the section named “Definitions of the control codes” in this manual for more information.
VF53 Wrong Job ID	The Barcode reader has successfully read the barcode on the current sheet, but it is not as expected. Specifically, the Job ID specified in the barcode is wrong. Make sure that the set loaded in the tray matches what has been programmed on the UI. Please refer to the section named “Definitions of the control codes” in this manual for more information.
VF54 Not Read	The Barcode reader is unable to detect the barcode on the paper. Make sure that a barcode is printed on the paper and it is in the right position as specified in the “barcode characteristics” section of this manual.
VF55 Not connected Tray A	Power off / power on the machine.
VF56 Not connected Tray B	Power off / power on the machine.
VF57 Parameters not saved in Barcode Tray A	Power off / power on the machine.
VF58 Parameters not saved in Barcode Tray B	Power off / power on the machine.
VF59 Wrong Page Number and Page Count	The Barcode reader has successfully read the barcode on the current sheet, but it is not as expected. Specifically, the Page Number and Count specified in the barcode are wrong. Make sure that the set loaded in the tray matches what has been programmed on the UI. Please refer to the section named “Definitions of the control codes” in this manual for more information.

Vacuum Feeder (VFX), Jam recovery, Auto Feeder Mode off

In the following pages is the procedure for jam recovery using manual settings in the VFX. Before starting the adjustments, make sure that all the parameters are set to “auto” mode.

Refer to “Front Float Air”, “Rear Float Air”, “Separation Air”, “Process Position”, “Vacuum Air” and “Pickup Time” in section 2, “Making Booklets” under “Advanded Settings in the VFX, trays A and B, Auto Feeder Mode off”

Refer to “Test Settings” in section 2, “Making Booklets” under “Advanded Settings in the VFX, trays A and B, Auto Feeder Mode off” to check if the sheets are floating correctly.

Refer to “Paper Stack Preparation” and “Preparing the VFX” in section 1, “Basics” for how to measure paper curl.

continued on next page

VFX, Jam recovery, Auto Feeder Mode off continues

Miss error

When the message “miss” is displayed, the paper is not being fed from the trays.

Procedure

Does paper have cross process direction curl?

N **Y**

Measure paper curl: if paper curl is negative, decrease process position by that amount, if paper curl is positive, increase process position by that amount.

Sheets are floating correctly

N **Y**

Exit

Decrease Process Position by 2 and check if the sheets are floating correctly.

Sheets are floating correctly

N **Y**

Exit

Increase Pick Up Time by 30 ms and run a job to test if the sheets are fed correctly.

Sheets are fed correctly

N **Y**

Exit

Increase Front Float Air by 10% and check if sheets are floating correctly.

Sheets are floating correctly

N **Y**

Exit

Increase Separation Air by 10% and check if sheets are floating correctly.

Sheets are floating correctly

N **Y**

Exit

Increase Vacuum Air by 10% and check if sheets are floating correctly. If Vacuum Air is already set at 100% skip this step.

Sheets are floating correctly

N **Y**

Exit

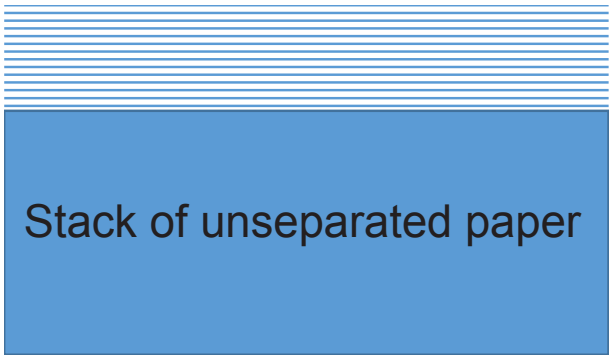
Increase Rear Float Air by 10% and check if sheets are floating correctly.

Sheets are floating correctly

N **Y**

Exit

Repeat the procedure until sheets float correctly.



If the VFX is set correctly, the sheets will be floating horizontally with equal amounts of separation between sheets.

- For 80 gsm paper approx 15-20 sheets shall be floating
- For 150 gsm paper approx 12 - 16 sheets shall be floating
- For 300 gsm approx 6-10 sheets shall be floating

continued on next page

VFX, Jam recovery, Auto Feeder Mode off continues

Jam, Too long, Too thick errors

When one of these messages is displayed, there might be jam or a double sheet detection in the trays.

Procedure

Does paper have cross process direction curl?

N **Y**

| Measure paper curl: if paper curl is negative, decrease process position by that amount, if paper curl is positive, increase process position by that amount.

Sheets are floating correctly

N **Y**

| | Exit

Increase Process Position by 2 and check if the sheets are floating correctly.

Sheets are floating correctly

N **Y**

| Exit

Increase Pick Up Time by 30 ms and run a job to test if the sheets are fed correctly.

Sheets are fed correctly

N **Y**

| Exit

Decrease Front Float Air by 10% and check if sheets are floating correctly.

Sheets are floating correctly

N **Y**

| Exit

Decrease Separation Air by 10% and check if sheets are floating correctly.

Sheets are floating correctly

N **Y**

| Exit

Decrease Vacuum Air by 10% and check if sheets are floating correctly.

Sheets are floating correctly

N **Y**

| Exit

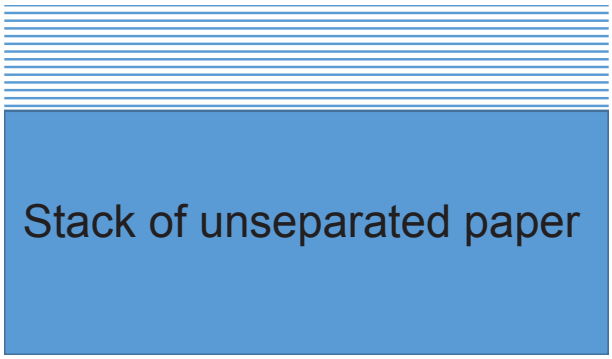
Decrease Rear Float Air by 10% and check if sheets are floating correctly.

Sheets are floating correctly

N **Y**

| Exit

Repeat the procedure until sheets float correctly.



If the VFX is set correctly, the sheets will be floating horizontally with equal amounts of separation between sheets.

- For 80 gsm paper approx 15-20 sheets shall be floating
- For 150 gsm paper approx 12 - 16 sheets shall be floating
- For 300 gsm approx 6-10 sheets shall be floating

Crease Side Trimmer (CST) fault codes

Code / message	Explanation / action
CST201 - CST210 Clear misfeed! **CST212** Clear misfeed! **CST220 - CST221** Clear misfeed! **CST230** Clear misfeed!	A misfeed has occurred in the CST module. See section 5, “Clearing Misfeed(s)” for how to clear misfeed(s). If feed errors occurs in the paper path or in the waste transport system, check for obstructions. See section 1, “Removing trim waste from trimmer blade area” for how to clear trimmer blade area from trim waste strips. If no obvious obstructions are found, see section 7, “REMARKS”, Maintaining Your Machine and clean the paper path.
CST211 Clear misfeed! **CST1005** Clear misfeed!	A misfeed has occurred in the CST module. See section 5, “Clearing Misfeed(s)” for how to clear misfeed(s). If feed errors occurs in the paper path or in the waste transport system, check for obstructions. See section 1, “Removing trim waste from trimmer blade area” for how to clear trimmer blade area from trim waste strips. If no obvious obstructions are found, see section 7, “REMARKS”, Maintaining Your Machine and clean the paper path. Change the type of media loaded from “fine“ to “coarse” or choose another type of media.

Booklet Maker (BM) fault codes

Code / message	Explanation / action
BM101 - Tray empty (Convenience Feeder)	Load paper in the Convenience Feeder.
BM102 - Misfeed (Convenience Feeder)	• Open the Convenience Feeder; • Clean the feed rollers (see “Cleaning Convenience Feeder Feed Rollers and Paper Separator Pad” in section 7 of this manual); • Repeat the “General paper stack preparation” procedure described in section 1 of this manual to make sure there is adequate separation among the sheets in the stack; • Reload the stack of paper into the Convenience Feeder; • From the UI, decrease the separation pressure; • From the UI, increase the feed pressure.
BM103 - Too thin (Convenience Feeder)	This fault code is generated if the DSD sensors detect a wrong paper thickness. • Make sure that the paper thickness loaded into the Convenience Feeder is correct, then run another proof (push the yellow button on the UI).

Code / message	Explanation / action
BM104 - Double feed (Convenience Feeder)	• Open the Convenience Feeder; • Clean the Separator Pad (see “Cleaning Convenience Feeder Feed Rollers and Paper Separator Pad” in section 7 of this manual); • Repeat the “General paper stack preparation” procedure described in section 1 of this manual to make sure there is adequate separation among the sheets in the stack; • Reload the stack of paper into the Convenience Feeder; • From the UI, increase the separation pressure; • From the UI, decrease the feed pressure.
BM105 - Too short sheet (Convenience Feeder)	Measure the actual length of the sheet and make sure it reflects the length entered in the UI.
BM106 - Too long sheet (Convenience Feeder)	• Measure the actual length of the sheet and make sure it reflects the length set in the UI. • Clean the feed rollers (see “Cleaning Convenience Feeder Feed Rollers and Paper Separator Pad” in section 7 of this manual).
BM107 - Jam (Convenience Feeder)	• Open the Convenience Feeder; • Remove misfed sheet(s); • Restart job.
BM201 - BM204 Misfeed	• Open the front door of the Booklet Maker; • Open the Feeder Transport; • Remove misfed sheet(s); • See section 7, “REMARKS”, Maintaining Your Machine and clean the paper path; • Restart job.
BM205 - Feeder Transport open	• Open the front door of the Booklet Maker; • Close the Feeder Transport.
BM206 - Double feed	• Open the Convenience Feeder; • Clean the Separator Pad (see “Cleaning Convenience Feeder Feed Rollers and Paper Separator Pad” in section 7 of this manual); • Repeat the “General paper stack preparation” procedure described in section 1 of this manual to make sure there is adequate separation among the sheets in the stack; • Reload the stack of paper into the Convenience Feeder; • From the UI, increase the separation pressure; • From the UI, decrease the feed pressure.
BM301 - **BM308** Misfeed (a paper parth sensor was covered for too long or it was not covered in time)	See section 7, “REMARKS”, Maintaining Your Machine and clean the paper path.

continued on next page

Booklet Maker (BM) fault codes (continued)

Code / message	Explanation / action
BM309 - Back Jogger Beam not in position	• Open the Top Cover of the Booklet Maker; • Set the Back Jogger Beam to place.
BM310 - M103 Side Jogger motor cannot reach position	• Open the Top Cover of the Booklet Maker; • Check the paper path and remove any obstruction.
BM311 - M102 Back Jogger motor cannot reach position	• Open the Top Cover of the Booklet Maker; • Check the paper path and remove any obstruction.
BM312 - M104 Staple Stop motor cannot reach position	• Open the Top Cover of the Booklet Maker; • Check the paper path and remove any obstruction.
BM406 - Paper set too thick	Paper stack is too thick and it is not within specifications. This can depend either on the thickness of the loaded media or on the number of sheets loaded in the machine. • Please see “set size guide” for more information about this matter.
BM407 - Paper set in compiler	• Open the Top Cover of the Booklet Maker; • Remove the set.
BM501 - Wire spool 1 empty	Replace spool 1 to continue production or disable stapling.
BM502 - Wire spool 2 empty	Replace spool 2 to continue production or disable stapling.
BM503 - Wire spool 3 empty	Replace spool 3 to continue production or disable stapling.
BM504 - Wire spool 4 empty	Replace spool 4 to continue production or disable stapling.
BM505 - Attention!	The paper size is not compatible with the stitching heads positions. • Deactivate or move the stitching heads or use another paper width.
BM601 - **BM602**- Sensor Q143 gives a wrong reading	See section 7, “REMARKS”, Maintaining Your Machine and clean the paper path.
BM603 - Paper Transport Baffle not in position	• Open the Top Cover of the Booklet Maker; • Set the Paper Transport Baffle back to place.
BM701 - **BM702**- Sensor Q131 gives a wrong reading	See section 7, “REMARKS”, Maintaining Your Machine and clean the paper path.
BM703 - Position not reached (M109 fold stop motor)	• Open the Door of the Finishing Module; • Clean any obstruction in the fold stop area.
BM704 - Position not reached (M110 skew motor)	• Open the Door of the Finishing Module; • Clean any obstruction in the fold stop area.

Finishing Module (FM) fault codes

Code / message	Explanation / action
FM901 - **FM902** Sensor Q189 gives a wrong reading	See section 7, “REMARKS”, Maintaining Your Machine and clean the paper path.
FM903 - FM904 Sensor Q181 gives a wrong reading	• See section 7, “REMARKS”, Maintaining Your Machine and clean the paper path. • Make sure that the pressure springs are set to upper position, where the pressure is equal to its highest value, see “Finishing Module” in section 7 of this manual.
FM905 Attention!	The operator has changed the square folding mode while running, therefore the Booklet Maker System cannot handle the squarefolding process while keeping the same processing speed. Restart the job to allow the upstream device to send the sets at the correct speed.
FM906 - FM907 Attention!	• Open the Top Cover of the Finishing Module; • Clean any obstruction in the squarefolding area.
FM1001 - FM1006 Misfeed	See section 7, “REMARKS”, Maintaining Your Machine and clean the paper path.
FM1008 Attention!	The operator has shortened the finished booklet length while running, therefore the Booklet Maker System cannot handle the cut process while keeping the same processing speed. Restart the job to allow the upstream device to send the sets at the correct speed.
FM1009 Attention!	• Open the Top Cover of the Finishing Module; • Clean any obstruction between the squarefolding area and the trimmer.
FM1101 Stacker full	Empty Stacker.
FM1102 Attention! Stacker Paper Stop Position faulty.	Move the Belt Stacker Stop Gate slightly in the sheet flow direction until you clear the error.
FM1103 Attention!	Adjust the Belt Stacker Stop Gate to the selected booklet size when high capacity mode is in use.
FM1104 Empty the stacker!	Empty the stacker: the booklet format has changed.
FM1105 Empty the stacker!	Empty the stacker: the squarefolding of the booklet has changed.
FM1106 Empty the stacker!	Empty the stacker.
FM1201 Trim waste bin full	Empty the trim waste bin.
FM1301 Corner/Edge stitching stacker full.	• Open the Door of the Finishing Module; • Empty stacker. *NOTE:* *Edge and corner stapling capability might not be available on all systems.*
FM1501 Waste transport jam/full!	Empty the waste transport

continued on next page

Finishing Module (FM) fault codes (continued)

Code / message	Explanation / action
FM9003 Malfunction **FM9009** Malfunction **FM9011** Malfunction **FM9012** Malfunction **FM10012** Malfunction **FM10014** Malfunction **FM10015** Malfunction **FM10017** Malfunction **FM15001** Malfunction	• Clean the system of any unfinished booklet / paper; • Power off / power on.

Stacker (ST) fault codes

Code / message	Explanation / action
ST101 Misfeed	Make sure that the Belt Stacker Stop Gate is set to the correct position if you are using high capacity mode, otherwise clean from paper/booklets.

2-Knife Side Trimmer (ST5000) fault codes

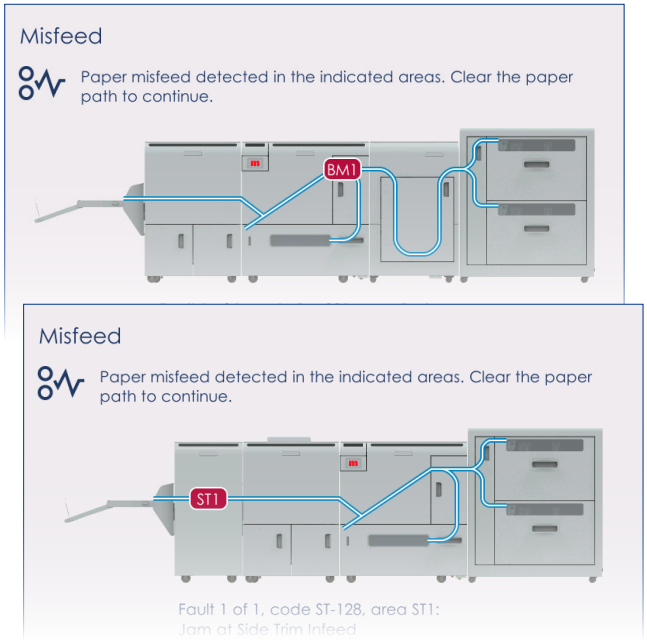
Code / message	Explanation / action
ST1128 - Jam at Side Trim Infeed **ST1129** - Jam at Side Trim Outfeed **ST1130** - Jam in Side Trim **ST1131** - Book Delivery too Fast	Open and then close the top cover of the side-trimmer. Then, if necessary, open the top cover of the side-trimmer and check for paper trimmings or obstructions. Close the top cover of the side-trimmer. If the message still does not clear, use the side-trimmer mains ON/OFF switch. Turn the side-trimmer OFF, wait at least 5 seconds and then turn the side-trimmer ON. If the problem continues, then call your service engineer.
ST1150 - Side Trim Offline (no comms)	Check that the mains power input cable and the communications cable are connected. Use the side-trimmer mains ON/OFF switch. Turn the side-trimmer OFF, wait at least 5 seconds and then turn the side-trimmer ON. If the problem continues, then call your service engineer.
ST1151 - Side Trim Cover open	The top cover of the side-trimmer is open. Close the top cover of the side-trimmer. If the message does not clear, open and then close the top cover of the side-trimmer. If the message still does not clear, use the side-trimmer mains ON/OFF switch. Turn the side-trimmer OFF, wait at least 5 seconds and then turn the side-trimmer ON. If the problem continues, then call your service engineer.
ST1153 - Check Side Trim Bin	The side-trim bin is either open or full. Check the side-trim bin. Empty the side-trim bin if necessary.

2-Knife Side Trimmer (ST5000) fault codes, continued

Code / message	Explanation / action
ST1154 - Side Trim Bin Full	The side-trim bin is full. Check the side-trim bin. Empty the side-trim bin if necessary.
ST1156 - Blade Positions Unsafe	Please check trim size does not conflict with staple positions in job. Open and then close the top cover of the side-trimmer.
ST1157 - Invalid Parameter	Invalid parameter detected. Open and then close the top cover of the side-trimmer.

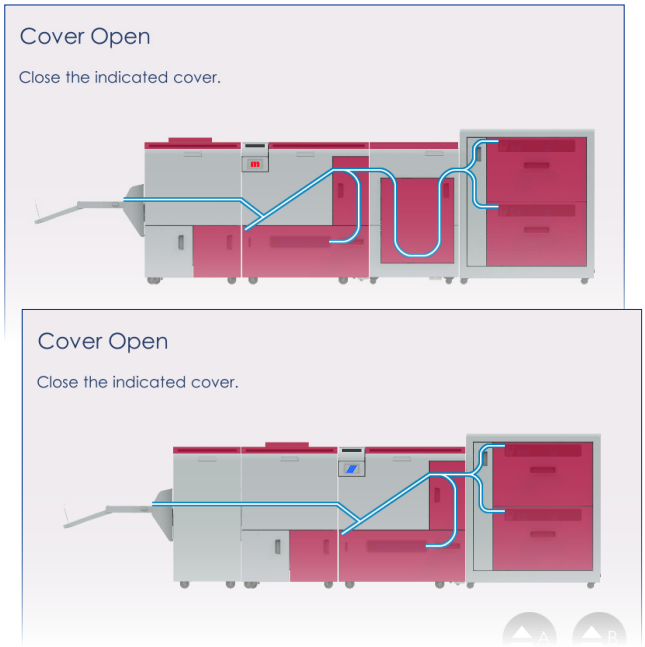
General fault codes

Clear Misfeed(s)



In general, fault codes indicate a misfeed condition. When a misfeed occurs, it is indicated visually where the misfeed occurred, by an error code and by a component description. See section 5, “Clearing Misfeeds”, for how to clear a misfeed.

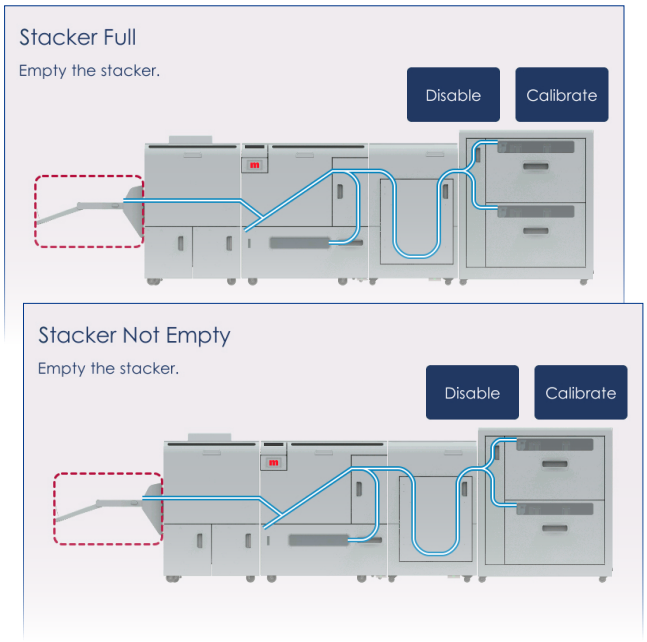
Close cover(s)



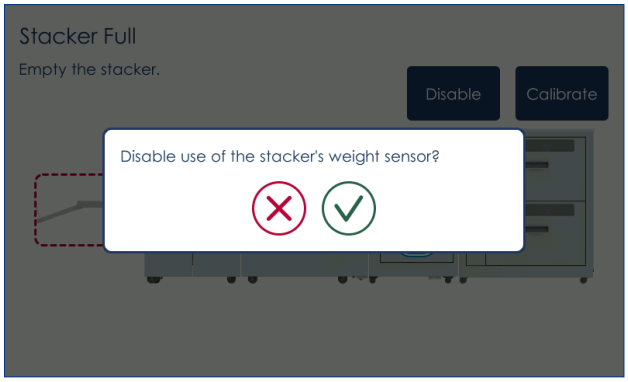
When the message “Cover Open” is displayed, it means that any of the interlock switches are actuated.
Check that the red marked top covers and doors are closed.

General fault codes, continued

Empty the stacker.

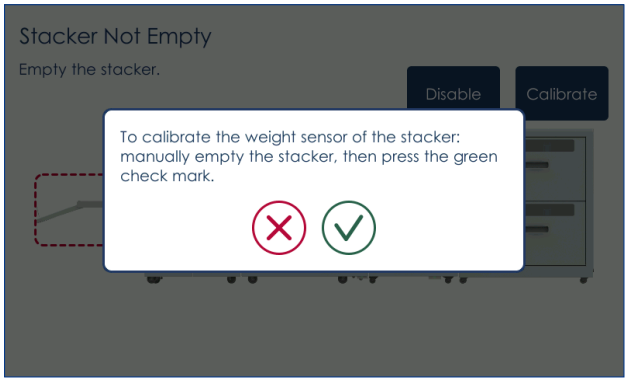


The action Empty the stacker will be displayed when the stacker is full or at start up if there are sets on the stacker. Empty the belt stacker to continue operation.



The Stacker Full message can be turned off. First press the [Disable] button, then confirm that the stacker weight sensor should be disabled by pressing the green check mark.

NOTE:
The weight sensor cannot be reenabled by an operator. To enable the weight sensor again, an authorized technician will be needed.



Should the Stacker Not Empty message be incorrect, the weight sensor might need to be calibrated. To do so, make sure that the stacker is empty and press the [Calibrate] button. Confirm by pressing the green check mark.

7. REMARKS

Do’s And Don’ts

- **Always** follow all warnings marked on, or supplied with, the equipment.
- **Always** exercise care in moving or relocating the equipment.
- ⚠ **CAUTION:**
  Unplug the power cord from the wall outlet and machine before you move or relocate the equipment.
- Do not remove the covers or guards that are fastened with screws.
- Do not override or bypass electrical or mechanical interlock devices.
- 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.
- ⚠ **WARNING:**
  Do not put fingers or other parts of the body between the upper and lower trimmer knives.
- Do not power off while the machine is running. Make sure the machine cycle has ended.
- Do not open covers while machine is running.
- Do not move machine while machine is running.
- Do not load the Belt Stacker more than what it is aimed for, max 20 kg / 44 lb.

Where to put Your Machine

Machine environment

- **Always** locate the equipment on a solid support surface with adequate strength for the weight of the machine.
- **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:

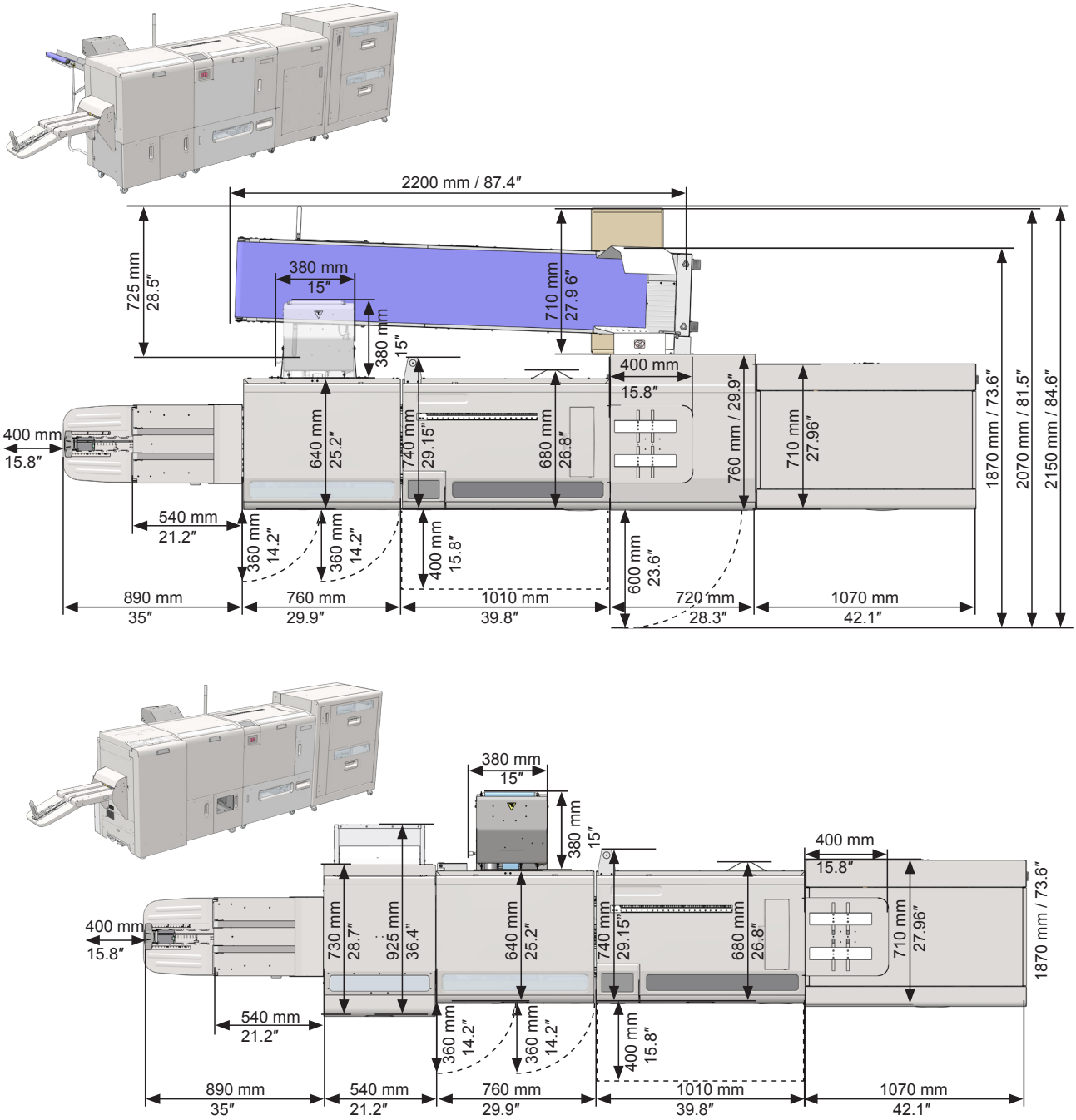
- Subjected to sudden temperature changes.
- Directly exposed to cool air from air-conditioner.
- Directly exposed to heat from heater.
- Directly exposed to sunlight.

Power connection

- **Always** connect the equipment to a properly grounded power source. If in doubt, have the power source checked by a qualified electrician.
- ⚠ **WARNING:**
  Improper grounding of the equipment can result in electrical shock.
- **Never** connect the machine to a power source that lacks a ground connection terminal.

Access to machine

Place the machine near the power source, providing clearance as shown.



BM5035/5050 Booklet Maker floor plan

Approximate floor space requirements / configuration

NOTE:
The 50 Sheet Upgrade Kit and the DSD Ultrasonic Upgrade Kit do 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″.

Maintaining Your Machines

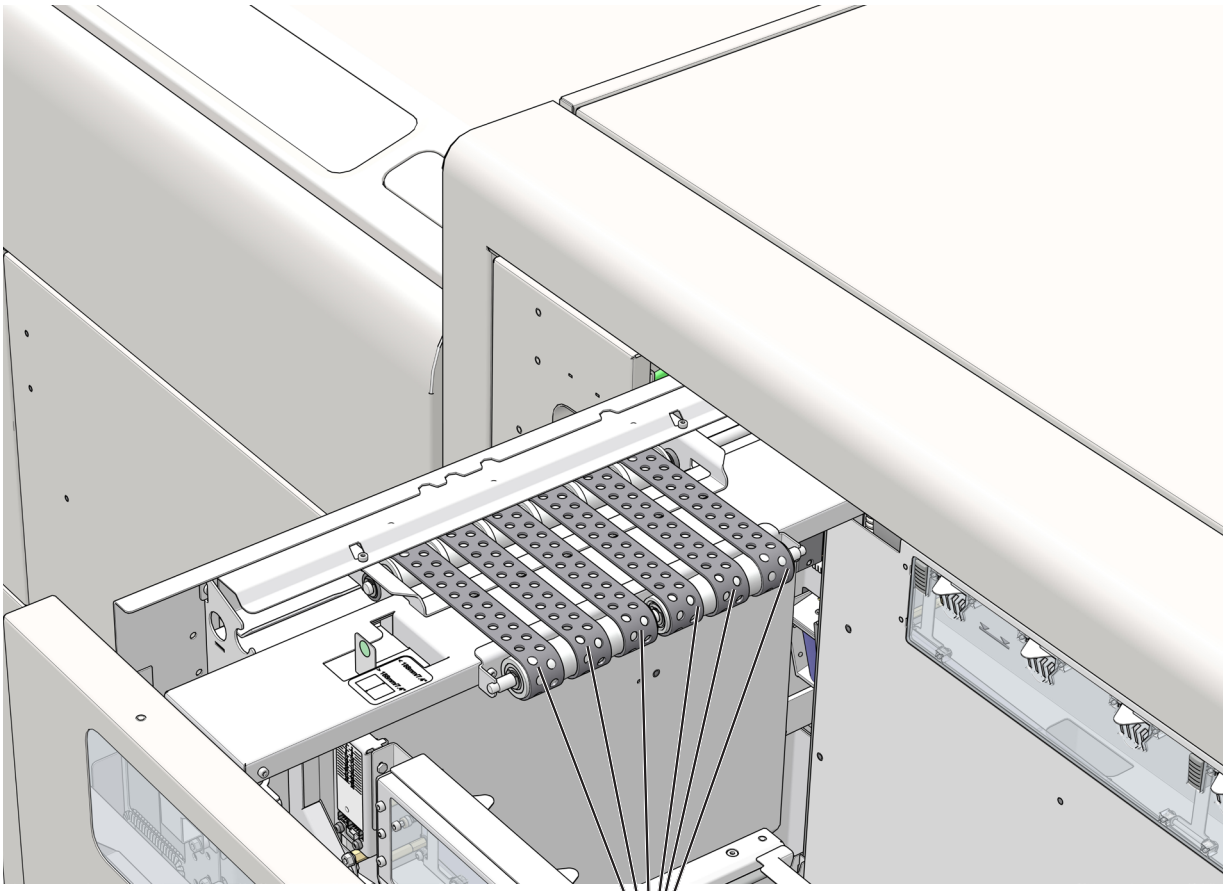
Never attempt any maintenance function that is not specifically described in this documentation.

VFX Vacuum Feeder

An increasing number of misfeeds may indicate a need to clean the VFX. Clean every 50 000 cycles or when the number of misfeeds increases. Use a vacuum cleaner, towels and brushes for general purpose cleaning of the paper path, bins, etc. In addition, follow the detailed cleaning instructions below:

Cleaning Suction Belts, DSD sensors and Checking Separator Pads

1. Open either Tray.
2. Clean the Suction Belts [A] with rubber reactivator alcohol.

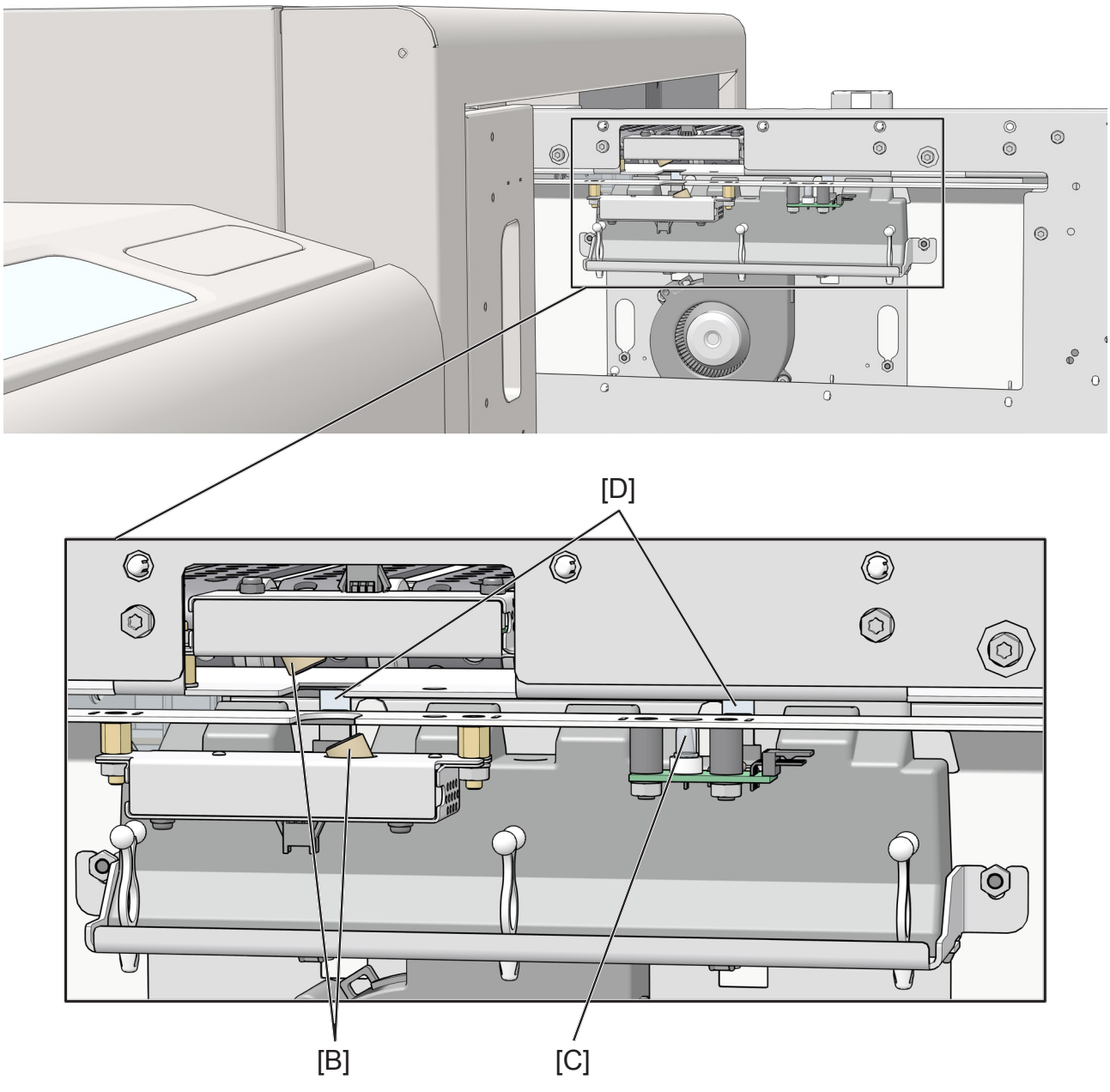


[A]

3 Remove dust from the Ultrasonic [B] and the Optical [C] Double Sheet Detector (DSD) sensors with a dry, soft cloth.

4 Check the Separator Pads [D] for wear, tear and position (refer to “Misfeed / Jam in Vacuum Trays when feeding thick media” in section 5 of this manual for how to measure the default position).
If the Separator Pads are worn (rounded edges/warped) or if broken, call for service to have them replaced.

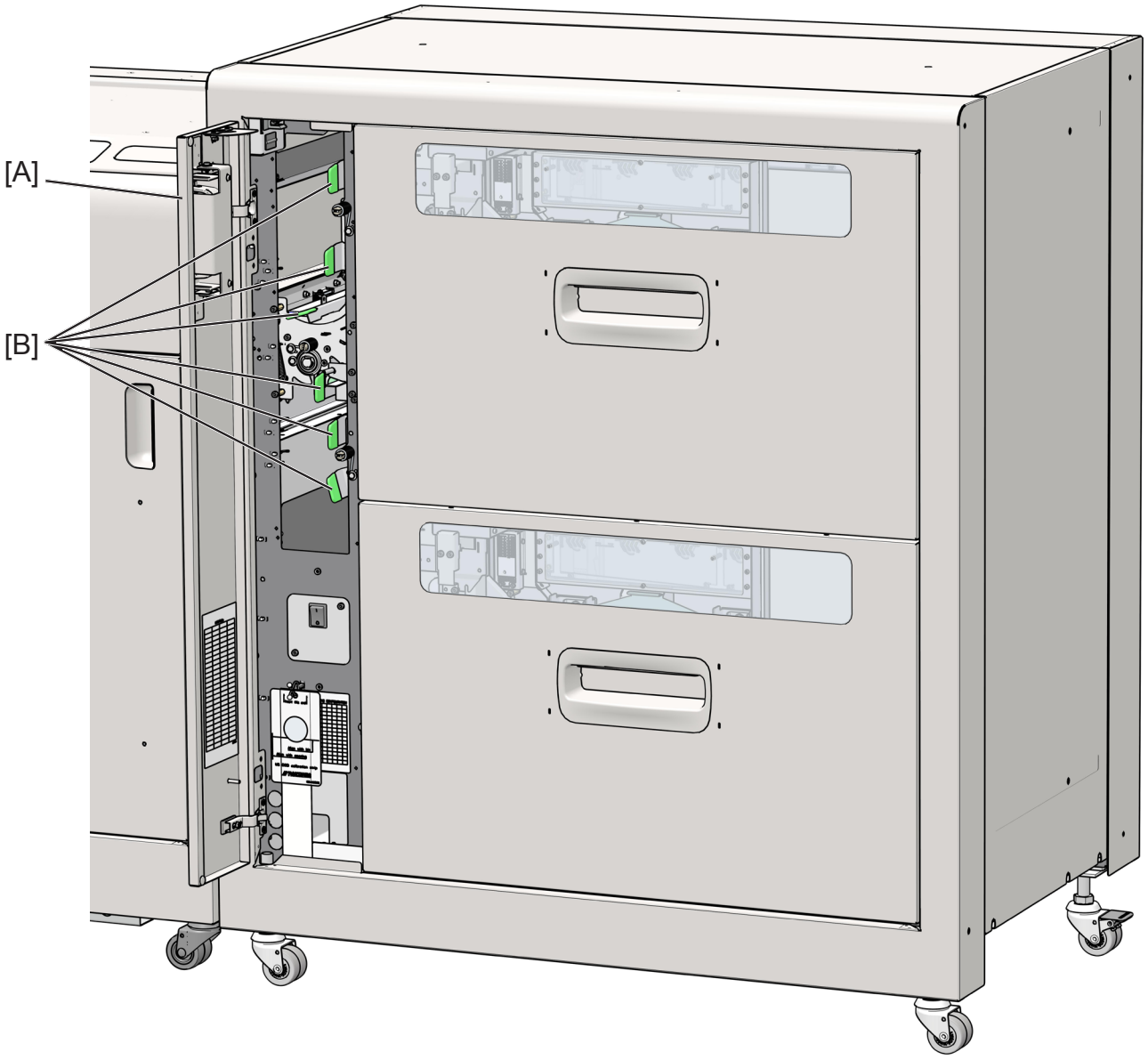
5 Close the Tray and repeat on the other Tray.



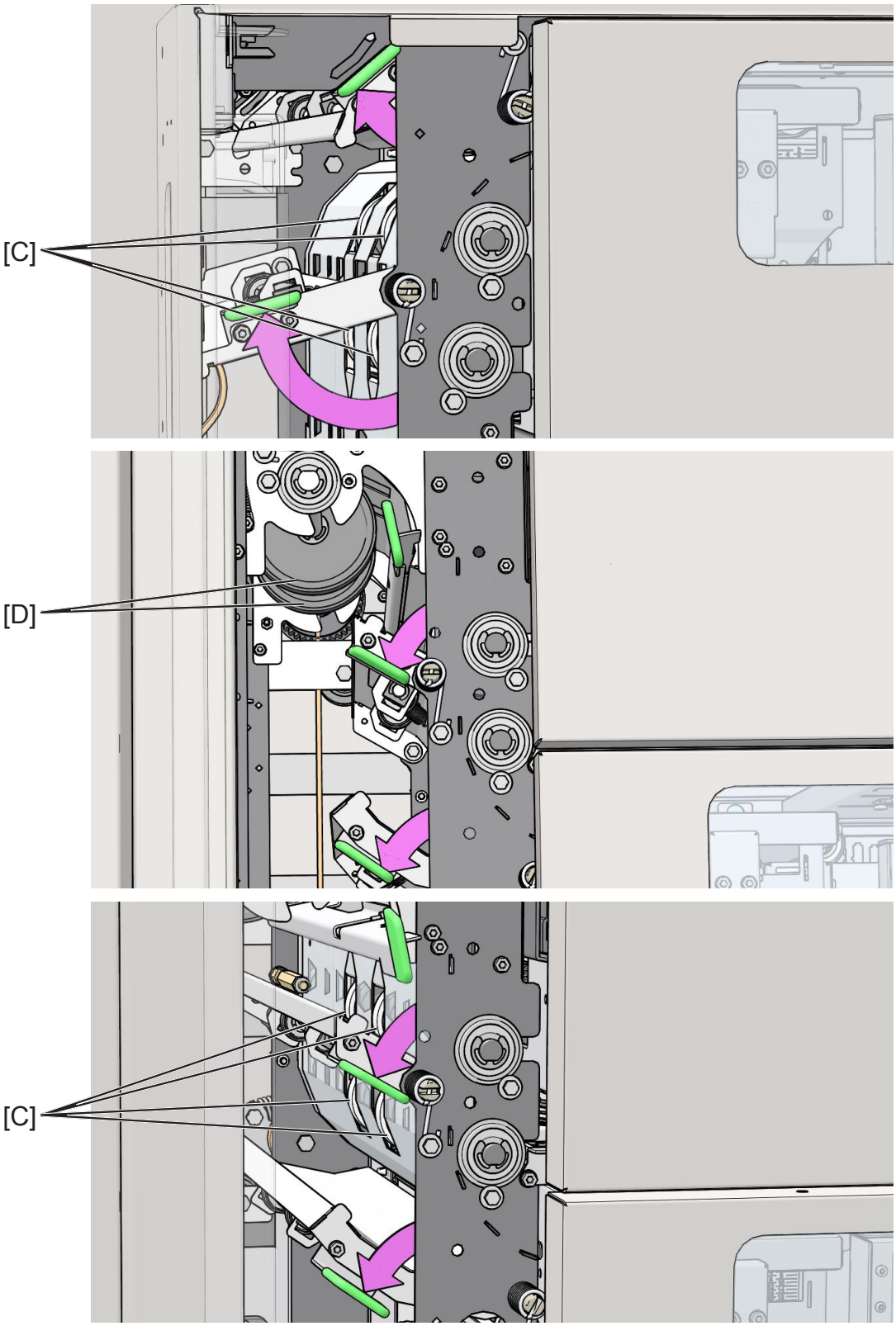
VFX Vacuum Feeder, continued

Cleaning the Baffles, Paper Chutes and Feed Rollers

1. Open the Door [A].
2. Move the green handles [B] to the Baffles and clean surfaces from toner smearings.



3 Clean, if needed, the Feed Rollers [C] inside the Baffles and the Infeed Wheels [D] with rubber reactivator alcohol.



NOTE:
Picture shows the VFX with its door transparent for clarity.

CST Module

The feed rollers and paper path need to be cleaned regularly when in use, and if the unit has not been used for a period of time. How often this should be done depends on the paper type and print quality.

An increasing number of misfeeds is an indication of the need to clean the feed roller, paper path and/or the sensors. Feed rollers and paper path are cleaned with the same cleaning agent used to clean digital printers and a lint free cloth. Sensors are wiped clean with a lint free cloth.

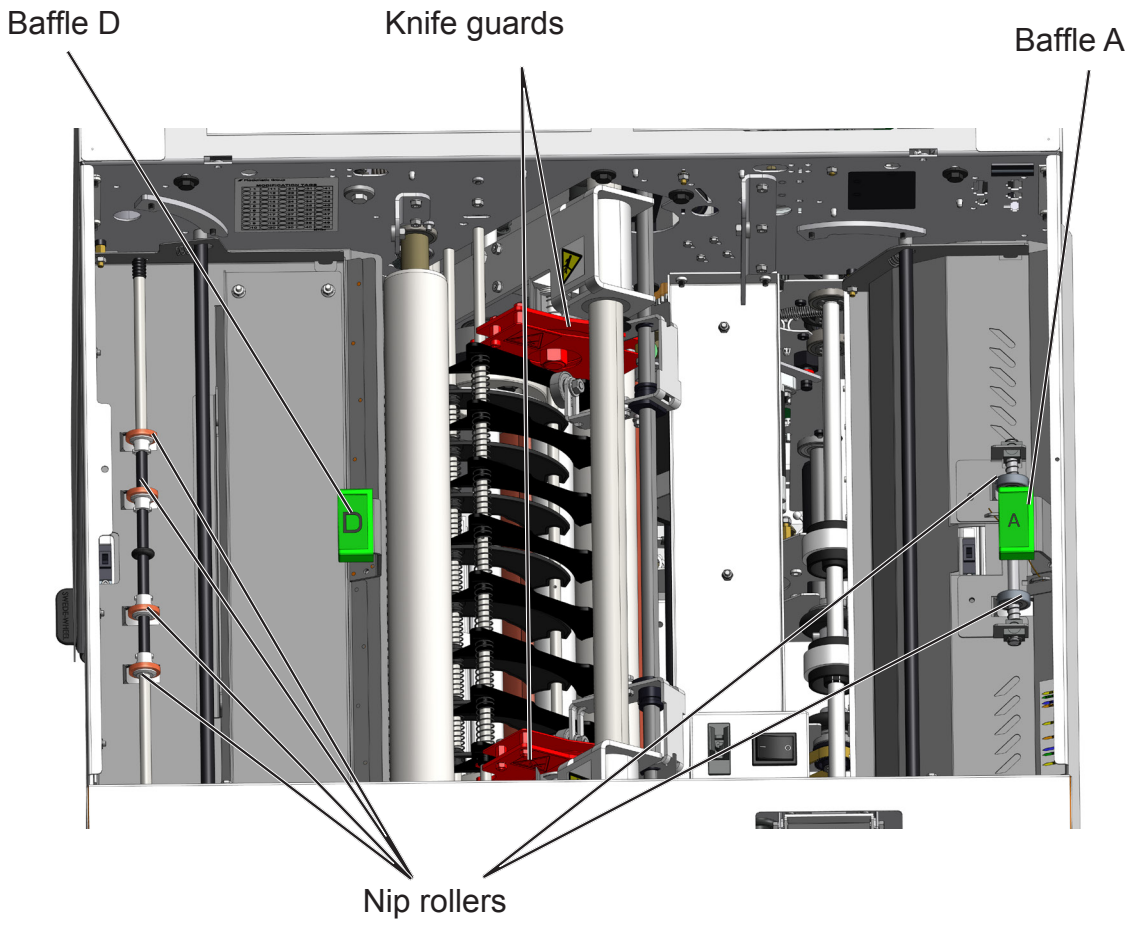
A problem with registration accuracy is often related to build up residual toner and paper dust.

⚠ **CAUTION:**
Never use any cleaning fluids on sensors.

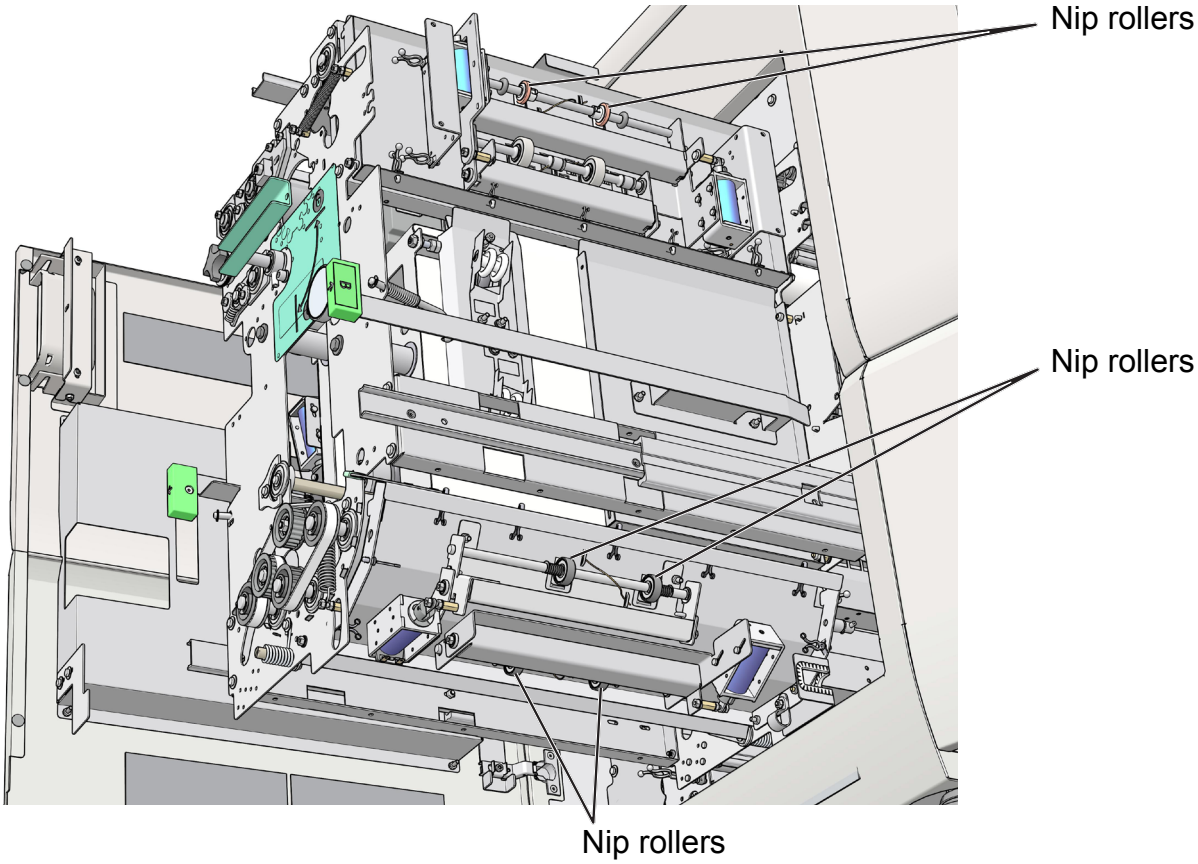
Cleaning the paper path transportation nip rollers (x12)

Also clean the idler rollers

⚠ **WARNING:**
Do not put your fingers inside the knife guards. Doing so may result in injury.



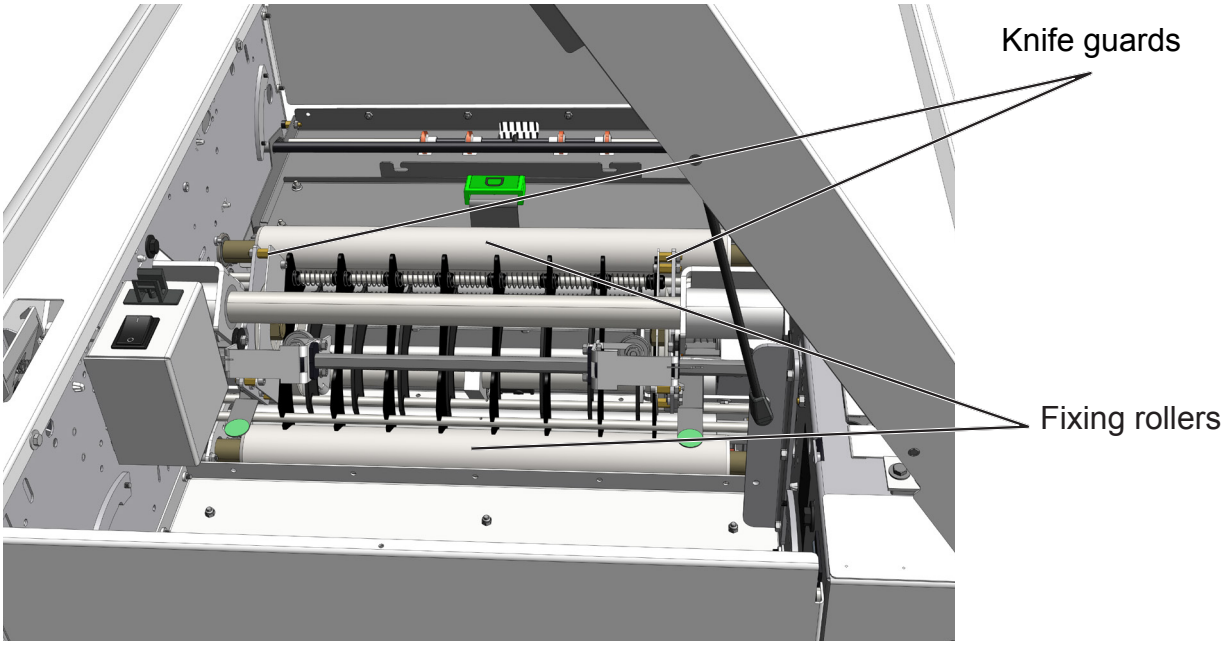
Cleaning the paper path transportation nip rollers (x12) continued



Cleaning the fixing rollers (x3)

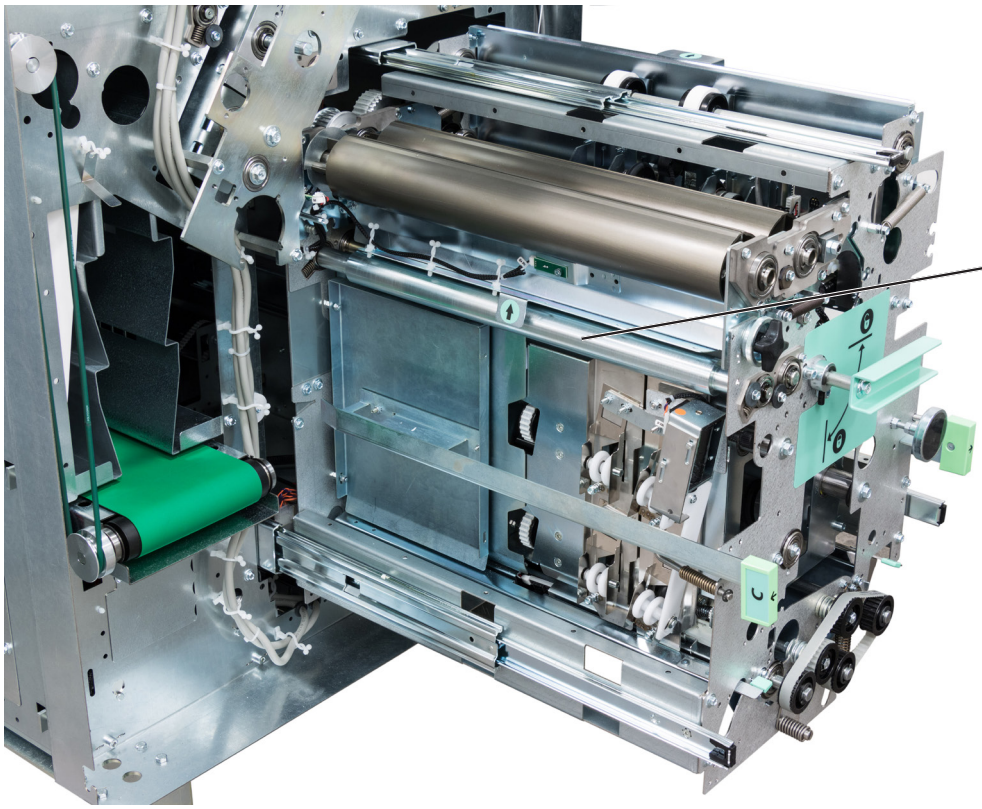
Also clean the idling rollers

⚠ **WARNING:**
Do not place your fingers inside the knife guards. Doing so may result in injury.

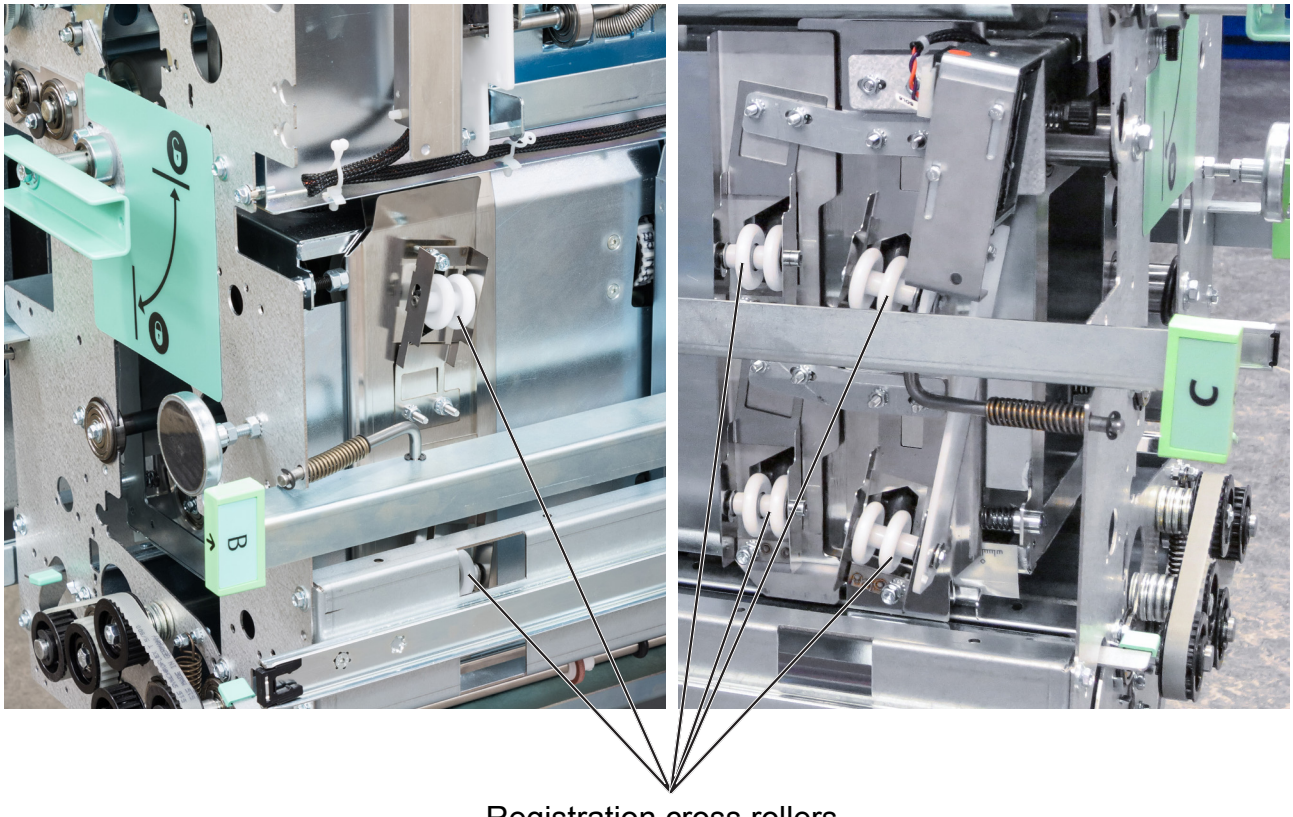


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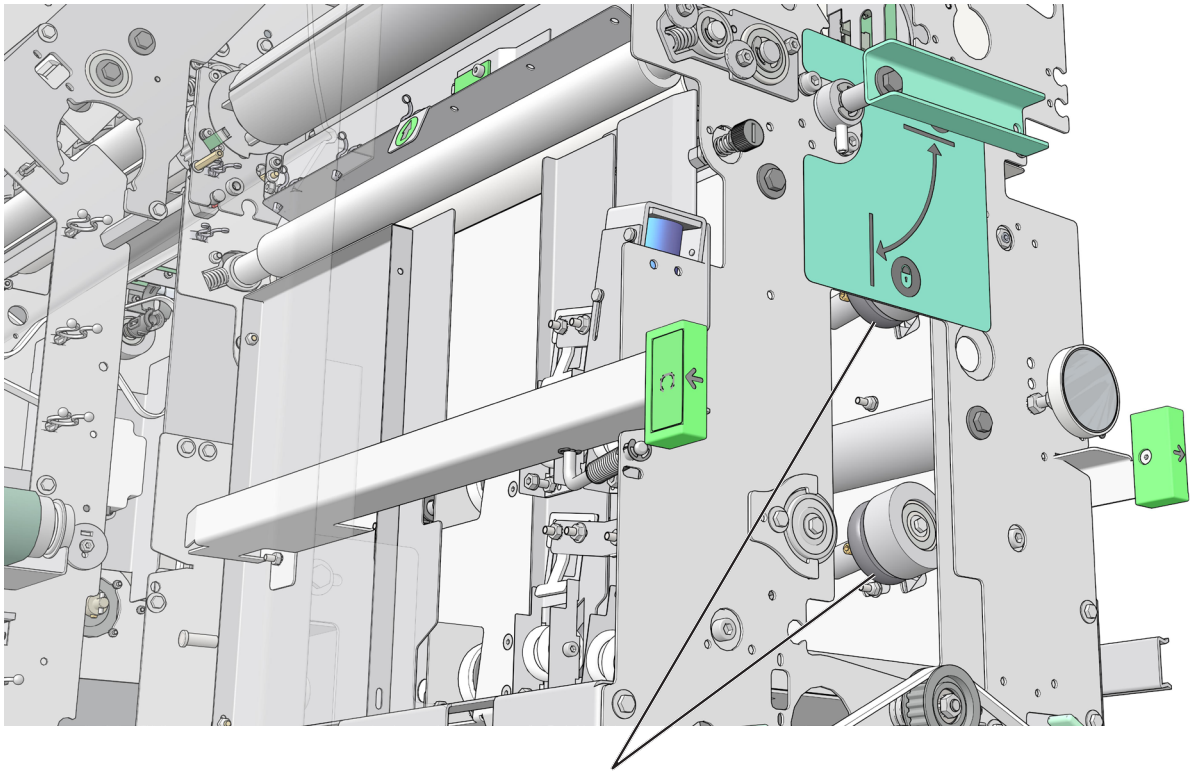
Cleaning the fixing rollers (x3) continued

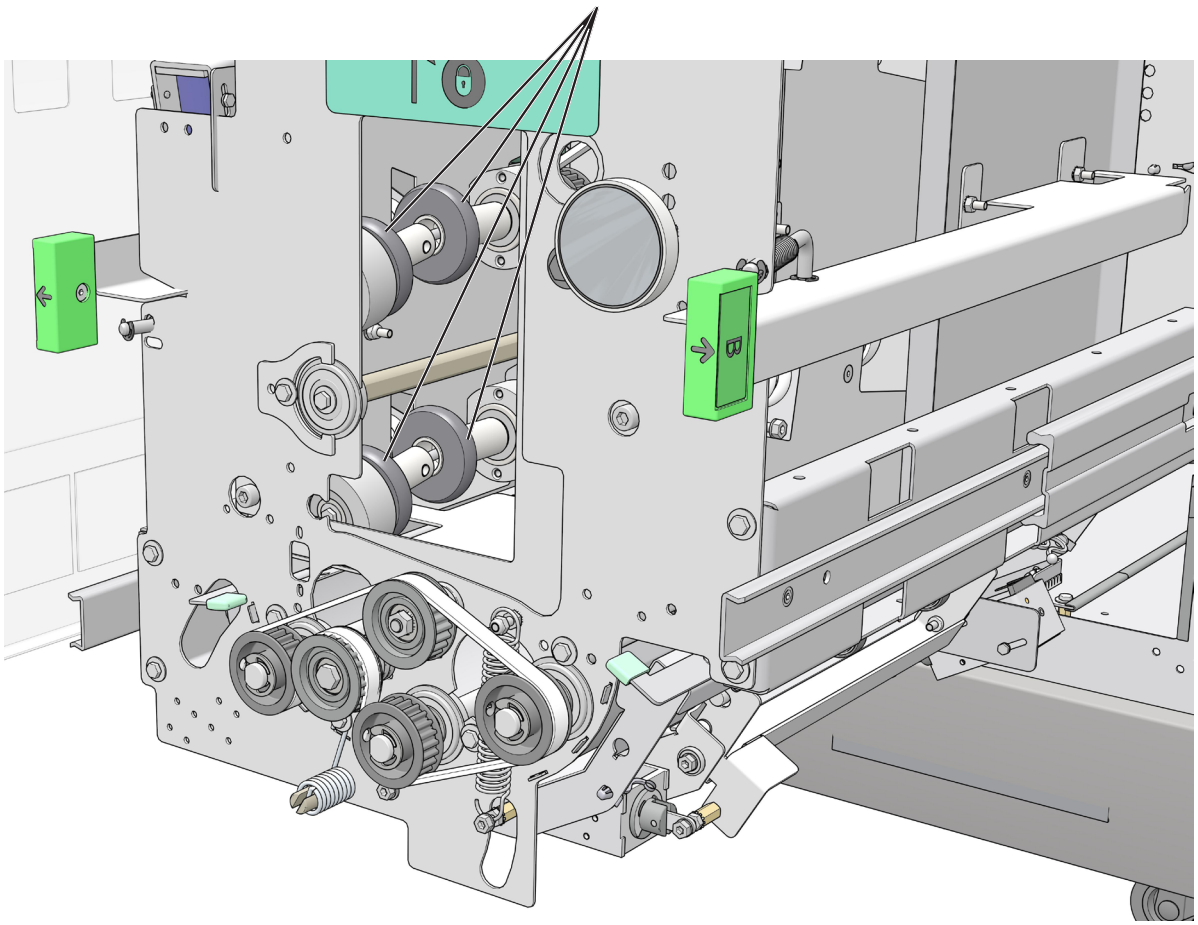


Cleaning the registration cross rollers (x6) & friction tires (x6)



Cleaning the registration cross rollers (x6) & friction tires (x6) continued





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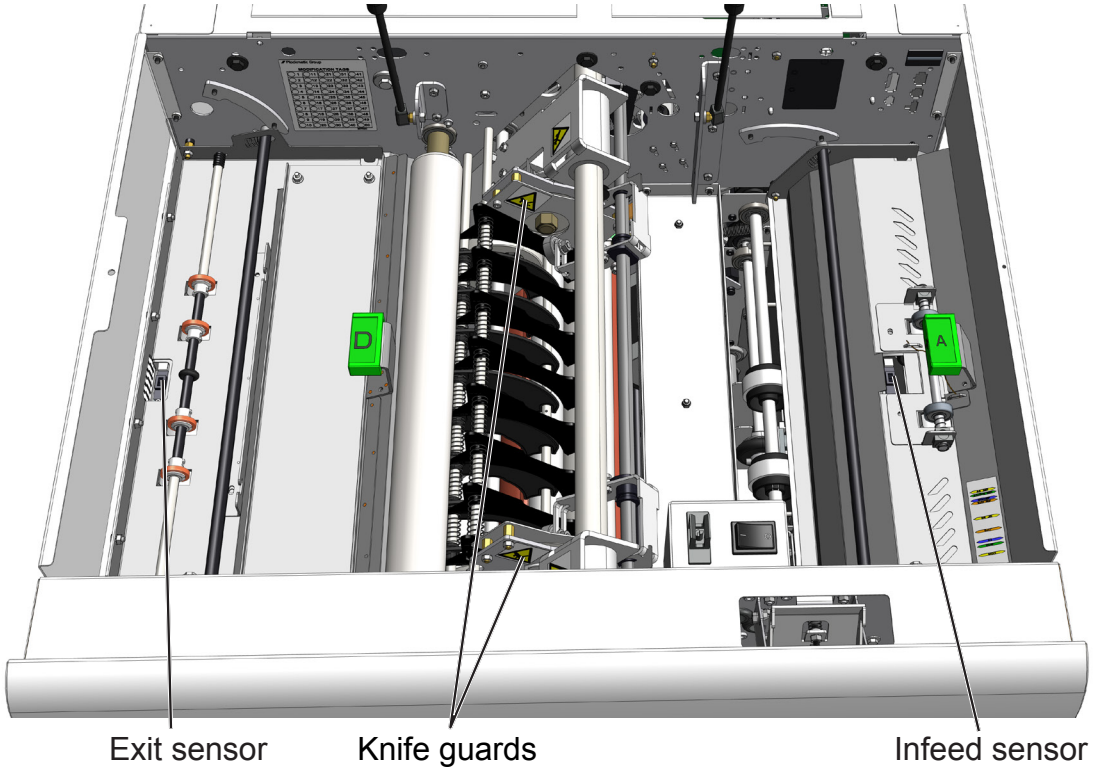
Cleaning the rotator rollers (x2)

Also clean the idler rollers



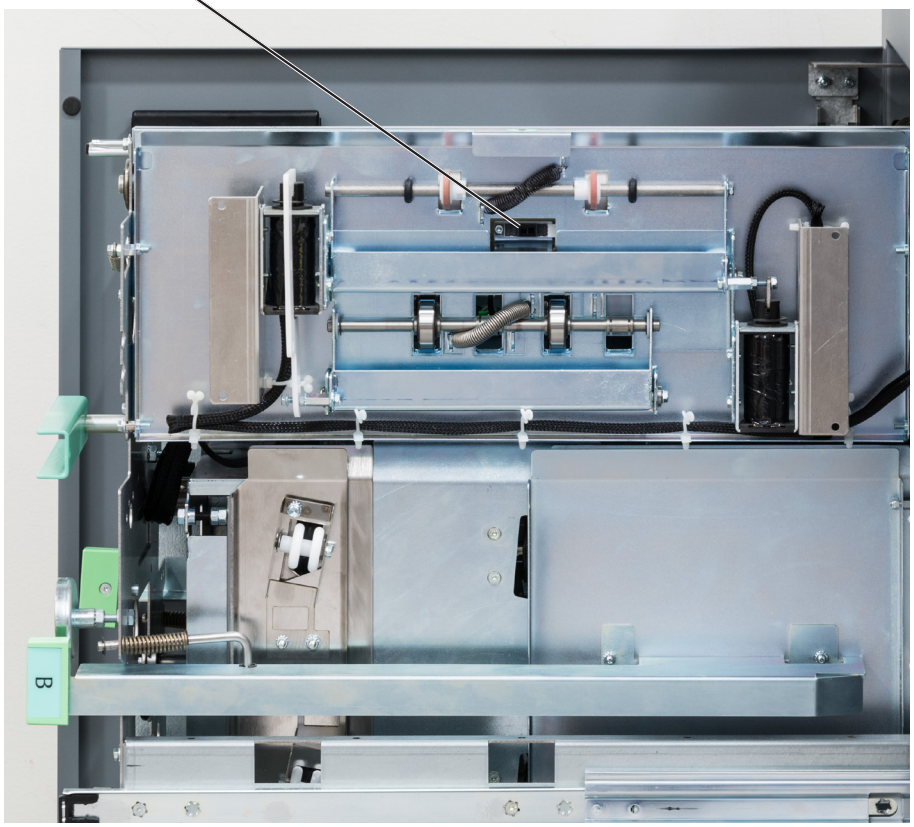
Cleaning the paper path sensors (x5)

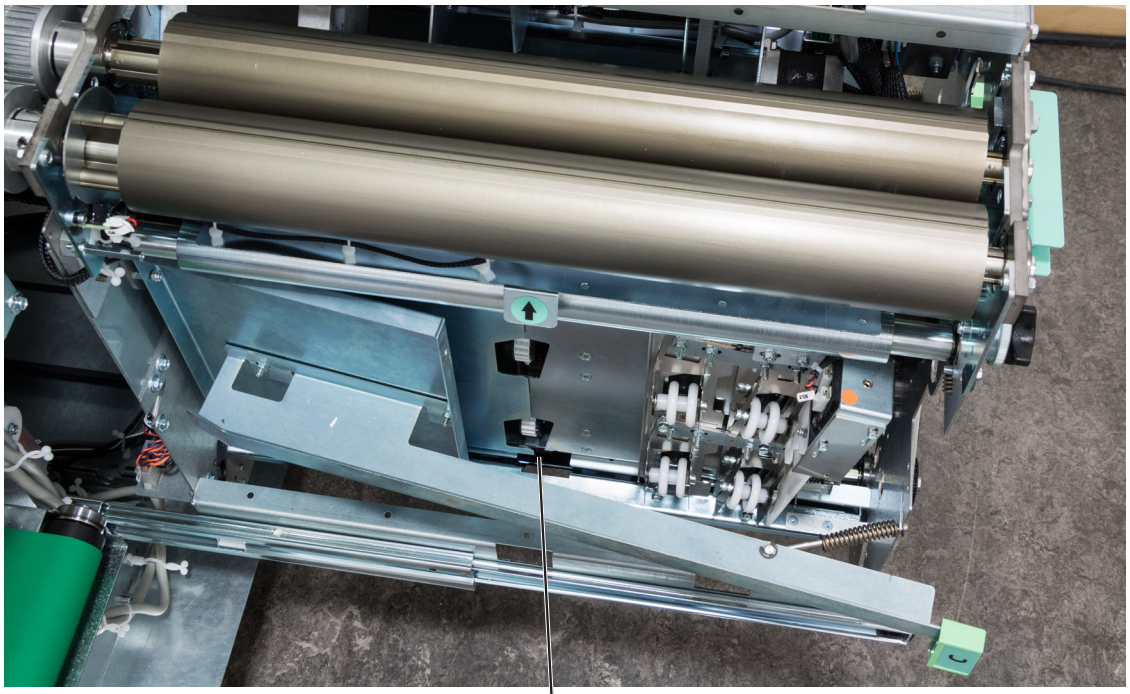
⚠ **WARNING:**
Do not put your fingers inside the knife guards. Doing so may result in injury.



Cleaning the paper path sensors (x5) continued

Rotator sensor

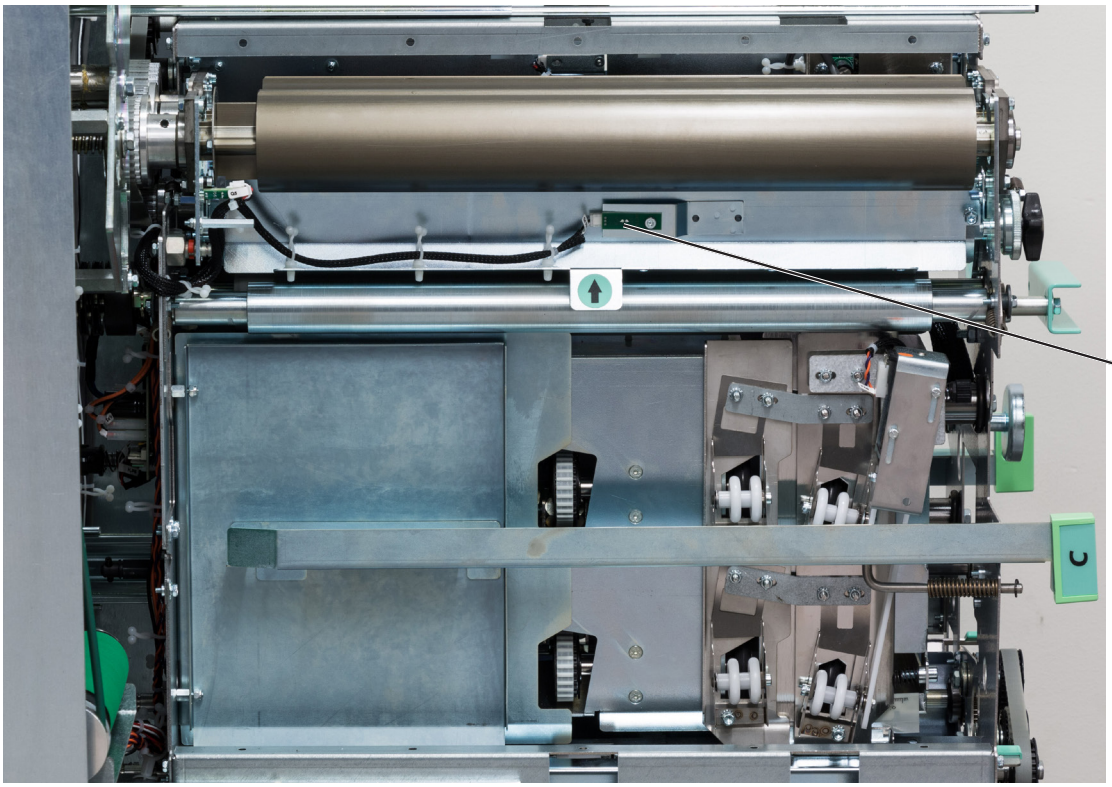




Registration sensor

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Cleaning the paper path sensors (x5) continued



Cleaning of creaser tools (x2)

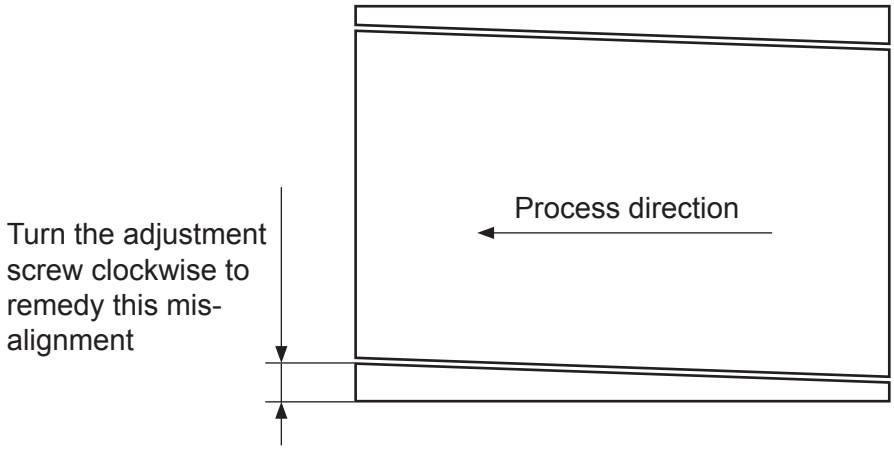
After a period of time toner and paper dust may leave residuals in the grooves of the tool. These grooves must be cleaned periodically to maintain creasing performance.



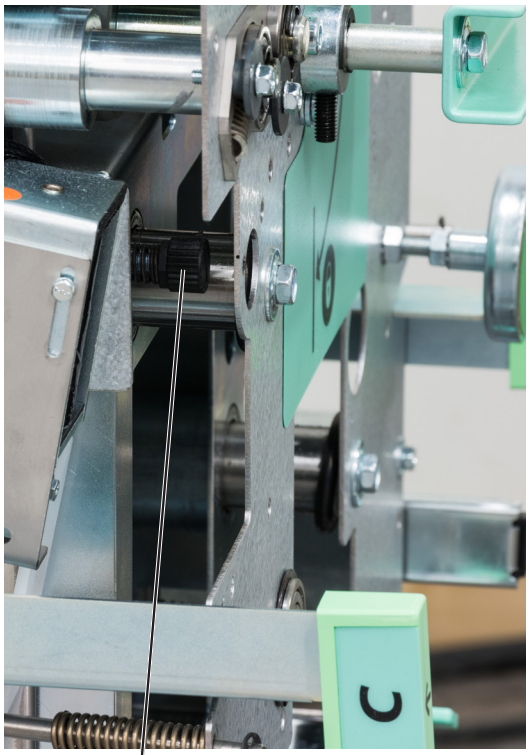
Adjustment of Side Trimmer registration angle (parallel cut)

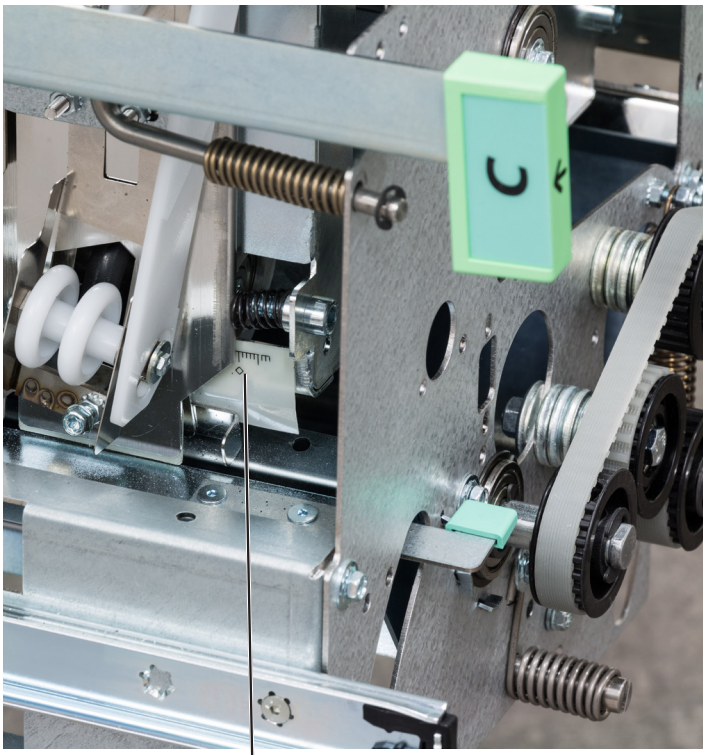
Adjustment of Side Trimmer registration angle (trimmer cut parallel to registration (operator side) edge)

1 Turn adjustment screw [A] in desired direction. Change in adjustment is reflected on the reference scale [B].



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



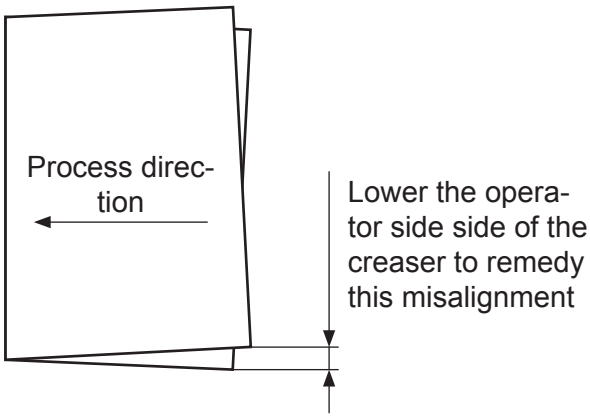


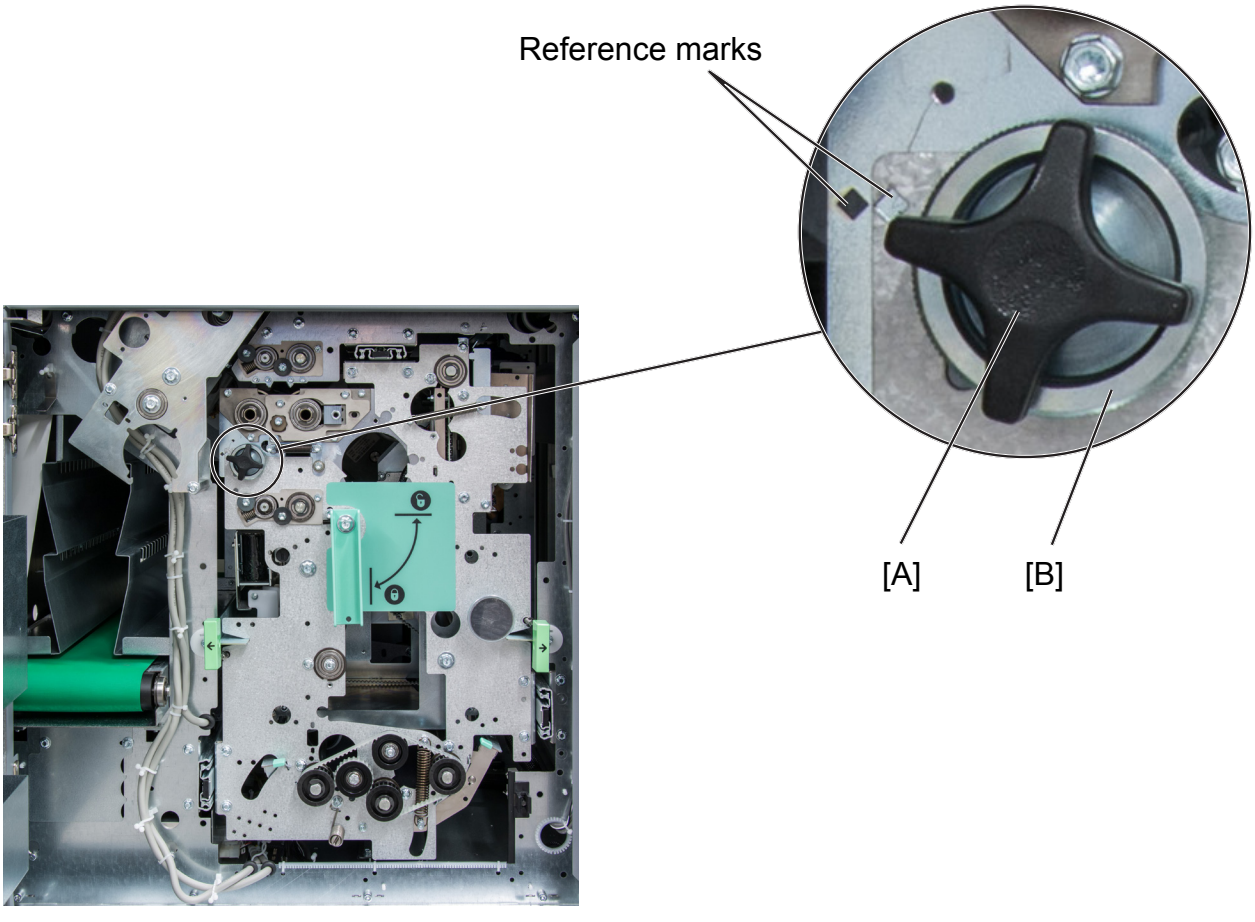
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Adjustment of Creaser registration angle

Adjustment of Creaser registration angle

1. Loosen the star shaped knob [A].
2. Turn the knurled eccentric adjuster [B] to move reference mark in the desired direction.
3. Tighten the star shaped knob [A] again.



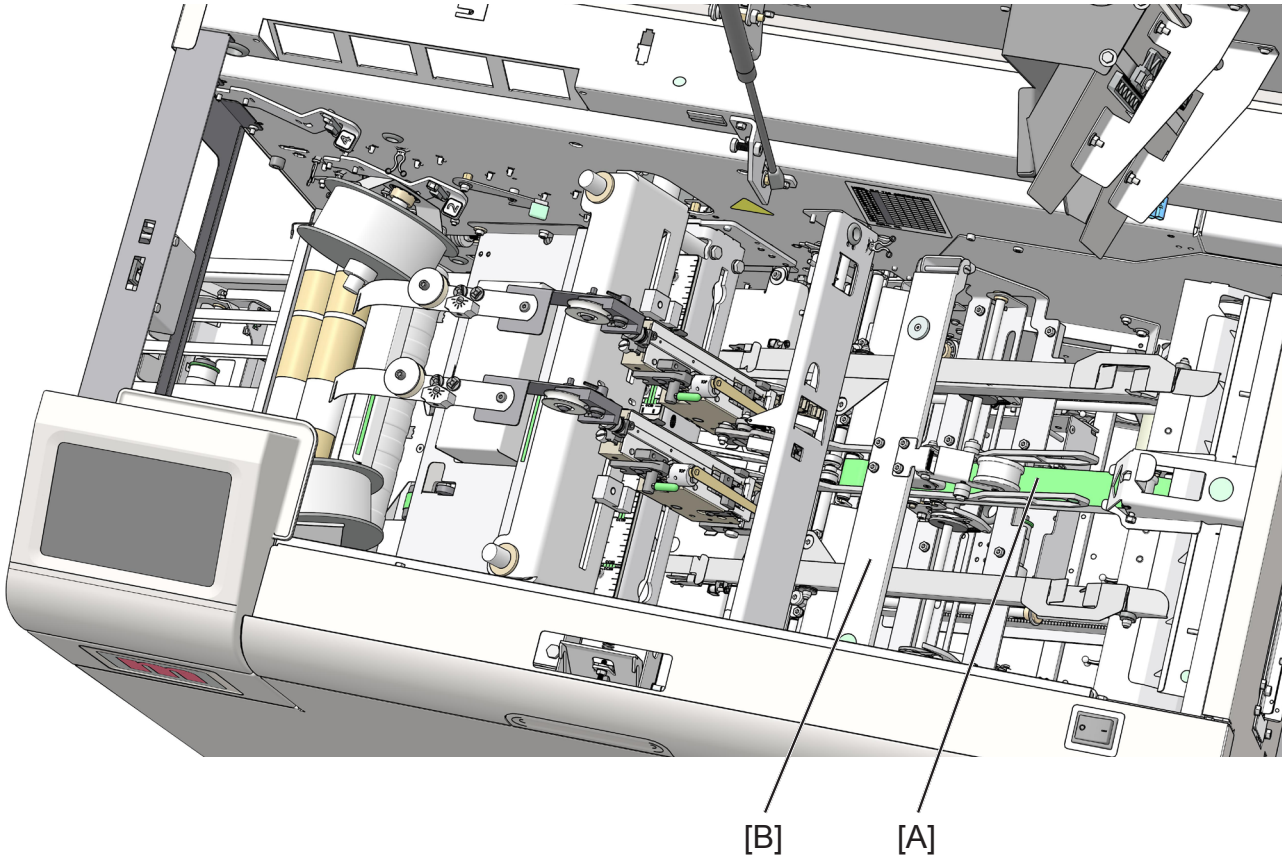


Booklet Maker

Cleaning the Booklet Maker Transport Belt

The Booklet Maker Transport belt need to be cleaned regularly when in use. How often this should be done depends on the paper type and print quality.
An increasing number of misfeeds is an indication of the need to clean the Transport belt.
Clean the Transport belt with water and a lint free cloth.

1. Open the Booklet Maker Top Cover.
2. Clean the Transport Belt [A]. The Feed Belt can easily be rotated in either direction.
3. Lifting the Back Jogger Beam [B] facilitates cleaning of the Feed Belt
4. Close the Booklet Maker Top Cover.

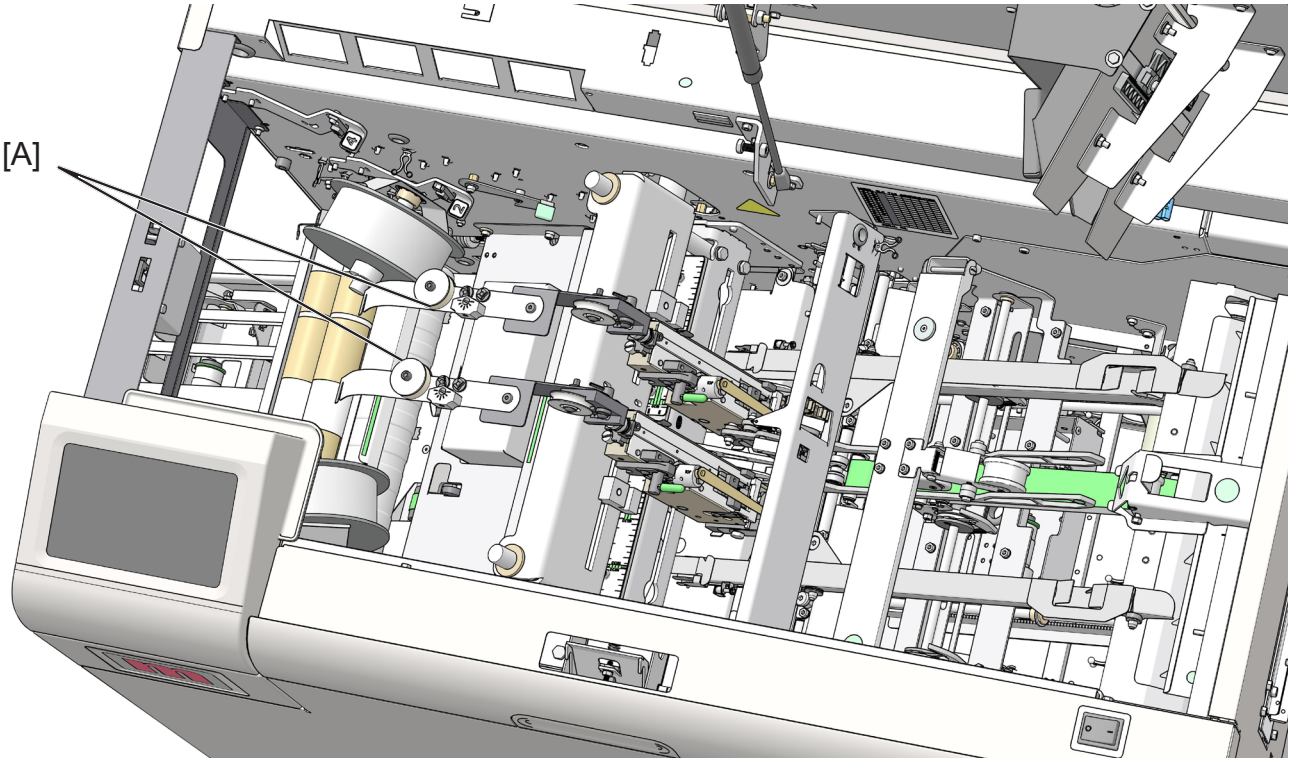


Booklet Maker, continued

Dampening the Felt Pads

The Felt Pads [A] should be dampened with oil so that the Stitching Wire can pick up oil when it is pulled throught the Pads before the Wire enters the Stitching Heads.
Dampen the Felt Pads [A] with a couple of drops of SAE 20W oil every 10 000 staples.

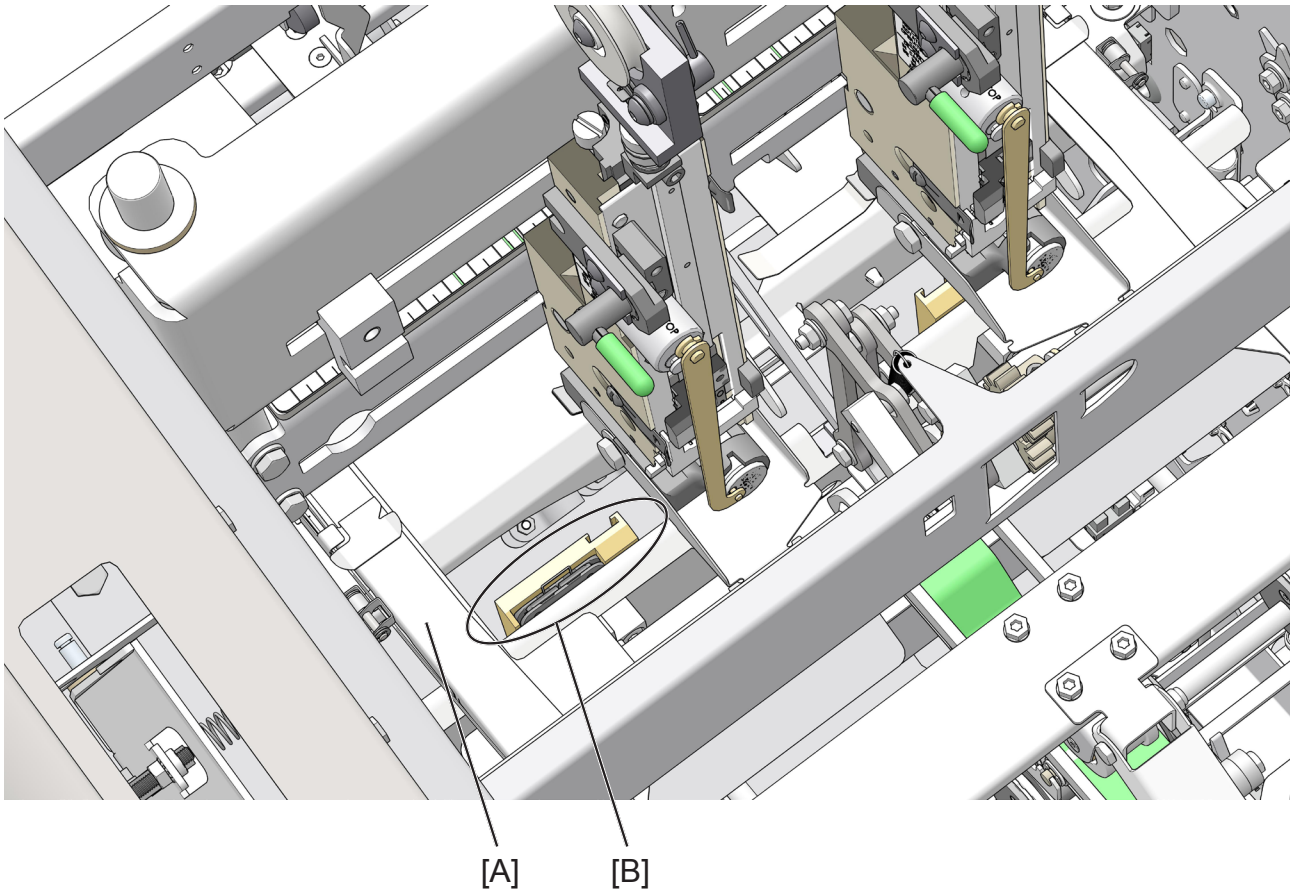
1. Open the Front Door and obtain the Oil Can stored inside the Door.
2. Open the Booklet Maker Top Cover.
3. Separate the Felt Pads [A] so you access the area where the Stitching Wire runs. Dampen with a couple (3–5) drops of oil. A completely new pad may need 30–40 drops.
4. Close the Booklet Maker Top Cover.
5. Put the Oil Can back in its storage inside the Front Door.
6. Close the Front Door.



Cleaning Clincher area

Grey marks around the staple area in the center of the booklet may be caused by metal dust from the staple. If the marks are caused by dirt deposits or metal dust on the clinchers, these marks can be reduced by operator cleaning or wiping clinch area with a clean rag. For high production environments (over 20k books/month) it is recommended that this is done once a week.

1. Open the Booklet Maker Top Cover.
2. To access the actual Clincher(s) area, Stitching Head(s) and Clincher(s) cannot remain aligned. Move either of them aside. See Section 1, “Basics”.
3. When needed, move Side Guides [A] aside for better access.
4. Wipe the Clincher area [B] with a clean rag.
5. After cleaning, make sure actual Stitching Head(s) are mechanically engaged and aligned with the corresponding Clincher(s). See Section 1, “Basics”.
6. Close the Booklet Maker Top Cover.

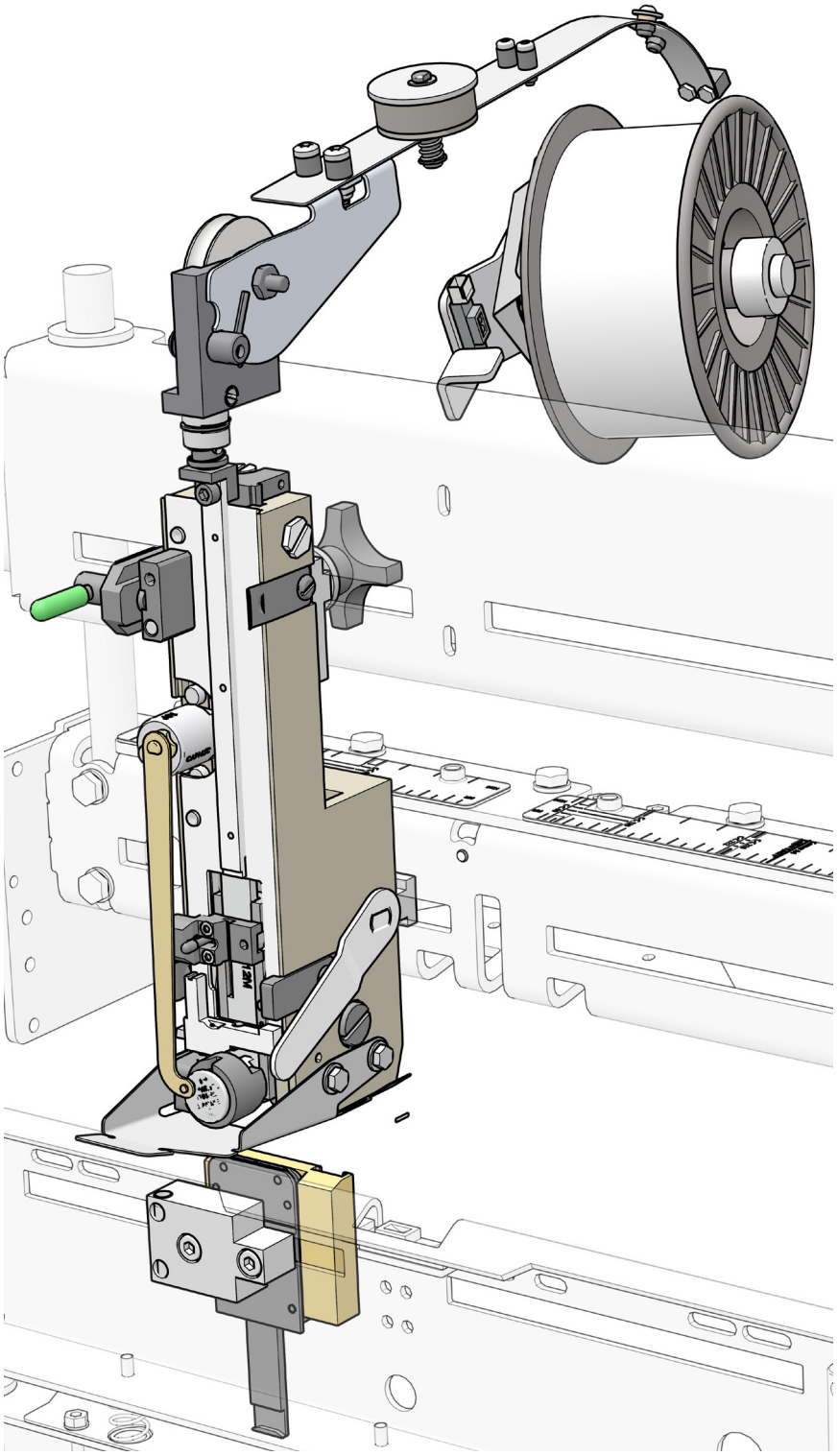


Booklet Maker, continued

Stitching Heads

The Stitching heads have to be serviced every 500k stitches or 12 months of use: make sure to request service when necessary.

NOTE:
Oil stains in the form of 2 or 4 small dots (where the 2 or 4 stitching heads are) might be seen on the first booklets after oiling/replacing the stitching heads.

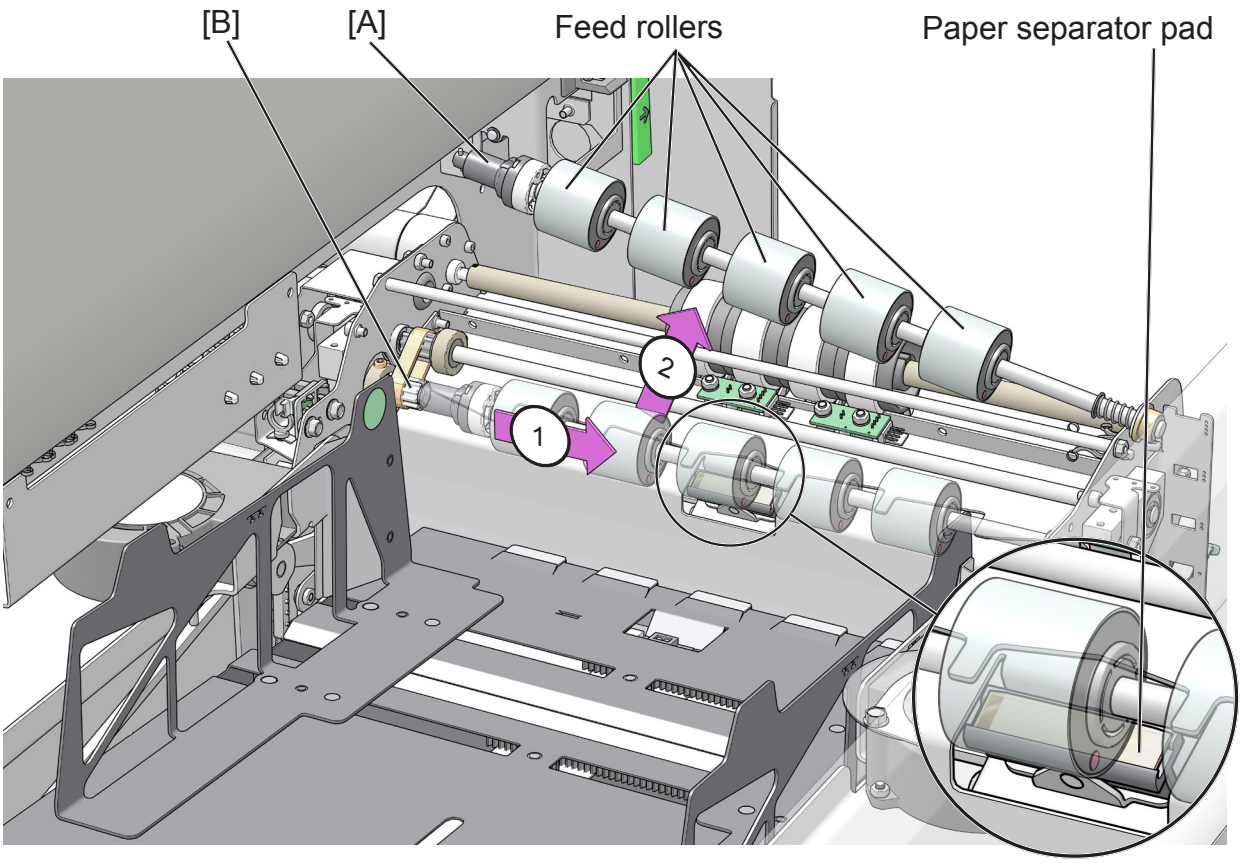


Cleaning Convenience Feeder

The Feed rollers and the paper separator pad need to be cleaned regularly when in use, and if the unit has not been used for a period of time. How often this should be done, depends on the paper type and print quality.
An increasing number of misfeeds, or double feeds, is an indication of the need to clean the Feed Rollers.

1. Open the Convenience Feeder and remove sheets from the bin.
2. Remove the feed roller assembly [A] by pressing it to the front of unit (1). The non operator side end of the feed roller assembly will now be released from the pulley [B] and the assembly can be lifted and removed (2).
3. Clean the Feed rollers and the Paper separator pad with water and a clean lint free cloth.
4. Reverse the removal procedure to install the feed roller. Lift the pulley [B] fo facilitate installation.

Regularly clean the Convenience Feeder from paper dust (every 100k books or less if necessary).



Finishing Module

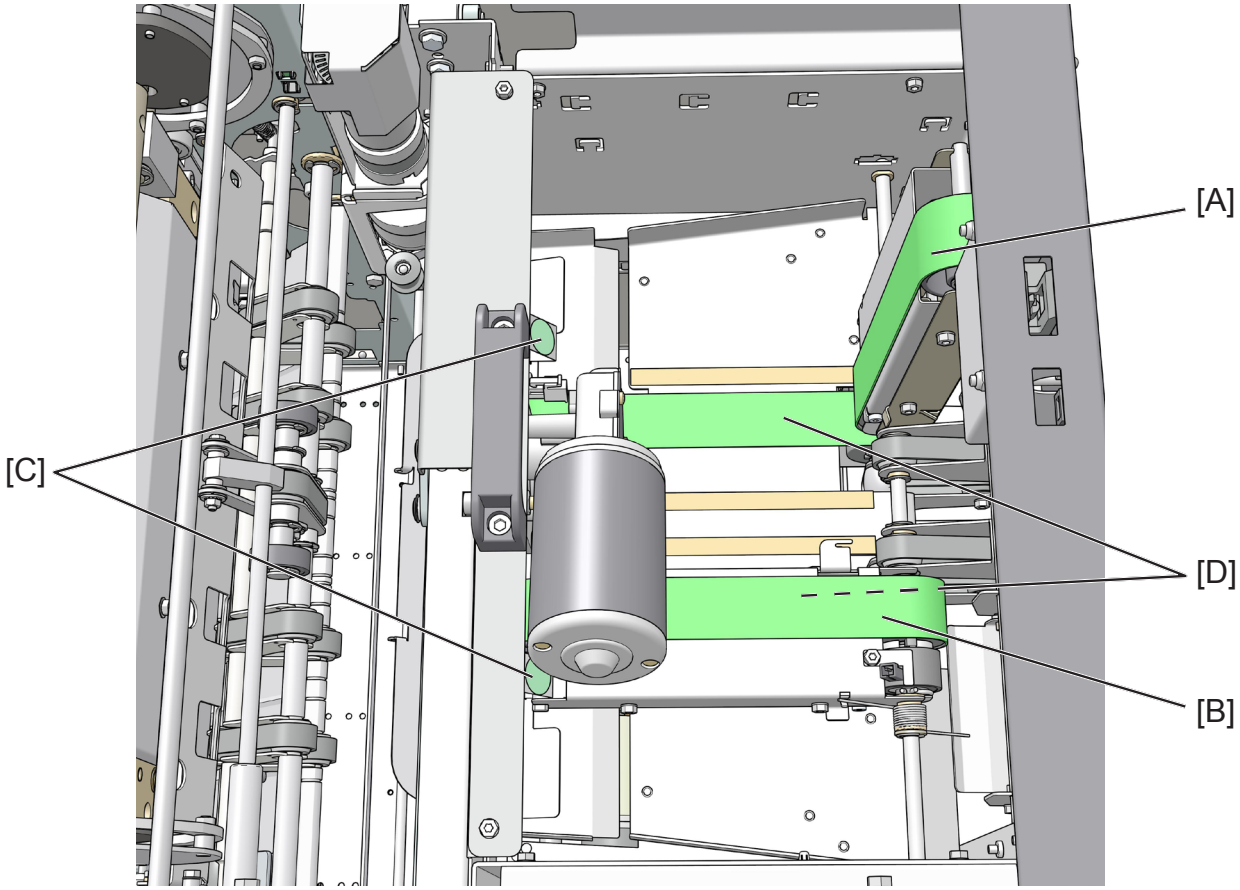
Cleaning SquareFold Feed Belts

The SquareFold Feed belts need to be cleaned regularly when in use. How often this should be done depends on the paper type and print quality.
An increasing number of misfeeds is an indication of the need to clean the feed belts.
Clean the feed belts with water and a lint free cloth.

1. Open the Finishing Module top cover.
2. Clean the upper feed belts [A] and [B]. The upper feed belts can easily be rotated in either direction.
3. Press the green dots on the release latches [C], and lift up the upper feed belts [A] and [B] to access the lower feed belts [D].

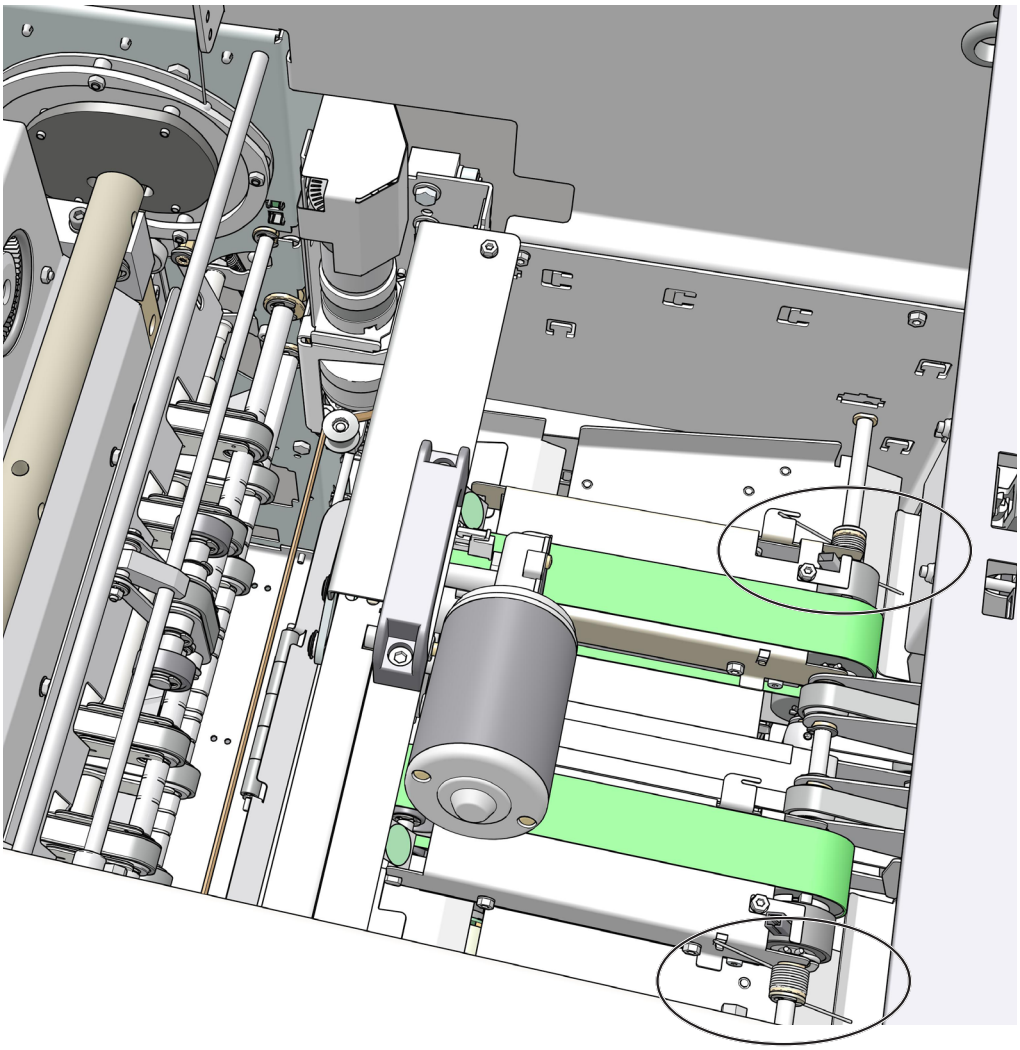
NOTE:
The upper feed belt [B] on the operator side cannot be lifted fully.

4. Clean the lower feed belts [D]. Rotate the lower feed belts towards the Trimmer for complete cleaning.
5. Place the upper feed belts in normal position.
6. Close the Finishing Module top cover.



SquareFold Pressure springs

If feed errors occur, check that the pressure on the upper feed belts is set to the default position. The pressure springs should always be at its upper position where the pressure is equal to its highest value.

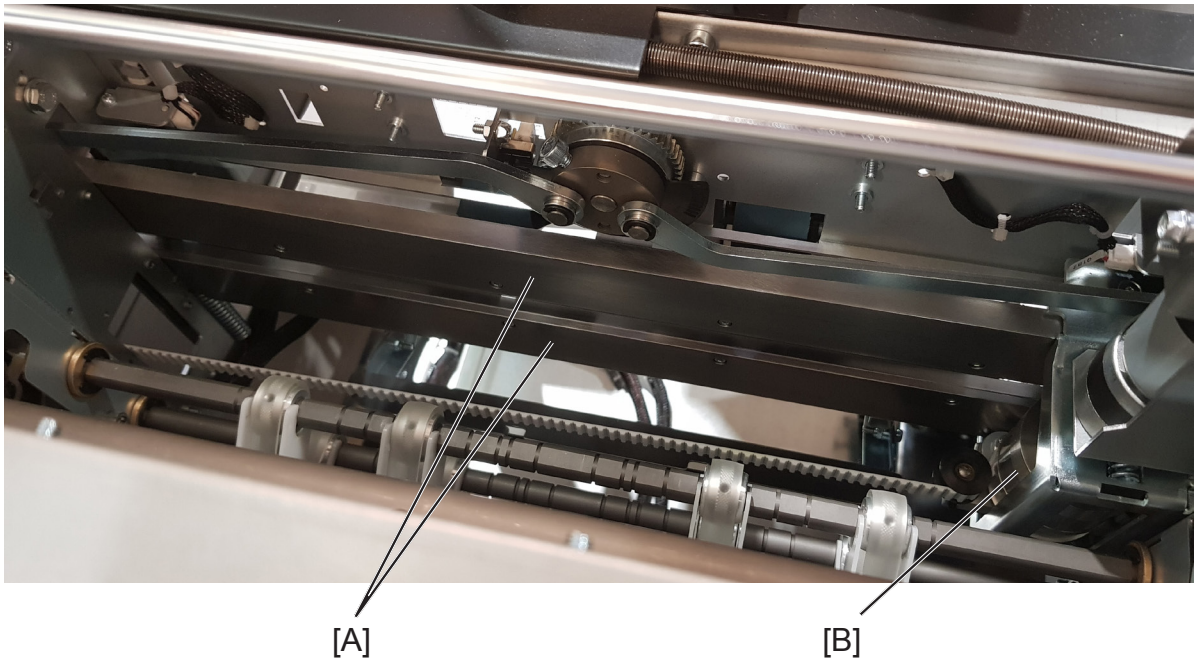


Finishing Module, continued

Cleaning SquareFold Clamps and Roller

The SquareFold Roller, Upper and Lower Clamp Beam needs to be cleaned regularly when in use. How often this should be done depends on the paper type and print quality. Color smeared off on the spine of the booklets is one indication of the need to clean the SquareFold Roller, Upper and Lower Clamp Beam. Clean with water and a lint free cloth.

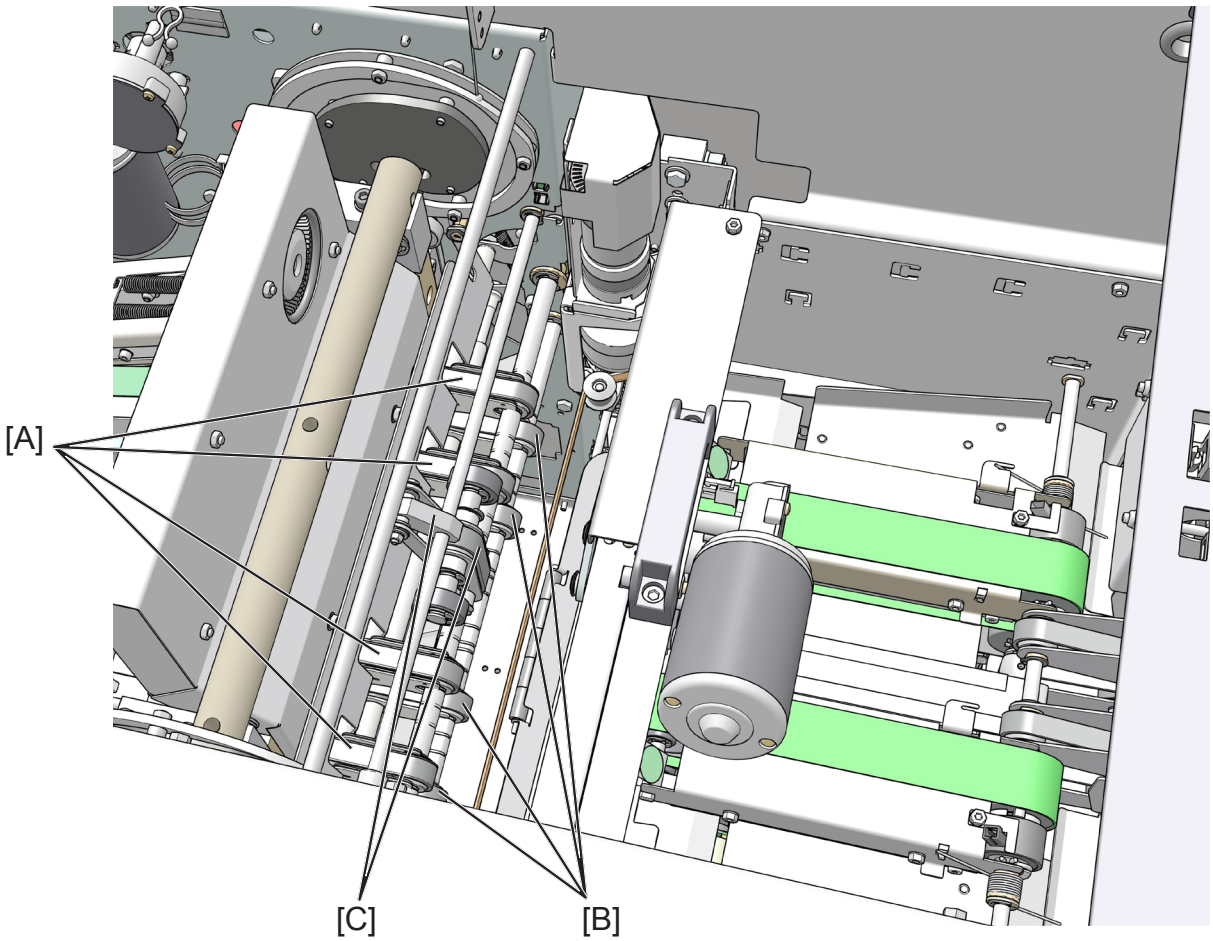
1. Open the Finishing Module top cover.
2. Clean the Upper and Lower Clamp Beam [A].
3. Clean the SquareFold Roller [B]. The Roller can easily be rotated by hand.
4. Close the Finishing Module top cover.



Cleaning Trimmer Infeed Transport Belts

The Trimmer Infeed Transport Feed Belts need to be cleaned regularly when in use. How often this should be done depends on the paper type and print quality.
An increasing number of misfeeds is an indication of the need to clean the feed belts.
Clean the feed belts with water and a lint free cloth.

1. Open the Finishing Module Top Cover.
2. Clean the 4 Upper Transport Feed Belts [A].
3. Clean the 4 Lower Transport Feed Belts [B].
4. Close the Finishing Module Top Cover.



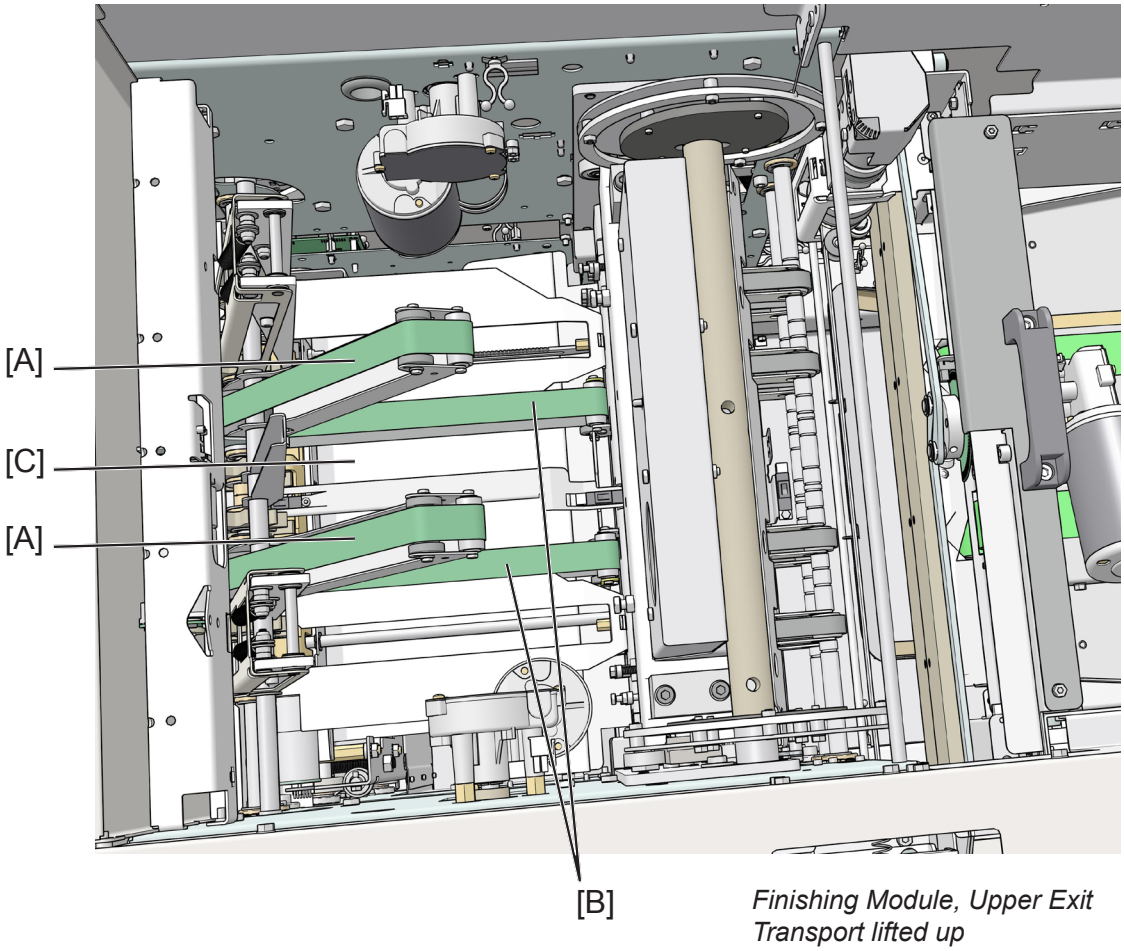
NOTE:
Picture shows the Short Booklet Feed Enhancement assembly [C] in its home position.

Finishing Module, continued

Cleaning Trimmer Exit Transport Belts

The Trimmer Exit Transport Feed Belts need to be cleaned regularly when in use. How often this should be done depends on the paper type and print quality.
An increasing number of misfeeds is an indication of the need to clean the feed belts.
Clean the feed belts with water and a lint free cloth.

1. Open the Finishing Module Top Cover.
2. Clean the 2 Upper Exit Transport Feed Belts [A].
3. Clean the 2 Lower Transport Feed Belts [B]. Use the Upper Exit Transport assembly Lift Lever [C] to access the Lower Transport Feed Belts [B]
4. Close the Finishing Module Top Cover.

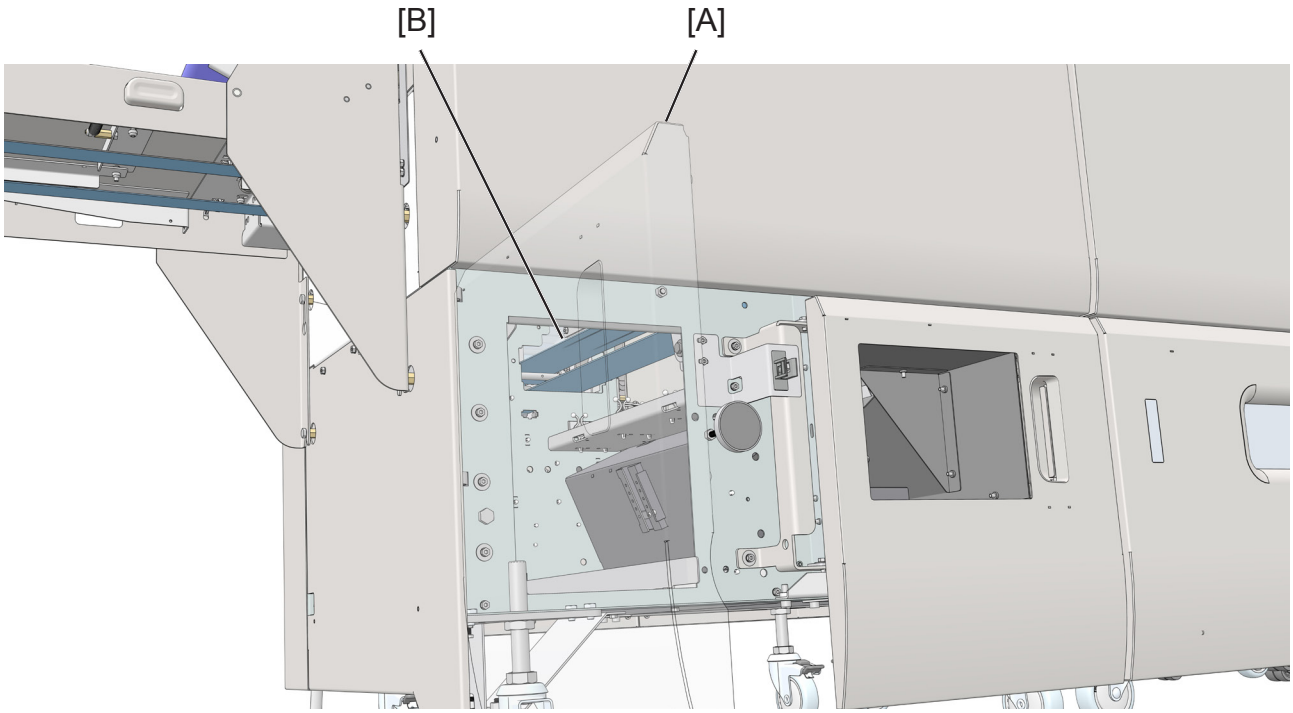


Finishing Module, Upper Exit Transport lifted up

Cleaning the Waste Transport

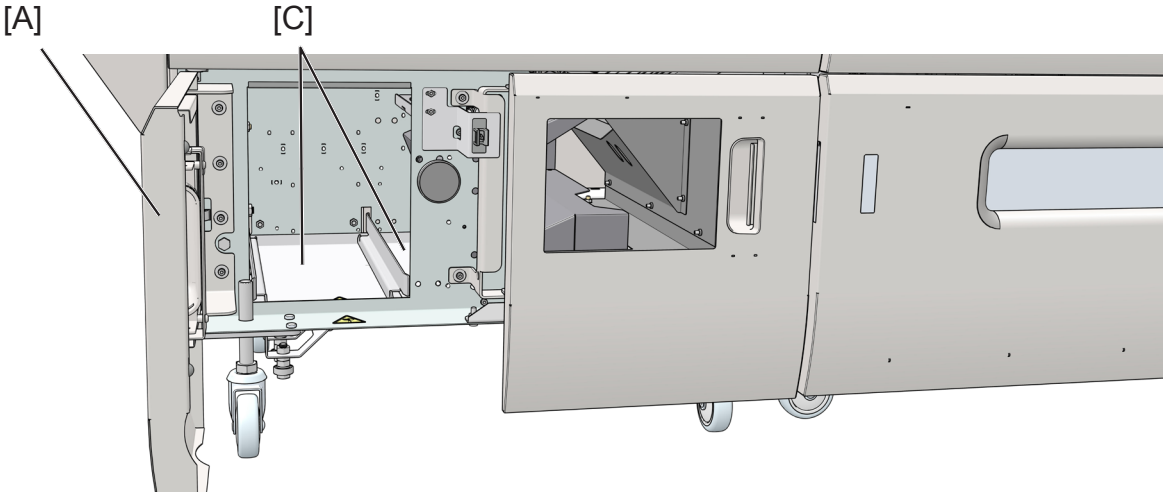
The Waste Transport needs to be cleaned from trim waste strips regularly when in use. How often this should be done depends on how frequently the Trimmer is used.
Proceed as follows:

1. Open the Finishing Module Left Door [A].
2. Pull the upper part of the Transport Belt [B] downwards and remove any trim waste strips.



Left door made transparent for clarity

3. Also remove any trim waste strips from the bottom area [C] inside the Finishing Module.
4. Close the Left Door [A] on the Finishing Module.

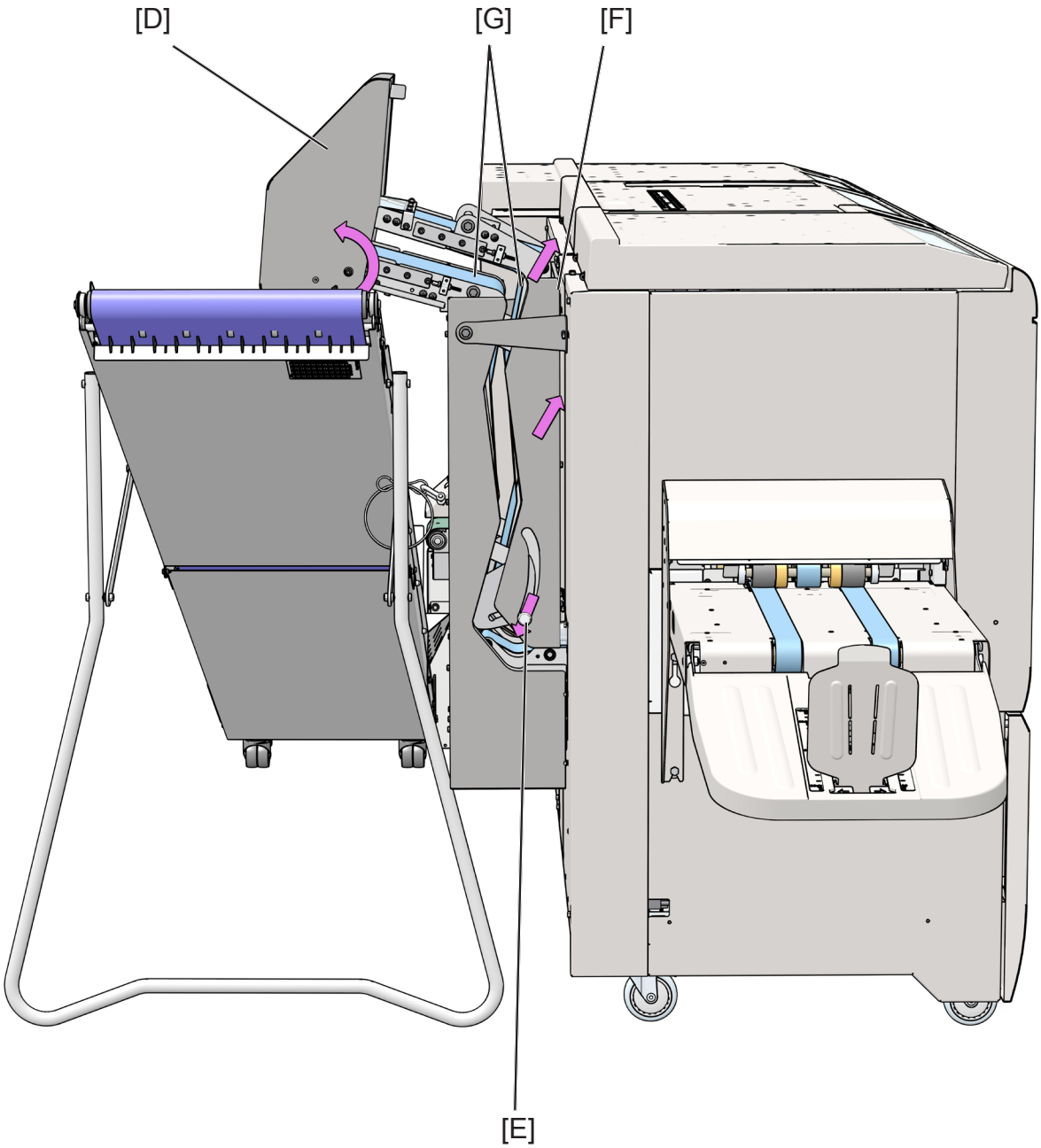


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Finishing Module, continued

Cleaning the Waste Transport, continued

1. Open the Waste Transport Top Cover [D].
2. Push down the Lever [E] to release the Jam Clearance Cover [F].
3. Remove any trim waste strips from between the transport belts [G].
4. Lift the Lever [E] to restore the Jam Clearance Cover to operating position.
5. Close the Top Cover [D].
6. Press the [Done] button on the User Interface to restart the job.

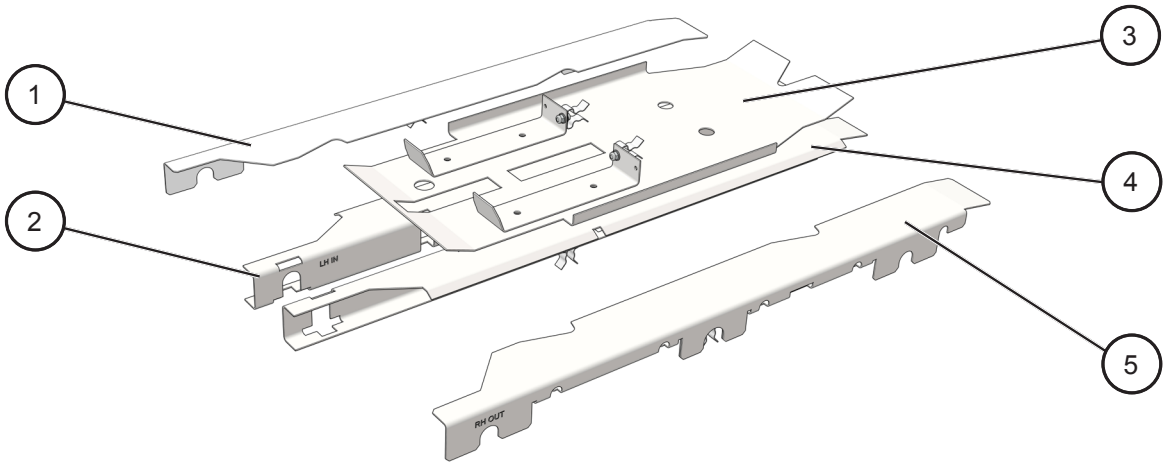


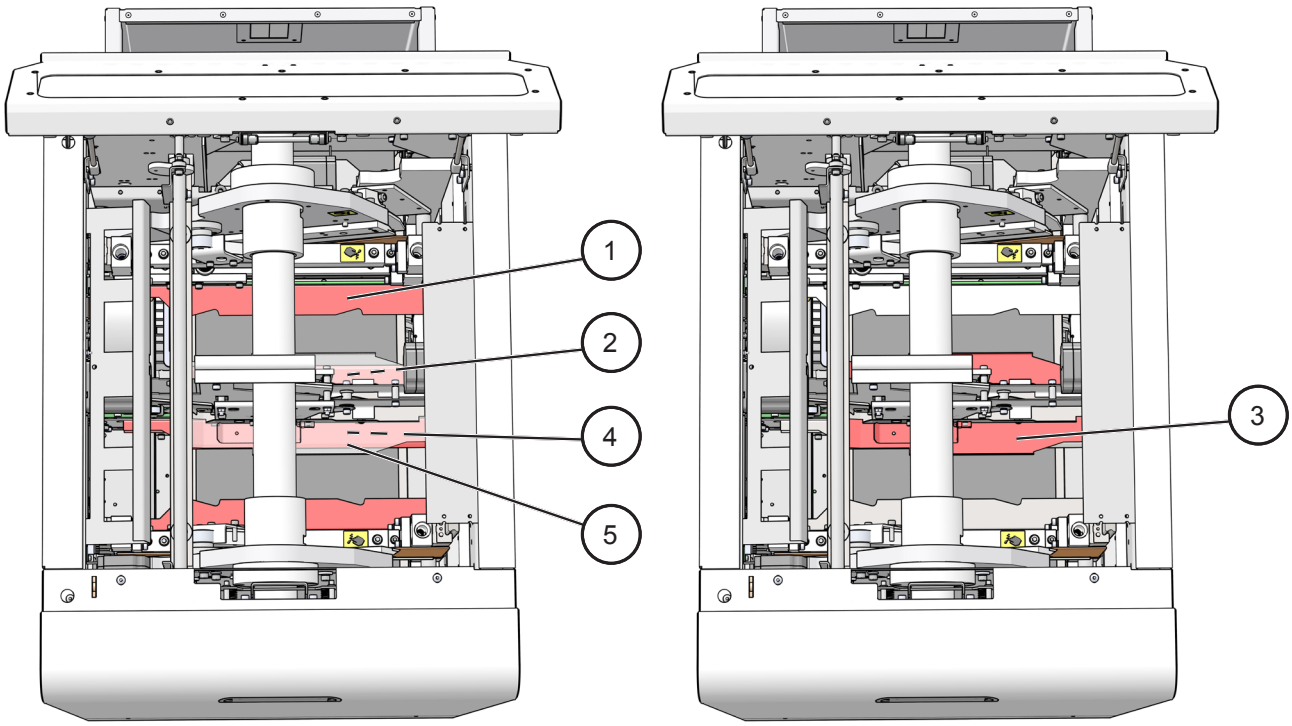
ST5000 Side Trimmer

Cleaning the Book Supports

The Book Supports need to be cleaned regularly when in use. How often this should be done depends on the paper type and print quality.
An increasing number of misfeeds is an indication of the need to clean the Book Supports.
Clean the Book Supports with water and a lint free cloth.

1. Remove the Book Supports. See section 1, “Basics, ST5000 Book Suppports”, for how to remove and re-fit the book supports.
2. Clean the Book Supports.
3. Fit the Book Supports. See section 1, “Basics, ST5000 Book Suppports”, for how to remove and re-fit the book supports.



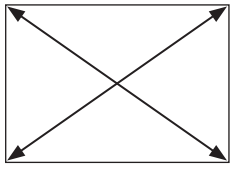


Best practices for the BM5035s/BM5050s system

NOTE:
Edge and corner stapling capability might not be available on all systems.

Note: Term staples is used to reference U shaped metal wire created by Booklet Maker (stitcher or stapler head).

- If the set is not properly registered (side jogged and back jogged), fine adjustment of registration may improve the situation. See section 2 Making Booklets", Fine-tuning booklet appearance for details.
- If staples have problems penetrating thicker sets of heavy media changing staple cartridge may improve the situation.
- If the booklets show markings or scratches the use of the "protection sheet" will improve the situation. See section 2, "Making Booklets", Customizing settings, Cover, Protection sheet.
- The SquareFold module may wrinkle the cover at the spine when light weight media is used for cover sheet. Changing to heavier stock or turning SquareFold off usually resolves the problem.
- Staple back may be radius shaped (bent) when running with SquareFold Module. Moving staple position so staple is centered on the spine will reduce this phenomenon.
- Covers may show marking along the spine of the booklet from the clamp in the SquareFold Module. The more pages in the booklet, the more evident the marking. The use of "protection sheet" eliminates this marking.
- If the Adjustment of "Bleed Trimmer registration angle" described in section 7 "REMARKS", Maintaining Your Machines in the OP manual is set too tight, the sheets may show wrinkles in the process direction.
  - To prevent this phenomenon, turn the adjustment screw counter clockwise until the wrinkles disappear.
- If there might be an incomplete set inside the BM System, this set has to be manually removed from the system by opening and closing the Top Cover of the Booklet Maker. This will purge the set.
- It is recommended to unload the corner and edge stacker often when stacking thinner sets. Thinner sets might trigger a stacker full message too early.
- Use care to avoid corner and edge sets getting damaged when unloading the stacker.
- For optimal stitch quality, consider placing the stitch along the fold line inside the book. Stitching away from fold line may result in decreased quality. Please note that when the stitch is positioned in the middle of the fold line, it might not align perfectly with the center of the spine.
- Prior to printing, it's important to make sure that the sheets themselves are square and uniform. If the diagonals are not equal the sheet is not uniform and square and the booklet quality will vary as a result. This problem is more common than you might think!
  - Measure the diagonals of the non-printed sheet.
    Both diagonals should measure **exactly** the same length.



Limitations of the BM5035s/BM5050s system

NOTE:
Edge and corner stapling capability might not be available on all systems.

Note: Term staples is used to reference U shaped metal wire created by Booklet Maker (stitcher or stapler head).

- If sheets entering the BM5035s/BM5050s is not uniform and square the booklet quality will vary accordingly.
- The maximum recommended number of sheets that can be folded without stapling is 2 sheets of 80 gsm. If there is very low friction between the sheets, running non stapled sets may be difficult.
- Staple position may vary on the spine when being square formed, especially on thicker booklets. Moving staple position so staple is centered on the spine will reduce this phenomenon.
- Staple may be radius shaped (bent) when running with the SquareFold Module. Moving staple position so staple is centered on the spine will reduce this phenomenon.
- Covers may show marking along the spine of the booklet from the clamp in the SquareFold Module. The more pages in the booklet, the more evident the marking. The use of “protection sheet” eliminates this marking.
- For some white coated stock, such as “Silk type” two sided coated paper, occasional fold roller marks may be observed on the “top side” of the book. Use of “protection sheet” eliminates this marking.
- For jobs with multiple sheets of 200 gsm or heavier, the SQF function is recommended to be switched on for an acceptable output and to avoid feed problem at output.
- Heavy weight media will show image crack in the spine, pre-crease the cover in the CST module to avoid cracking. If covers are fed from CF pre creasing offline is recommended.
- Marks from the fold knife may appear on sensitive media on the inner sheet. These marks are more common on thicker books with high toner coverage on the centre sheet. Toner smearing from the fold knife can be removed/reduced by running a number of unprinted booklets of uncoated paper.
- Covers may show markings from the Convenience Feeder separation process.
- Small booklets, A5/ 5.5 × 8.5″ or smaller, may stack poorly on the conveyer.
- Sheets may show marks from the “registration rollers” in the CST module. Changing media will improve the situation. This phenomenon has been seen on the following media:
  - OK Top coated: 157 gsm
  - OK Art post : 186.1 gsm
  - Color Copy coated glossy: 135 gsm
  - OK Top coated: 127.9 gsm
  - Cocoon Silk: 250 gsm
  - Mohawk Color Copy Gloss: 216 gsm
  - OK Art post: 209.4 gsm
  - Ricoh my paper: 67 gsm

continued on next page

Limitations of the BM5035s/BM5050s system, cont.

- On some coated media, staples may not completely penetrate the set resulting in a faulty staple. If problem persists, consider changing media. Staple may not be able to penetrate the number of sheets indicated by the “Set Size Guide”. Some uncoated extra “dense” paper may show the same limitation. The following list shows examples of media where this has been observed:
  - Futura Laser Gloss 80c
  - Hammermil Laser Print
  - OPUS Gloss
  - Mondi Color Copy 200 gsm
  - Sterling Premium Digital Gloss 80T
- When trimming small amount (less than 5 mm or 0.2″) in the FM module on books made from more than 2 sheets, the cut may not be clean, leaving trim waste hanging from the book.
- Paper can show markings on the lead edge of the set from the compiler area. It can be eliminated by help of the trimmer in the FM module. Alternately, clean the machine according to the Maintenance section, especially as described under “Cleaning Booklet Maker Feed Belt. Running 20 sets 4-8 sheet booklets of unprinted A3/12”x18” uncoated paper could help reducing the marks. If not, call service.
- For thick booklets, the clinch quality of the staples may show limitations resulting in the staple legs to be spaced away from the sheets.
- For thick booklets with a thin cover, the cover can be “pulled back” during the registration process in the Face Trimmer. This can result in the cover sheet not being trimmed. Recommendation is to use a heavier cover for thick books (over approx. 15 sheets).
- For some media, the legs of the staples may not be properly clinched causing the legs of the staple to be spaced away from the inner sheet. This phenomenon occurs on extra thick books over 40 sheets made from “soft” paper (recycled and some non-coated media mostly). This phenomenon has been observed on:
  - Mondi Color Copy 120 gsm
- The SquareFold roller can pick up “colour” from the first staple during the SquareFold process. After one full revolution of the SquareFold roller, the colour is smeared off on the spine of the booklet. This phenomenon occurs more for some coated media and for higher SquareFold modes.
- The “pressure foot” in the SquareFold module can cause a shiny mark on sensitive media. This phenomenon has been observed on Glossy media.
- A gray/silver line in the center of the spine can sometimes be observed on booklets. This is caused by the Stop Gate in the SquareFold module. This phenomenon is worse on some coated media. Changing media will improve.
- Marks around the staple position on the outside of the booklet cover may be caused by dirt deposits underneath or on the staple. Changing media may improve. Changing staple cartridge will improve.
- Grey marks around the staple area in the center of the booklet may be caused by metal dust from the staple. This phenomenon is worse on matte coated media. Changing media will improve. Cleaning the clincher area will improve. Trying to get the staple more centred inside the book may also improve.

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Limitations of the BM5035s/BM5050s system, cont.

- Grey marks around the staple area on the spine can sometimes be observed when using the SquareFold module. This may be caused by dirt deposits underneath or on the staple that are picked up by the SquareFold roller during the SquareFold process. This phenomenon occurs more for some coated media and for higher SquareFold Pressure Settings. Selecting a lower SquareFold pressure setting may improve. Switching off the SquareFold may improve. Changing staple cartridge may improve.
- An overly strong SquareFold setting and a slightly misaligned center sheet will cause wrinkles along the inner sheet spine. Selecting a lower SquareFold setting will reduce this phenomenon.
- For booklets without Face Trim, the trailing edge of the booklet may be damaged by the drive belts on the stacker. Plockmatic recommends using Face Trim or thicker sheets to minimize damage.
- Extra heavy media 300-350gsm may not rotate correctly in the CST module. As a workaround operator can try to run media in SEF mode. This may help. This phenomenon has been seen on the following media: Reina (A4 348.8 gsm) .
- For some coated media the Face Trimmer may not be able to cut through the complete book. If this occurs, change to different media or reduce number of sheets in book. This phenomenon has been observed on the following media:
  - Ohji materia OK art post (232.8 gsm)
- Books made from 1-3 sheets of thin media longer than 420 mm may show fold quality variation. If this occurs, change media to improve quality.
- Curled sheets coming out of the feeder will result in increased JAM rate. Flat Curl amount above 10 mm is outside specification. Place sheet on flat surface with the curl going up. Measure distance from surface to tip of curled sheet. If distance is equal or greater than 10 mm curl amount is out of spec.
- On thin books (2-4 sheets) that do not have the staple position centred in the fold line paper tear or paper damage may occur around the staple legs as the book passes through the fold rollers. This is more common when thin media (below 90gsm plain and 110gsm coated) is used. If this issue occurs, moving the staple position so it aligns with fold line this issue will improve.
- On some media small gray marks can be visible around the staples in the centre of the book. Marks are caused by dirt deposits or metal dust on the clinchers. These marks can be reduced by operator cleaning or wiping clinch area with a clean rag. For high production environments (over 20k books/month) it is recommended that this is done once a week.
- Thin media (below 110 gsm) in warm and humid environment may be difficult to feed through the CST module. The CST may in this situation create streak creases coming from the fixing rollers and the sheets not being flat as they enter. This phenomenon has been seen on the following media types:
  - Ricoh My paper (65-80 gsm)
- Thinner sheets (plain paper below 90 gsm or coated below 110 gsm) may generate a paper “dogear”. If dog ear occurs, then fold quality will be poor. This phenomenon is more common on larger sheet sizes. Changing to a heavier media will improve.

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Limitations of the BM5035s/BM5050s system, cont.

- Books made folded over the long edge (menu style books) without SQF may unfold and as a result they will stack poorly on stacker. For menu style books the SQF function is recommended.
- The drive belts in the Trimmer may cause a small polished mark on the top cover of the book on silk coated media and similar. This is caused by the registration process, reducing the TR registration time may reduce these marks. Please use function Adjust Trimmer Registration in the Tools menu.
- For some media trim waste from the CST can get stuck in the waste chute causing a jam. This phenomenon is worse in dry environments without climate control when the risk for static output is higher. Installing the optional Antistatic kit in the CST may improve this situation.
  If system is installed in area with cold winters (North USA, Canada and North Europe) in a room without climate control the option Antistatic kit is recommended.
- Thin large sheets may get “dog ears” in lead edge paper corner. This phenomenon may be seen on large sheets longer than 400 mm that are also thin below 80 gsm. Workaround is to use heavier paper above 80gsm.
- The BM5035s/5050s Booklet Maker systems are suited for customers whose booklet making needs will not exceed a yearly average of 40,000 booklets per month.
- The SquareFold roller can pick up “colour” from the first staple during the SquareFold process. After one full revolution of the SquareFold roller, the colour is smeared off on the spine of the booklet. This phenomenon occurs more for some coated media and for higher SquareFold modes. See how to clean the SquareFold pressure roller and clamps in the Maintenance section.
- The Optical Double Sheet Detection sensors in the VFX should not be turned on when feeding 200 gsm / 74 lb Cover or higher density paper. You may also have to avoid using this function when processing pages with heavy dark areas.
- The Optical Double Sheet Detection sensors cannot be turned on when feeding mixed media from the trays of the VFX. When mixed media is used only use the Ultrasonic DSD sensor.
- When loading paper in the trays of the VFX, make sure that it has the same direction of paper curl: paper with different curl directions cannot be mixed, doing so would result in a misfeed or a jam.
- When loading paper in the trays of the VFX make sure that its wave curl is not greater than 2 mm otherwise a paper jam might occur.
- Auto Feeder Mode in the screen Advanced Feeder Settings is optimized for pre-printed papers. When running white un-printed papers in Auto Feeder Mode, fan settings may not work correctly. For optimum performance on un-printed papers, please turn off Auto Feeder Mode and follow procedure for MANUAL fan settings described in this manual.
- For optimum performance in the VFX, media shall be stored in a climate controlled environment.
  For media stored in environment with relative humidity over 50% performance of the VFX may be reduced.
  The following media types have shown this phenomenon:
  - *Mondi Color Copy Gloss 250gsm A4 SEF*
- Thin media <70gsm with smaller sheet sizes (A4 SEF, 8.5 x 11” SEF or A5 LEF) may show higher jam rate than normal.
  The following media types have shown this phenomenon:
  - *My Paper / 67 gsm / A5*

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Limitations of the BM5035s/BM5050s system, cont.

- For media that is less flexible (stiff) media in the interval 300gsm – 350gsm feeding may not be possible.
  The following media types have shown this phenomenon:
  - *River Shetland paper / 350gsm / SRA3*
- The VFX might produce pressure marks on lowest paper in the paper pile if media is sensitive.
- The VFX is suited for customers whose processing needs will not exceed a monthly average of 200,000 sheets from each tray.
- The VFX might show marks from the vacuum belts when running extra thin media. This issue might occur when using 80 gsm plain and 100 gsm coated types of paper. The recommended solution to this is that of using MANUAL process settings (rather than Auto Feeder Mode) and to reduce the vacuum amount. This will reduce / eliminate such marks.
- When the trays in the VFX are used in MANUAL MODE, the Process Position can only be set to 10 or lower. If higher Process Position is used, MAX load capacity will be reduced by approximately 5 to 10 mm.
- In humid non climate-controlled environments an increased number of double feed jams has been observed in the VFX.
- For optimum feeding performance in the VFX, the paper stack should be “fanned” by the operator prior to loading the tray. This reduces the risk of double feed from the trays. For more information, see “Paper Stack Preparation” in section 1 “Basics”.
- The Ultrasonic Double Sheet Detection Sensors in the VFX does NOT work on all 400 gsm types of paper, as paper density can vary significantly (900/50 = 1800% in one sheet).
- The Optical Double Sheet Detection Sensors in the VFX does NOT work on sheets thicker than 250 gsm.
- The trays in the VFX might have problems feeding the last sheet when processing thicker media (thicker than 350 gsm).
- When running corner and edge stapling jobs, thicker sets might not reach the stacker and could get stuck in the fold pocket.
- When running corner and edge stapling jobs, thinner sets might trigger a stacker full message too early.
- On some sensitive types of coated media, smearing marks might be noticeable on the cover of the booklets with low coverage print. Using a thicker cover might help avoid this phenomenon.
- The Convenience Feeder might have limitations when used to feed unprinted paper.
- When running the BM with four stitch heads, the maximum number of sheets is reduced to 30 sheets of 80 gsm plain paper.

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8. Specification

Machine Specifications

VFX Vacuum Feeder (option)

	Specifications	Remarks
Minimum paper size, W&L	120x210 mm / 4.7x8.3″	
Maximum paper size	356x660 mm / 14x26.5″	
Minimum paper weight	64 gsm / 16 lb Bond uncoated	
Maximum paper weight	Same as Booklet Maker	
Maximum loading capacity, each bin	270 mm / 10.6”	
Maximum loading weight, each bin	92 kg / 202 lb	
Off-line Use	Possible with Service UI	
Weight	250 kg / 550 lb	
Dimensions (L × H × D)	For footprint, see section 7, Access to machine	
Power Source	100-240 V / 50-60 Hz	+6%, -10%
Power Consumption	4A @ 230V, 8A @ 100V	Continuous operation
Operating temperature	10-30°C	

Machine Specifications, continued

CST 3.0 Crease Trim Module (option)

	Specifications	Remarks
Speed	Same as BM5035s/BM5050s Booklet Maker	
Input Paper Width Min	120 mm / 4.7” (bypass only) 158.5 mm / 6.2″	
Input Paper Width Max	330 mm / 13″	5 mm / 0.2″ Head and Foot Trim will automatically be turned on
Output Paper Size Min	120 mm / 4.7” (bypass only) 148.5 mm / 5.85″	
Output Paper Size Max	320 mm / 12.6″	
Paper Weight (Minimum)	Same as BM5035s/BM5050s Booklet Maker	
Paper Weight (Maximum)	Same as BM5035s/BM5050s Booklet Maker	Limited performance with some media above 300 gsm
Creaser Tools Fine tool Coarse tool	 Stock < 120 gsm Stock > 120 gsm (gsm =grams per sq. meter)	
Bleed Trimmer Minimum bleed trimming Maximum bleed trimming Max asymmetric bleed trimming	 5 mm / 0.2″ 30 mm / 1.2″ ±5 mm / 0.2″	On each side of the set
Input / Output Sheets	Same as BM5035s/BM5050s Booklet Maker	
Off-line Use	Not possible	
Weight, net	212 kg / 467 lb	
Dimensions (L × H × D)	For footprint, see section 7, Access to machine	Docking bracket to Booklet Maker sticks out 85 mm / 3.3″
Power Source	100–240 V AC +6%/-10%, 4–2 A, 50–60 Hz	
Power Consumption	300 W, idle 400 W, max peak	Continuous operation
Environmental Requirements	For environmental requirements of the system refer to BM5035s/BM5050s Booklet Maker specifications.	

Machine Specifications, continued

BM5035s/BM5050s Booklet Maker

General Specifications

	Specifications	Remarks
Speed (Online usage)	Ask your local dealer for details.	Actual speed in number of booklets (per min / hour) depends on number of sheets per booklet.
Paper Weight Min	64 gsm / 16 lb Bond uncoated 105 gsm / 28 lb Bond coated	Limited performance with some media below 80 gsm
Paper Weight Max	300 gsm / 111 lb Cover (350 gsm / 130 lb Cover limited)	Limited performance with some media above 300 gsm
Folding capability, no staple	1 to 2 sheets	
Booklet output size, Max Uncut: Using Min trimming:	 H×W: 320x310 mm / 12.6x12.2″ H×W: 320x305 mm / 12.6x12″	
Handfeeding	Possible	
Weight	210 kg / 463 lb	
Dimensions (L × H × D)	For footprint, see section 7, Access to machine	
Power Source	100–240 V AC +6%/-10%, 4–2 A, 50–60 Hz	
Power consumption	250–300 W, idle 400 W, max peak	Continuous Operation
Noise emission	62 dB	Complete system
Environmental Requirements Air Humidity: Temperature:	 30% - 80% RH 15 - 28 °C / 59 - 82 °F	For optimum performance of the system, environment should be kept within 40% - 50% RH and room temperature should be within 18 - 26 °C / 64 - 78 °F

NOTE:
Plockmatic uses QT open source license (LGPL) to develop the software used in this machine (https://www.qt.io/qt-licensing-terms).

Specifications, Stitching version (ISP)

	Specifications	Remarks
Paper Size, Min Booklet making Edge or corner stapling	 W×L: 120x210 mm / 4.7x8.3″ W×L: 279,4x210 mm / 11x8.3″	Smallest paper size a CST can cut down to is 148,5 mm / 5.85”. For paper sizes narrower than that, max set thickness is reduced to 30 sheets 80 gsm / 20lb Bond or 3,0 mm / 0.12”.

continued on next page

Machine Specifications, continued

BM5035s/BM5050s Booklet Maker, continued

Specifications, Stitching version (ISP)

	Specifications	Remarks
Paper Size, Max Booklet making Edge or corner stapling	 W×L: 320x620 mm / 12.6x24.4″ W×L: 297x215,9 mm / 11.7x8.5″	
Folding capability	1 - 2 sheets	
Folding/stitching capability	BM5035s: 2 - 35 sheets of 80gsm / 20lb Bond BM5050s: 2 - 50 sheets of 80gsm / 20lb Bond	Max set thickness is 5 mm / 0.2” for BM505s. For paper sizes narrower than 148,5 mm / 5.85”, max set thickness is 3,0 mm / 0.12” for both BM5030s and BM5050s.
Stitching capability, edge or corner stapling	Up to 30 sheets	BM5035s BM5050s
Recommended Staple Positions		
Booklet making		See section “Recommended Staple Positions” below.
Edge stapling	Variable between: 80 - 218 mm / 3.15 - 8.6”	2 Stitching Heads installed 4 Stitching Heads installed, 2 Stitching Heads deactivated 4 Stitching Heads installed, all activated
Corner stapling	Stitching Head at 249 mm / 9.8” (124,5 mm / 4.9” from centre of long edge of the sheet) 7 mm / 0.28″ from long edge of paper 15,2 mm / 0,6” from short edge of 8.5x11” 24 mm / 0.95” from short edge of A4	Single Stitching Head only A4 or 8.5x11” paper size only. See section “Recommended Staple Positions” below.
Internal Stacking capacity, Edge or corner stapling	50 mm / 2″	It is recommended to unload the stacker often when stacking thinner sets. Thinner sets might trigger a stacker full message too early. Thicker sets might not reach the stacker and could get stuck in the fold pocket.
Booklet output size, Min Uncut: Using Min trimming:	 H×W: 120x105 mm / 4.7x4.1″ H×W: 120x100 mm / 4.7x4.0″	

NOTE:
Edge and corner stapling capability might not be available on all systems.

Machine Specifications, continued

CF5000 Convenience Feeder (option)

	Specifications	Remarks
Maximum Speed used as an internal feeder	9000 sheets per hour, A4 / Letter, short end feed. Number of booklets per hour depends on the number of sheets per set.	
Paper Size Min	120x210 mm / 4.7x8.3″	
Paper Size Max	320x620 mm / 12.6x24.4″	
Paper Weight (Minimum)	80 gsm / 20 lb Bond (65 gsm / 17 lb Bond uncoated limited)	Limited performance with some media below 80 gsm
Paper Weight (Maximum)	300 gsm / 110 lb Cover (250-350 gsm/93-130 lb Cover limited)	Limited performance with media up to 350 gsm / 130 lb Cover
Convenience Feeder Capacity	80 mm (app. 800 sheets of 80 gsm paper) 3.15″ (app. 800 sheets of 20 lb Bond paper)	
Off-line Use	Possible	(Together with Booklet maker)
Weight	30 kg / 66 lb or less	
Power Source	From BM5035s/BM5050s Booklet Maker	

FM5000 Finishing Module

	Specifications	Remarks
Auto trim length	Starting at 5 mm / 0.2″ at 2 sheets per set and increasing	Adjustable in 0.1 mm (0.004″) steps
Minimum recommended trimming	5 mm / 0.2″ *	Bypass of Trimmer is possible
Maximum trimming	16 mm / 0.63″ per cut	Possible to trim down to 100 mm (4″). Trim larger than 16 mm / 0.63″ will cause trimmer to make multiple cycles. This reduces system speed in some applications. Multiple cuts also affect lifetime.
Square fold capacity	2 - 50 sheets per booklet	
Square fold capacity, booklet size W × L	All sizes that are supported by the Booklet Maker	
Belt Stacker capacity	See table below	80gsm/20lb Bond
Weight	150 kg / 330 lb	
Dimensions (L × H × D)	For footprint, see section 7, Access to machine	
Power Source	From BM5035s/BM5050s Booklet Maker	
Environmental Requirements	For environmental requirements of the system refer to BLM5035s/BLM5050s Booklet Maker specifications.	

continued on next page

Machine Specifications, continued

FM5000 Finishing Module, continued

Belt Stacker Capacity

Paper size	Sheets per set	Square forming on/off	Belt Stacker mode	Booklets on Stacker
A4/8.5x11″	2	off	auto	75
A4/8.5x11″	2	off	high	145
A4/8.5x11″	5	off	auto	36
A4/8.5x11″	5	off	high	81
A4/8.5x11″	10	on	auto	62
A4/8.5x11″	10	on	high	80
A4/8.5x11″	50	on	auto	11
A4/8.5x11″	50	on	high	16
A3/11x17"	2	off	auto	60
A3/11x17"	2	off	high	120
A3/11x17"	5	off	auto	32
A3/11x17"	5	off	high	40
A3/11x17"	10	on	auto	31
A3/11x17"	10	on	high	58
A3/11x17"	50	on	auto	10
A3/11x17"	50	on	high	14

SRA3/12*18″ 250gsm/74lb Cover can use the same capacity as A3/11*17″ as long as square formiing mode >6 is used

Waste Transport (option)

	Specifications	Remarks
Weight	25 kg / 55.1 lb	
Dimensions (L × H × D)	For footprint, see section 7, Access to machine	
Power Source	From FM5000 Finishing Module	

Trim Waste Conveyor (option)

	Specifications	Remarks
Weight	30 kg / 66.2 lb	
Power Source	Belt driven from the CST	

BST4000-1 Belt Stacker Module (option)

	Specifications	Remarks
Speed	Variable	
Overlap	Adjustable	
Capacity	A4 / 8,3″x11,7″ ....≥ 1,000 A3 / 11,7″x16,5″ .....≥ 500	Booklet of 2 sheets 80gsm / 20lb Bond Booklet of 2 sheets 80gsm / 20lb Bond
Side guides	Adjustable 0-357 mm / 14″	
Weight	70 kg / 1541 lb	
Dimensions Table height Width Length	 575 - 1000 mm / 22.6″ - 39.4″ 440 mm / 17″ 1380 mm / 54″	 Input height = Table height + 60 mm / 2.4″ + Control unit + 350 mm / 14″ for end stacking tray
Power Source	100–240 V AC +6%/-10%, 1 A, 50–60 Hz	
Power Consumption	70 W or less	

ST5000 Side Trimmer (option)

	Specifications	Remarks
Speed	950 Booklets per hour.	Minimum cycle time: 3,8 seconds
Booklet size (W x L)	Min: 120x80 mm / 4.7x3.15″ Max: 320x310 mm / 12.6x12.2″	
Book Thickness	Max: 10,4 mm / 0.4” Min: One sheet folded	
Trimming	Minimum trim width: 120 mm / 4.7” Maximum trim width: 320 mm / 12.6” Maximum side trim: 40 mm / 1.6” Minimum side trim: 1 mm / 0.04”	 No trim Each side Each side
Weight	321 kg / 707.7 lb	
Power Source	100–240 V AC +6%/-10%, 1 A, 50–60 Hz	
Power Consumption	Stand-by: 40VA (10W) In operation: 1200VA (750W)	 During trimming (1 second of cycle)

Machine Specifications, continued

System Set Size Guide

NOTE:
The following tables are guidelines designed to give an indication on how many sheet a specific application can have for a given media weight.
Exact number of sheets depends on media type and image.

When the optional four head kit is installed, the maximum amount of sheets in a set is limited to 30.

For paper sizes narrower than 148,5 mm / 5.85", max set thickness is reduced to 30 sheets 80 gsm / 20lb Bond or 3,0 mm / 0.12".

Saddle Stapling, BM5035s

Paper weight				Paper Size					
				Longer than 450 mm / 18"		A3 or 11 x 17"		A4 or 8,5 x 11"	
				Area Coverage		Area Coverage		Area Coverage	
Bond	Cover	Index	Gsm	Low	Full	Low	Full	Low	Full
20	28	42	80	35	32	35	30	35	30
24	33	50	90	35	32	32	29	32	29
31	45	66	120	25	24	22	19	22	19
36	50	75	140	19	17	19	15	20	15
53	74	110	200	15	14	13	10	13	10
58	80	120	220	13	12	12	9	11	9
76	105	158	280	12	10	10	7	10	7
82	114	170	300	9	9	8	6	8	6
			350*	2	2	2	2	2	2

**Some media supported. Creasing of cover and center sheet required*

Saddle Stapling BM5050s

Paper weight				Paper Size					
				Longer than 450 mm / 18"		A3 or 11x17"		A4 or 8.5x11"	
				Area Coverage		Area Coverage		Area Coverage	
Bond	Cover	Index	Gsm	Low	Full	Low	Full	Low	Full
20	28	42	80	50	32	50	32	50	33
24	33	50	90	45	32	45	31	45	32
31	45	66	120	25	24	25	23	26	25
36	50	75	140	19	17	20	17	22	20
53	74	110	200	15	14	15	14	16	15
58	80	120	220	13	12	14	13	15	13
76	105	158	280	12	10	12	10	12	10
82	114	170	300	9	9	9	9	9	9
			350*	2	2	2	2	2	2

**Some media supported. Creasing of cover and center sheet required*

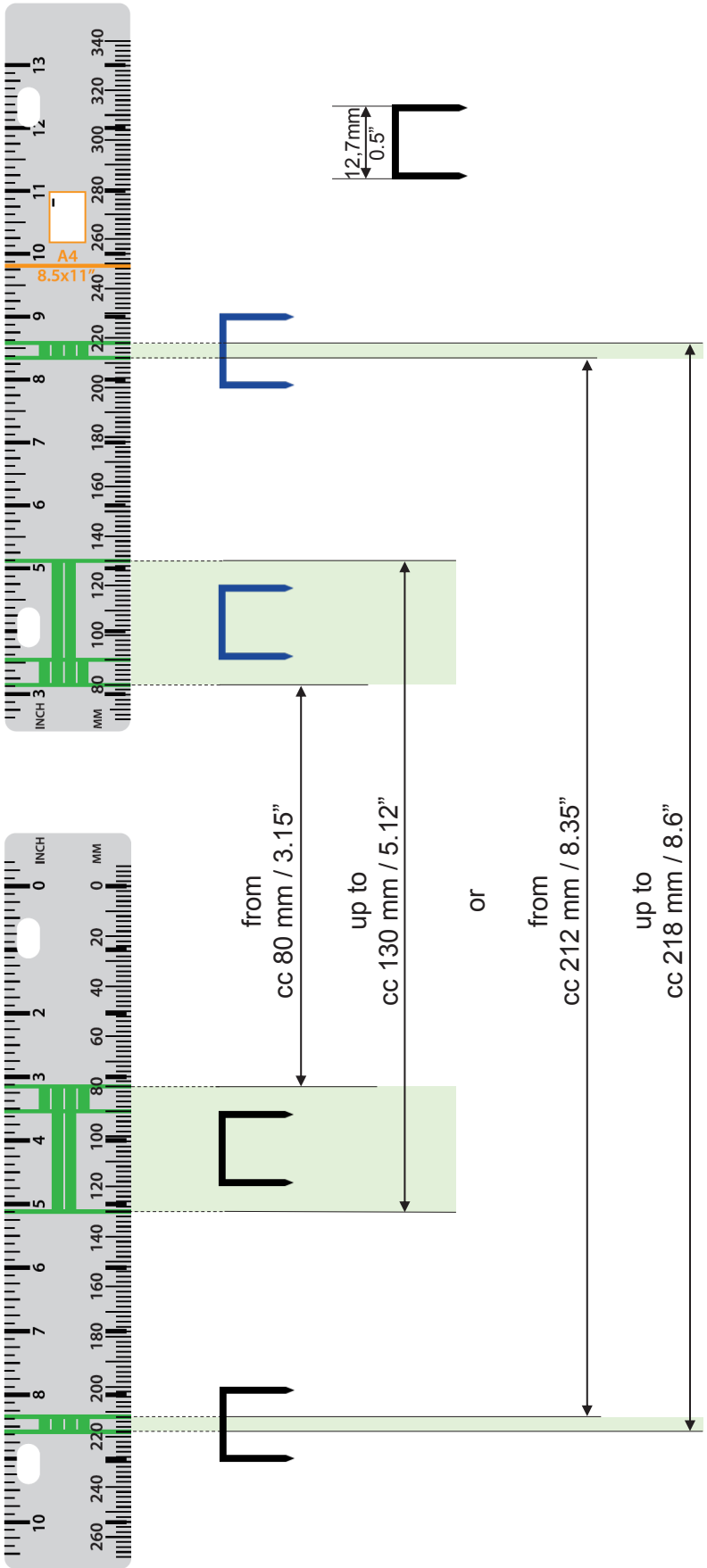
Edge and Corner Staple Specification

Paper weight				Paper Size	
				A4 or 8.5x11"	
				Area Coverage	
Bond	Cover	Index	Gsm	Low	Full
20	28	42	80	30	25
24	33	50	90	25	25
31	45	66	120	25	25
36	50	75	140	20	20
53	74	110	200	15	15
58	80	120	220	14	12
76	105	158	280	10	10
82	114	170	300	9	9

NOTE:
Edge and corner stapling capability might not be available on all systems.

Recommended Staple Positions

Making booklets using two Stitching Heads



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Declaration of Conformity

Plockmatic Group

EU & UK DECLARATION OF CONFORMITY [1]

No.[2] ..... **D0003152 (D.8)**
Manufacturer [3] ..... Plockmatic International AB, Telefonvägen 30, S-126 26 Hägersten, Sweden

This declaration of conformity is issued under the sole responsibility of the manufacturer [4]

Object of the Declaration [5]				
Type/Model [6]	**F125-001**	**F125-002**	**F125-011**	**F125-012**
Name [7]	AF602	AF602LR	VF602, VFX	VF602LR
Description [8]	Air Assisted Friction Feeder		Vacuum Feeder	

The object of the declaration is in conformity with the requirements of the following documents [9]	
EU Directive [10] ***UK Statutory Instrument***	**Standard** [11] ***UK Designated Standard***
(LVD) 2014/35/EU ***S.I. 2016/1101***	EN IEC 62368-1:2020+A11:2020
(EMC) 2014/30/EU ***S.I. 2016/1091***	EN 55032:2015 + A11:2020, Class A EN 55035:2017 + A11:2020 EN 61000-3-2:2014 EN 61000-3-3:2013
(RoHS) 2011/65/EU ***S.I. 2012/3032***	EN 62321:2009, EN 63000:2018
Additional information [10] International certification: UL 62368-1, 3rd Ed., CSA C22.2 No. 62368-1:19, 3rd Ed., IEC 62368-1: 2018; FCC Part 15 (2012) Subpart B, Class B, ICES-003 Issue 5 Class B	
Signed for and on behalf of [11] Hägersten, 2022-11-17 13:23  Bengt Olenfalk Group Quality Manager	

БЪЛГАРСКИ; 1) ЕС Декларация за съответствие; 2) Номер; 3) Производител; 4) Настоящата декларация за съответствие е издадена на отговорността на производителя; 5) Предмет на декларацията; 6) Модел/Тип; 7) Назначение; 8) Описание; 9) Предметът на декларацията, описан по-горе, отговаря на съответното законодателство на Съюза за хармонизация; 10) Директива; 11) Стандарт ; 12) Допълнителна информация; 13) Подписано за и от името на
ČESKÝ; 1) EU Prohlášení o shodě; 2) Číslo; 3) Výrobce; 4) Toto prohlášení o shodě se vydává na výhradní odpovědnost výrobce; 5) Předmět prohlášení; 6) Model/Typ; 7) Označení; 8) Popis; 9) Výše popsaný předmět prohlášení je ve shodě s příslušnými harmonizačními právními předpisy Unie; 10) Směrnice; 11) Norma; 12) Dodatečné informace; 13) Podepsáno za a jménem na
DANSK; 1) EU-Overensstemmelseserklæring; 2) Nummer; 3) Producent; 4) Denne overensstemmelseserklæring udstedes på fabrikantens ansvar; 5) Erklæringens genstand; 6) Model/Type; 7) Betegnelse; 8) Beskrivelse; 9) Genstanden for erklæringen, som beskrevet ovenfor, er i overensstemmelse med den relevante EU-harmoniseringslovgivning; 10) Direktiv; 11) Standard; 12) Yderligere information; 13) Underskrevet for og vegne
DEUTSCH; 1) EU-Konformitätserklärung; 2) Nummer; 3) Hersteller; 4) Die alleinige Verantwortung für die Ausstellung dieser Konformitätserklärung trägt der Hersteller; 5) Gegenstand der Erklärung; 6) Modell/Typ; 7) Bezeichnung; 8) Beschreibung; 9) Der oben beschriebene Gegenstand der Erklärung erfüllt die einschlägigen Harmonisierungsrechtsvorschriften der Union; 10) Direktive; 11) Standard; 12) Weitere Informationen; 13) Zur Unterzeichnung und Namen
EESTI; 1) ELi Vastavusdeklaratsioon; 2) Number; 3) Valmistaja; 4) Käesolev vastavausdeklaratsioon on välja antud tootja ainuvastutusel; 5) Deklareeritav; 6) Mudel/Type; 7) Nimetus; 8) Kirjeldus; 9) Eelkirjeldatud deklareeritav toode on kooskõlas asjaomaste liidu ühtlustamisaktidega; 10) Direktiivi; 11) Standard; 12) Lisainfo; 13) Allkirjastatud ja nimel
SUOMI; 1) EU-Vaatimustenmukaisuusvakuutus; 2) Määrä; 3) Valmistaja; 4) Tämä vaatimustenmukaisuusvakuutus on annettu valmistajan yksinomaisella vastuulla; 5) Vakuutuksen kohde; 6) Malli/Tyyppi; 7) Nimitys; 8) Kuvaus; 9) Edellä kuvattu vakuutuksen kohde on asiaa koskevan unionin yhdenmukaistamislainsäädännön vaatimusten mukainen; 10) Direktiivi; 11) Standardi; 12) Lisäinformaatio; 13) Allekirjoitettu ja puolesta
FRANÇAIS; 1) Décларation UE de conformité; 2) Nombre; 3) Fabricant; 4) La présente déclaration de conformité est établie sous la seule responsabilité du fabricant; 5) Objet de la déclaration; 6) Modèle/type; 7) Désignation; 8) Description; 9) L'objet de la déclaration décrit ci-dessus est conforme à la législation d'harmonisation de l'Union applicable; 10) Directif; 11) Standard; 12) Information Supplémentaire; 13) Signé pour et au nom de
GAEILGE; 1) Dearbhú comhréireachta AE; 2) Uimhir; 3) Manufacturer; 4) Tá an dearbhú comhréireachta arna eisiúint faoi fhreagracht an mhonaróra; 5) Cuspóir an dearbhaithe; 6) Cineál; 7) Ainmniú; 8) Tuairisc; 9) Is é cuspóir an dearbhaithe a thugtar i gcomhréir leis an reachtaíocht chomhchuibhithe ábhartha an Aontais; 10) Treoir; 11) Caighdeánach; 12) Eolas breise; 13) Arna shíniú le haghaidh agus thar ceann an
ΕΛΛΗΝΙΚΗ; 1) Δηλωση συμμορφωσησ ΕΕ; 2) αριθμός; 3) Κατασκευαστής; 4) Η παρούσα δήλωση συμμόρφωσης εκδίδεται με αποκλειστική ευθύνη του κατασκευαστή; 5) Αντικείμενο της δήλωσης; 6) Μοντέλο/Τύπος; 7) Ονομασία; 8) Περιγραφή; 9) Ο στόχος της δήλωσης που περιγράφεται παραπάνω είναι σύμφωνος με τη σχετική ενωσιακή νομοθεσία εναρμόνισης; 10) διευθυντικός; 11) Πρότυπο; 12) Επιπλέον πληροφορίες; 13) Υπογραφή για λογαριασμό και εξ ονόματος του
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MAGYAR; 1) EU–Megfelelőségi nyilatkozat; 2) Szám; 3) Gyártó; 4) Ezt a megfelelőségi nyilatkozatot a gyártó kizárólagos felelőssége mellett adják ki; 5) A nyilatkozat tárgya; 6) Modell/Típus; 7) Kijelölés; 8) Leírás; 9) A fent ismertetett nyilatkozat tárgya megfelel a vonatkozó uniós harmonizációs jogszabályoknak; 10) Irányelv; 11) Standard; 12) További információ; 13) Aláírva nevében
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ITALIANO; 1) Dichiarazione di conformità UE; 2) Numero; 3) Produttore; 4) La presente dichiarazione di conformità è rilasciata sotto la responsabilità esclusiva del fabbricante; 5) Oggetto della dichiarazione; 6) Modello/Tipo; 7) Designazione; 8) Descrizione; 9) L'oggetto della dichiarazione di cui sopra è conforme alla pertinente normativa di armonizzazione dell'Unione; 10) Direttiva; 11) Standard; 12) Informazioni aggiuntive; 13) Firmato e per conto di
LATVIEŠU; 1) ES Atbilstības deklarācija; 2) Numurs; 3) Ražotājs; 4) Šī atbilstības deklarācija ir izdota vienīgi uz ražotāja atbildību; 5) Deklarācijas priekšmets; 6) Modelis/tips; 7) Apzīmējums; 8) Apraksts; 9) Iepriekš aprakstītais deklarācijas priekšmets atbilst attiecīgajam Savienības saskaņošanas tiesību aktam; 10) Direktīva; 11) Standarts; 12) Papildus informācija; 13) Parakstīts vārdā
LIETUVIŲ; 1) ES Atitikties deklaracija; 2) Skaičius; 3) Gamintojas; 4) Ši atitikties deklaracija išduota tik gamintojo atsakomybe; 5) Deklaracijos objektas; 6) Modelis/tipas; 7) Pavadinimas; 8) Aprašymas; 9) Pirmiau aprašytas deklaracijos objektas atitinka susijusius derinamuosius Sąjungos teisės aktus; 10) Direktyva; 11) Standartinė; 12) Papildoma informacija; 13) Pasirašyta ir vardu
MALTESE; 1) Dikjarazzjoni ta' konformità tal-UE; 2) Numru; 3) Manifattur; 4) Din id-dikjarazzjoni ta' konformità tinħareġ taħt ir-responsabbiltà unika tal-manifattur; 5) Għan tad-dikjarazzjoni; 6) Mudell/Tip; 7) Deżinjazzjoni; 8) Deskrizzjoni; 9) L-għan tad-dikjarazzjoni deskritt hawn fuq huwa konformi mal-leġislazzjoni ta' armonizzazzjoni rilevanti tal-Unjoni; 10) Direttiva; 11) Standard; 12) informazzjoni addizzjonali; 13) Iffirmat għal u f'isem il
NEDERLANDS; 1) EU-Conformiteitsverklaring; 2) Nummer; 3) Fabrikant; 4) Deze conformiteitsverklaring wordt verstrekt onder volledige verantwoordelijkheid van de fabrikant; 5) Voorwerp van de verklaring; 6) Model/Type; 7) Benaming; 8) Beschrijving; 9) Het hierboven beschreven voorwerp is in overeenstemming met de desbetreffende harmonisatiewetgeving van de Unie; 10) Richtlijn; 11) Standaard; 12) Aanvullende informatie; 13) Ondertekend voor en namens
NORSK; 1) EU-Erklæring; 2) Nummer; 3) Produsent; 4) Denne samsvarserklæringen er utstedt under ansvar av produsenten; 5) Formålet med erklæringen; 6) Type; 7) Betegnelse; 8) Beskrivelse; 9) Formålet med erklæringen som er beskrevet ovenfor er i samsvar med relevante Union harmoniseringslovgivning; 10) Direktiv; 11) Standard; 12) Ytterligere informasjon; 13) Signert for og vegne av
POLSKI; 1) Deklaracja zgodności UE; 2) Numer; 3) Producent; 4) Niniejsza deklaracja zgodności wydana zostaje na wyłączną odpowiedzialność producenta; 5) Przedmiot deklaracji; 6) Model/Typ; 7) Oznaczenie; 8) Opis; 9) Wymieniony powyżej przedmiot niniejszej deklaracji jest zgodny z odnośnymi wymaganiami unijnego prawodawstwa harmonizacyjnego; 10) Dyrektywa; 11) Standard; 12) Dodatkowe informacje; 13) Podpisano imieniu
PORTUGUÊS; 1) Declaração UE de conformidade; 2) Número; 3) Fabricante; 4) A presente declaração de conformidade é emitida sob a exclusiva responsabilidade do fabricante; 5) Objecto da declaração; 6) Modelo/Tipo; 7) A denominação; 8) Descrição; 9) O objeto da declaração acima descrito está em conformidade com a legislação de harmonização da União aplicável; 10) Directiva; 11) Padrão; 12) Informações adicionais; 13) Assinado por e nome
ROMÂNĂ; 1) Declarația UE de conformitate; 2) Număr; 3) Producător; 4) Prezenta declarație de conformitate este emisă pe răspunderea exclusivă a producătorului; 5) Obiectul declarației; 6) Model/Tip; 7) Desemnare; 8) Descriere; 9) Obiectul declarației descris mai sus este în conformitate cu legislația relevantă de armonizare a Uniunii; 10) Directivă; 11) Standard; 12) Informatii aditionale; 13) Semnat pentru și în numele
SLOVENSKÝ; 1) EÚ Vyhlásenie o zhode; 2) Číslo; 3) Výrobca; 4) Toto vyhlásenie o zhode sa vydáva na výhradnú zodpovednosť výrobcu; 5) Predmet vyhlásenia; 6) Model/Typ; 7) Označenie; 8) Popis; 9) Uvedený predmet vyhlásenia je v zhode s príslušnými harmonizačnými právnymi predpismi Únie; 10) Smernice; 11) Štandardné; 12) Doplňujúce informácie; 13) Podpísané za av mene na
SLOVENŠČINA; 1) Izjava EU o skladnosti; 2) Število; 3) Proizvajalec; 4) Ta izjava o skladnosti je izdana na lastno odgovornost proizvajalca; 5) Predmet izjave; 6) Model/Type; 7) Oznaka; 8) Opis; 9) Predmet navedene izjave je v skladu z ustrezno zakonodajo Unije o harmonizaciji; 10) Direktiva; 11) Standardna; 12) Dodatne informacije; 13) Podpisano za in v imenu
ESPAÑOL; 1) Declaración UE de conformidad; 2) Número; 3) Fabricante; 4) La presente declaración de conformidad se expide bajo la exclusiva responsabilidad del fabricante; 5) Objeto de la declaración; 6) Tipo de modelo; 7) Designación; 8) Descripción; 9) El objeto de la declaración descrita anteriormente es conforme con la legislación de armonización pertinente de la Unión; 10) Directiva; 11) Estándar; 12) Información Adicional; 13) Firmado por y nombre
SVENSKA; 1) EU-Försäkran om överensstämmelse; 2) Nummer; 3) Tillverkare; 4) Denna försäkran om överensstämmelse utfärdas på tillverkarens eget ansvar; 5) Föremålet för försäkran; 6) Modell/Typ; 7) Beteckning; 8) Beskrivning; 9) Föremålet för försäkran ovan överensstämmer med den relevanta harmoniserade unionslagstiftningen; 10) Direktiv; 11) Standard; 12) Extra information; 13) Undertecknat för och på uppdrag av

Declaration of Conformity, continued

Plockmatic Group

EU & UK DECLARATION OF CONFORMITY [1]

No.[2] ..... **N0007333 (A.6)**
Manufacturer [3] ..... Plockmatic International AB, Telefonvägen 30, S-126 26 Hägersten, Sweden

This Declaration of Conformity is issued under the sole responsibility of the manufacturer [4]

Object of the Declaration [5]		
Model/Type [6]	**F137-001, F137-002, F137-011, F137-012**	**F138-001, F138-002**
Name [7]	Systems BM5000 / PBM5000 / BLM5000	FM5000
Description [8]	Booklet maker modules, incl dedicated options and accessories	Finishing module

The object of the declaration is in conformity with the requirements of the following documents [9]	
EU Directive [10] ***UK Statutory Instrument***	**Standard** [11] ***UK Designated Standard***
Directive [10]	**Standard** [11]
(LVD) 2014/35/EU ***S.I. 2016/1101***	EN IEC 62368-1:2020+A11:2020
(EMC) 2014/30/EU ***S.I. 2016/1091***	EN 55032:2015 + A11:2020, EN 55035:2017 + A11:2020, IEC 61000-3-2:2014, IEC 61000-3-3:2013, IEC 61000-6-2:2005, EN 61000-6-4:2007+A1:2011
(RoHS) 2011/65/EU ***S.I. 2012/3032***	EN 62321:2009, EN 63000:2018
Additional information [12] International certification: UL 62368-1, 3rd Edition, CSA C22.2 No. 62368-1:2019, IEC 62368-1:2018, FCC Part 15 (2015) Subpart B Section 15, Class A.	
Signed for and on behalf of [13]	Hägersten, 2022-12-14 12:46 Bengt Olenfalk Group Quality Manager

БЪЛГАРСКИ; 1) ЕС Декларация за съответствие; 2) Номер; 3) Производител; 4) Настоящата декларация за съответствие е издадена на отговорността на производителя; 5) Предмет на декларацията; 6) Модел/Тип; 7) Назначение; 8) Описание; 9) Предметът на декларацията, описан по-горе, отговаря на съответното законодателство на Съюза за хармонизация; 10) Директива; 11) Стандарт ; 12) Допълнителна информация; 13) Подписано за и от името на
ČESKÝ; 1) EU Prohlášení o shodě; 2) Číslo; 3) Výrobce; 4) Toto prohlášení o shodě se vydává na výhradní odpovědnost výrobce; 5) Předmět prohlášení; 6) Model/Typ; 7) Označení; 8) Popis; 9) Výše popsaný předmět prohlášení je ve shodě s příslušnými harmonizačními právními předpisy Unie; 10) Směrnice; 11) Norma; 12) Dodatečné informace; 13) Podepsáno za a jménem na
DANSK; 1) EU-Overensstemmelseserklæring; 2) Nummer; 3) Producent; 4) Denne overensstemmelseserklæring udstedes på fabrikantens ansvar; 5) Erklæringens genstand; 6) Model/Type; 7) Betegnelse; 8) Beskrivelse; 9) Genstanden for erklæringen, som beskrevet ovenfor, er i overensstemmelse med den relevante EU-harmoniseringslovgivning; 10) Direktiv; 11) Standard; 12) Yderligere information; 13) Underskrevet for og vegne
DEUTSCH; 1) EU-Konformitätserklärung; 2) Nummer; 3) Hersteller; 4) Die alleinige Verantwortung für die Ausstellung dieser Konformitätserklärung trägt der Hersteller; 5) Gegenstand der Erklärung; 6) Modell/Typ; 7) Bezeichnung; 8) Beschreibung; 9) Der oben beschriebene Gegenstand der Erklärung erfüllt die einschlägigen Harmonisierungsrechtsvorschriften der Union; 10) Direktive; 11) Standard; 12) Weitere Informationen; 13) Zur Unterzeichnung und Namen
EESTI; 1) ELi Vastavusdeklaratsioon; 2) Number; 3) Valmistaja; 4) Käesolev vastavausdeklaratsioon on välja antud tootja ainuvastutusel; 5) Deklareeritav; 6) Mudel/Type; 7) Nimetus; 8) Kirjeldus; 9) Eelkirjeldatud deklareeritav toode on kooskõlas asjaomaste liidu ühtlustamisaktidega; 10) Direktiivi; 11) Standard; 12) Lisainfo; 13) Allkirjastatud ja nimel
SUOMI; 1) EU-Vaatimustenmukaisuusvakuutus; 2) Määrä; 3) Valmistaja; 4) Tämä vaatimustenmukaisuusvakuutus on annettu valmistajan yksinomaisella vastuulla; 5) Vakuutuksen kohde; 6) Malli/Tyyppi; 7) Nimitys; 8) Kuvaus; 9) Edellä kuvattu vakuutuksen kohde on asiaa koskevan unionin yhdenmukaistamislainsäädännön vaatimusten mukainen; 10) Direktiivi; 11) Standardi; 12) Lisäinformaatio; 13) Allekirjoitettu ja puolesta
FRANÇAIS; 1) Déclaration UE de conformité; 2) Nombre; 3) Fabricant; 4) La présente déclaration de conformité est établie sous la seule responsabilité du fabricant; 5) Objet de la déclaration; 6) Modèle/type; 7) Désignation; 8) Description; 9) L'objet de la déclaration décrit ci-dessus est conforme à la législation d'harmonisation de l'Union applicable; 10) Directif; 11) Standard; 12) Information Supplémentaire; 13) Signé pour et au nom de
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ΕΛΛΗΝΙΚΗ; 1) Δήλωση συμμορφωσης ΕΕ; 2) αριθμός; 3) Κατασκευαστής; 4) Η παρούσα δήλωση συμμόρφωσης εκδίδεται με αποκλειστική ευθύνη του κατασκευαστή; 5) Αντικείμενο της δήλωσης; 6) Μοντέλο/Τύπος; 7) Ονομασία; 8) Περιγραφή; 9) Ο στόχος της δήλωσης που περιγράφεται παραπάνω είναι σύμφωνος με τη σχετική ενωσιακή νομοθεσία εναρμόνισης; 10) διευθυντικός; 11) Πρότυπο; 12) Επιπλέον πληροφορίες; 13) Υπογραφή για λογαριασμό και εξ ονόματος του
HRVATSKI; 1) EU Izjava o sukladnosti; 2) Broj; 3) Proizvođač; 4) Za izdavanje EU izjave o sukladnosti odgovoran je isključivo proizvođač; 5) Predmet deklaracije; 6) Model/Tip; 7) Oznaka; 8) Deskripcija; 9) Predmet navedene izjave u skladu je s mjerodavnim zakonodavstvom Unije o usklađivanju; 10) Direktiva; 11) Standard; 12) Dodatne informacije; 13) Potpisao za iu ime
MAGYAR; 1) EU–Megfelelőségi nyilatkozat; 2) Szám; 3) Gyártó; 4) Ezt a megfelelőségi nyilatkozatot a gyártó kizárólagos felelőssége mellett adják ki; 5) A nyilatkozat tárgya; 6) Modell/Típus; 7) Kijelölés; 8) Leírás; 9) A fent ismertetett nyilatkozat tárgya megfelel a vonatkozó uniós harmonizációs jogszabályoknak; 10) Irányelv; 11) Standard; 12) További információ; 13) Aláírva nevében
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MALTESE; 1) Dikjarazzjoni ta' konformità tal-UE; 2) Numru; 3) Manifattur; 4) Din id-dikjarazzjoni ta' konformità tinħareg taħt ir-responsabbiltà unika tal-manifattur; 5) Għan tad-dikjarazzjoni; 6) Mudell/Tip; 7) Deżinjazzjoni; 8) Deskrizzjoni; 9) L-għan tad-dikjarazzjoni deskritt hawn fuq huwa konformi mal-leġislazzjoni ta' armonizzazzjoni rilevanti tal-Unjoni; 10) Direttiva; 11) Standard; 12) informazzjoni addizzjonali; 13) Iffirmat għal u f'isem il
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NORSK; 1) EU-Erklæring; 2) Nummer; 3) Produsent; 4) Denne samsvarserklæringen er utstedt under ansvar av produsenten; 5) Formålet med erklæringen; 6) Type; 7) Betegnelse; 8) Beskrivelse; 9) Formålet med erklæringen som er beskrevet ovenfor er i samsvar med relevante Union harmoniseringslovgivning; 10) Direktiv; 11) Standard; 12) Ytterligere informasjon; 13) Signert for og vegne av
POLSKI; 1) Deklaracja zgodności UE; 2) Numer; 3) Producent; 4) Niniejsza deklaracja zgodności wydana zostaje na wyłączną odpowiedzialność producenta; 5) Przedmiot deklaracji; 6) Model/Typ; 7) Oznaczenie; 8) Opis; 9) Wymieniony powyżej przedmiot niniejszej deklaracji jest zgodny z odnośnymi wymaganiami unijnego prawodawstwa harmonizacyjnego; 10) Dyrektywa; 11) Standard; 12) Dodatkowe informacje; 13) Podpisano imieniu
PORTUGUÊS; 1) Declaração UE de conformidade; 2) Número; 3) Fabricante; 4) A presente declaração de conformidade é emitida sob a exclusiva responsabilidade do fabricante; 5) Objecto da declaração; 6) Modelo/Tipo; 7) A denominação; 8) Descrição; 9) O objeto da declaração acima descrito está em conformidade com a legislação de harmonização da União aplicável; 10) Directiva; 11) Padrão; 12) Informações adicionais; 13) Assinado por e nome
ROMÂNĂ; 1) Declarația UE de conformitate; 2) Număr; 3) Producător; 4) Prezenta declarație de conformitate este emisă pe răspunderea exclusivă a producătorului; 5) Obiectul declarației; 6) Model/Tip; 7) Desemnare; 8) Descriere; 9) Obiectul declarației descris mai sus este în conformitate cu legislația relevantă de armonizare a Uniunii; 10) Directivă; 11) Standard; 12) Informații aditionale; 13) Semnat pentru și în numele
SLOVENSKÝ; 1) EÚ Vyhlásenie o zhode; 2) Číslo; 3) Výrobca; 4) Toto vyhlásenie o zhode sa vydáva na výhradnú zodpovednosť výrobcu; 5) Predmet vyhlásenia; 6) Model/Typ; 7) Označenie; 8) Popis; 9) Uvedený predmet vyhlásenia je v zhode s príslušnými harmonizačnými právnymi predpismi Únie; 10) Smernice; 11) Štandardné; 12) Doplňujúce informácie; 13) Podpísané za av mene na
SLOVENŠČINA; 1) Izjava EU o skladnosti; 2) Število; 3) Proizvajalec; 4) Ta izjava o skladnosti je izdana na lastno odgovornost proizvajalca; 5) Predmet izjave; 6) Model/Type; 7) Oznaka; 8) Opis; 9) Predmet navedene izjave je v skladu z ustrezno zakonodajo Unije o harmonizaciji; 10) Direktiva; 11) Standardna; 12) Dodatne informacije; 13) Podpisano za in v imenu
ESPAÑOL; 1) Declaración UE de conformidad; 2) Número; 3) Fabricante; 4) La presente declaración de conformidad se expide bajo la exclusiva responsabilidad del fabricante; 5) Objeto de la declaración; 6) Tipo de modelo; 7) Designación; 8) Descripción; 9) El objeto de la declaración descrita anteriormente es conforme con la legislación de armonización pertinente de la Unión; 10) Directiva; 11) Estándar; 12) Información Adicional; 13) Firmado por y nombre
SVENSKA; 1) EU-Försäkran om överensstämmelse; 2) Nummer; 3) Tillverkare; 4) Denna försäkran om överensstämmelse utfärdas på tillverkarens eget ansvar; 5) Föremålet för försäkran; 6) Modell/Typ; 7) Beteckning; 8) Beskrivning; 9) Föremålet för försäkran ovan överensstämmer med den relevanta harmoniserade unionslagstiftningen; 10) Direktiv; 11) Standard; 12) Extra information; 13) Undertecknat för och på uppdrag av

Plockmatic Group

EU & UK DECLARATION OF CONFORMITY [1]

No.[2] ..... **D0001499 (I.11)**
Manufacturer [3] ..... Plockmatic International AB, Telefonvägen 30, S-126 26 Hägersten, Sweden

This Declaration of Conformity is issued under the sole responsibility of the manufacturer [4]

Object of the Declaration [5]										
Type/Model [6]	**F122-001**	**F122-002**	**F122-003**	**F122-012**	**F122-013**	**F122-102**	**F122-103**	**F134-001**	**F135-001**	**F136-001, F136-002, F136-003, F136-004**
Name [7]	RCT, RCT 2.0, RCT30 (4B7, BE6)	CT5010e, CT5030, CST500, CST2000, PBM-RCT (2.0), RCT50, SD-RCT	PBM-RCTe	RCT 3.0	PBM-RCT 3.0, CST 3.0, CST3000, RCT 3.0, SD-RCT 3.0	CT XL	CT XL Bridge	SD-INT	PBM PUMO	Trim Waste Conveyor TWC 2.0
Description [8]	Rotator Creaser Trimmer						Interface		Purge Module	(option)

The object of the declaration is in conformity with the requirements of the following documents [9]	
EU Directive [10] ***UK Statutory Instrument***	**Standard** [11] ***UK Designated Standard***
(LVD) 2014/35/EU ***S.I. 2016/1101***	EN 62368-1:2014 + A11:2017, EN IEC 62368-1:2020 + A11:2020
(EMC) 2014/30/EU ***S.I. 2016/1091***	EN 55032:2015 + AC1:2016 + A1:2020 + A11:2020 (Class A), EN 55035:2017 + A11:2020, EN 61000-3-2:2014, EN 61000-3-3:2013, EN 61000-6-2:2005, EN 61000-6-4:2007+A1
(RoHS) 2011/65/EU ***S.I. 2012/3032***	EN 62321:2009, EN 63000:2018
Additional information [12]	Compliant with: EN IEC 62368-1:2020+A11:2020; IEC 62368-1: 2018, 3rd Edition; UL 62368-1, 3rd Edition, 2019; CAN/CSA C22.2 No. 62368-1:19, 3rd Edition; FCC Part 15 (2015) Subpart B Class A; ICES-003 Issue 6 Class A
Signed for and on behalf of [13]	Hägersten, 2025-02-05 07:46  Bengt Olenfalk Group Quality Manager

БЪЛГАРСКИ; 1) ЕС Декларация за съответствие; 2) Номер; 3) Производител; 4) Настоящата декларация за съответствие е издадена на отговорността на производителя; 5) Предмет на декларацията; 6) Модел/Тип; 7) Назначение; 8) Описание; 9) Предметът на декларацията, описан по-горе, отговаря на съответното законодателство на Съюза за хармонизация; 10) Директива; 11) Стандарт ; 12) Допълнителна информация; 13) Подписано за и от името на
ČESKÝ; 1) EU Prohlášení o shodě; 2) Číslo; 3) Výrobce; 4) Toto prohlášení o shodě se vydává na výhradní odpovědnost výrobce; 5) Předmět prohlášení; 6) Model/Typ; 7) Označení; 8) Popis; 9) Výše popsaný předmět prohlášení je ve shodě s příslušnými harmonizačními právními předpisy Unie; 10) Směrnice; 11) Norma; 12) Dodatečné informace; 13) Podepsáno za a jménem na
DANSK; 1) EU-Overensstemmelseserklæring; 2) Nummer; 3) Producent; 4) Denne overensstemmelseserklæring udstedes på fabrikantens ansvar; 5) Erklæringens genstand; 6) Model/Type; 7) Betegnelse; 8) Beskrivelse; 9) Genstanden for erklæringen, som beskrevet ovenfor, er i overensstemmelse med den relevante EU-harmoniseringslovgivning; 10) Direktiv; 11) Standard; 12) Yderligere information; 13) Underskrevet for og vegne
DEUTSCH; 1) EU-Konformitätserklärung; 2) Nummer; 3) Hersteller; 4) Die alleinige Verantwortung für die Ausstellung dieser Konformitätserklärung trägt der Hersteller; 5) Gegenstand der Erklärung; 6) Modell/Typ; 7) Bezeichnung; 8) Beschreibung; 9) Der oben beschriebene Gegenstand der Erklärung erfüllt die einschlägigen Harmonisierungsrechtsvorschriften der Union; 10) Direktive; 11) Standard; 12) Weitere Informationen; 13) Zur Unterzeichnung und Namen
EESTI; 1) ELi Vastavusdeklaratsioon; 2) Number; 3) Valmistaja; 4) Käesolev vastavausdeklaratsioon on välja antud tootja ainuvastutusel; 5) Deklareeritav; 6) Mudel/Type; 7) Nimetus; 8) Kirjeldus; 9) Eelkirjeldatud deklareeritav toode on kooskõlas asjaomaste liidu ühtlustamisaktidega; 10) Direktiivi; 11) Standard; 12) Lisainfo; 13) Allkirjastatud ja nimel
SUOMI; 1) EU-Vaatimustenmukaisuusvakuutus; 2) Määrä; 3) Valmistaja; 4) Tämä vaatimustenmukaisuusvakuutus on annettu valmistajan yksinomaisella vastuulla; 5) Vakuutuksen kohde; 6) Malli/Tyyppi; 7) Nimitys; 8) Kuvaus; 9) Edellä kuvattu vakuutuksen kohde on asiaa koskevan unionin yhdenmukaistamislainsäädännön vaatimusten mukainen; 10) Direktiivi; 11) Standardi; 12) Lisäinformatio; 13) Allekirjoitettu ja puolesta
FRANÇAIS; 1) Déclaration UE de conformité; 2) Nombre; 3) Fabricant; 4) La présente déclaration de conformité est établie sous la seule responsabilité du fabricant; 5) Objet de la déclaration; 6) Modèle/type; 7) Désignation; 8) Description; 9) L'objet de la déclaration décrit ci-dessus est conforme à la législation d'harmonisation de l'Union applicable; 10) Directif; 11) Standard; 12) Information Supplémentaire; 13) Signé pour et au nom de
GAEILGE; 1) Dearbhú comhréireachta AE; 2) Uimhir; 3) Monaróir; 4) Tá an dearbhú comhréireachta arna eisiúint faoi fhreagracht an mhonaróra; 5) Cuspóir an dearbhaithe; 6) Cineál; 7) Ainmniú; 8) Tuairisc; 9) Is é cuspóir an dearbhaithe a thugtar i gcomhréir leis an reachtaíocht chomhchuibhithe ábhartha an Aontais; 10) Treoir; 11) Caighdeánach; 12) Eolas breise; 13) Arna shíniú le haghaidh agus thar ceann an
ΕΛΛΗΝΙΚΗ; 1) Δήλωση συμμορφωσηρ ΕΕ; 2) αριθμός; 3) Κατασκευαστής; 4) Η παρούσα δήλωση συμμόρφωσης εκδίδεται με αποκλειστική ευθύνη του κατασκευαστή; 5) Αντικείμενο της δήλωσης; 6) Μοντέλο/Τύπος; 7) Ονομασία; 8) Περιγραφή; 9) Ο στόχος της δήλωσης που περιγράφεται παραπάνω είναι σύμφωνος με τη σχετική ενωσιακή νομοθεσία εναρμόνισης; 10) διευθυντικός; 11) Πρότυπο; 12) Επιπλέον πληροφορίες; 13) Υπογραφή για λογαριασμό και εξ ονόματος του
HRVATSKI; 1) EU Izjava o sukladnosti; 2) Broj; 3) Proizvođač; 4) Za izdavanje EU izjave o sukladnosti odgovoran je isključivo proizvođač; 5) Predmet deklaracije; 6) Model/Tip; 7) Oznaka; 8) Deskripcija; 9) Predmet navedene izjave u skladu je s mjerodavnim zakonodavstvom Unije o usklađivanju; 10) Direktiva; 11) Standard; 12) Dodatne informacije; 13) Potpisao za iu ime
MAGYAR; 1) EU–Megfelelőségi nyilatkozat; 2) Szám; 3) Gyártó; 4) Ezt a megfelelőségi nyilatkozatot a gyártó kizárólagos felelőssége mellett adják ki; 5) A nyilatkozat tárgya; 6) Modell/Típus; 7) Kijelölés; 8) Leírás; 9) A fent ismertetett nyilatkozat tárgya megfelel a vonatkozó uniós harmonizációs jogszabályoknak; 10) Irányelv; 11) Standard; 12) További információ; 13) Aláírva nevében
ÍSLENSKA; 1) ESB Leyfisyfirlýsing; 2) Fjöldi; 3) Framleiðandi; 4) Þessi samræmisyfirlýsing er sett alfarið á ábyrgð framleiðanda; 5) Markmið yfirlýsingarinnar; 6) Gerð; 7) Tilnefning; 8) Lýsing; 9) Markmið yfirlýsingarinnar lýst er hér að ofan er í samræmi við viðeigandi Union samhæfingu löggjafar; 10) Tilskipun; 11) Standard; 12) Viðbótarupplýsingar; 13) Undirritað fyrir og fyrir hönd
ITALIANO; 1) Dichiarazione di conformità UE; 2) Numero; 3) Produttore; 4) La presente dichiarazione di conformità è rilasciata sotto la responsabilità esclusiva del fabbricante; 5) Oggetto della dichiarazione; 6) Modello/Tipo; 7) Designazione; 8) Descrizione; 9) L'oggetto della dichiarazione di cui sopra è conforme alla pertinente normativa di armonizzazione dell'Unione; 10) Direttiva; 11) Standard; 12) Informazioni aggiuntive; 13) Firmato e per conto di
LATVIEŠU; 1) ES Atbilstības deklarācija; 2) Numurs; 3) Ražotājs; 4) Šī atbilstības deklarācija ir izdota vienīgi uz ražotāja atbildību; 5) Deklarācijas priekšmets; 6) Modelis/tips; 7) Apzīmējums; 8) Apraksts; 9) Iepriekš aprakstītais deklarācijas priekšmets atbilst attiecīgajam Savienības saskaņošanas tiesību aktam; 10) Direktīva; 11) Standarts; 12) Papildus informācija; 13) Parakstīts vārdā
LIETUVIŲ; 1) ES Atitikties deklaracija; 2) Skaičius; 3) Gamintojas; 4) Ši atitikties deklaracija išduota tik gamintojo atsakomybe; 5) Deklaracijos objektas; 6) Modelis/tipas; 7) Pavadinimas; 8) Aprašymas; 9) Pirmiau aprašytas deklaracijos objektas atitinka susijusius derinamuosius Sąjungos teisės aktus; 10) Direktyva; 11) Standartinė; 12) Papildoma informacija; 13) Pasirašyta ir vardu
MALTESE; 1) Dikjarazzjoni ta' konformità tal-UE; 2) Numru; 3) Manifattur; 4) Din id-dikjarazzjoni ta' konformità tinħareg taħt ir-responsabbiltà unika tal-manifattur; 5) Għan tad-dikjarazzjoni; 6) Mudell/Tip; 7) Deżinjazzjoni; 8) Deskrizzjoni; 9) L-għan tad-dikjarazzjoni deskritt hawn fuq huwa konformi mal-leġislazzjoni ta' armonizzazzjoni rilevanti tal-Unjoni; 10) Direttiva; 11) Standard; 12) informazzjoni addizzjonali; 13) Iffirmat għal u f'isem il
NEDERLANDS; 1) EU-Conformiteitsverklaring; 2) Nummer; 3) Fabrikant; 4) Deze conformiteitsverklaring wordt verstrekt onder volledige verantwoordelijkheid van de fabrikant; 5) Voorwerp van de verklaring; 6) Model/Type; 7) Benaming; 8) Beschrijving; 9) Het hierboven beschreven voorwerp is in overeenstemming met de desbetreffende harmonisatiewetgeving van de Unie; 10) Richtlijn; 11) Standaard; 12) Aanvullende informatie; 13) Ondertekend voor en namens
NORSK; 1) EU-Erklæring; 2) Nummer; 3) Produsent; 4) Denne samsvarserklæringen er utstedt under ansvar av produsenten; 5) Formålet med erklæringen; 6) Type; 7) Betegnelse; 8) Beskrivelse; 9) Formålet med erklæringen som er beskrevet ovenfor er i samsvar med relevante Union harmoniseringslovgivning; 10) Direktiv; 11) Standard; 12) Ytterligere informasjon; 13) Signert for og vegne av
POLSKI; 1) Deklaracja zgodności UE; 2) Numer; 3) Producent; 4) Niniejsza deklaracja zgodności wydana zostaje na wyłączną odpowiedzialność producenta; 5) Przedmiot deklaracji; 6) Model/Typ; 7) Oznaczenie; 8) Opis; 9) Wymieniony powyżej przedmiot niniejszej deklaracji jest zgodny z odnośnymi wymaganiami unijnego prawodawstwa harmonizacyjnego; 10) Dyrektywa; 11) Standard; 12) Dodatkowe informacje; 13) Podpisano imieniu
PORTUGUÊS; 1) Declaração UE de conformidade; 2) Número; 3) Fabricante; 4) A presente declaração de conformidade é emitida sob a exclusiva responsabilidade do fabricante; 5) Objecto da declaração; 6) Modelo/Tipo; 7) A denominação; 8) Descrição; 9) O objeto da declaração acima descrito está em conformidade com a legislação de harmonização da União aplicável; 10) Directiva; 11) Padrão; 12) Informações adicionais; 13) Assinado por e nome
ROMÂNĂ; 1) Declarația UE de conformitate; 2) Număr; 3) Producător; 4) Prezenta declarație de conformitate este emisă pe răspunderea exclusivă a producătorului; 5) Obiectul declarației; 6) Model/Tip; 7) Desemnare; 8) Descriere; 9) Obiectul declarației descris mai sus este în conformitate cu legislația relevantă de armonizare a Uniunii; 10) Directivă; 11) Standard; 12) Informatii aditionale; 13) Semnat pentru și în numele
SLOVENSKÝ; 1) EÚ Vyhlásenie o zhode; 2) Číslo; 3) Výrobca; 4) Toto vyhlásenie o zhode sa vydáva na výhradnú zodpovednosť výrobcu; 5) Predmet vyhlásenia; 6) Model/Typ; 7) Označenie; 8) Popis; 9) Uvedený predmet vyhlásenia je v zhode s príslušnými harmonizačnými právnymi predpismi Únie; 10) Smernice; 11) Štandardné; 12) Doplňujúce informácie; 13) Podpísané za av mene na
SLOVENŠČINA; 1) Izjava EU o skladnosti; 2) Število; 3) Proizvajalec; 4) Ta izjava o skladnosti je izdana na lastno odgovornost proizvajalca; 5) Predmet izjave; 6) Model/Type; 7) Oznaka; 8) Opis; 9) Predmet navedene izjave je v skladu z ustrezno zakonodajo Unije o harmonizaciji; 10) Direktiva; 11) Standardna; 12) Dodatne informacije; 13) Podpisano za in v imenu
ESPAÑOL; 1) Declaración UE de conformidad; 2) Número; 3) Fabricante; 4) La presente declaración de conformidad se expide bajo la exclusiva responsabilidad del fabricante; 5) Objeto de la declaración; 6) Tipo de modelo; 7) Designación; 8) Descripción; 9) El objeto de la declaración descrita anteriormente es conforme con la legislación de armonización pertinente de la Unión; 10) Directiva; 11) Estándar; 12) Información Adicional; 13) Firmado por y nombre

8

Declaration of Conformity, continued

Plockmatic Group

EU & UK DECLARATION OF CONFORMITY [1]

No.[2] ..... **D0000356 (K.5)**
Manufacturer [3] ..... Plockmatic International AB, Telefonvägen 30, S-126 26 Hägersten, Sweden

This declaration of conformity is issued under the sole responsibility of the manufacturer [4]

Object of the Declaration [5]	
Type/Model [6]	**PL4700, F680**
Name [7]	BST4000, BST4000-1, F680, Y980, BST6200, F656, PLBS
Description [8]	Belt Conveyor Stacker

The object of the declaration is in conformity with the requirements of the following documents [9]

EU Directive [10] *UK Statutory Instrument*	**Standard** [11] *UK Designated Standard*
(LVD) 2014/35/EU *S.I. 2016/1101*	EN 62368-1:2014 + A11:2017
(EMC) 2014/30/EU *S.I. 2016/1091*	EN 55032:2015 + A11:2020, Class A, EN 55035:2017 + A11:2020, EN 61000-3-2:2014, EN 61000-3-3:2013
(RoHS) 2011/65/EU *S.I. 2012/3032*	EN 62321:2009, EN 63000:2018

Additional information [12] International certification: UL 62368-1, 2nd Ed, 2014-12-01, CAN/CSA C22.2 No. 62368-1-14, 2nd Ed., FCC Part 15 (2015) Subpart B, Class A, ICES-003 Issue 6:2016, Class B, IEC 62368-1:2014 (Second Edition). List of countries addressed: Australia / New Zealand, EU Group and National Differences, Japan, USA / Canada

Signed for and on behalf of [13] Hägersten, 2021-12-16 09:27

Bengt Olenfalk
Group Quality Manager

БЪЛГАРСКИ; 1) ЕС Декларация за съответствие; 2) Номер; 3) Производител; 4) Настоящата декларация за съответствие е издадена на отговорността на производителя; 5) Предмет на декларацията; 6) Модел/Тип; 7) Назначение; 8) Описание; 9) Предметът на декларацията, описан по-горе, отговаря на съответното законодателство на Съюза за хармонизация; 10) Директива; 11) Стандарт ; 12) Допълнителна информация; 13) Подписано за и от името на
ČESKÝ; 1) EU Prohlášení o shodě; 2) Číslo; 3) Výrobce; 4) Toto prohlášení o shodě se vydává na výhradní odpovědnost výrobce; 5) Předmět prohlášení; 6) Model/Typ; 7) Označení; 8) Popis; 9) Výše popsaný předmět prohlášení je ve shodě s příslušnými harmonizačními právními předpisy Unie; 10) Směrnice; 11) Norma; 12) Dodatečné informace; 13) Podepsáno za a jménem na
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DEUTSCH; 1) EU-Konformitätserklärung; 2) Nummer; 3) Hersteller; 4) Die alleinige Verantwortung für die Ausstellung dieser Konformitätserklärung trägt der Hersteller; 5) Gegenstand der Erklärung; 6) Modell/Typ; 7) Bezeichnung; 8) Beschreibung; 9) Der oben beschriebene Gegenstand der Erklärung erfüllt die einschlägigen Harmonisierungsrechtsvorschriften der Union; 10) Direktive; 11) Standard; 12) Weitere Informationen; 13) Zur Unterzeichnung und Namen
EESTI; 1) ELi Vastavusdeklaratsioon; 2) Number; 3) Valmistaja; 4) Käesolev vastavusdeklaratsioon on välja antud tootja ainuvastutusel; 5) Deklareeritav; 6) Mudel/Type; 7) Nimetus; 8) Kirjeldus; 9) Eelkirjeldatud deklareeritav toode on kooskõlas asjaomaste liidu ühtlustamisaktidega; 10) Direktiivi; 11) Standard; 12) Lisainfo; 13) Allkirjastatud ja nimel
SUOMI; 1) EU-Vaatimustenmukaisuusvakuutus; 2) Määrä; 3) Valmistaja; 4) Tämä vaatimustenmukaisuusvakuutus on annettu valmistajan yksinomaisella vastuulla; 5) Vakuutuksen kohde; 6) Malli/Tyyppi; 7) Nimitys; 8) Kuvaus; 9) Edellä kuvattu vakuutuksen kohde on asiaa koskevan unionin yhdenmukaistamislainsäädännön vaatimusten mukainen; 10) Direktiivi; 11) Standardi; 12) Lisäinformaatio; 13) Allekirjoitettu ja puolesta
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GAEILGE; 1) Dearbhú comhréireachta AE; 2) Uimhir; 3) Monaróir; 4) Tá an dearbhú comhréireachta arna eisiúint faoi fhreagracht an mhonaróra; 5) Cuspóir an dearbhaithe; 6) Cineál; 7) Ainmniú; 8) Tuairisc; 9) Is é cuspóir an dearbhaithe a thugtar i gcomhréir leis an reachtaíocht chomhchuibhithe ábhartha an Aontais; 10) Treoir; 11) Caighdeánach; 12) Eolas breise; 13) Arna shíniú le haghaidh agus thar ceann an
ΕΛΛΗΝΙΚΗ; 1) Δήλωση συμμορφωσησ ΕΕ; 2) αριθμός; 3) Κατασκευαστής; 4) Η παρούσα δήλωση συμμόρφωσης εκδίδεται με αποκλειστική ευθύνη του κατασκευαστή; 5) Αντικείμενο της δήλωσης; 6) Μοντέλο/Τύπος; 7) Ονομασία; 8) Περιγραφή; 9) Ο στόχος της δήλωσης που περιγράφεται παραπάνω είναι σύμφωνος με τη σχετική ενωσιακή νομοθεσία εναρμόνισης; 10) διευθυντικός; 11) Πρότυπο; 12) Επιπλέον πληροφορίες; 13) Υπογραφή για λογαριασμό και εξ ονόματος του
HRVATSKI; 1) EU Izjava o sukladnosti; 2) Broj; 3) Proizvođač; 4) Za izdavanje EU izjave o sukladnosti odgovoran je isključivo proizvođač; 5) Predmet deklaracije; 6) Model/Tip; 7) Oznaka; 8) Deskripcija; 9) Predmet navedene izjave u skladu je s mjerodavnim zakonodavstvom Unije o usklađivanju; 10) Direktiva; 11) Standard; 12) Dodatne informacije; 13) Potpisao za iu ime
MAGYAR; 1) EU–Megfelelőségi nyilatkozat; 2) Szám; 3) Gyártó; 4) Ezt a megfelelőségi nyilatkozatot a gyártó kizárólagos felelőssége mellett adják ki; 5) A nyilatkozat tárgya; 6) Modell/Típus; 7) Kijelölés; 8) Leírás; 9) A fent ismertetett nyilatkozat tárgya megfelel a vonatkozó uniós harmonizációs jogszabályoknak; 10) Irányelv; 11) Standard; 12) További információ; 13) Aláírva nevében
ÍSLENSKA; 1) ESB Leyfisyfirlýsing; 2) Fjöldi; 3) Framleiðandi; 4) Þessi samræmisyfirlýsing er sett alfarið á ábyrgð framleiðanda; 5) Markmið yfirlýsingarinnar; 6) Gerð; 7) Tilnefning; 8) Lýsing; 9) Markmið yfirlýsingarinnar lýst er hér að ofan er í samræmi við viðeigandi Union samhæfingu löggjafar; 10) Tilskipun; 11) Standard; 12) Viðbótarupplýsingar; 13) Undirritað fyrir og fyrir hönd
ITALIANO; 1) Dichiarazione di conformità UE; 2) Numero; 3) Produttore; 4) La presente dichiarazione di conformità è rilasciata sotto la responsabilità esclusiva del fabbricante; 5) Oggetto della dichiarazione; 6) Modello/Tipo; 7) Designazione; 8) Descrizione; 9) L'oggetto della dichiarazione di cui sopra è conforme alla pertinente normativa di armonizzazione dell'Unione; 10) Direttiva; 11) Standard; 12) Informazioni aggiuntive; 13) Firmato e per conto di
LATVIEŠU; 1) ES Atbilstības deklarācija; 2) Numurs; 3) Ražotājs; 4) Šī atbilstības deklarācija ir izdota vienīgi uz ražotāja atbildību; 5) Deklarācijas priekšmets; 6) Modelis/tips; 7) Apzīmējums; 8) Apraksts; 9) Iepriekš aprakstītais deklarācijas priekšmets atbilst attiecīgajam Savienības saskaņošanas tiesību aktam; 10) Direktīva; 11) Standarts; 12) Papildus informācija; 13) Parakstīts vārdā
LIETUVIŲ; 1) ES Atitikties deklaracija; 2) Skaičius; 3) Gamintojas; 4) Ši atitikties deklaracija išduota tik gamintojo atsakomybe; 5) Deklaracijos objektas; 6) Modelis/tipas; 7) Pavadinimas; 8) Aprašymas; 9) Pirmiau aprašytas deklaracijos objektas atitinka susijusius derinamuosius Sąjungos teisės aktus; 10) Direktyva; 11) Standartinė; 12) Papildoma informacija; 13) Pasirašyta ir vardu
MALTESE; 1) Dikjarazzjoni ta' konformità tal-UE; 2) Numru; 3) Manifattur; 4) Din id-dikjarazzjoni ta' konformità tinħareg taħt ir-responsabbiltà unika tal-manifattur; 5) Għan tad-dikjarazzjoni; 6) Mudell/Tip; 7) Deżinjazzjoni; 8) Deskrizzjoni; 9) L-għan tad-dikjarazzjoni deskritt hawn fuq huwa konformi mal-leġislazzjoni ta' armonizzazzjoni rilevanti tal-Unjoni; 10) Direttiva; 11) Standard; 12) informazzjoni addizzjonali; 13) Iffirmat għal u f'isem il
NEDERLANDS; 1) EU-Conformiteitsverklaring; 2) Nummer; 3) Fabrikant; 4) Deze conformiteitsverklaring wordt verstrekt onder volledige verantwoordelijkheid van de fabrikant; 5) Voorwerp van de verklaring; 6) Model/Type; 7) Benaming; 8) Beschrijving; 9) Het hierboven beschreven voorwerp is in overeenstemming met de desbetreffende harmonisatiewetgeving van de Unie; 10) Richtlijn; 11) Standaard; 12) Aanvullende informatie; 13) Ondertekend voor en namens
NORSK; 1) EU-Erklæring; 2) Nummer; 3) Produsent; 4) Denne samsvarserklæringen er utstedt under ansvar av produsenten; 5) Formålet med erklæringen; 6) Type; 7) Betegnelse; 8) Beskrivelse; 9) Formålet med erklæringen som er beskrevet ovenfor er i samsvar med relevante Union harmoniseringslovgivning; 10) Direktiv; 11) Standard; 12) Ytterligere informasjon; 13) Signert for og vegne av
POLSKI; 1) Deklaracja zgodności UE; 2) Numer; 3) Producent; 4) Niniejsza deklaracja zgodności wydana zostaje na wyłączną odpowiedzialność producenta; 5) Przedmiot deklaracji; 6) Model/Typ; 7) Oznaczenie; 8) Opis; 9) Wymieniony powyżej przedmiot niniejszej deklaracji jest zgodny z odnośnymi wymaganiami unijnego prawodawstwa harmonizacyjnego; 10) Dyrektywa; 11) Standard; 12) Dodatkowe informacje; 13) Podpisano imieniu
PORTUGUÊS; 1) Declaração UE de conformidade; 2) Número; 3) Fabricante; 4) A presente declaração de conformidade é emitida sob a exclusiva responsabilidade do fabricante; 5) Objecto da declaração; 6) Modelo/Tipo; 7) A denominação; 8) Descrição; 9) O objeto da declaração acima descrito está em conformidade com a legislação de harmonização da União aplicável; 10) Directiva; 11) Padrão; 12) Informações adicionais; 13) Assinado por e nome
ROMÂNĂ; 1) Declarația UE de conformitate; 2) Număr; 3) Producător; 4) Prezenta declarație de conformitate este emisă pe răspunderea exclusivă a producătorului; 5) Obiectul declarației; 6) Model/Tip; 7) Desemnare; 8) Descriere; 9) Obiectul declarației descris mai sus este în conformitate cu legislația relevantă de armonizare a Uniunii; 10) Directivă; 11) Standard; 12) Informatii aditionale; 13) Semnat pentru și în numele
SLOVENSKÝ; 1) EÚ Vyhlásenie o zhode; 2) Číslo; 3) Výrobca; 4) Toto vyhlásenie o zhode sa vydáva na výhradnú zodpovednosť výrobcu; 5) Predmet vyhlásenia; 6) Model/Typ; 7) Označenie; 8) Popis; 9) Uvedený predmet vyhlásenia je v zhode s príslušnými harmonizačnými právnymi predpismi Únie; 10) Smernice; 11) Štandardné; 12) Doplňujúce informácie; 13) Podpísané za av mene na
SLOVENŠČINA; 1) Izjava EU o skladnosti; 2) Število; 3) Proizvajalec; 4) Ta izjava o skladnosti je izdana na lastno odgovornost proizvajalca; 5) Predmet izjave; 6) Model/Type; 7) Oznaka; 8) Opis; 9) Predmet navedene izjave je v skladu z ustrezno zakonodajo Unije o harmonizaciji; 10) Direktiva; 11) Standardna; 12) Dodatne informacije; 13) Podpisano za in v imenu
ESPAÑOL; 1) Declaración UE de conformidad; 2) Número; 3) Fabricante; 4) La presente declaración de conformidad se expide bajo la exclusiva responsabilidad del fabricante; 5) Objeto de la declaración; 6) Tipo de modelo; 7) Designación; 8) Descripción; 9) El objeto de la declaración descrita anteriormente es conforme con la legislación de armonización pertinente de la Unión; 10) Directiva; 11) Estándar; 12) Información Adicional; 13) Firmado por y nombre
SVENSKA; 1) EU-Försäkran om överensstämmelse; 2) Nummer; 3) Tillverkare; 4) Denna försäkran om överensstämmelse utfärdas på tillverkarens eget ansvar; 5) Föremålet för försäkran; 6) Modell/Typ; 7) Beteckning; 8) Beskrivning; 9) Föremålet för försäkran ovan överensstämmer med den relevanta harmoniserade unionslagstiftningen; 10) Direktiv; 11) Standard; 12) Extra information; 13) Undertecknat för och på uppdrag av

Plockmatic Group

morgana

EU & UK DECLARATION OF CONFORMITY [1]

No.[2] ..... **N0007516 (C.3)**
Manufacturer [3] ..... Morgana Systems Ltd, Davy Ave., Milton Keynes MK5 8HJ, United Kingdom

This Declaration of Conformity is issued under the sole responsibility of the manufacturer [4]

Object of the Declaration [5]	
Type/Model [6]	**F161-x0z, where x represents customization and z variant**
Name [7]	**2-Knife Trimmer, P2T, ST5000**
Description [8]	**Booklet Trimmer**

The object of the declaration is in conformity with the requirements of the following documents: [9]

Directive [10] *UK Statutory Instrument*	**Standard** [11] *UK Designated Standard*
(LVD) 2014/35/EU *S.I. 2016/1101*	EN 62368-1:2014 + A11:2017 BS EN 62368-1:2014 + A11:2017
(EMC) 2014/30/EU *S.I. 2016/1091*	EN 55032:2015 + A11:2020 (Class A), EN 55035:2017 + A11:2020, EN 61000-3-2:2014, EN 61000-3-3:2013
(RoHS) 2011/65/EU *S.I. 2012/3032*	EN 62321:2009, EN 63000:2018
Additional information [12] International certification: UL 62368-1, 2nd Edition; CSA C22.2 No. 62368-1:2014; IEC 62368-1:2014; FCC CFR 47: Part 15, Subpart B:2012; ICES-003:2004; VCCI: April 2012	
Signed for and on behalf of [13] Hägersten, 2021-12-16 13:15  Bengt Olenfalk Group Quality Manager	

БЪЛГАРСКИ; 1) ЕС Декларация за съответствие; 2) Номер; 3) Производител; 4) Настоящата декларация за съответствие е издадена на отговорността на производителя; 5) Предмет на декларацията; 6) Модел/Тип; 7) Назначение; 8) Описание; 9) Предметът на декларацията, описан по-горе, отговаря на съответното законодателство на Съюза за хармонизация; 10) Директива; 11) Стандарт ; 12) Допълнителна информация; 13) Подписано за и от името на

ČESKÝ; 1) EU Prohlášení o shodě; 2) Číslo; 3) Výrobce; 4) Toto prohlášení o shodě se vydává na výhradní odpovědnost výrobce; 5) Předmět prohlášení; 6) Model/Typ; 7) Označení; 8) Popis; 9) Výše popsaný předmět prohlášení je ve shodě s příslušnými harmonizačními právními předpisy Unie; 10) Směrnice; 11) Norma; 12) Dodatečné informace; 13) Podepsáno za a jménem na

DANSK; 1) EU-Overensstemmelseserklæring; 2) Nummer; 3) Producent; 4) Denne overensstemmelseserklæring udstedes på fabrikantens ansvar; 5) Erklæringens genstand; 6) Model/Type; 7) Betegnelse; 8) Beskrivelse; 9) Genstanden for erklæringen, som beskrevet ovenfor, er i overensstemmelse med den relevante EU-harmoniseringslovgivning; 10) Direktiv; 11) Standard; 12) Yderligere information; 13) Underskrevet for og vegne

DEUTSCH; 1) EU-Konformitätserklärung; 2) Nummer; 3) Hersteller; 4) Die alleinige Verantwortung für die Ausstellung dieser Konformitätserklärung trägt der Hersteller; 5) Gegenstand der Erklärung; 6) Modell/Typ; 7) Bezeichnung; 8) Beschreibung; 9) Der oben beschriebene Gegenstand der Erklärung erfüllt die einschlägigen Harmonisierungsrechtsvorschriften der Union; 10) Direktive; 11) Standard; 12) Weitere Informationen; 13) Zur Unterzeichnung und Namen

EESTI; 1) ELi Vastavusdeklaratsioon; 2) Number; 3) Valmistaja; 4) Käesolev vastavausdeklaratsioon on välja antud tootja ainuvastutusel; 5) Deklareeritav; 6) Mudel/Type; 7) Nimetus; 8) Kirjeldus; 9) Eelkirjeldatud deklareeritav toode on kooskõlas asjaomaste liidu ühtlustamisaktidega; 10) Direktiivi; 11) Standard; 12) Lisainfo; 13) Allkirjastatud ja nimel

SUOMI; 1) EU-Vaatimustenmukaisuusvakuutus; 2) Määrä; 3) Valmistaja; 4) Tämä vaatimustenmukaisuusvakuutus on annettu valmistajan yksinomaisella vastuulla; 5) Vakuutuksen kohde; 6) Malli/Tyyppi; 7) Nimitys; 8) Kuvaus; 9) Edellä kuvattu vakuutuksen kohde on asiaa koskevan unionin yhdenmukaistamislainsäädännön vaatimusten mukainen; 10) Direktiivi; 11) Standardi; 12) Lisäinformaatio; 13) Allekirjoitettu ja puolesta

FRANÇAIS; 1) Déclaration UE de conformité; 2) Nombre; 3) Fabricant; 4) La présente déclaration de conformité est établie sous la seule responsabilité du fabricant; 5) Objet de la déclaration; 6) Modèle/type; 7) Désignation; 8) Description; 9) L'objet de la déclaration décrit ci-dessus est conforme à la législation d'harmonisation de l'Union applicable; 10) Directif; 11) Standard; 12) Information Supplémentaire; 13) Signé pour et au nom de

GAEILGE; 1) Dearbhú comhréireachta AE; 2) Uimhir; 3) Manufacturer; 4) Tá an dearbhú comhréireachta arna eisiúint faoi fhreagracht an mhonaróra; 5) Cuspóir an dearbhaithe; 6) Cineál; 7) Ainmniú; 8) Tuairisc; 9) Is é cuspóir an dearbhaithe a thugtar i gcomhréir leis an reachtaíocht chomhchuibhithe ábhartha an Aontais; 10) Treoir; 11) Caighdeánach; 12) Eolas breise; 13) Arna shíniú le haghaidh agus thar ceann an

ΕΛΛΗΝΙΚΗ; 1) Δηλωση συμμορφωσησ ΕΕ; 2) αριθμός; 3) Κατασκευαστής; 4) Η παρούσα δήλωση συμμόρφωσης εκδίδεται με αποκλειστική ευθύνη του κατασκευαστή; 5) Αντικείμενο της δήλωσης; 6) Μοντέλο/Τύπος; 7) Ονομασία; 8) Περιγραφή; 9) Ο στόχος της δήλωσης που περιγράφεται παραπάνω είναι σύμφωνος με τη σχετική ενωσιακή νομοθεσία εναρμόνισης; 10) διευθυντικός; 11) Πρότυπο; 12) Επιπλέον πληροφορίες; 13) Υπογραφή για λογαριασμό και εξ ονόματος του

HRVATSKI; 1) EU Izjava o sukladnosti; 2) Broj; 3) Proizvođač; 4) Za izdavanje EU izjave o sukladnosti odgovoran je isključivo proizvođač; 5) Predmet deklaracije; 6) Model/Tip; 7) Oznaka; 8) Deskripcija; 9) Predmet navedene izjave u skladu je s mjerodavnim zakonodavstvom Unije o usklađivanju; 10) Direktiva; 11) Standard; 12) Dodatne informacije; 13) Potpisao za iu ime

MAGYAR; 1) EU–Megfelelőségi nyilatkozat; 2) Szám; 3) Gyártó; 4) Ezt a megfelelőségi nyilatkozatot a gyártó kizárólagos felelőssége mellett adják ki; 5) A nyilatkozat tárgya; 6) Modell/Típus; 7) Kijelölés; 8) Leírás; 9) A fent ismertetett nyilatkozat tárgya megfelel a vonatkozó uniós harmonizációs jogszabályoknak; 10) Irányelv; 11) Standard; 12) További információ; 13) Aláírva nevében

ÍSLENSKA; 1) ESB Leyfisyfirlýsing; 2) Fjöldi; 3) Framleiðandi; 4) Þessi samræmisyfirlýsing er sett alfarið á ábyrgð framleiðanda; 5) Markmið yfirlýsingarinnar; 6) Gerð; 7) Tilnefning; 8) Lýsing; 9) Markmið yfirlýsingarinnar lýst er hér að ofan er í samræmi við viðeigandi Union samhæfingu löggjafar; 10) Tilskipun; 11) Standard; 12) Viðbótarupplýsingar; 13) Undirritað fyrir og fyrir hönd

ITALIANO; 1) Dichiarazione di conformità UE; 2) Numero; 3) Produttore; 4) La presente dichiarazione di conformità è rilasciata sotto la responsabilità esclusiva del fabbricante; 5) Oggetto della dichiarazione; 6) Modello/Tipo; 7) Designazione; 8) Descrizione; 9) L'oggetto della dichiarazione di cui sopra è conforme alla pertinente normativa di armonizzazione dell'Unione; 10) Direttiva; 11) Standard; 12) Informazioni aggiuntive; 13) Firmato e per conto di

LATVIEŠU; 1) ES Atbilstības deklarācija; 2) Numurs; 3) Ražotājs; 4) Šī atbilstības deklarācija ir izdota vienīgi uz ražotāja atbildību; 5) Deklarācijas priekšmets; 6) Modelis/tips; 7) Apzīmējums; 8) Apraksts; 9) Iepriekš aprakstītais deklarācijas priekšmets atbilst attiecīgajam Savienības saskaņošanas tiesību aktam; 10) Direktīva; 11) Standarts; 12) Papildus informācija; 13) Parakstīts vārdā

LIETUVIŲ; 1) ES Atitikties deklaracija; 2) Skaičius; 3) Gamintojas; 4) Ši atitikties deklaracija išduota tik gamintojo atsakomybe; 5) Deklaracijos objektas; 6) Modelis/tipas; 7) Pavadinimas; 8) Aprašymas; 9) Pirmiau aprašytas deklaracijos objektas atitinka susijusius derinamuosius Sąjungos teisės aktus; 10) Direktyva; 11) Standartinė; 12) Papildoma informacija; 13) Pasirašyta ir vardu

MALTESE; 1) Dikjarazzjoni ta' konformità tal-UE; 2) Numru; 3) Manifattur; 4) Din id-dikjarazzjoni ta' konformità tinħareg taħt ir-responsabbiltà unika tal-manifattur; 5) Għan tad-dikjarazzjoni; 6) Mudell/Tip; 7) Deżinjazzjoni; 8) Deskrizzjoni; 9) L-għan tad-dikjarazzjoni deskritt hawn fuq huwa konformi mal-leġislazzjoni ta' armonizzazzjoni rilevanti tal-Unjoni; 10) Direttiva; 11) Standard; 12) informazzjoni addizzjonali; 13) Iffirmat għal u f'isem il

NEDERLANDS; 1) EU-Conformiteitsverklaring; 2) Nummer; 3) Fabrikant; 4) Deze conformiteitsverklaring wordt verstrekt onder volledige verantwoordelijkheid van de fabrikant; 5) Voorwerp van de verklaring; 6) Model/Type; 7) Benaming; 8) Beschrijving; 9) Het hierboven beschreven voorwerp is in overeenstemming met de desbetreffende harmonisatiewetgeving van de Unie; 10) Richtlijn; 11) Standaard; 12) Aanvullende informatie; 13) Ondertekend voor en namens

NORSK; 1) EU-Erklæring; 2) Nummer; 3) Produsent; 4) Denne samsvarserklæringen er utstedt under ansvar av produsenten; 5) Formålet med erklæringen; 6) Type; 7) Betegnelse; 8) Beskrivelse; 9) Formålet med erklæringen som er beskrevet ovenfor er i samsvar med relevante Union harmoniseringslovgivning; 10) Direktiv; 11) Standard; 12) Ytterligere informasjon; 13) Signert for og vegne av

POLSKI; 1) Deklaracja zgodności UE; 2) Numer; 3) Producent; 4) Niniejsza deklaracja zgodności wydana zostaje na wyłączną odpowiedzialność producenta; 5) Przedmiot deklaracji; 6) Model/Typ; 7) Oznaczenie; 8) Opis; 9) Wymieniony powyżej przedmiot niniejszej deklaracji jest zgodny z odnośnymi wymaganiami unijnego prawodawstwa harmonizacyjnego; 10) Dyrektywa; 11) Standard; 12) Dodatkowe informacje; 13) Podpisano imieniu

PORTUGUÊS; 1) Declaração UE de conformidade; 2) Número; 3) Fabricante; 4) A presente declaração de conformidade é emitida sob a exclusiva responsabilidade do fabricante; 5) Objecto da declaração; 6) Modelo/Tipo; 7) A denominação; 8) Descrição; 9) O objeto da declaração acima descrito está em conformidade com a legislação de harmonização da União aplicável; 10) Directiva; 11) Padrão; 12) Informações adicionais; 13) Assinado por e nome

ROMÂNĂ; 1) Declarația UE de conformitate; 2) Număr; 3) Producător; 4) Prezenta declarație de conformitate este emisă pe răspunderea exclusivă a producătorului; 5) Obiectul declarației; 6) Model/Tip; 7) Desemnare; 8) Descriere; 9) Obiectul declarației descris mai sus este în conformitate cu legislația relevantă de armonizare a Uniunii; 10) Directivă; 11) Standard; 12) Informatii aditionale; 13) Semnat pentru și în numele

SLOVENSKÝ; 1) EÚ Vyhlásenie o zhode; 2) Číslo; 3) Výrobca; 4) Toto vyhlásenie o zhode sa vydáva na výhradnú zodpovednosť výrobcu; 5) Predmet vyhlásenia; 6) Model/Typ; 7) Označenie; 8) Popis; 9) Uvedený predmet vyhlásenia je v zhode s príslušnými harmonizačnými právnymi predpismi Únie; 10) Smernice; 11) Štandardné; 12) Doplňujúce informácie; 13) Podpísané za av mene na

SLOVENŠČINA; 1) Izjava EU o skladnosti; 2) Število; 3) Proizvajalec; 4) Ta izjava o skladnosti je izdana na lastno odgovornost proizvajalca; 5) Predmet izjave; 6) Model/Type; 7) Oznaka; 8) Opis; 9) Predmet navedene izjave je v skladu z ustrezno zakonodajo Unije o harmonizaciji; 10) Direktiva; 11) Standardna; 12) Dodatne informacije; 13) Podpisano za in v imenu

ESPAÑOL; 1) Declaración UE de conformidad; 2) Número; 3) Fabricante; 4) La presente declaración de conformidad se expide bajo la exclusiva responsabilidad del fabricante; 5) Objeto de la declaración; 6) Tipo de modelo; 7) Designación; 8) Descripción; 9) El objeto de la declaración descrita anteriormente es conforme con la legislación de armonización pertinente de la Unión; 10) Directiva; 11) Estándar; 12) Información Adicional; 13) Firmado por y nombre

SVENSKA; 1) EU-Försäkran om överensstämmelse; 2) Nummer; 3) Tillverkare; 4) Denna försäkran om överensstämmelse utfärdas på tillverkarens eget ansvar; 5) Föremålet för försäkran; 6) Modell/Typ; 7) Beteckning; 8) Beskrivning; 9) Föremålet för försäkran ovan överensstämmer med den relevanta harmoniserade unionslagstiftningen; 10) Direktiv; 11) Standard; 12) Extra information; 13) Undertecknat för och på uppdrag av