



BAUMFOLDER

# Operator Control Panel Operation Instructions

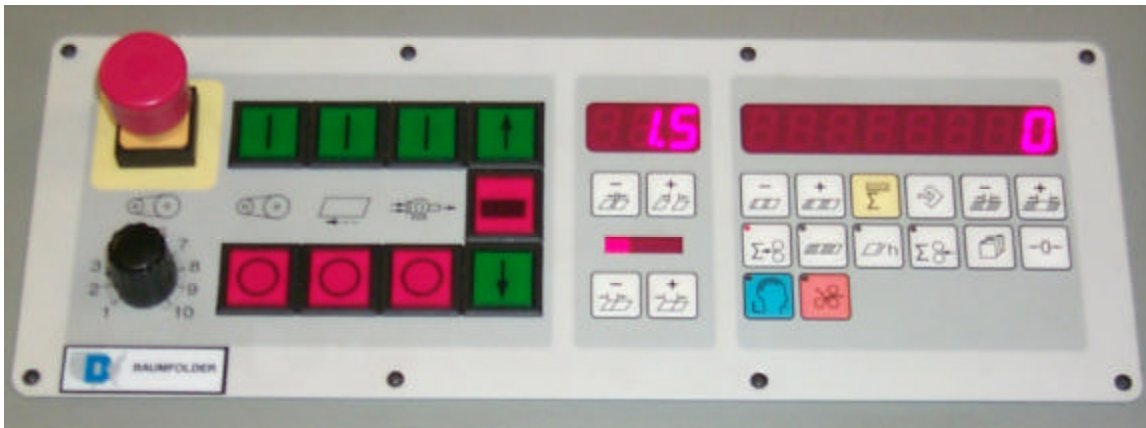
For Model(s):

2015 Pile Feed

2018 Pile Feed

2020 Pile Feed

2020 Continuous Feed








## **BAUMFOLDER 2000 Series “QUICK START” INSTRUCTIONS**

### **TURNING THE MAIN SWITCH ON**


When you turn on the Main Power Switch located on the side of the Control Box , you must let the Control automatically run a self-test. During the self-test **DO NOT** Press any buttons. Pressing of a button will cause an Error Message to appear in the Main Display. To CLEAR Message turn Power OFF at the Main Power Switch—WAIT **5 SECONDS**, then turn Power back on.

1. Turn on Main Power Switch on left side of control enclosure.  
- Wait until control finishes self-test.
2. Load paper on Pile Feed Table. Press Pile up  GREEN Button  
Pile will raise automatically to correct height.


NOTE: To STOP Pile—Press RED  Button

3. To START Drive Motor & Pump—Press GREEN Button ABOVE the  l.  
To STOP Drive Motor ---Press RED Button BELOW th  bol or Press EMERGENCY STOP BUTTON

### **RAISING AND LOWERING THE PILE FEEDER LIFT TABLE**

1. After loading paper onto Pile Feeder Lift Table, Press the GREEN  Button  
This will raise the paper to the proper feeding height automatically. You can stop the Pile Feeder Lift Table by Pressing the RED Pile Feeder

STOP  Button


2. To lower the Pile Feeder Table, you must first Press the RED Pile Feeder STOP  Button




Then Press the GREEN  Button to lower Pile Feed Table. The Table will lower and stop automatically in its lowest position.

## STARTING PRODUCTION WITH THE BAUM 2020

1. To START the Folder Drive, Press the GREEN Button on the Control Panel

just ABOVE the  symbol, this will Start the Folder Drive and the Pump will automatically come on.


2. To STOP the Folder Drive, Press the RED Button on the Control Panel

just BELOW the  symbol or Press the RED EMERGENCY STOP Button on the Control Panel or on the Stacker Control Panel. The Folder Drive will STOP, The Pump may continue to run for about 7 seconds. If you want to stop the pump at the same time as the folder drive press the Drive STOP button twice within a 0.5 seconds.

The Pump circuit has a minimum ON time of 4 SECONDS. If the Pump is commanded OFF within 4 seconds after it is started, it will continue run for the duration of the 4 seconds and then shut OFF.

3. To Turn the Pump ON without the Folder Drive coming On, Press the

GREEN Button ABOVE the  symbol

4. To Turn the Pump OFF, Press the RED Button BELOW the  symbol NOTE: the Pump will stay ON for at least 4 SECONDS before being able to shut off.

### **Easy Mode:**


This mode is an automatic setup mode that sets the sheet gap to 1 inch and vacuum duration to 5 inches. Most jobs may be ran with this mode of operation. A Z-fold or a product with a window will require the Continuous Mode of operation. [You can not change the sheet gap or vacuum duration settings manually using the Easy-Mode. Only the DCT500 mode or Continuous Cycle mode allows adjustment of these settings.](#)



The Easy-Mode is used for folds that require half of the sheet length or less going into the foldplate. These folding applications normally operate with a 1.0 Inch sheet gap. If you are folding half of the sheet length or more into the foldplate you must have a greater gap.

## TURN THE EASY-PARAMETER ON/OFF

1. Press the  **Machine Setup button** found in the top row.

2. Press the  **Sheet Gap + or – Buttons** until **P20** appears in the sheet gap display.


3. Press the  **Batch Count + Button** until **P25** appears in the sheet gap display. You will now see the word “EASY” in the counter display, see Figure E1.



Figure E1.



**4.** Look to the right hand end of the counter display. If an “ 1 “ appears in the display the Easy-Parameter is turned on. If an “ 0 “ is displayed, the Easy-Parameter is turned off, see Figure E1.



To turn the Easy-Parameter on or off, **Press the Plus (+) button for the batch time delay setup.** Pressing this button changes the “ 1 “ to an “ 0 “ and back. This button is found at the far right side of the top row, see Figure E1.



**5.** Press the **Machine Setup button again** in the top row to confirm and exit programming mode.

## SELECT EASY MODE



Pressing this button enables the selection of either the EASY mode or cYcL mode



Pressing these buttons will toggle between the **EASY** mode or **cYcL** mode. Set **EASY** in the large display. You will notice that the sheet gap display screen has (3) dashes when the Easy Mode is on and a number when it is off.



Press the mode selection button again to exit mode selection.

## SELECT CONTINUOUS CYCLE MODE

It is recommended to use the continuous cycle mode when the job requires more than  $\frac{1}{2}$  of the sheet length to go in the #1 fold plate or if the product has a window that will be sensed as the trailing edge of the sheet.

The continuous cycle mode allows you to select the SHEET GAP, SHEET LENGTH and the SUCTION LENGTH.



Pressing this button enables the selection of either the EASY mode or cYcL mode



Pressing these buttons will toggle between the **EASY** mode or **cYcL** mode. Set **cYcL** in the large display (see figure E1).

## SETTING THE SHEET GAP AND SHEET LENGTH



The small 3 digit display shows the current setting for the sheet gap. The number on the right hand side of the large display (1) represents the current sheet length. Set the sheet gap and sheet length for the current job.

## SETTING THE SUCTION LENGTH




Use the + and – buttons under the 10 segment bar graph display to adjust the suction length. Each segment represents 5% of sheet length. If 10 segments are illuminated 50% of sheet length is selected. So, it is important that the sheet length is set properly for the current job.




Press the mode selection button again to exit mode selection.



## TO START FEEDING

1. Press the GREEN Button to START the Folder Drive and the Pump.
2. Press the GREEN Button ABOVE the  symbol to START the Vacuum Solenoid. The Sucker Wheel will pull a sheet from the Feeder onto the Register.

## TO STOP FEEDING

1. Press the RED Button BELOW the  symbol. This will turn the Vacuum Solenoid OFF. The Sucker Wheel will STOP pulling sheets—BUT the Folder Drive and the Pump will stay ON.


NOTE: You can also STOP feeding by Pressing the

RED PILE FEEDER STOP  BUTTON.



## CHANGE SPEED OF FOLDER DRIVE

To change the speed of the Folder Drive, just turn the Potentiometer Speed adjust Knob on the Main Control Panel 1 thru 10, 10 being maximum speed

## MACHINE PARAMETERS



Pressing  Button allows access to the Machine Parameters. The Machine Parameters may be monitored, some changed and various options (kicker, pile re-load, etc.) enabled or disabled.



Navigation through the parameters is accomplished by using the following procedure:


1. Pressing  and  directly UNDER the 3 digit display will select the various Parameters **Groups** by count of tens.







## BAUMFOLDER

EXAMPLE: Hold the  MINUS Button, this will automatically count back to P00 (group P0). Now by Pressing the  Button will take you to the next Parameter Group **P10 – P20 – P30 – P40 – P50 – P60**

2. Pressing  and  directly UNDER the left 3 digits of the Large 8 digit display, this will select the individual Parameters in a select group.

EXAMPLE: Start with the first Group of Parameters, the 3 digit display reads P00. Pressing the  this will take you to Parameters **P01 – P02 – P03 – P04 – P05**

- To go to the next Group of Parameters Press   
The display will show P10. Pressing the  button will take you to Parameters **P11 – P12 – P13 – P14** (continue this sequence to move thru the rest of the Parameter Groups **P20 – P30 – P40 – P50 – P60**)

3. To change one of the machines Parameter Settings Press  or  Buttons UNDER the right most 2 digits of the large 8 digit display.

The following is a list of the available parameters. Please see the Operators Manual for a definition of each parameter.





## BAUMFOLDER

P00 - InPUt = 1

P01 - oUt = 1

P02 - ErEnAt = 0

P03 - HniFE = 0

P04 - ErGo = 0

P05 - □□□ = 0

P10 - SPd = 0 = The speed the machine is running meter/min.

P11 - 0.00 = Job Run Time

P12 - 0.00 = Job Stop Time

P13 - 0.00 = Job Make Ready Time

P14 - 0.00 = Pause Time

P20 - Inches

P21 - EnGlish

P23 - PAUSE = 0

P25 - EASY = 1

P26 - dct = 2.6.4

P27 - P - 2020

P28 - Port OFF

P30 - 01000000

P31 - 10000000

P32 - 00000000

P33 - 00000000

P34 - 00000010

P35 - 00000000

P40 - 0.00

P41 - 0.00

P42 - 0.00

P43 - 0

P44 - 0

P45 - 0


P50 = The number of hours the machine is powered on.

P51 = The number of hours the machine is running.

P52 = The total number of sheets counted thru the machine.

P60 - test = 0






To get out of the Machine Parameter Settings Mode, Press  again. The displays will return to normal operations.


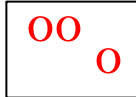
## BATCH COUNTING SETUP

To enter Batch Count Set-Up, Press 

- This will bring up 3 display functions on the Control Panel.



First is the Small 3 digit display – this display must show 

If the display shows any other Mode, the Batch Counter will not function. To change, Press the  or  Buttons directly UNDER the 3 digit display to change this Mode of Operation.



NOTE: If the display shows  or  the wrong batching device is selected. These batching devices are Options not sold as standard equipment.

- In the Large 8 digit display you will see 2 display functions.



- Is the number of sheets in the batch.
- Is the time delay between batches.
  - In the first 3 digits of the 8 digit display, this is the number of Sheets in each batch. To adjust the number, press the  or  Button directly UNDER the display until the desired number is displayed.
  - In the last 2 digits of the 8 digit display, is the time between batches setting. This setting moves in Tenth ( $10^{\text{th}}$ ) of Seconds, to adjust, Press




the  or  Buttons directly UNDER the 2 digit display until the desired delay number is displayed.

EXAMPLE:







This is set-up for 10 pieces in a Batch with a 1.5 second delay between Batches.

3. To return back to RUN mode, Press  Button and set either the Batch Size or Time Delay to Zero and the Folder will run continuously.

## STOP FEED

In Batch Count Mode, you also can have the Feeder Set-Up for a Stop Feed Count. You can enter the number of Sheets that you wish to Feed and the Feeder will Feed that number and STOP. The feeder will not Re-Start until you Press SHEET START Button.

1. Press the  Button on the Control Panel, the 3 display functions on the Control Panel will appear.
  - A. In the first 3 digits of the 8 digit display enter the Number of Sheets that you wish the Feeder to Feed by Pressing either  or  Buttons.
  - B. In the Last 2 digits of the 8 digit display, Press and HOLD the  Button until the LETTERS **SE** appears – the machine will now Feed only the Number of Sheets that you have entered.

EXAMPLE:





With this setting the Feeder will run 10 sheets




and Stop Feeding.

## RESETTING THE TOTAL COUNTER

To reset the Total Counter, Press Button  ; ensure the red LED is illuminated.

Press Button  and HOLD DOWN for 3 SECONDS,  
The Large 8 digit display will begin to Count **BACKWARDS** from 5.4.3.2.1,  
then display **CLEARED**, the Counter is then ZERO.


You **MUST** Press and HOLD Button  as the display is counting

**BACKWARDS**, if at anytime the  ZERO Button is released, the Counter will display the Last Count Value

NOTE The Batch counter will also be reset to 0 by this procedure.


## RESETTING THE BATCH COUNTER

Press the Batch counter Button  ; ensure the red LED is illuminated.

Press Button  and HOLD DOWN for 3 SECONDS,  
The Large 8 digit display will begin to Count **BACKWARDS** from 5.4.3.2.1,  
then display **CLEARED**, the Counter is then ZERO.

NOTE The Total counter will **not** be reset to zero.

## TURN OFF BATCH COUNTING:

Press the  counter setup button and set either the batch size or time dwell to zero.

**Exit** the counter setup mode by pressing the counter setup button again or any button in the second row.