

HEIDELBERG



ST90 SADDLE STITCHER OPERATORS MANUAL

TP10543

FUNDAMENTAL SAFETY INSTRUCTIONS!

The diagrams and descriptions used in these instructions are not necessarily applicable to the specification of the machine supplied. Modifications, made for reasons of technical or operational improvement, are embodied without notice.

FUNDAMENTAL SAFETY INSTRUCTIONS!

These operating instructions are designed to familiarize the user with the machine and its designated use.

The instruction manual contains important information on how to operate the machine safely, properly and most efficiently. Observing these instructions helps to avoid danger, to reduce repair costs and downtimes and to increase the reliability and life of the machine.

In addition to the operating instructions and to the mandatory rules and regulations for accident prevention and environmental protection in the country and place of use of the machine, the generally recognized technical rules for safe and proper working must also be observed.

The following signs and designations are used in the manual to designate instructions of particular importance.

-  **Important**
(refers to special information on how to use the machine/plant most efficiently)
-  **Attention**
(refers to special information and/or orders and prohibitions directed towards preventing damage)
-  **Danger**
(refers to orders and prohibitions designed prevent injury or extensive damage)

1.0 Basic operation and designated use of the machine/plant

1.0.1

The machine /plant has been built in accordance with state-of-the art standards and the recognized safety rules. Nevertheless, its use may constitute a risk to life and limb of the user or of third parties, or cause damage to the machine and to other material property.

1.0.2

The machine/plant must only be used in technically perfect condition in accordance with its designated use and the instructions set out in the operating manual, and only by safety-conscious persons who are fully aware of the risks involved in operating the machine/plant. Any functional disorders, especially those affecting the safety of the machine/plant, should therefore be rectified immediately.

1.0.3

The machine/installation is designed exclusively for paper finishing of minimum and maximum sheet sizes (see corresponding operating instructions). Using the machine/ installation for purposes other than those mentioned above is considered contrary to its designated use. The manufacturer/ supplier cannot be held liable for any damage or injury arising from such misuse. The risk of such misuse lies entirely with the user.

Operating the machine within the limits of its designated use also involves observing the instructions set out in the operating manual and complying with the inspection and maintenance directives. The working temperature of the machine should range between 0° and 55° C.

1.1 Organizational measures

1.1.1

The operating instructions must always be at hand at the place of use of the machine/plant, e.g. by stowing them in the tool compartment or tool-box provided for such purpose.

1.1.2

Personnel entrusted with work on the machine must have read the operating instructions and in particular the chapter on safety before beginning work. Reading the instructions after work has begun is too late. This applies especially to persons working only occasionally on the machine, e.g. during setting up or maintenance.

1.1.3

For reasons of security, long hair must be tied back or otherwise secured, garments must be close-fitting and no jewelry - such as rings - may be worn. Injury may result from being caught up in the machinery or from rings catching on moving parts.

1.1.4

Observe all safety instructions and warnings attached to the machine/plant.

1.1.5

See to it that safety instructions and warnings attached to the machine are always complete and perfectly legible.

1.1.6

In the event of safety-relevant modifications or changes in the behaviour of the machine/plant during operation, stop the machine/plant immediately and report the malfunction to the competent authority/person.

1.1.7

Never make any modifications, additions or conversions which might affect safety without the supplier's approval. This also applies to the installation and adjustment of safety devices and valves as well as to welding work on load-bearing elements.

1.1.8

Spare parts must comply with the technical requirements specified by the manufacturer. Spare parts from original equipment manufacturers can be relied to do so.

1.1.9

Report any accident that occurs due to a malfunction of the machine though all prescribed safety precautions were observed directly to our agency.

1.2 Selection and qualification of personnel - Basic responsibilities

1.2.1

Employ only trained or instructed staff and set out clearly the individual responsibilities of the personnel for operation, set-up, maintenance and repair.

1.2.2

Make sure that only authorized personnel works on or with the machine.

1.2.3

Work on the electrical system and equipment of the machine/plant must be carried out only by a skilled electrician or by instructed persons under the supervision and guidance of a skilled electrician and in accordance with electrical engineering rules and regulations.

1.2.4

Work on gas fueled equipment (gas consumers) may be carried out by specially trained personnel only.

1.3 Safety instructions governing specific operational phases

1.3.1 Standard operation

1.3.1.1

Avoid any operational mode that might be prejudicial to safety.

1.3.1.2

Take the necessary precautions to ensure that the machine is used only when in a safe and reliable state. Operate the machine only if all protective and safety-oriented devices, such as removable safety devices, emergency shut-off equipment, sound-proofing elements and exhausters, are in place and fully functional.

1.3.1.3

Check the machine/plant at least once per working shift for obvious damage and defects. Report any changes (incl. changes in the machine's working behaviour) to the competent organization/person immediately. If necessary, stop the machine immediately and lock it.

1.3.1.4

Before starting up or setting the machine/plant in motion, make sure that nobody is at risk.

1.3.2

Special work in conjunction with utilization of the machine/plant and maintenance and repairs during operation; disposal of parts and consumables.

1.3.2.1

Always press the emergency (Not-Stop) button first, if you stop the machine for adjustments or maintenance work which must not be done while the machine is in operation.

1.3.2.2

For extensive maintenance or repair work, turn off the main power supply.

1.3.2.3

After making adjustments or after doing maintenance or repair work, always make sure that all tools or other objects are removed from the machine. Otherwise they might fall into the machine, causing severe damage or injuries.

1.3.2.4

Keep the floor around the entire machine clean. Immediately clean any oil, grease or paint spills up off the floor. Remove tools, cleaning cloths or paper scraps from all work areas.

1.3.2.5

Never clean moving parts of the machine (rollers, shafts) or remove any test sheets, spoiled sheets or bits of paper in such areas.

1.3.2.6

Observe the adjusting, maintenance and inspection activities and intervals set out in the operating instructions, including information on the replacement of parts and equipment. These activities may be executed by skilled personnel only.

1.3.2.7

Brief operating personnel before beginning special operations and maintenance work, and appoint a person to supervise the activities.

1.3.2.8

If the machine/plant is completely shut down for maintenance and repair work, it must be secured against inadvertent starting by:

- locking the principal control elements and removing the ignition key and/or
- attaching a warning sign to the main switch.

1.4.1 Electric energy

1.4.1.1

Use only original fuses with the specified current rating. Switch off the machine/plant immediately if trouble occurs in the electrical system.

1.4.1.2

If provided for in the regulations, the power supply to parts of machines and plants, on which inspection, maintenance and repair work is to be carried out must be cut off. Before starting any work, check the de-energized parts for the presence of power and ground or short-circuit them in addition to insulating adjacent live parts and elements.

1.4.1.3

The electrical equipment of machines/plants is to be inspected and checked at regular intervals. Defects such as loose connections or scorched cables must be rectified immediately.



Warning!

To avoid bruising, keep hands away when operating moving machine parts!

1.4.1.4

Necessary work on live parts and elements must be carried out only in the presence of a second person who can cut off the power supply in case of danger by actuating the emergency shut-off or main power switch. Secure the working area with a red-and-white safety chain and a warning sign. Use insulated tools only.



Warning!

Do not reach into moving belts!

1.4.1.5

Only unplug or plug electrical connectors if the main switch has been disconnected.



Warning!

Be careful! Height adjustment devices might cause bruising!

1.4.1.6

Only connect the folding units and no machines of other brands to the existing connectors. Any electrical connection of our folding machines with other brands needs our express consent.



Warning!

Only operate machine when covers are closed.

1.4.1.7

For electrical connection, observe the prescribed admissible voltage and frequency. The minimum voltage protection required for this folder is 25 Amps.

1.4.1.8

Keep switch cabinets closed.

1.4.1.9

The socket outlet shall be installed near the folder and shall be easily accessible.

1.4.2

Oil, grease and other chemical substances

1.4.2.1

When handling oil, grease and other chemical substances, observe the product-related safety regulations.

1.5 Description and definition of the safety labels and pictographs on the machine

Replace damaged pictographs by new ones. The corresponding reference numbers are indicated.

GRUNDLEGENDE SICHERHEITS- HINWEISE!

Die in diesen Hinweisen verwendeten Diagramme und Beschreibungen gelten nicht notwendigerweise für die gelieferte Maschine. Änderungen, die aus technischen Gründen oder für einen verbesserten Betrieb durchgeführt wurden, werden ohne Vorankündigung übernommen.

GRUNDLEGENDE SICHERHEITSHINWEISE!

Die vorliegende Bedienungsanleitung dient dazu, dass sich der Anwender mit der Maschine und deren Einsatzzweck vertraut macht.

Die Bedienungsanleitung enthält wichtige Informationen über den sicheren, bestimmungsgemäßen und wirkungsvollen Betrieb der Maschine. Bei Beachtung dieser Anweisungen werden Gefahren vermieden, Reparaturkosten und Stillstandszeiten verringert sowie die Zuverlässigkeit und die Lebensdauer der Maschine erhöht.

Zusätzlich zur Bedienungsanleitung und den verbindlichen Vorschriften und Bestimmungen zur Verhinderung von Unfällen sowie im Hinblick auf den Umweltschutz in dem Land, in dem die Maschine eingesetzt wird, sind ebenfalls die allgemein anerkannten technischen Vorschriften für sicheres und korrektes Arbeiten zu beachten.

Die folgenden Zeichen und Bezeichnungen werden im Handbuch verwendet, um auf Anweisungen von besonderer Bedeutung hinzuweisen.

Wichtig



(bezieht sich auf besondere Informationen darüber, wie die Maschine/Anlage am wirkungsvollsten eingesetzt wird)

Achtung



(bezieht sich auf besondere Informationen bzw. Anweisungen und Verbote, mit denen Schäden verhindert werden sollen)

Gefahr



(bezieht sich auf Anweisungen und Verbote, mit denen Verletzungen oder größere Schäden verhindert werden sollen)

1.0

Grundlegender Betrieb und Einsatzzweck der Maschine/Anlage

1.0.1

Die Maschine/Anlage wurde in Übereinstimmung mit den neuesten Normen und anerkannten Sicherheitsvorschriften hergestellt. Trotzdem kann ein Risiko für das Leben oder die Gliedmaßen des Anwenders oder Dritter gegeben sein, oder eine Beschädigung der Maschine und anderer Gegenstände verursacht werden.

1.0.2

Die Maschine/Anlage darf nur in technisch einwandfreiem Zustand in Übereinstimmung mit dem Einsatzzweck und den in der Bedienungsanleitung dargelegten Anweisungen und nur durch Personen bedient werden, die sich der mit dem Betrieb der Maschine/Anlage verbundenen Risiken bewusst sind. Jegliche Funktionsstörungen, besonders diejenigen, welche die Sicherheit der Maschine/Anlage betreffen sind daher sofort zu beheben.

1.0.3

Die Maschine/Anlage wurde ausschließlich für die Verarbeitung von Bögen mit bestimmten Mindest- und Höchstformaten konstruiert (siehe die entsprechende Bedienungsanleitung). Wird die Maschine/Anlage für andere, als die zuvor aufgeführten Zwecke verwendet, wird dies als im Gegensatz zum Einsatzzweck stehend angesehen. Der Hersteller/Lieferant kann für Schäden oder Verletzungen, die sich aus solch einem Missbrauch ergeben, nicht haftbar gemacht werden. Das Risiko solch eines Missbrauchs trägt allein der Anwender.

Ein Betrieb der Maschine innerhalb der Grenzen des Einsatzzwecks beinhaltet ebenfalls die Einhaltung der in der Bedienungsanleitung enthaltenen Anweisungen sowie der Inspektions- und Wartungsrichtlinien. Die Betriebstemperatur der Maschine muss zwischen 0 °C und 55 °C liegen.

1.1 Organisatorische Schutzmaßnahmen

1.1.1

Die Bedienungsanleitung muss am Aufstellungsort der Maschine/Anlage stets zur Hand sein, z.B. indem diese im Werkzeugfach oder in dem für diesen Zweck vorgesehenen Werkzeugkasten aufbewahrt wird.

1.1.2

Die mit der Arbeit an der Maschine beauftragten Personen müssen die Bedienungsanleitung und insbesondere das Kapitel über Sicherheit vor Arbeitsbeginn durchgelesen haben. Wird die Anleitung erst nach Arbeitsbeginn durchgelesen, ist dies zu spät. Dies gilt besonders für Personen, die nur gelegentlich an der Maschine arbeiten, wie z.B. während des Einrichtens oder während Wartungsarbeiten.

1.1.3

Aus Sicherheitsgründen langes Haar hochbinden oder auf andere Weise schützen, eng anliegende Kleidung und keinen Schmuck, wie z.B. Ringe, tragen. Verfängt sich das Haar in der Maschine, oder geraten Ringe in beweglichen Teilen, kann dies zu Verletzungen führen.

1.1.4

Alle an der Maschine/Anlage angebrachten Sicherheitshinweise und Warnungen beachten.

1.1.5

Darauf achten, dass an der Maschine angebrachte Sicherheitshinweise und Warnungen stets vollständig und gut lesbar sind.

1.1.6

Bei sicherheitsrelevanten Modifizierungen oder Änderungen im Verhalten der Maschine/Anlage während des Betriebs, die Maschine/Anlage sofort anhalten und die Störung der hierfür zuständigen Person melden.

1.1.7

Ohne Zustimmung des Lieferanten nie Modifizierungen, Zusätze oder Umbauten vornehmen, welche die Sicherheit beeinflussen könnten. Dies gilt ebenfalls für den Einbau und die Einstellung von Sicherheitsvorrichtungen und Ventilen sowie für Schweißarbeiten an lasttragenden Elementen.

1.1.8

Ersatzteile müssen die vom Hersteller festgelegten technischen Anforderungen erfüllen. Stammen Ersatzteilen von OEM-Herstellern, kann davon ausgegangen werden, dass diese Anforderungen erfüllt werden.

1.1.9

Unserer Vertretung jeglichen Unfall sofort melden, zu dem es aufgrund einer Störung der Maschine gekommen ist, obwohl alle vorgeschriebenen Sicherheitsmaßnahmen beachtet wurden.

1.2 Auswahl und Qualifikation des Personals - Grundlegende Verantwortung

1.2.1

Nur entsprechend geschulte oder ausgebildete Personen einsetzen und die jeweilige Verantwortung dieser Personen im Hinblick auf den Betrieb, die Einrichtung, Wartung und Reparatur eindeutig festlegen.

1.2.2

Sicherstellen, dass nur dazu berechtigte Personen an oder mit der Maschine arbeiten.

1.2.3

Arbeiten an elektrischen Systemen oder Vorrichtungen der Maschine/Anlage dürfen nur von einem erfahrenen Elektriker oder von Personen unter Aufsicht und Anleitung eines erfahrenen Elektrikers sowie in Übereinstimmung mit den elektrotechnischen Vorschriften und Bestimmungen durchgeführt werden.

1.2.4

Arbeiten an gasbetriebenen Geräten (Gasverbraucher) dürfen nur von hierfür besonders geschulten Personen durchgeführt werden.

1.3 Sicherheitsanweisungen bezüglich spezieller Betriebsphasen

1.3.1 Standardbetrieb

1.3.1.1

Jegliche Betriebsart vermeiden, die die Sicherheit gefährden könnte.

1.3.1.2

Die erforderlichen Sicherheitsmaßnahmen ergreifen, um sicherzustellen, dass die Maschine nur dann eingesetzt wird, wenn sie sich in einem sicheren und zuverlässigen Zustand befindet. Die Maschine nur betreiben, wenn alle Schutz- und Sicherheitsvorrichtungen, wie z.B. abnehmbare Sicherheitsvorrichtungen, Not-Aus-Vorrichtungen, Schallschutzelemente und Entlüfter, angebracht und funktionsfähig sind.

1.3.1.3

Die Maschine/Anlage mindestens ein Mal pro Arbeitsschicht auf offensichtliche Schäden und Defekte überprüfen. Jegliche Änderungen (einschl. Änderungen im Arbeitsverhalten der Maschine) sofort den hierfür zuständigen Personen melden. Falls erforderlich, die Maschine sofort anhalten und verriegeln.

1.3.1.4

Bevor die Maschine/Anlage angefahren oder in Betrieb genommen wird, ist sicherzustellen, dass niemand gefährdet ist.

1.3.2

Besondere Arbeiten in Zusammenhang mit der Nutzung der Maschine/Anlage sowie Wartungs- und Reparaturarbeiten; Entsorgung von Teilen und Verbrauchsmaterial.

1.3.2.1

Stets zuerst die Not-Stopp-Taste drücken, falls die Maschine für Einstellungs- oder Wartungsarbeiten angehalten wird, die nicht während des Betriebs der Maschine durchgeführt werden dürfen.

1.3.2.2

Für umfangreiche Wartungs- oder Reparaturarbeiten die Hauptstromversorgung ausschalten.

1.3.2.3

Wurden Einstellungen vorgenommen oder Wartungs- oder Reparaturarbeiten durchgeführt, anschließend stets sicherstellen, dass alle Werkzeuge oder Gegenstände von der Maschine entfernt wurden. Diese können sonst in die Maschine fallen und schwere Schäden oder Verletzungen verursachen.

1.3.2.4

Den Boden um die gesamte Maschine herum sauber halten. Öl-, Fett- oder Farbflecken sofort vom Boden aufwischen. Werkzeuge, Reinigungstücher oder Papierschnitzel aus allen Arbeitsbereichen entfernen.

1.3.2.5

Nie sich bewegende Teile der Maschine (Walzen, Wellen) reinigen, oder Justagemittel, beschädigte Bögen oder Papierschnitzel in diese Bereichen mit sich bewegenden Teilen entfernen.

1.3.2.6

Die Einstell-, Wartungs- und Inspektionsmaßnahmen und -intervalle beachten, die in der Bedienungsanleitung angegeben sind, einschließlich Informationen über den Austausch von Teilen und Ausrüstungsteilen. Diese Maßnahmen dürfen nur von erfahrenen Personen durchgeführt werden.

1.3.2.7

Das Bedienungspersonal vor Beginn besonderer Bedienungs- oder Wartungsarbeiten einweisen und eine Person benennen, die diese Maßnahmen überwacht.

1.3.2.8

Wird die Maschine/Anlage für Wartungs- und Reparaturarbeiten vollständig stillgelegt, diese gegen ein unbeabsichtigtes Starten durch folgende Maßnahmen absichern:

- Verriegeln der Hauptsteuerelemente und Abziehen des Schlüssels bzw.
- Anbringen eines Warnschildes am Hauptschalter.

1.4.1 Elektrische Energie

1.4.1.1

Nur Original-Sicherungen mit der angegebenen Nennleistung verwenden. Die Maschine/Anlage sofort ausschalten, falls es zu Störungen im elektrischen System kommt.

1.4.1.2

Ist dies in den Vorschriften angegeben, die Stromzufuhr zu den Teilen der Maschinen und Anlagen abschalten, an denen Inspektions-, Wartungs- und Reparaturarbeiten durchgeführt werden sollen. Bevor mit den Arbeiten begonnen wird, überprüfen, ob die abgeschalteten Teile noch stromführend sind und diese zusätzlich zur Isolierung angrenzender stromführender Teile und Elemente erden oder kurzschließen.

1.4.1.3

Die elektrischen Ausrüstungsteile von Maschinen/Anlagen in regelmäßigen Abständen untersuchen und überprüfen. Defekte, wie z.B. lockere Anschlüsse oder durchgeschmorte Kabel sofort reparieren.

1.4.1.4

Erforderliche Arbeiten an stromführenden Teilen und Elementen dürfen nur in Anwesenheit einer zweiten Person durchgeführt werden, die die Stromzufuhr im Gefahrenfall durch Betätigen des Not-Aus-Schalters abschalten kann. Den Arbeitsbereich mit einer rotweißen Sicherheitskette und einem Warnschild absichern. Nur isolierte Werkzeuge verwenden.

1.4.1.5

Stecker nur ziehen oder einstecken, wenn der Hauptschalter ausgeschaltet wurde.

1.4.1.6

Nur die Falzaggregate und keine Maschinen anderer Marken an die vorhandenen Stecker anschließen. Jeder Anschluss unserer Falzstationen an Maschinen anderer Marken bedarf unserer ausdrücklichen Zustimmung.

1.4.1.7

Beim elektrischen Anschluss die vorgeschriebene zulässige Spannung und Frequenz beachten. Der für diese Falzmaschine erforderliche Mindestspannungsschutz beträgt 25 Ampere.

1.4.1.8

Schaltschränke geschlossen halten.

1.4.1.9

Die Steckdosen müssen neben der Falzmaschine angebracht und leicht zugänglich sein.

1.4.2

Öl, Fett und andere chemische Substanzen

1.4.2.1

Beim Umgang mit Öl, Fett und anderen chemischen Substanzen die produktbezogenen Sicherheitsvorschriften beachten.

1.5 Beschreibung und Definition der Sicherheitsaufkleber und Piktogramme auf der Maschine

Beschädigte Piktogramme durch neue ersetzen. Die entsprechenden Referenznummern sind angegeben.

Warnung!



Zur Vermeidung von Quetschungen, die Hände nicht in die Nähe von sich bewegenden Maschinenteilen bringen!

Warnung!



Nicht in sich bewegende Riemen greifen!

Warnung!



Vorsichtig sein! Durch Vorrichtungen zur Höhenverstellung können Quetschungen verursacht werden!

Warnung!



Die Maschine nur mit geschlossenen Abdeckungen betreiben.

INSTRUCTIONS FONDAMENTALES SUR LA SÉCURITÉ

Les schémas et les descriptions utilisés au cours de ces instructions ne sont pas nécessairement applicables aux spécifications de la machine fournie. Les modifications, réalisées pour des motifs techniques ou d'amélioration du fonctionnement sont intégrées sans avis préalable.

INSTRUCTIONS FONDAMENTALES SUR LA SÉCURITÉ

Ces instructions de fonctionnement sont conçues afin de familiariser l'utilisateur avec la machine et l'utilisation pour laquelle elle a été conçue.

Le manuel d'instruction contient d'importantes informations sur la manière de faire fonctionner la machine en toute sécurité, correctement et le plus efficacement possible. L'observation de ces instructions permet d'éviter les dangers, de réduire les coûts de réparation et la durée d'indisponibilité, et d'augmenter la fiabilité et la durée de vie de la machine.

Outre les instructions de fonctionnement et les règles et règlements impératifs destinés à éviter les accidents et à protéger l'environnement dans ce pays et sur le lieu d'utilisation de la machine, les règles techniques généralement reconnues relatives à la sécurité et à des conditions de travail adéquates doivent être observées.

Les signes et désignations suivants sont utilisés dans le manuel pour désigner des instructions d'une importance particulière.



Important
(se réfère aux informations spéciales sur la manière d'utiliser la machine/l'installation de la manière la plus efficace possible)



Attention
(se réfère aux informations spéciales et/ou aux ordres et interdictions applicables afin d'éviter des détériorations)



Danger
(se réfère aux ordres et interdictions applicables afin d'éviter toute blessure ou d'importantes détériorations)

1.0
Fonctionnement de base et utilisation prévue de la machine/de l'installation

1.0.1
Cette machine/installation a été construite conformément à des normes ultramodernes et à des règles de sécurité reconnues. Son utilisation peut néanmoins constituer un risque grave, voire mortel, pour l'utilisateur ou un tiers, ou provoquer des détériorations sur la machine ou sur d'autres matériels.

1.0.2
La machine/installation ne doit être utilisée que dans des conditions techniques parfaites conformément à l'utilisation prévue et aux instructions portées sur le manuel de fonctionnement, et uniquement par des personnes qui sont, en toute conscience, totalement averties des risques qu'implique le fonctionnement de la machine/de l'installation. Tous défauts

fonctionnels, particulièrement ceux pouvant affecter la sécurité de la machine/l'installation, doivent être de ce fait immédiatement réparés.

1.0.3
La machine/installation est conçue exclusivement pour le finissage d'un papier aux dimensions de feuilles minimales et maximales (reportez-vous aux instructions de fonctionnement correspondantes). L'utilisation de cette machine/installation pour des objectifs autres que ceux mentionnés ci-dessus est considérée comme étant contraire à l'usage auquel elle est destinée. Le fabricant/fournisseur ne peut en aucun cas être tenu pour responsable d'aucun dommage ou blessure découlant d'un tel mésusage. Le risque d'un tel mésusage repose entièrement sur l'utilisateur.

L'exploitation de cette machine dans les limites définies lors de sa conception implique aussi l'observation des instructions présentées dans le manuel de fonctionnement ainsi que le respect des directives de maintenance et d'inspection. La température de travail de la machine doit se situer entre 0° et 55 °C.

1.1 Mesures organisationnelles

1.1.1
Les instructions de fonctionnement doivent toujours être à portée de main sur le lieu d'exploitation de la machine/d'installation, par exemple en les rangant dans le compartiment des outils ou dans une boîte à outils fournie à cet effet.

1.1.2
Le personnel à qui la machine a été confiée doit avoir lu les instructions d'exploitation et en particulier le chapitre sur la sécurité avant de commencer un travail. La lecture des instructions après le démarrage d'un travail est trop tardive. Ceci s'applique spécifiquement aux personnes ne travaillant qu'occasionnellement sur la machine, c'est à dire pendant les réglages ou la maintenance.

1.1.3
Pour des raisons de sécurité, les cheveux longs doivent être attachés et protégés, les vêtements doivent être ajustés et les bijoux, comme des bagues ou des anneaux, doivent être proscrits. De sérieuses blessures peuvent survenir si les cheveux sont happés par la machine ou si un anneau se trouve pris par des pièces en mouvement.

1.1.4
Conformez-vous à toutes les instructions de sécurité et aux avertissements apposés sur la machine/installation.

1.1.5
Assurez-vous que les instructions de sécurité et les avertissements apposés sur la machine sont complets et parfaitement lisibles.

1.1.6
En cas de modifications pertinentes sur la sécurité ou de modifications du comportement de la machine/de l'installation pendant son fonctionnement, arrêtez immédiatement cette dernière et avisez la personne compétente de ce mauvais fonctionnement.

1.1.7

Ne procédez jamais à aucune modification, ajout ou transformation qui pourrait affecter la sécurité sans l'approbation du fournisseur. Ceci s'applique aussi à l'installation et au réglage des dispositifs et des vannes de sécurité ainsi que des soudures sur les éléments porteurs.

1.1.8

Les pièces détachées doivent être conformes aux spécifications techniques publiées par le fabricant. Les pièces détachées d'origine des fabricants de l'équipement peuvent être utilisées en toute confiance.

1.1.9

Veillez fournir un rapport à notre agence si un accident s'est produit en raison d'un mauvais fonctionnement de la machine même si toutes les précautions de sécurité prescrites ont été observées.

1.2

Sélection et qualification du personnel – Responsabilités essentielles

1.2.1

Utilisez seulement un personnel instruit et formé, et définissez clairement les responsabilités individuelles de chacun lors du fonctionnement, des réglages, de la maintenance et des réparations.

1.2.2

Assurez-vous que seul un personnel autorisé travaille sur cette machine.

1.2.3

Les travaux sur le système et l'équipement électriques de la machine/de l'installation doivent être effectués uniquement par un électricien compétent ou par des personnes formées sous la supervision et les conseils d'un électricien et conformément aux règles et règlements du génie électrique.

1.2.4

Les travaux sur des équipements alimentés en essence (consommateurs d'essence) ne peuvent être réalisés que par un personnel spécialement formé.

1.3 Instructions de sécurité concernant les phases opérationnelles spécifiques

1.3.1 Fonctionnement standard

1.3.1.1

Évitez tout mode de fonctionnement qui irait à l'encontre de la sécurité.

1.3.1.2

Prenez les précautions nécessaires afin de vous assurer que la machine est utilisée uniquement lorsqu'elle se trouve dans un état de fiabilité et de sécurité normales. Faites fonctionner la machine seulement si les dispositifs de protection et de sécurité, tels que des dispositifs de sécurité amovibles, un équipement d'arrêt d'urgence, des éléments d'insonorisation et des extracteurs d'air sont en place et en état de fonctionnement.

1.3.1.3

Vérifiez au moins une fois la machine/l'installation lors de chaque changement de poste à la recherche de détériorations et de défauts. Signalez immédiatement toute modification (y compris les changements du comportement de travail de la machine) à la personne ou au service compétent. Au besoin, arrêtez la machine immédiatement et verrouillez-la.

1.3.1.4

Avant de démarrer ou de mettre la machine en mouvement, assurez-vous que personne n'est en danger.

1.3.2

Travaux spéciaux conjointement à l'utilisation de la machine/de l'installation, et à la maintenance et aux réparations pendant le fonctionnement ; mise au rebut des pièces et des consommables.

1.3.2.1

Vous devez toujours appuyer d'abord sur le bouton d'urgence (Pas d'arrêt), si vous arrêtez la machine pour des réglages ou une maintenance qui ne doivent pas être réalisés pendant que la machine est en fonctionnement.

1.3.2.2

Pour une maintenance ou des réparations importantes, l'alimentation secteur doit être interrompue.

1.3.2.3

Après avoir procédé au réglage, à la maintenance ou aux réparations, assurez-vous toujours que la machine est libre de tous les outils et autres objets utilisés. Dans le cas contraire, ils pourraient tomber dans la machine et provoquer des détériorations ou des blessures graves.

1.3.2.4

Le sol tout autour de la machine doit être propre. Nettoyez immédiatement toutes taches d'huile, de graisse ou de peinture. Nettoyez les zones de travail des outils, des chi?ons ou des morceaux de papier qui pourraient s'y trouver.

1.3.2.5

Ne nettoyez jamais des pièces en mouvement de la machine (rouleaux, axes), ni ne retirez aucune feuille de test, feuille maculée ou morceau de papier dans de tels emplacements.

1.3.2.6

Observez les périodes de réglage, de maintenance et d'inspection conformément aux intervalles définis sur les instructions d'exploitation, y compris les informations de remplacement de pièces et d'équipements. Ces tâches doivent être entreprises uniquement par un personnel dûment formé.

1.3.2.7

Veillez informer le personnel d'exploitation avant de commencer des opérations spéciales ou de maintenance, et désignez une personne pour surveiller ces activités.

1.3.2.8

Si la machine/l'installation est totalement à l'arrêt pour une maintenance et des réparations, elle doit être verrouillée afin d'éviter tout redémarrage intempestif de la manière suivante :

- verrouillage des éléments de contrôle principaux et retrait de la clef de démarrage et/ou
- apposition d'un avis sur le commutateur principal du secteur.

1.4.1 Énergie électrique

1.4.1.1

Utilisez uniquement des fusibles d'origine correspondant à la tension et au courant nominal. Mettez immédiatement hors tension la machine/l'installation si des problèmes apparaissent au niveau du système électrique.

1.4.1.2

Si les règlements le stipulent, l'alimentation des pièces de la machine et de l'installation, sur lesquelles une inspection, une maintenance et des réparations doivent avoir lieu, doit être interrompue. Avant de commencer un travail quelconque, vérifiez l'absence de tension sur les pièces dont l'alimentation a été interrompue, et mettez-les à la masse ou en court-circuit en plus de l'isolation des pièces et des éléments adjacents sous tension.

1.4.1.3

L'équipement électrique des machines/des installations doit être inspecté et vérifié à intervalles réguliers. Des défauts tels que des connexions desserrées ou des câbles brûlés doivent être immédiatement corrigés.

1.4.1.4

Les travaux nécessaires sur des pièces et des éléments sous tension doivent être uniquement conduits en présence d'une deuxième personne pouvant interrompre l'alimentation électrique en cas de danger en déclenchant le disjoncteur d'urgence ou le commutateur secteur. La zone de travail doit être protégée par une chaîne de couleur rouge et blanche accompagnée d'un panneau d'avertissement. N'utilisez que des outils isolés.

1.4.1.5

Ne connectez ou déconnectez des connecteurs électriques que si le commutateur principal est hors service.

1.4.1.6

Connectez seulement les unités de pliage et aucune autre machine de marque différente aux connecteurs existants. Toute connexion électrique de nos plieuses avec des plieuses d'autres marques nécessite notre accord exprès.

1.4.1.7

Observez les tensions et fréquences prescrites et admissibles lors de la connexion électrique. La protection minimale requise pour cette plieuse est de 25 A.

1.4.1.8

Les armoires des commutateurs doivent être fermées.

1.4.1.9

La prise d'alimentation sera installée à proximité de la plieuse et sera facilement accessible.

1.4.2

Huiles, graisses et autres substances chimiques

1.4.2.1

Observez les réglementations de sécurité différentes aux produits lors de la manutention des huiles, des graisses et d'autres substances chimiques.

1.5 Description et définition des étiquettes de sécurité et des pictogrammes sur la machine

Remplacez les pictogrammes endommagés par de nouveaux. Les numéros de référence correspondant sont indiqués.

Avertissement !



Pour éviter toute blessure par écrasement, éloignez vos mains en faisant fonctionner les diverses pièces de la machine !

Avertissement !



Ne touchez pas aux courroies en mouvement !

Avertissement !



Soyez prudent. Les dispositifs de réglage de la hauteur peuvent provoquer des blessures par écrasement !

Avertissement !



Cette machine ne doit fonctionner que si tous les couvercles sont fermés.

INSTRUCCIONES FUNDAMENTALES DE SEGURIDAD

Los diagramas y descripciones que se utilizan en estas instrucciones no son necesariamente aplicables a la especificación de la máquina suministrada. Las modificaciones hechas con el fin de introducir mejoras técnicas o de funcionamiento se incorporan sin aviso.

INSTRUCCIONES FUNDAMENTALES DE SEGURIDAD

Estas instrucciones de funcionamiento están diseñadas para que el usuario se familiarice con la máquina y su uso indicado.

El manual de instrucciones contiene información importante sobre cómo manejar la máquina de manera segura, correcta y eficaz. La observación de estas instrucciones contribuirá a evitar peligros, reducir el coste de las reparaciones y los tiempos de inactividad, y aumentar la fiabilidad y la vida útil de la máquina.

Además de las instrucciones de funcionamiento y de las reglas y normas obligatorias para la prevención de accidentes y la protección del medio ambiente vigentes en el país y lugar en que se utilice la máquina, también deben observarse las reglas técnicas generalmente aceptadas para un trabajo seguro y correcto.

Los siguientes símbolos y designaciones se utilizan en el manual para designar instrucciones de importancia especial.



Importante

(se refiere a información especial sobre cómo utilizar la máquina o planta más eficazmente)



Atención

(se refiere a información especial y/o órdenes y prohibiciones dirigidas a prevenir daños o lesiones)



Peligro

(se refiere a órdenes y prohibiciones diseñadas para prevenir lesiones y daños extensos)

1.0 Funcionamiento básico y uso indicado de la máquina/planta

1.0.1

La máquina/planta está diseñada de acuerdo con normas avanzadas y reglas de seguridad reconocidas. No obstante, su uso puede constituir un peligro para la vida y un riesgo de amputación para el usuario o terceros, u ocasionar daño a la máquina y a otra propiedad material.

1.0.2

La máquina/planta sólo debe utilizarse si se encuentra en perfecto estado técnico, conforme a su uso indicado y de acuerdo con las instrucciones descritas en el manual de funcionamiento, y únicamente deberán manejarla personas adiestradas en seguridad que sean plenamente conscientes de los riesgos involucrados en el manejo de la máquina/planta. Los problemas funcionales, especialmente los que afectan a la seguridad de la máquina/planta, deberán por consiguiente rectificarse inmediatamente.

1.0.3

La máquina/instalación está diseñada exclusivamente para el acabado mecánico de hojas de papel de tamaño mínimo y máximo (ver las instrucciones de funcionamiento correspondientes). El uso de la máquina/instalación para fines distintos a los mencionados más arriba se considera contrario a su uso indicado. El fabricante/proveedor no es responsable de los daños o lesiones que se produzcan como consecuencia de un uso incorrecto. El riesgo que implica un uso incorrecto es total responsabilidad del usuario.

El manejo de la máquina dentro de los límites de su uso indicado implica también la observación de las instrucciones descritas en el manual de funcionamiento y el cumplimiento de las directivas de inspección y mantenimiento. La temperatura de funcionamiento de la máquina debe estar entre 0° y 55°C.

1.1 Medidas de organización

1.1.1

Las instrucciones de funcionamiento deben tenerse siempre a mano en el lugar donde se va a utilizar la máquina/planta; por ejemplo, pueden guardarse en el compartimiento de las herramientas o en la caja de herramientas suministrada para tal efecto.

1.1.2

El personal encargado del manejo de la máquina debe haber leído las instrucciones de funcionamiento, especialmente el capítulo sobre seguridad, antes de empezar a trabajar. Leerlas una vez comenzado el trabajo es hacerlo demasiado tarde. Esto se aplica especialmente a personas que trabajan sólo ocasionalmente en la máquina; por ejemplo, durante la instalación o las tareas de mantenimiento.

1.1.3

Por razones de seguridad, el pelo largo debe llevarse sujeto atrás o recogido de alguna otra forma, debe llevarse ropa ceñida y no deben usarse joyas, como anillos. Es posible que se produzcan lesiones al engancharse la ropa o el cabello en la maquinaria o los anillos en las piezas móviles.

1.1.4

Observe todas las instrucciones y advertencias de seguridad de las etiquetas adheridas a la máquina/planta.

1.1.5

Compruebe que las etiquetas con instrucciones y advertencias de seguridad en la máquina estén siempre completas y puedan leerse sin problemas.

1.1.6

Si se producen modificaciones o cambios relevantes para la seguridad en el comportamiento de la máquina/planta durante su funcionamiento, pare la máquina/planta inmediatamente e informe del funcionamiento incorrecto a la persona/autoridad competente.

1.1.7

Nunca realice modificaciones, adiciones o conversiones que puedan afectar a la seguridad sin la aprobación del proveedor. Esto se aplica también a la instalación y ajuste de dispositivos de seguridad y válvulas, así como al trabajo de soldadura en elementos que soportan carga.

1.1.8

Las piezas de repuesto deben cumplir con los requisitos técnicos especificados por el fabricante. Se da por entendido que éste es el caso con las piezas de repuesto de fabricantes de equipos originales.

1.1.9

Notifique directamente a nuestra agencia cualquier accidente que se produzca debido a un mal funcionamiento de la máquina, pese a haberse observado todas las precauciones de seguridad prescritas.

1.2 Selección y cualificación del personal – Responsabilidades básicas

1.2.1

Emplee únicamente personal entrenado o instruido y exponga claramente las responsabilidades individuales del personal en cuanto al manejo, instalación, mantenimiento y reparación.

1.2.2

Asegúrese de que sólo personal autorizado trabaje en o con la máquina.

1.2.3

El trabajo en el equipo y sistema eléctrico de la máquina/planta debe llevarlo a cabo únicamente un electricista cualificado o personas adiestradas en el manejo de la máquina bajo la supervisión y guía de un electricista cualificado y de acuerdo con las reglas y regulaciones de ingeniería eléctrica.

1.2.4

El trabajo en equipos accionados mediante gas (consumidores de gas) debe realizarlo sólo personal especialmente entrenado.

1.3 Instrucciones de seguridad que rigen fases operativas específicas

1.3.1 Funcionamiento estándar

1.3.1.1

Evite los modos de funcionamiento que puedan ser perjudiciales para la seguridad.

1.3.1.2

Tome las precauciones necesarias para asegurar que la máquina se utilice únicamente de manera segura y fiable. Utilice la máquina sólo si todos los dispositivos de protección y los diseñados con fines de seguridad, como dispositivos de seguridad desmontables, equipo de parada de emergencia, insonorizadores y aspiradores, están en su lugar y en estado óptimo de funcionamiento.

1.3.1.3

Revise la máquina/planta por lo menos una vez por turno de trabajo para ver si hay daños o defectos obvios. Notifique inmediatamente cualquier cambio (inclusive cambios en el funcionamiento de la máquina) a la persona/organización competente. Si es necesario, detenga la máquina inmediatamente y ciérrela con candado.

1.3.1.4

Antes de arrancar o poner en marcha la máquina/planta, asegúrese de que nadie corra peligro.

1.3.2

Trabajo especial junto con la utilización de la máquina/planta y el mantenimiento y las reparaciones durante su funcionamiento; eliminación de piezas de desecho y productos consumibles.

1.3.2.1

Pulse siempre primero el botón de emergencia (Not-Stop - Parada de emergencia) si detiene la máquina para realizar ajustes o tareas de mantenimiento, ya que este tipo de trabajo no debe hacerse con la máquina en funcionamiento.

1.3.2.2

Para un mantenimiento o trabajo de reparación más amplio, apague el interruptor principal de la alimentación eléctrica.

1.3.2.3

Después de realizar los ajustes o después de terminar las tareas de mantenimiento o el trabajo de reparación, compruebe siempre que se han apartado de la máquina todas las herramientas u objetos. Esto evitará que caigan en la máquina y causen daños o lesiones graves.

1.3.2.4

Mantenga limpio el suelo alrededor de toda la máquina. Limpie inmediatamente los derrames de aceite, grasa o pintura del suelo. Retire las herramientas, los trapos para limpiar o los trozos de papel de todas las áreas de trabajo.

1.3.2.5

Nunca limpie piezas móviles de la máquina (rodillos, ejes) ni quite hojas de prueba, hojas manchadas o trozos de papel en dichas áreas.

1.3.2.6

Observe las actividades de ajuste, mantenimiento e inspección y los intervalos establecidos en las instrucciones de funcionamiento, así como la información sobre la sustitución de piezas y equipo. Estas actividades debe realizarlas únicamente personal cualificado.

1.3.2.7

Dé instrucciones a los operadores antes de empezar las operaciones y trabajo de mantenimiento especiales, y designe a una persona para supervisar las actividades.

1.3.2.8

Si la máquina/planta se apaga completamente para mantenimiento y trabajo de reparación, deben tomarse las medidas siguientes para evitar su puesta en marcha accidental:

- cerrar con llave o candado los principales elementos de control y quitar la llave de ignición y/o
- poner un signo de advertencia en el interruptor principal.

1.4.1 Energía eléctrica

1.4.1.1

Utilice únicamente fusibles originales con la corriente especificada. Apague la máquina/planta inmediatamente si tiene problemas con el sistema eléctrico.

1.4.1.2

Si así se dispone en las regulaciones, deberá cortarse el suministro eléctrico a los componentes de las máquinas y plantas en los que se va a llevar a cabo trabajo de inspección, mantenimiento o reparación. Antes de iniciar cualquier trabajo, revise los componentes energizados para detectar la presencia de corriente en ellos y establezca una conexión a tierra o cortocircuito además de aislar los elementos y partes activas adyacentes.

1.4.1.3

El equipo eléctrico de máquinas/plantas debe inspeccionarse y controlarse a intervalos regulares. Los defectos como conexiones sueltas o cables quemados deben corregirse inmediatamente.

1.4.1.4

El trabajo necesario en los elementos y partes activas debe realizarse únicamente en presencia de una segunda persona que pueda cortar la alimentación eléctrica en caso de peligro, accionando el cierre de emergencia o el interruptor principal. Proteja el área de trabajo con una cadena de seguridad roja y blanca, y un signo de advertencia. Utilice únicamente herramientas aisladas.

1.4.1.5

Enchufe o desenchufe conectores eléctricos sólo si el interruptor principal se ha desconectado.

1.4.1.6

Conecte únicamente unidades de plegado a los conectores existentes. No conecte a ellos ninguna máquina de otras marcas. Cualquier conexión eléctrica de nuestras máquinas de plegado con otras marcas necesita contar con nuestra autorización expresa.

1.4.1.7

Para la conexión eléctrica, observe el voltaje y frecuencia admisibles prescritos. La protección de voltaje mínimo requerida para esta plegadora es 25 amperios.

1.4.1.8

Mantenga los armarios de interruptores cerrados.

1.4.1.9

La toma eléctrica con el enchufe debe instalarse cerca de la plegadora de manera que sea fácil acceder a ella.

1.4.2

Aceite, grasa y otras sustancias químicas

1.4.2.1

Al manejar aceite, grasa y otras sustancias químicas, observe las normas de seguridad relacionadas con el producto.

1.5 Descripción y definición de las etiquetas y pictogramas de seguridad en la máquina

Cambie los pictogramas deteriorados por otros nuevos. Se indican los números de referencia correspondientes.



Advertencia

Para evitar magulladuras, mantenga las manos alejadas al manejar las piezas móviles de la máquina.



Advertencia

No toque las cintas transportadoras.



Advertencia

Tenga cuidado. Los dispositivos de ajuste de la altura pueden ocasionar magulladuras



Advertencia

Utilice la máquina sólo con las cubiertas cerradas.

INSTRUÇÕES IMPORTANTES DE SEGURANÇA!

Os diagramas e descrições usados nestas instruções não são necessariamente aplicáveis à especificação da máquina fornecida. Modificações feitas por motivos de melhorias técnicas ou operacionais são incorporadas sem aviso prévio.

INSTRUÇÕES IMPORTANTES DE SEGURANÇA!

Estas instruções operacionais foram concebidas para familiarizar o usuário com a máquina e seu uso.

O manual de instruções contém informações importantes sobre como operar a máquina com segurança, de forma adequada e mais eficiente. A observação destas instruções ajuda a evitar o perigo, a reduzir os custos de reparação e paradas, e a aumentar a confiabilidade e vida útil da máquina.

Além do manual de instruções, das regras e regulamentos obrigatórios para prevenção de acidentes, da proteção ambiental no país e do local de uso da máquina, também devem ser observadas as normas técnicas geralmente reconhecidas para um trabalho seguro e adequado.

Os sinais e designações abaixo são usados no manual para designar instruções de particular importância.



Importante

(refere-se a informações especiais sobre como usar a máquina/planta da forma mais eficiente)



Atenção

(refere-se a informações especiais e/ou ordens e proibições dirigidas para prevenir os danos)



Perigo

(refere-se às ordens e proibições concebidas para evitar ferimentos ou danos extensos)

1.0

Operação básica e uso designado da máquina/planta

1.0.1

A máquina/planta foi construída de acordo com os padrões mais avançados e normas de segurança reconhecidas. No entanto, seu uso pode constituir um risco à vida e à integridade física do usuário ou de terceiros, ou causar danos à máquina e a outros bens materiais.

1.0.2

A máquina/planta deve ser usada apenas em condições tecnicamente perfeitas, de acordo com seu uso designado e com as instruções estabelecidas no manual de operação, e apenas por pessoas conscientizadas quanto à segurança, plenamente sabedoras dos riscos envolvidos na operação da máquina/planta. Quaisquer distúrbios funcionais, especialmente aqueles que afetam a segurança da máquina/planta, devem ser imediatamente corrigidos.

1.0.3

A máquina/installação é projetada exclusivamente para acabamento de papel em tamanhos de folha de mínimo e máximo (veja as instruções operacionais correspondentes). O uso da máquina/installação para propósitos diferentes dos mencionados acima é considerado contrário ao uso designado. O fabricante/fornecedor não pode ser responsabilizado por quaisquer danos ou ferimentos resultantes de mau uso. O risco do mau uso é da total responsabilidade do usuário.

Opere a máquina dentro dos limites de seu uso designado envolve também observar as instruções estabelecidas no manual de instruções e seguir as diretrizes de inspeção e manutenção. A temperatura de trabalho da máquina deve variar entre 0° e 55°C.

1.1 Medidas organizacionais

1.1.1

As instruções de operação devem estar sempre à mão no local de uso da máquina/planta, mantendo-as no compartimento ou na caixa de ferramentas providenciada para esse propósito, por exemplo.

1.1.2

O pessoal encarregado de trabalhar na máquina deve ter lido as instruções de operação e, especialmente, o capítulo sobre segurança, antes de começar a trabalhar. Ler as instruções após o trabalho ter começado é tarde demais. Isso se aplica especialmente às pessoas que trabalham apenas ocasionalmente na máquina, durante a instalação ou manutenção, por exemplo.

1.1.3

Por razões de segurança, cabelos longos devem ser amarrados para trás ou presos, o vestuário deve ser aderentes e não pode ser usada nenhuma jóia, como por exemplo, anéis. Ser pego no maquinário ou se um anel ficar preso nas peças móveis poderá resultar em lesão.

1.1.4

Observe todas as instruções e alertas de segurança afixadas na máquina/planta.

1.1.5

Assegure-se de que as instruções e alertas de segurança afixados na máquina estejam sempre completa e perfeitamente legíveis.

1.1.6

Em caso de modificações ou alterações no comportamento da máquina/planta relevantes à segurança durante a operação, pare a máquina/planta imediatamente e comunique o defeito à autoridade/pessoa competente.

1.1.7

Nunca faça quaisquer modificações, adições ou conversões que possam afetar a segurança, sem a aprovação do fornecedor. Isto também se aplica à instalação e ao ajuste de dispositivos de segurança e válvulas, bem como para trabalhos de soldagem em elementos de suporte de carga.

1.1.8

As peças de reposição devem seguir os requisitos técnicos especificados pelo fabricante. As peças de reposição de fabricantes de equipamento original podem ser assim consideradas.

1.1.9

Comunique qualquer acidente que ocorra devido a uma avaria da máquina, apesar de todas as precauções de segurança prescritas terem sido observadas, diretamente à nossa agência.

1.2 Seleção e qualificação de pessoal - Responsabilidades básicas

1.2.1

Empregue apenas pessoal treinado ou instruído e definir claramente as responsabilidades individuais do pessoal para a operação, instalação, manutenção e reparo.

1.2.2

Certifique-se de que somente pessoal autorizado trabalhe com a máquina.

1.2.3

Os trabalhos no sistema elétrico e equipamentos da máquina/planta devem ser realizados apenas por um eletricista qualificado ou por pessoas instruídas, sob supervisão e orientação de um eletricista qualificado e de acordo com as normas e regulamentos de engenharia elétrica.

1.2.4

Trabalhos em equipamentos a gás (consumidores de gás) podem ser realizados apenas por pessoas especialmente treinadas.

1.3 Instruções de segurança que regem fases operacionais específicas

1.3.1

Operação padrão

1.3.1.1

Evite qualquer modo de operação que possa ser prejudicial à segurança.

1.3.1.2

Tome as precauções necessárias para garantir que a máquina seja usada apenas quando estiver em condição segura e confiável. Opere a máquina somente se todos os dispositivos de proteção e segurança orientada, como dispositivos de segurança removível, equipamento de parada de emergência, elementos de proteção contra ruídos e exaustores, estejam no lugar e perfeita operação.

1.3.1.3

Verifique a máquina/planta quanto a danos e defeitos óbvios, pelo menos uma vez por turno de trabalho. Comunique imediatamente quaisquer mudanças (inclusive mudanças no comportamento de trabalho da máquina) para a organização/pessoa competente. Se necessário, pare a máquina imediatamente e trave-a.

1.3.1.4

Antes de iniciar ou operar a máquina/planta, certifique-se de que ninguém esteja correndo risco.

1.3.2

Trabalho especial em conjunto com o uso da máquina/planta e manutenção e reparos durante a operação; descarte de peças e consumíveis.

1.3.2.1

Pressione sempre o botão de emergência (Not-Stop) primeiro, se parar a máquina para ajustes ou trabalhos de manutenção que não devam ser feito enquanto a máquina estiver em operação.

1.3.2.2

Para trabalhos de manutenção ou reparo de maiores proporções, desligue a fonte de alimentação principal.

1.3.2.3

Após fazer ajustes ou trabalhos de manutenção ou reparo, certifique-se sempre de que todas as ferramentas ou outros objetos tenham sido removidos da máquina. Caso contrário, podem cair dentro da máquina, causando graves danos ou ferimentos.

1.3.2.4

Manter todo o chão em torno da máquina limpo. Limpe imediatamente qualquer derrame óleo, graxa ou tinta do chão. Remover ferramentas, panos de limpeza ou pedaços de papel de todas as áreas de trabalho.

1.3.2.5

Nunca limpe as partes móveis da máquina (rolos, eixos) ou remova as folhas de teste, folhas estragadas ou fragmentos de papel em tais áreas.

1.3.2.6

Observe as atividades de ajuste, manutenção e inspeção e os intervalos previstos no manual de instruções, incluindo informações sobre a substituição de peças e equipamentos. Essas atividades podem ser realizadas apenas por pessoal especializado.

1.3.2.7

Informe o pessoal de operação antes do início de trabalhos de operações e manutenção especiais e nomeie uma pessoa para supervisionar as atividades.

1.3.2.8

Se a máquina/planta estiver completamente desligada para trabalhos de manutenção e reparo, ela deve ser protegida contra partida inadvertida por meio de:

- bloqueio dos elementos de controle principal e remoção da chave de ignição e/ou
- afixação de um sinal de alerta no interruptor principal.

1.4.1 Energia elétrica

1.4.1.1

Use apenas fusíveis originais com a classificação de corrente especificada. Desligue a máquina/planta imediatamente se ocorrerem problemas no sistema elétrico.

1.4.1.2

Se previsto nas normas, o fornecimento de energia para partes de máquinas e plantas, no qual devem ser realizados trabalhos de inspeção, manutenção e reparo, deve ser cortado. Antes de iniciar qualquer trabalho, verifique as peças desenergizadas quanto à presença de energia e aterre ou ligue em curto-circuito, além de isolar peças e elementos energizados adjacentes.

1.4.1.3

Os equipamentos elétricos de máquinas/plantas devem ser inspecionados e verificados em intervalos regulares. Defeitos, tais como conexões soltas ou cabos queimados, devem ser corrigidos imediatamente.



Atenção!

Para evitar contusões, mantenha as mãos afastadas quando estiver operando peças de máquinas em movimento!

1.4.1.4

Os trabalhos necessários em peças e elementos energizados devem ser realizados apenas na presença de uma segunda pessoa que possa cortar o fornecimento de energia em caso de perigo, acionando a parada de emergência ou o interruptor principal de força. Proteja a área de trabalho com uma corrente de segurança vermelha-e-branca e um sinal de alerta. Use somente ferramentas isoladas.



Atenção!

Afasto-se de correias em movimento!

1.4.1.5

Apenas desligue ou ligue conectores elétricos se o interruptor principal tiver sido desconectado.



Atenção!

Cuidado! Dispositivos de ajuste de altura podem causar contusões!

1.4.1.6

Apenas conecte as unidades de dobrar e nenhuma máquina de outras marcas, aos conectores existentes. Qualquer conexão elétrica de nossas máquinas de dobrar com outras marcas precisa do nosso consentimento expresso.



Atenção!

Somente opere a máquina quando as tampas estiverem fechadas.

1.4.1.7

Para a ligação elétrica, observe a tensão e a frequência admissíveis prescritas. A proteção de tensão mínima necessária para esta dobradeira é de 25 Amps.

1.4.1.8

Mantenha os gabinetes de comutadores fechados.

1.4.1.9

A tomada deve ser instalada próxima à dobradeira e deve ser facilmente acessíveis.

1.4.2

Óleo, graxa e outras substâncias químicas

1.4.2.1

Ao lidar com óleo, graxa e outras substâncias químicas, observe os regulamentos de segurança relacionados com o produto.

1.5 Descrição e definição das etiquetas e pictogramas de segurança na máquina

Substitua os pictogramas danificados por novos. Os números de referência correspondentes são indicados.

HEIDELBERG



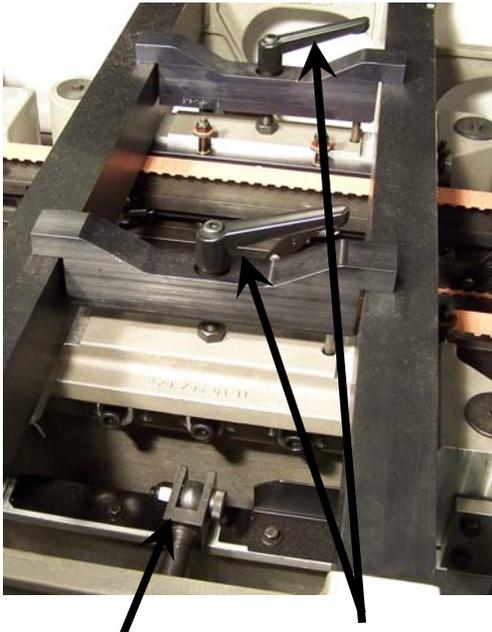
ST90 SADDLE STITCHER OPERATORS MANUAL

MAKEREADY #1: TRIMMER POSITION

The trimmer make ready position #1 automatically jogs the machine until the knives are in their lowest position (Approximately 170 Degrees).

1) ENGAGE EMERGENCY STOP!

- 2) Release the kip handles, then the clamp levers on the head and foot knife assembly, (see picture below).



Clamp Lever

Kip Handles

- 3) Turn the trimmer knife hand wheel in a clockwise rotation, thus removing back-lash, positioning the head knife casting to the scale for desired trim, (see the following pictures).



Scale

- 4) Lock the clamp levers first, then the kip handles.
- 5) **Disengage emergency stop.**

Minimum Trim Size: 5 ½" – 1 UP

Maximum Trim Size: 13 ¾" - 1 UP

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

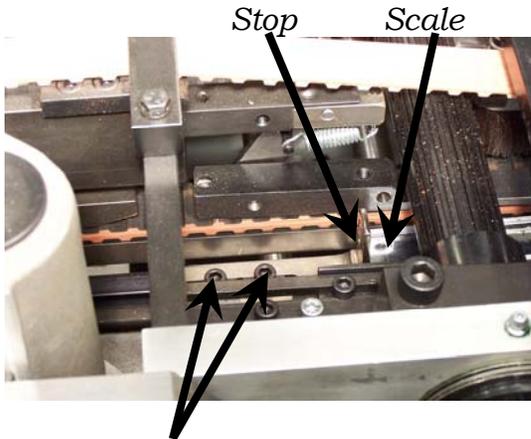
MAKEREADY #2: TRIMMER POSITION (1-7)

The trimmer make ready position#2 automatically jogs the machine until the trimmer transfer belts just stops. The knife clamps will be approximately .590" (15mm) from the bed knives, approximately 82 degrees.

1) ENGAGE EMERGENCY STOP!

- 2) Loosen the face knife stop screws that have no washers and position the stops to the scale for the desired face trim, (see picture below). **NOTE:** for books over 9 ½" (241mm)

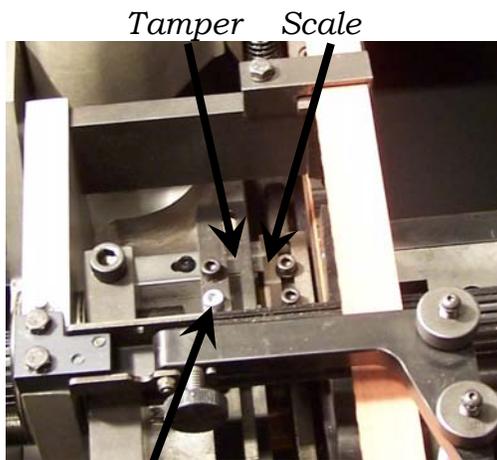
you must use the single stop fingers and the book stops must be turned around.



Face Knife Stop Screws

Tighten face knife screws.

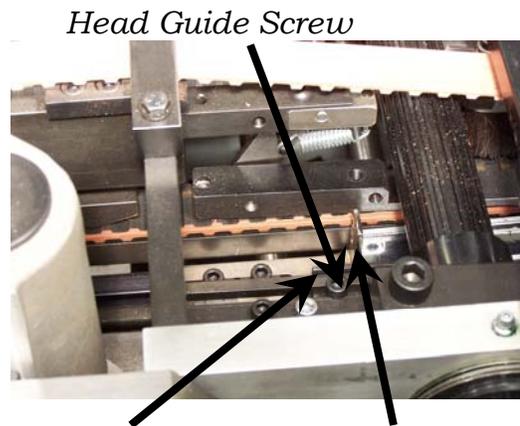
- 3) Loosen the tamper locking screw on the tamper assembly and position the tamper head guide to the scale for desired head trim, (see picture below).



Tamper Locking Screw

Tighten tamper locking screws.

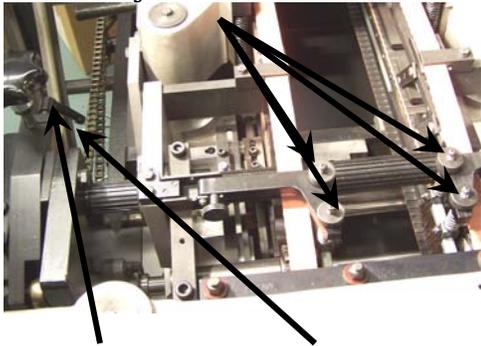
- 4) Loosen the head guide tamper block and position it between 0" - .394" (0 - 10mm) before the face knife book stops, (see picture below). **NOTE:** Formats with longer face knife trim dimension may require the tamper block to be positioned 2" (50mm) + before face stops.



Head Guide *Stop*
Tighten head guide tamper block screws.

- 5) Raise the face knife brushes and place a complete untrimmed product between the trimmer transfer belts, with the spine contacting the face knife stops. Loosen kip handle lock and adjust the transfer belt star knob to obtain slight drag while pulling the product to and from the face knife stops a distance of .787" (20mm), (see picture below).

Face Knife Brushes

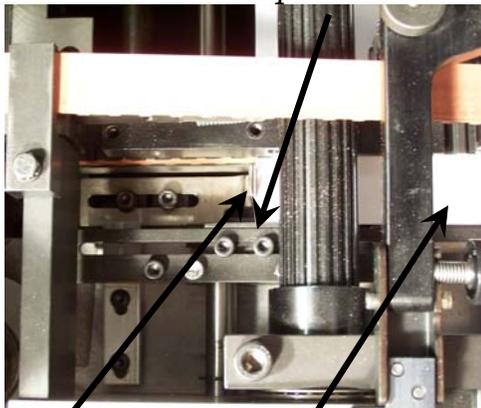


Star Knob Kip Handel

Tighten the kip handle.

- 6) Lower the face knife brushes to obtain a slight drag on the product, (see picture above and below). **NOTE:** Unequal brush pressure may cause the product to transfer out of register to the head / foot trim position.

Tamper Guide



Face Knife Stop Product

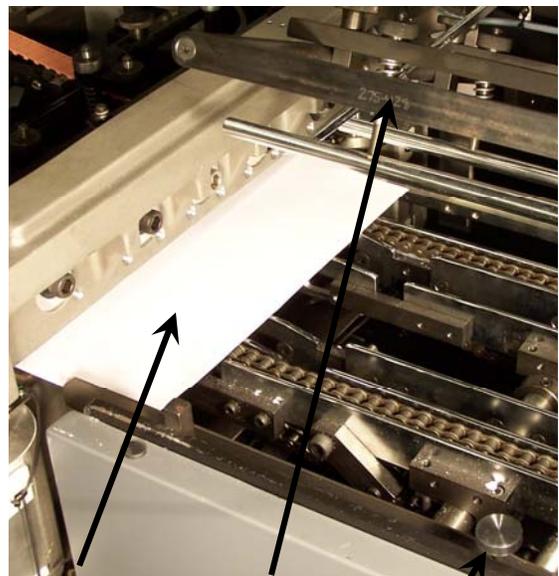
- 7) Position the complete product with the spine against the face knife stops and the head against the tamper guide block.

Minimum Trim Size: 3 ½”
(88.9mm)
Maximum Trim Size: 12”
(304.8mm)

To close this file pick “File”
“Close” in the upper left hand
corner, or pick the “X” in the
upper right hand corner.

**MAKEREADY #2: TRIMMER
POSITION (8-12)**

- 8) Raise the upper infeed hold down assembly. Loosen the thumb screws on the infeed head guide and position the end nearest the face knife .08” - .160” (2 – 4mm) away from the head of the pre-position product, (see picture below).



*Product Hold Down
Thumb Screw*

Tighten the thumb screws.

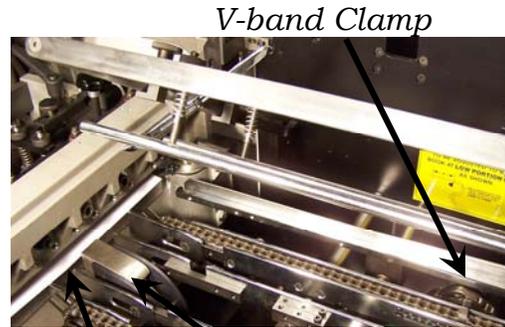
- 9) Position a complete product on the infeed support rails with the spine .394” (10mm)

before the face knife and the head against the infeed head guide, (see picture below).



Product Infeed Head Guide

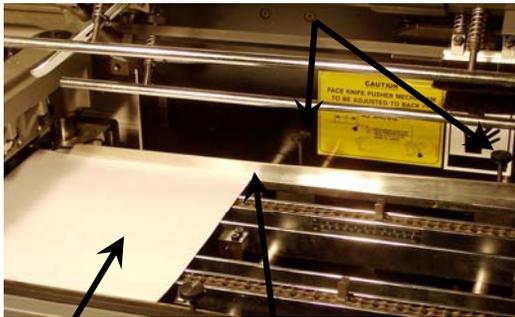
that is 5 1/2" (140mm) and smaller.



Product Pusher

- 10) Loosen the infeed foot guide thumb screws and position the end of the guide (nearest the face knife) against the product with slight pressure, (see picture below).

Thumb Screws



Product Infeed Foot Guide

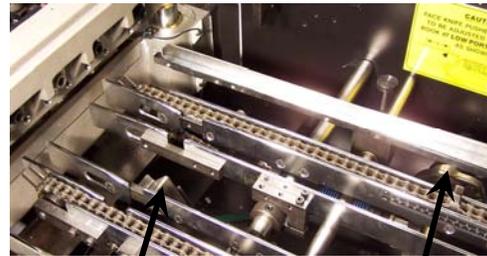
Tighten the thumb screws.

- 11) Disengage the face knife pusher V-band drive clamp and position the face knife pusher to contact the untrimmed face of the product with slight pressure, (see following picture below). **NOTE:** The face knife pusher is normally used on product

Lock V-band clamp.

NOTE: If the face knife pusher is not being used, lower the pusher .18" (5mm) below the infeed support rails and lock the V-band clamp (see picture below).

NOTE: FAILURE TO DO SO MAY RESULT IN MECHANICAL DAMAGE!



Pusher V-band Clamp

- 12) **Disengage emergency stop.**

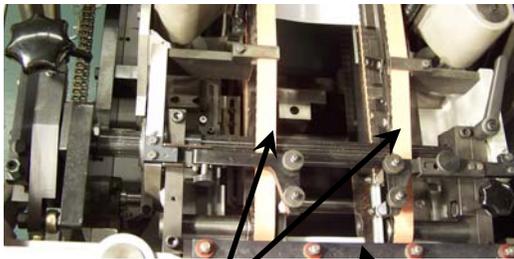
To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

MAKE READY # 3: INFEEED POSITION

The infeed make ready position #3 automatically jogs the machine until the trimmer transfer belts travel from a stopped position forward .78" (20mm), approximately 280 degrees.

1) **ENGAGE EMERGENCY STOP!**

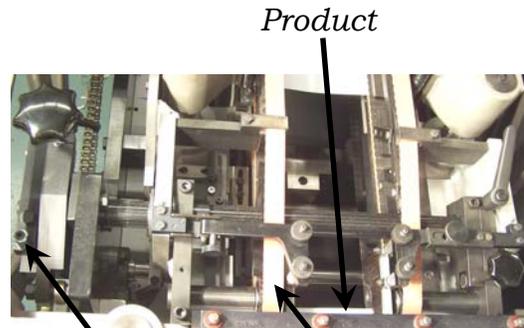
- 2) Place a complete product between the trimmer transfer belts at the face knife position, (see picture below).



Trimmer Transfer Belts
Product

- 3) Loosen the lock nut on the forward transfer belt tension stop and turn the set screw to apply heavy belt pressure on the head side of the product, (see picture below).

NOTE: This is only adjusted when changing from a thin to a very thick or a very thick to a thin product.



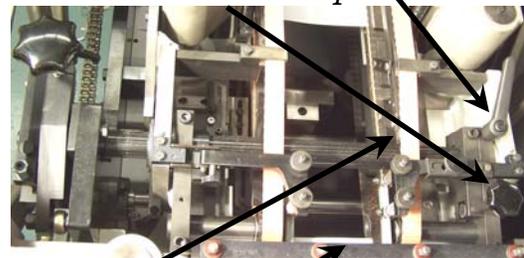
Lock Nut *Head Side Belt*

Tighten the lock nut.

- 4) Loosen the kip handle on the foot transfer belt tension assembly and turn the star knob matching pressure to the head, (see picture below).

NOTE: This adjustment is only made if adjust in #3 was made.

Star Knob *Kip Handel*

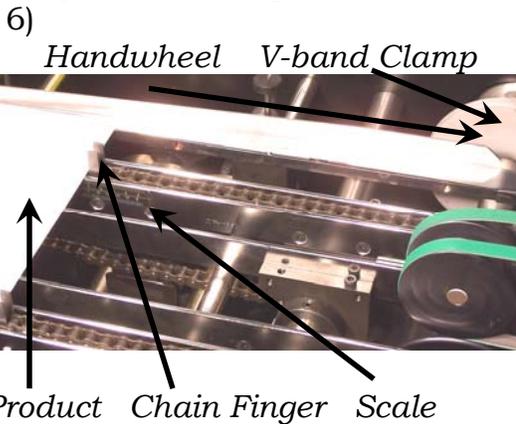


Foot Side Belt *Product*

Tighten kip handle.

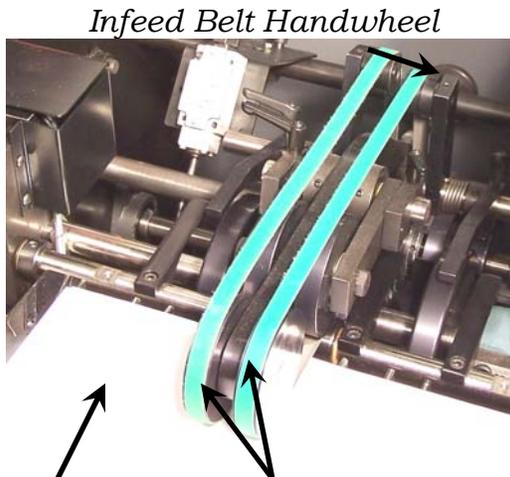
NOTE: Unequal head and foot belt pressure WILL cause the product to transfer out of register to the head / foot trim position.

- 5) In the direction of paper travel, place the spine of an untrimmed product on the infeed scale corresponding with the finished face trim size. Disengage the infeed V-band drive clamp. With the hand wheel position the infeed fingers to contact the untrimmed face of the product, (see picture below).



Engage the infeed V-band drive clamp.

- 7) Place a complete product under the infeed transfer belt exit rollers and adjust the hand wheel to apply a slight drag on the product, (see picture below).



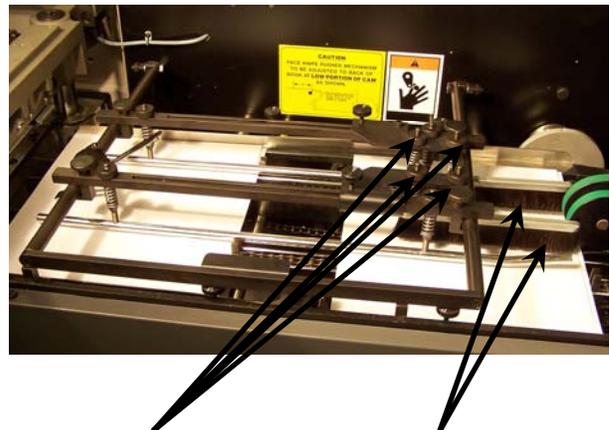
Product Infeed Belts

- 8) Position one complete product on the infeed support rails near the face knife and a second near the infeed transfer assembly. Lower the upper hold down assembly and adjust the hold down rails, (see picture below).



Hold Down Assy. Rails Adjust hold down brushes for a slight drag on the product, (see picture below).

NOTE: Unequal pressure from the hold down brushes may cause improper register against the infeed chain fingers during operation.



Adjusting Knobs

Brushes

Remove products.

9) **Disengage emergency stop.**

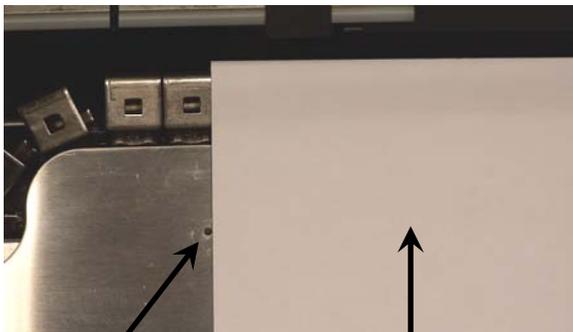
To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

MAKEREADY #4: SADDLE CHAIN POSITION

The saddle chain make ready position #4 automatically jogs the machine until the stitching unit shuttle fingers are all the way toward the right (toward the signature feeders), approximately 0 degrees.

1) **ENGAGE EMERGENCY STOP!**

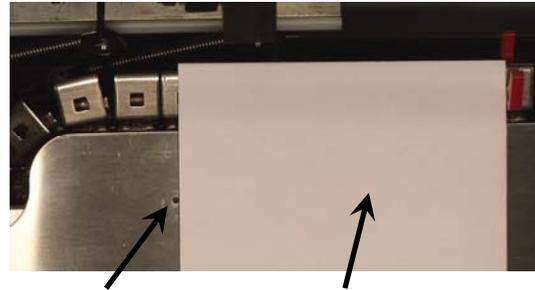
2) In the direction of the spine, fold the longest signature being run in half. Hold the left side of the signature to the right side of the reference hole on the stitcher sheet guide, (see picture below).



Reference Hole *Folded Product*

3) **Disengage emergency stop.**

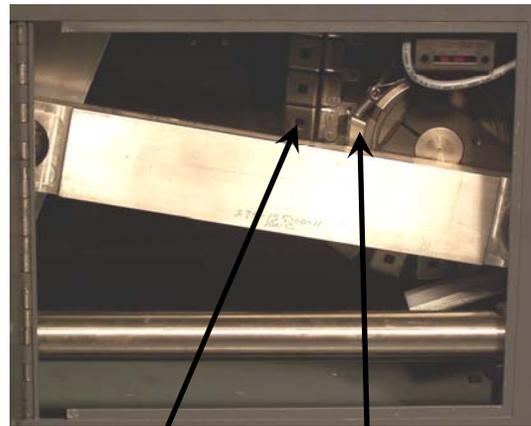
4) Jog the machine until a saddle chain finger contacts the right side of signature, (see picture below).



Reference Hole *Folded Product*

5) **ENGAGE EMERGENCY STOP!**

6) Disengage the saddle chain V-band drive clamp, (see picture below).



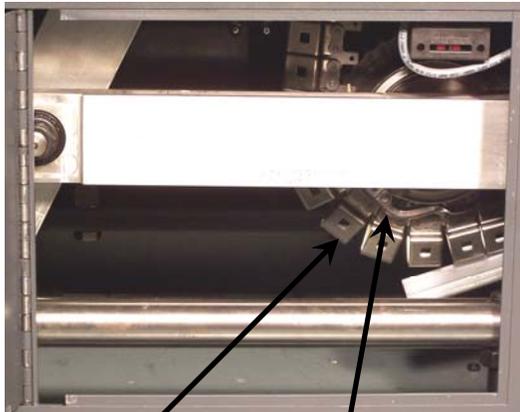
Drive Chain
V-band Drive Clamp

7) **Disengage emergency stop.**

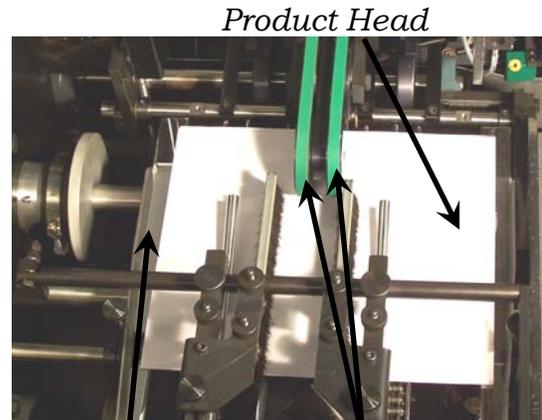
8) Run machine to saddle chain make ready position #4, approximately 0 degrees.

9) **ENGAGE EMERGENCY STOP!**

10) Engage the saddle chain V-band drive clamp, (see picture below).



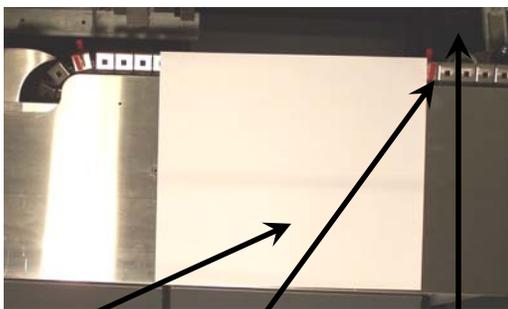
Drive Chain
V-band Drive Clamp



Product Head
Product Foot *Transfer Belts*

11) **Disengage emergency stop.**

12) Place the product on the saddle chain after the inspector. At run speed jog the product onto the infeed table, stopping it before the face edge of product reaches the exit rollers of the infeed transfer belt assembly, (see pictures below).



Product *Chain Finger* *Inspector*

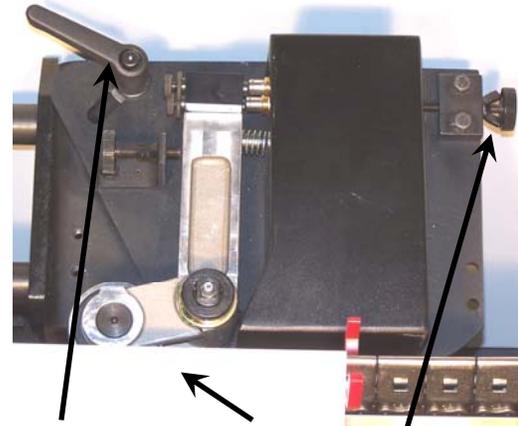
13) In this position the head and the foot of the product must be centered on the infeed table. **NOTE:** If the signature is not centered on the infeed table, **ENGAGE EMERGENCY STOP**, disengage the saddle V-band drive clamp and pull the saddle chain forward or backward accordingly. Engage the saddle chain V-band drive clamp. Redo items 11,12 and 13.

14) **Disengage emergency stop.**

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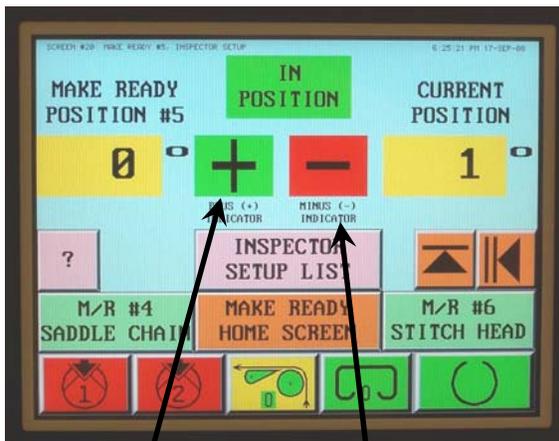
MAKEREADY #5: INSPECTOR POSITION

The inspector position automatically jogs the machine until the lower inspector roller timing mark is in line with the center of the upper inspection roller. **NOTE:** Check to ensure that the plus (+) indicator is green and the minus (-) indicator is red, (see picture below), approximately 0 degree.



Kip Handle *Product* *Knurl Knob*

Tighten the inspector kip handle.



Plus (+) Indicator *Minus (-) Indicator*

- 1) **ENGAGE EMERGENCY STOP!**
- 2) Loosen the inspector assembly kip handle and place a complete product on the saddle chain between the upper and lower inspector rollers. Turn the inspector assembly knurl knob until both - & + indicators in the operator interface are green, (see picture below).

- 3) Remove thinnest signature. Fine tune the minus (-) inspector by loosening the minus (-) locking nut and rotating the (-) thumb screw clockwise until the minus (-) indicator in the operator interface turns green. Then rotate the minus (-) thumb screw counter clockwise until the minus (-) indicator in the operator interface turns red. Then continue turning clockwise for ¼ to 1 revolution, (see picture below). Add signature back in and the minus (-) indicator should be green, remove signature again and the minus (-) indicator should be red.

4)



Minus (-) Thumb Screw

Locking Nut

Tighten the minus (-) locking nut without moving the thumb screw.



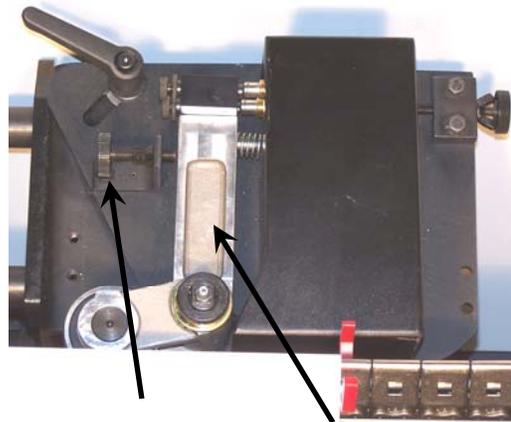
Plus (+) Thumb Screw

locking Nut

Tighten the plus (+) locking nut without moving the thumb screw.

- 5) Add two thinnest signatures. Fine tune the plus (+) inspector by loosening the plus (+) locking nut and rotating the plus (+) thumb screw counterclockwise until the plus (+) indicator in the operator interface turns green. Then rotate the plus (+) thumb screw clockwise until the plus (+) indicator in the operator interface turns red. Then continue turning clockwise for $\frac{1}{4}$ to 1 revolution, (see picture below). Remove one signature and the plus (+) indicator should be green, add the signature back in again and the plus (+) indicator should be red.

- 6) To test the final settings, place a complete product between the inspection rollers. Push and pull the inspection arm back and forth. The plus (+) and minus (-) indicator lights should change from green to red then back to both indicators being green when the inspection arm is left in its neutral position, (see picture below).



Thumb Screw Inspector Arm

- 7) Adjust the inspector gap set thumb screw to allow for a .020" (.5mm) gap between the inspector arm and the gap set thumb screw, (see picture above).
- 8) **Disengage emergency stop.**

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

MAKEREADY #6: STITCHING HEAD

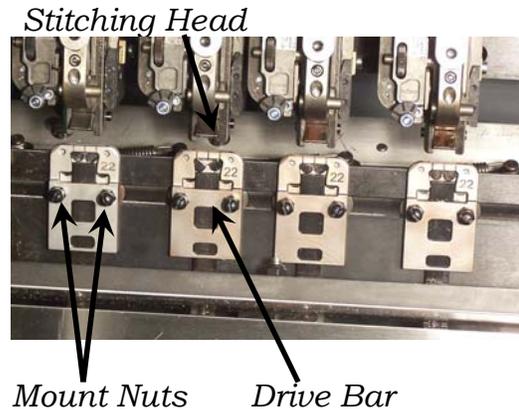
- 1) **ENGAGE EMERGENCY STOP!**
- 2) Refer to the Hohner head manual for detailed information.
- 3) Loosen the 4mm stitching head mount bolt. Locate the stitching head to desired stitch position, (see picture below).



Stitching Head Mounting Bolt

Tighten the stitching head mount bolt.

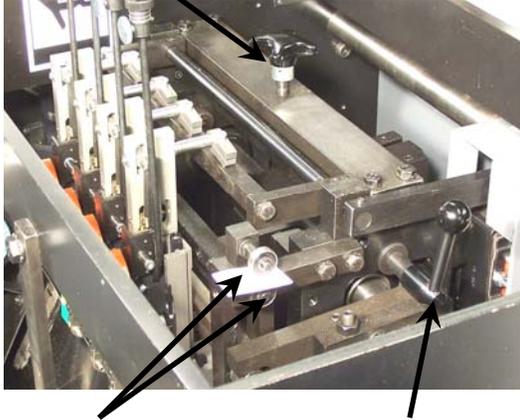
- 4) Loosen the clincher mount nuts and position the clincher driver bar to the exact center of the stitching heads\ driver, (see picture below).



Tighten clincher mount nuts.

- 5) Disengage the stitcher compression kip handles. Place 1/2 of the product between the stitcher roller bearing gauge. Turn the stitcher star knob to apply slight drag on the product, (see picture below).

Star Knob



Bearing Gauge

Kip Handle

Tighten kip handle.

6) **Disengage emergency stop.**

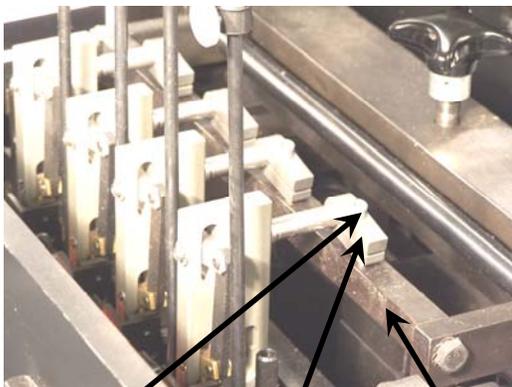
To close this file pick “File”
“Close” in the upper left hand
corner, or pick the “X” in the
upper right hand corner.

MAKEREADY #7: STOP STITCH

- 1) **ENGAGE EMERGENCY STOP!**
- 2) Turn the stitch mode to “OFF”/“GREEN”.



- 3) Loosen stop stitch finger screw. Position the stop stitch finger so that there is no gap between the finger and stop stitch bar, (see following pictures).



Screw Finger Bar

Tighten the stop stitch finger screw. Do this on all stitching heads being used.

- 4) Test the stop stitch solenoid by using the “STOP STITCH SOLENOID TEST” button on the Stop Stitch Setup List screen.



- 5) In the Stop Stitch Setup screen, Turn the stop stitch solenoid mode to “AUTOMATIC”/”YELLOW”.



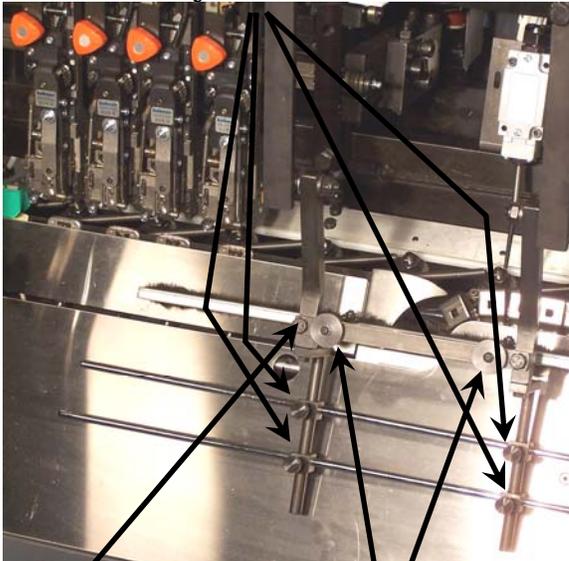
- 6) **Disengage emergency stop.**

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

MAKEREADY #8: TEST RUN STITCHER THROUGH TRIMMER

- 1) Lower the stitcher sheet guide brush assembly and set the brush for slight drag on the product. Adjust the hold down rail approximately .390” (10mm) above the lower edge of the product, (see following picture).

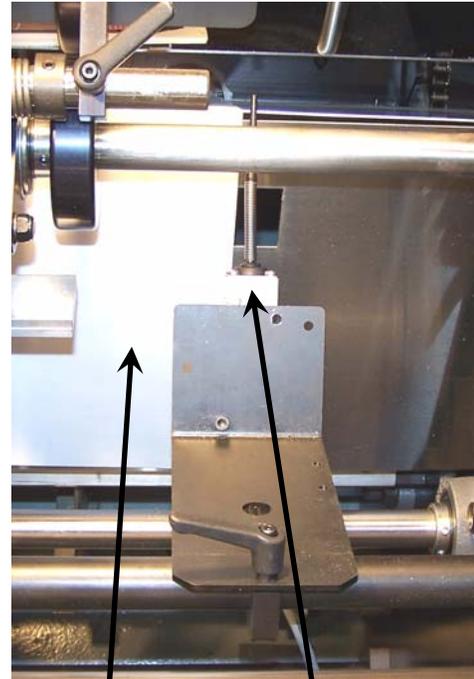
Guide adjust screw



Guide Brush Assy

Brush Adjust screw

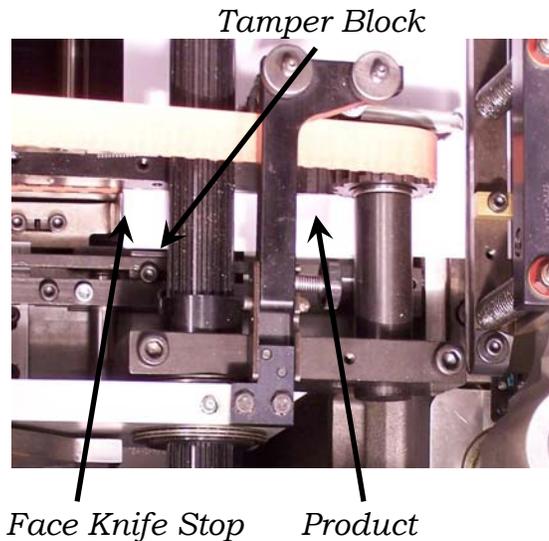
Place the product on the saddle chain before the inspector. At run speed jog the product until it reaches the infeed tucker position and stop while the product is still contacting the stitcher sheet guides. Position the tucker jam detector approximately .190" (5mm) from the foot of the product, (see picture below).



Product

Tucker Jam Switch

2) Jog the product into the face knife stop position watching to ensure the spine reaches the stops just after they have peaked, however the tamper block has not yet contacted the head of the product. Once the tamper block contacts the head of the product watch for .080 (2mm) of tamp, (see picture below).



for operation. The eventual order of adjustments will probably be determined as the operator becomes more familiar with the functions of the unit. To Begin, the following procedures is recommended:

- 1) Adjust the left and right hopper guide plates to the size of the cover stock. The centerline of the cover should be aligned with the scribe line of the hopper center plate.

The hopper guide plates are adjusted by releasing the clamp on the hopper side block and sliding the guide plate to the desired location. Then tighten the clamp.

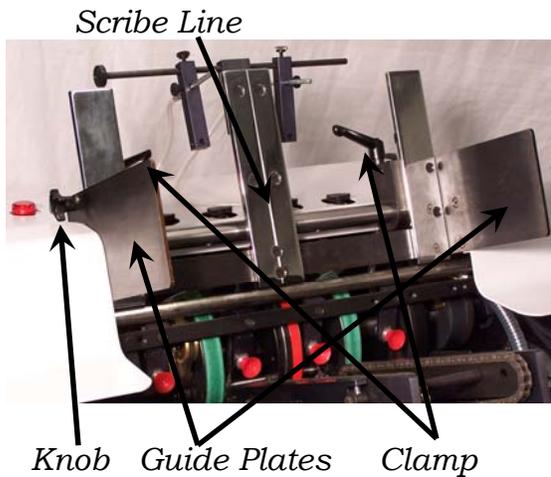
A fine adjustment can be obtained by turning the knob located on the side of the hopper adjusting block. Adjust the guide plates so the sheets can move without binding, but remain aligned with the hopper center plate, (see the following picture).

- 3) Adjust the infeed chain finger + or - to achieve proper timing to the stops and adjust the infeed side guides left or right to achieve proper tamping travel.
- 4) Jog product through the trimmer and check the finished product for trim accuracy. Adjust accordingly.
- 5) Place three to five complete products on the saddle chain before the inspector and run them at machine speed watching to ensure proper registration at each station.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

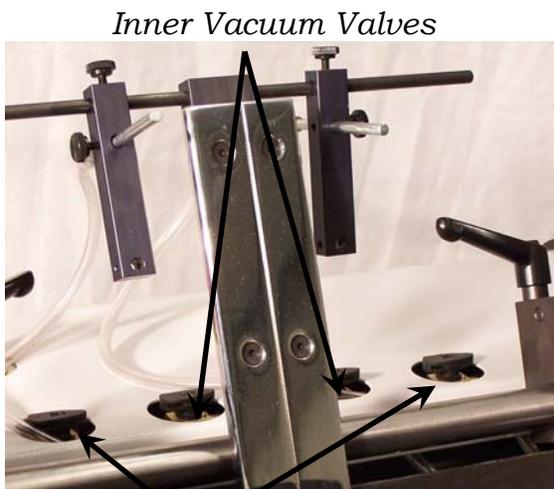
MAKEREADY #9: HIGH FOLIO FEEDER

Several steps are normally necessary to prepare the machine

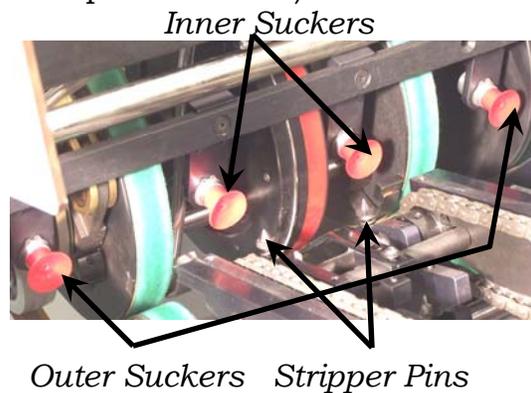


- 2) The vacuum supply to the Cover Folder Feeder is controlled separately for all four suction cups. These valves are located on the vacuum manifold and the control knob is accessed from the top of the unit, (see picture below).

NOTE: To prevent vacuum loss, be sure to turn off all four vacuum valves when Cover Folder Feeder is not in use.



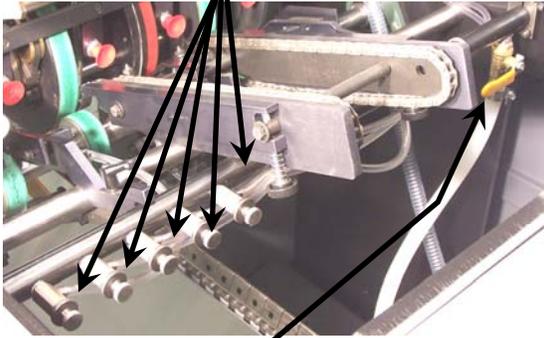
When making the initial setup, use just the two inner suckers. The two outer suckers are only used when necessary and the vacuum to these suckers should be off unless being used. The outer sucker assemblies can be repositioned on the mounting bar if necessary. The inner suckers should align close to the stripper pin, (see picture below).



Initial setting for the stripper pins is approximately 1/16" (1.5mm) above the rails. The pins may be raised or lowered as necessary to suit the material. The pins should be above the rails for consistent feeding.

- 3) Air separation of the cover at the stripper pins is essential to prevent picking up more than one sheet. There are five blower tubes, each controlled by a valve on the manifold, (see following picture).

Blow Valves



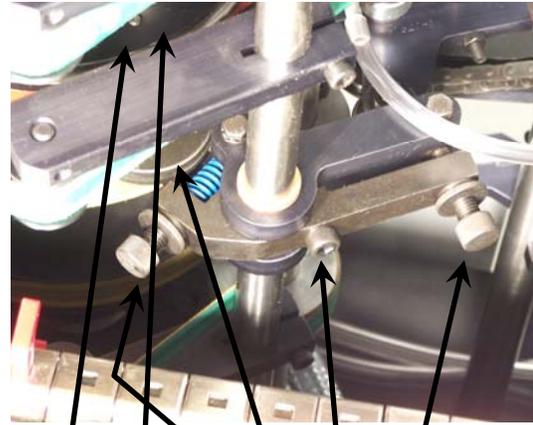
Main Blow Shut Off

These blower tubes provide air flow to separate the cover sheets. An initial setting is obtained by first making sure the valves are completely closed, then opening each valve approximately ¼ turn and securing with the knurled locking nut. This setting can be varied to suit the material being used. Open the valves further for heavier material and less for lighter stock. Each blower tube may be adjusted to direct the air flow as needed.

NOTE: When the cover folder is not in use, be sure to turn the main blow supply valve off.

- 4) To adjust the scoring wheels to each other, first release the clamping screw that holds the small wheel assembly to the tie bar. Insert a sample thickness of cover stock between the scoring wheels to obtain an approximate setting. Remove the sample material, making sure the inner and outer

wheels are aligned central to each other, (see picture below). Tighten the locking screw.

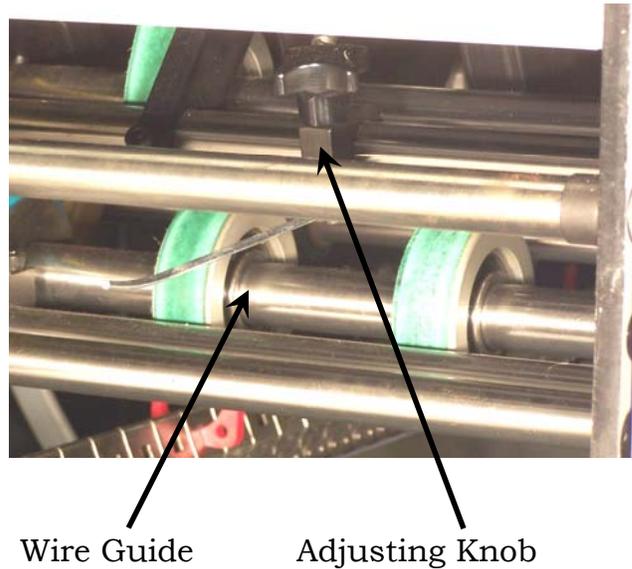
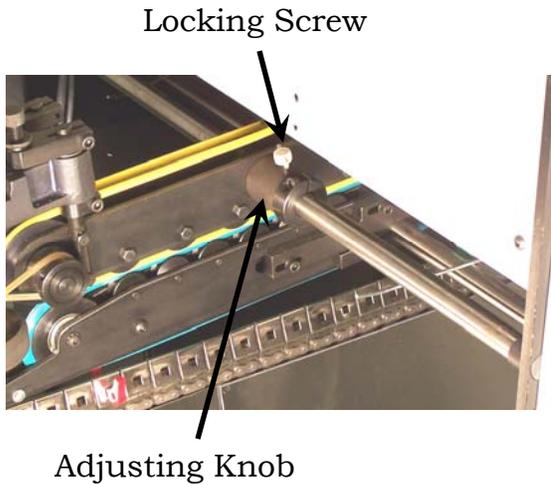


- 1. Large Scoring Wheel
- 2. Insert Stock Here- Between Scoring Wheels
- 3. Wheel Tension Screw
- 4. Small Scoring Wheel
- 5. Clamping Screw
- 6. Fine Adjust Screw

Two knurled screws with lock nuts are used for further adjustments on the small wheel assembly. One screw maintains spring tension on the wheel. The other is for fine adjustment. Before moving the wheel, the knurled screws should be set to provide maximum thread adjustment.

- 5) The cover receives a preliminary fold in the belt assembly before being delivered to the pinch or squeeze rollers. To engage the upper belt assembly, rotate the knurled

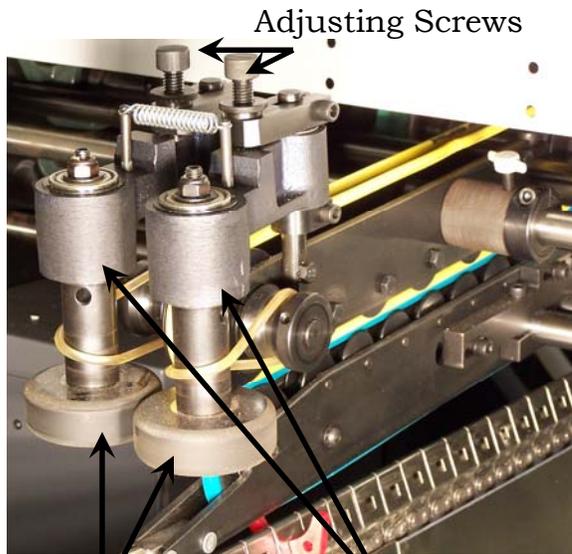
adjustment knob on the tie bar, (see picture below).



Run a sample cover through the unit to be sure the sheet receives the correct fold. The cover sheet should not enter the pinch rolls flat. If additional adjustments are necessary, rotate the eccentric adjusting knob more or less as required. Extra control through the best assembly is provided by the paper guide wires (see picture below).

NOTE: Care should be used when using these guides. Too much pressure may cause excessive marking.

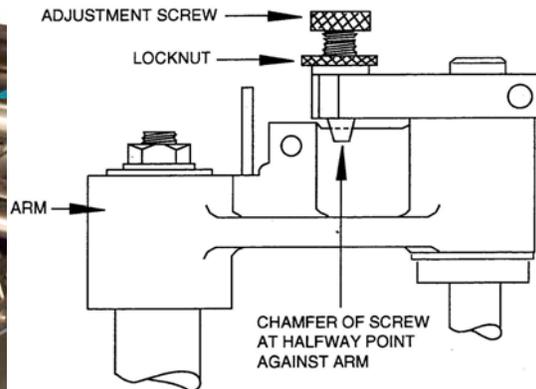
- 6) The cover should be fed into the pinch rollers approximately $\frac{1}{4}$ " (6mm) from the top of the rollers. The height of the rollers is adjusted by moving the stop collar and the pinch roller stop arm. If the cover sheet is not fed into the rollers at the proper height, the tail of the sheets may drop lower than the rollers, (see following picture).



Pinch Rollers Arms

The pinch rollers are centered on the cover sheet by loosening the clamping screw on the pinch roller stop arms and moving the rollers from side to side as needed.

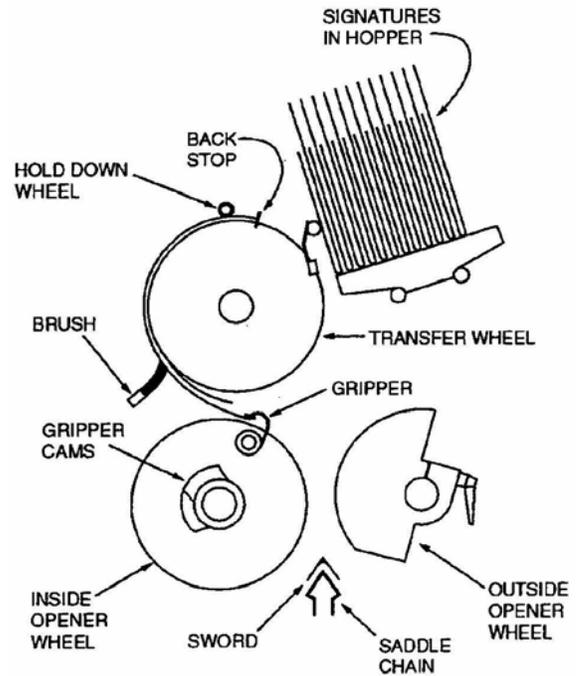
Final pressure on the fold is adjusted by means of the pinch roller adjustment screws. First loosen the lock nuts. Clockwise rotation on the knurled screw moves the roller to center. The screw should be set to give maximum adjustment by setting to the middle of the chamfer as shown (see the following diagram).



To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

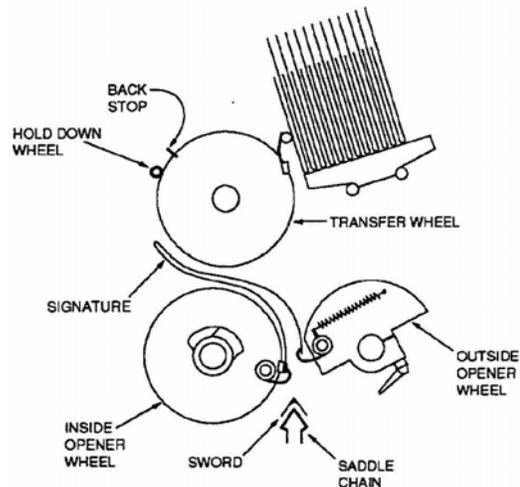
**MAKEREADY #9: HIGH FOLIO LIP
SETUP**

- 1) Unlock the “V” Band clamp on the drive chain hub.
- 2) Turn the hopper vacuum valve on.
- 3) Feed the signature to the back stop, rotating the unit with the Hand wheel.
- 4) Adjust the back stop, if necessary, to allow the inside opener gripper to grip 1/8” (3mm) of the signature.
- 5) Set the brush to hold the signature against the transfer wheel. This will help maintain the lap.
- 6) Set the inside opener wheel gripper cam for mechanical opening. **NOTE:** This cam is also adjusted for vacuum opening.



- 7) Advance the signature unit until the short leg is at the center line of the outside opener wheel.
- 8) Adjust the outside opener wheel so the opener finger tucks between the short leg and lip of signature.

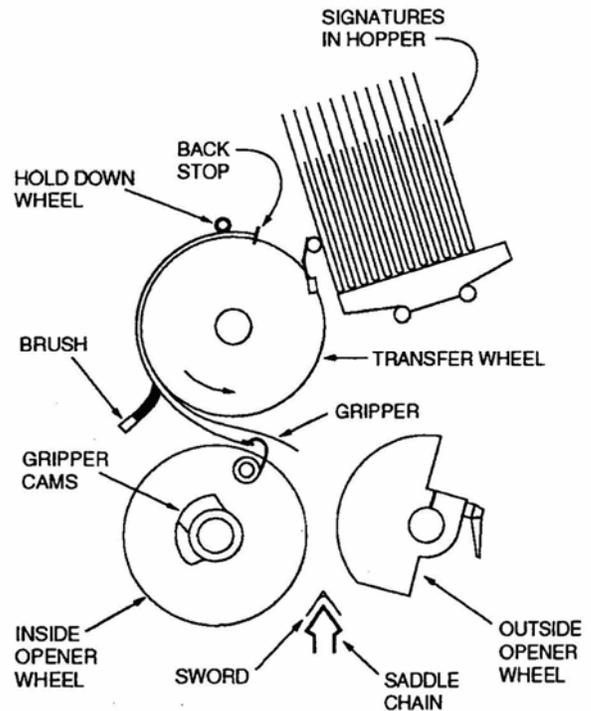
The following illustration is for steps (1-6).



This illustration is for steps (7-8).

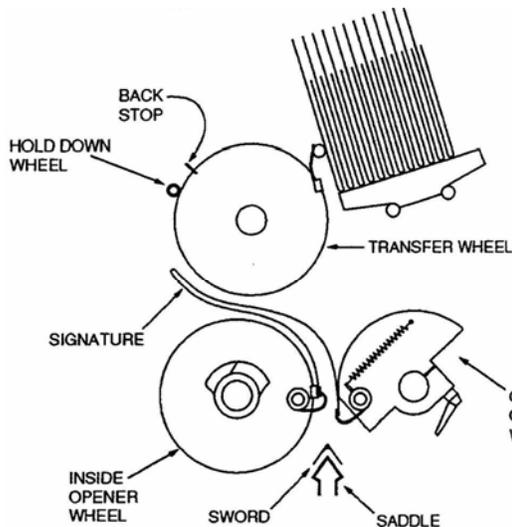
**MAKEREADY #9 LOW FOLIO LIP
SETUP**

- 1) Unlock the "V" Band clamp on the drive chain hub.
- 2) Turn the hopper vacuum valve on.
- 3) Feed the signature to the back stop, rotating the unit with the Handwheel.
- 4) Adjust the back stop, if necessary, to allow the inside opener gripper to pass under the lip and hold the short leg of the signature.
- 5) Set the brush to hold the signature against the transfer wheel. This will help maintain the lap.
- 6) Set the inside opener wheel gripper cam for mechanical opening. **NOTE:** This cam is also adjusted for vacuum opening.

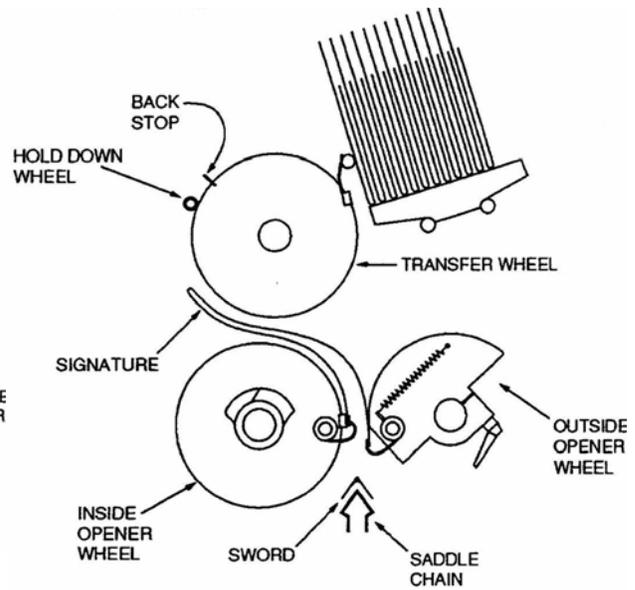


This illustration is for steps (1-6).

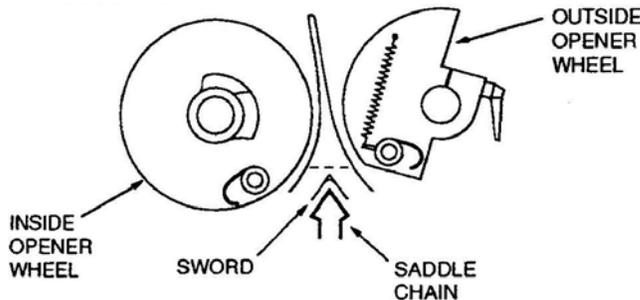
- 7) Advance the signature unit until the short leg is at the center line of the outside opener wheel.
- 8) Adjust the outside opener wheel so the opener finger tucks between the short leg and lip of signature.



This illustration is for steps (7-8).



- 9) Rotate unit until the signature is just above the sword. Then jog the machine until the saddle finger is approximately 5" (127mm) from the lead edge of the signature. Re-lock the "V" Band drive clamp.



This illustration is for steps (9).

NOTE: Make sure the vacuum is only open to the hopper suckers. Then test run a quantity of signatures using the reject tray.

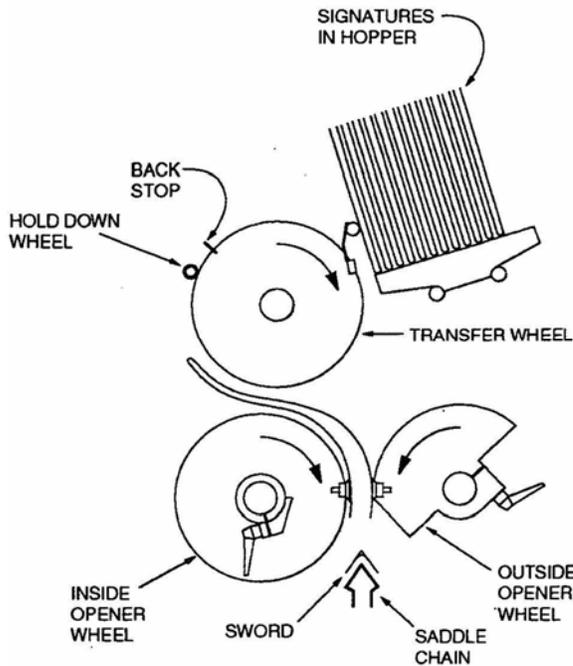
To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

MAKEREADY #9: VACUUM OPEN/ NOLIP SETUP

- 1) Loosen the cam clamp on the inner opener shaft with an allen wrench. Rotate so the cams are fully extended. Retighten the cam clamp. This setting causes the fixed opener gripper to release the signature, allowing the vacuum to take over. Add one or two offset bars to back stop for skewing as needed.
- 2) Set the back stop to the width of the signature. The inside opener gripper will pull both sides of the signature to a point where the vacuum takes over control of the signature.
- 3) Rotate the hand wheel to the position shown, and then adjust the suckers on the inside and outside opener wheels to within 1/4" (6mm) of

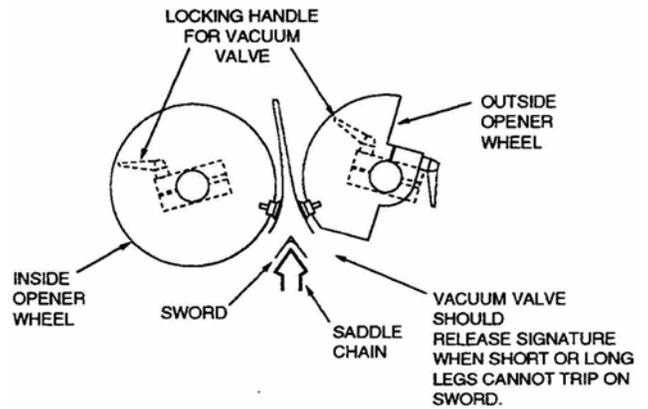
the edge of the signature cover.

- 4) Turn the inside and outside vacuum valves on.



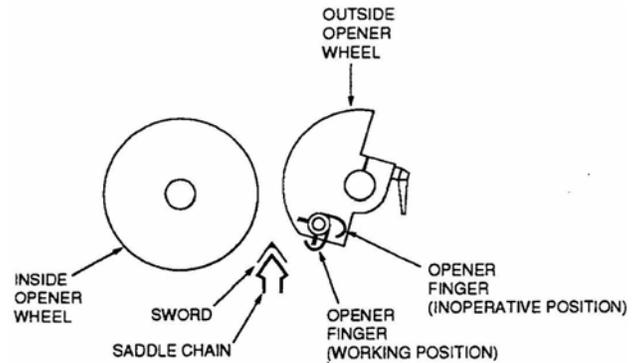
This illustration is for steps (1-4).

- 5) Rotate the unit until the signature has opened over the sword. Then adjust the vacuum valves to release the signature.
- 6) Feeding covers, four pages and good signatures with no lip, it is normal to run with vacuum only. Therefore, the opener finger should be disabled. To do this, press the outside opener gripper finger between the ball points.



This illustration is for steps (5-6).

- 7) Feeding certain signatures may require the use of vacuum open and the opener fingers since the sucker only holds the outer page of the signature. The opener finger is used to catch the remaining page or pages.

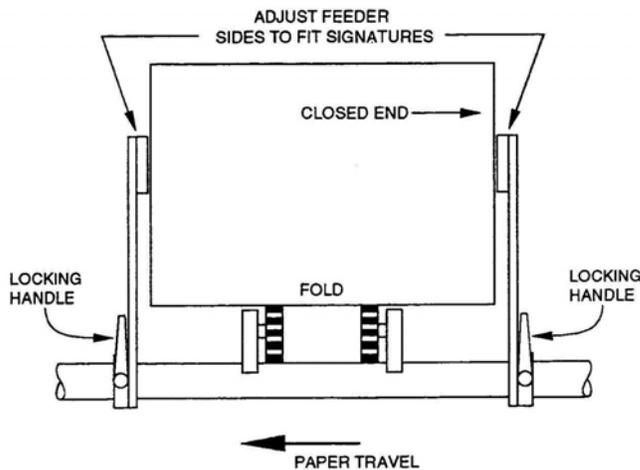


This illustration is for step (7).

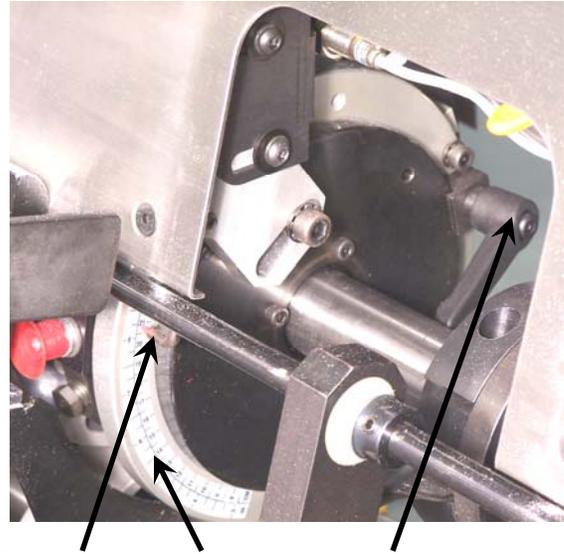
To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

MAKEREADY #9 FEEDER **TRANSFER WHEEL**

- 1) To load the signatures in the hoppers, the signatures should be presented to the hoppers as flat as possible. This may require some preparation by the personnel who are loading the hoppers, (see diagram below).



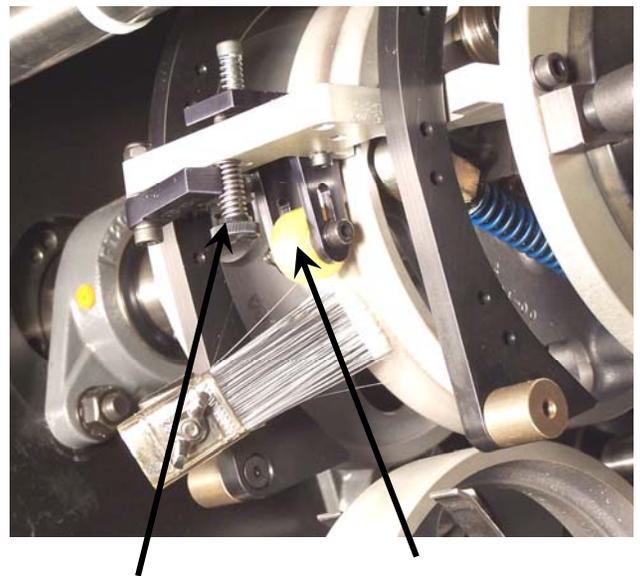
- 2) Assure that the transfer grippers have $\frac{1}{4}$ " to $\frac{5}{16}$ " (6-8mm) gripper bite for pulling the sheet from the hopper, (Factory setting).
- 3) To set the opener back stop loosen the kip handle. Measure the longest leg of the signature and set the pointers to that dimension on the scale (see picture below).



Pointer Scale Kip Handle

Tighten kip handle.

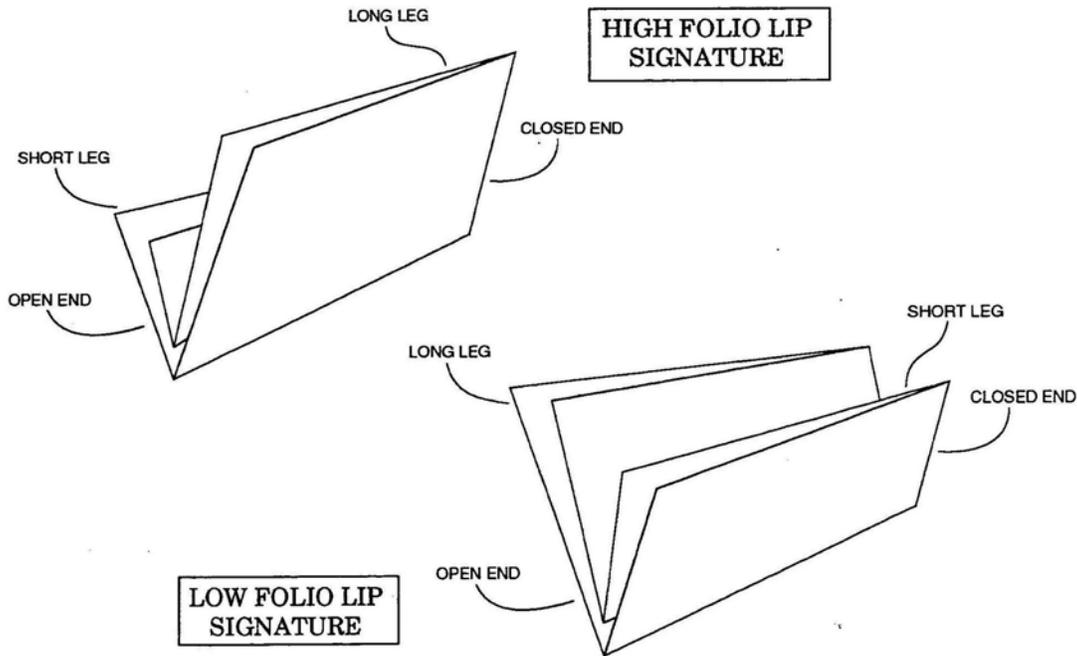
- 4) Adjust the backstop wheel so there is a slight drag on the signature. This setting keeps the signature against the backstop after the transfer wheel grippers have opened, (see picture below).



Adjusting Screw Backstop Wheel

5) Use diagram below to help determine type of signature that will be used. A signature falls into three types, a High Folio Lip, Low Folio Lip and a No Lip signature.

Once determined, go back to X-position and pick the proper signature and continue feeder setup.



A no lip signature = both legs are the same length.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

TRIMMER KNIFE INSTALLATION

For installing all six knives the following procedure is recommended:

1) Assure that the machine position is at 0 degree position.

2) **Assure that the emergency stop is engaged.**

3) Install the bed knives by reinstalling the five socket head cap screws and used to hold the knives in position.

4) Install the head and foot knives using one of the five screws as a handle to hold the knife in position while the other screws are installed, remove the handle

- screw and install it in the center hole.
- 5) Install the five screws holding the upper face knife, in the same manner as the head and foot knives.
 - 6) Install the three paper clamps last.
 - 7) Disengage the emergency stop.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

TRIMMER KNIFE REMOVAL

In case of failure to cut or difficulty in cutting check the condition of the upper (face and side) knives and lower (bed) knives. Dull knives cut only with a great amount of force. If too great a clearance exists between the knives, the bottom sheet of the set will not cut cleanly.

For removing all six knives the following procedure is recommended:

- 1) Use make ready X-position set at 0 degree or use make ready #4 or #5 to run the machine into the top of the trimmer stroke.
- 2) **Engage emergency stop.**
- 3) Remove the three paper clamps first.
- 4) Remove the five screws holding the upper face knife, starting with the center bolt and place it into the opposite side of the knife for use as a handle in holding the knife.
- 5) Remove the head and foot knives in the same manner.
- 6) Remove the bed knives by removing the five socket head cap screws and used to install them.

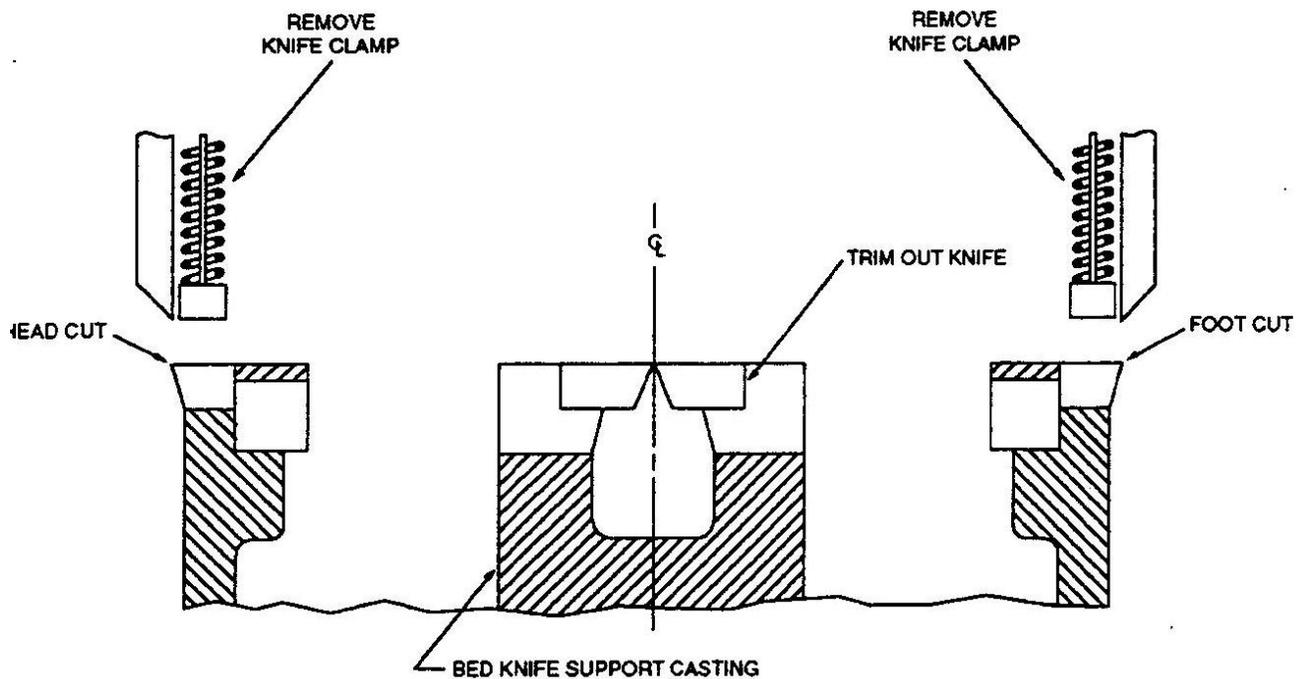
To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

4th & 5th KNIFE INSTALLATION

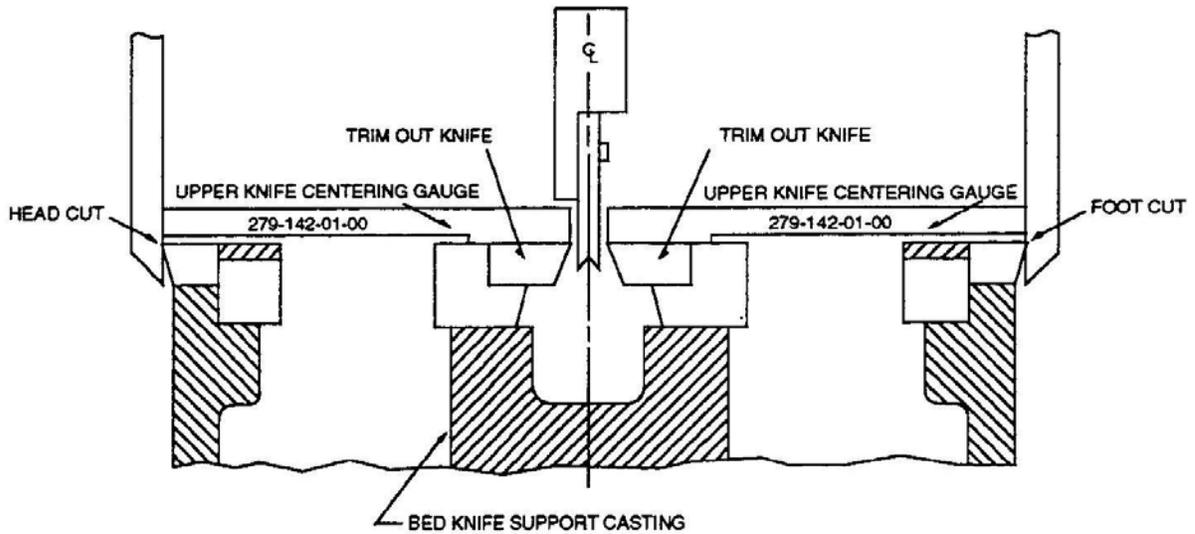
For installing the 4th and 5th knives the following procedure is recommended:

- 1) Jog the machine to the position where the book clamps are compressed approximately ½” (13mm).
- 2) **Engage emergency stop!**
- 3) Loosen the clamping lever on both the head and foot bed knife support castings.
- 4) Crank the head and foot knives to where they are approximately 16” (406mm) apart. This will allow space to set in the 4th and 5th bed knife support and the centering gauges. Tighten the clamping levers.

- 5) **Disengage the emergency stop.**
- 6) Jog trimmer so that the knives are in full lift position, (0 degree position).
- 7) **Engage the emergency stop!**
- 8) Remove book clamps and install the lower casting with the slotted hole in the casting towards the delivery, (see illustration below).

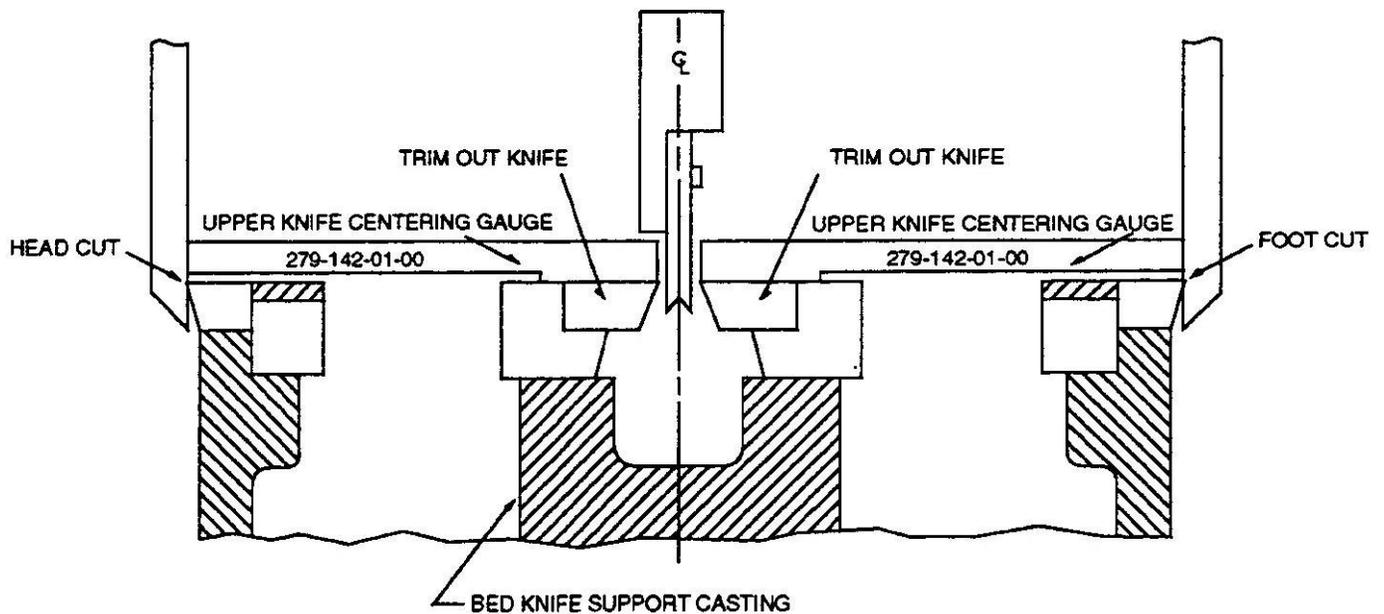


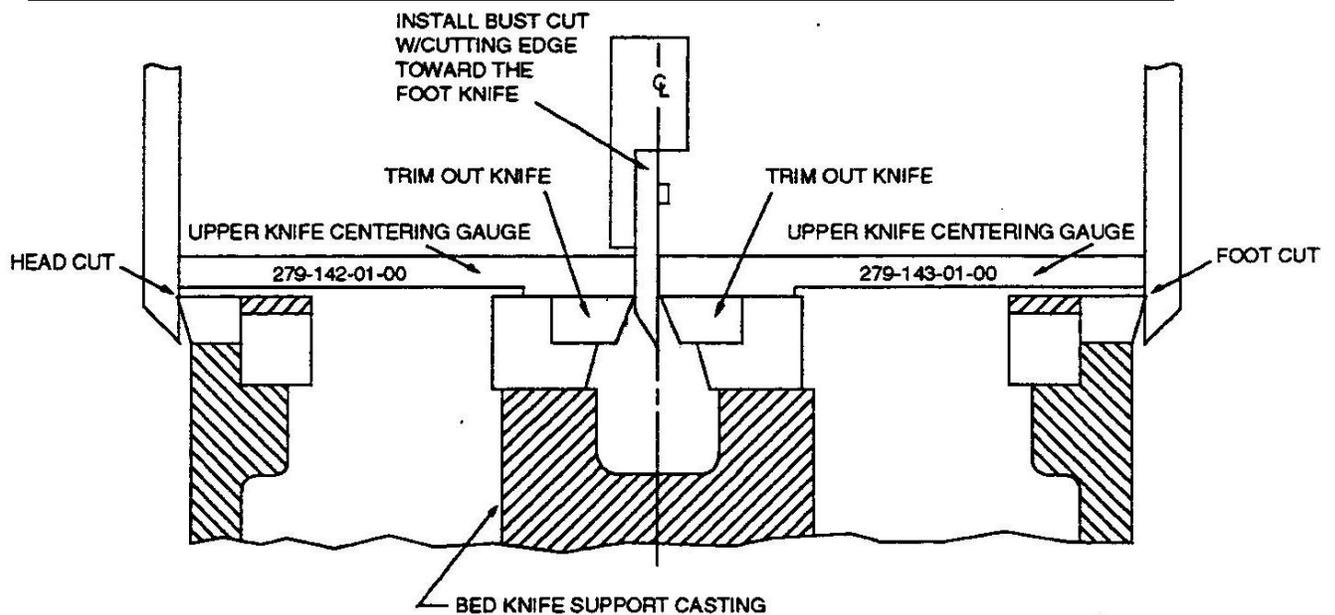
- 9) Open lower bed knives and insert center knife in between bottom bed knives.
- 10) Lower the assembly down and start allen cap screws through the clamping bar and center knife housing.
- 11) Install centering gauges with lip towards the center knife, (see the following illustration).



12) Using crank, adjust the head and foot knives in. This will parallel the 4th and 5th knives with the head and foot knives.

13) Tighten the allen head screws on the clamping bracket, (see illustrations below, one is showing center trim knife and the other is showing a bust cut).





14) Crank the head and foot knife apart and remove the centering gauges.

15) **Disengage emergency stop.**

16) Jog trimmer so that knives are down and adjust the bed knives to the center knife.

17) Jog trimmer so that the knives are in full lift position, (0 degree position).

18) **Engage the emergency stop!**

19) Install all clamps.

20) **Disengage emergency stop.**

21) Recheck the cutting by placing a single sheet of

MAINTENANCE / GENERAL LUBRICATION

The ST-90 is completely lubricated at the factory, but for long service life the machine should be lubricated every 600 hours of operation.

NOTE: Lubrication is **NOT** required on the hopper feed chains!

Note: Reference applicable stitching head manual for lubrication requirements.

Lubrication Type:

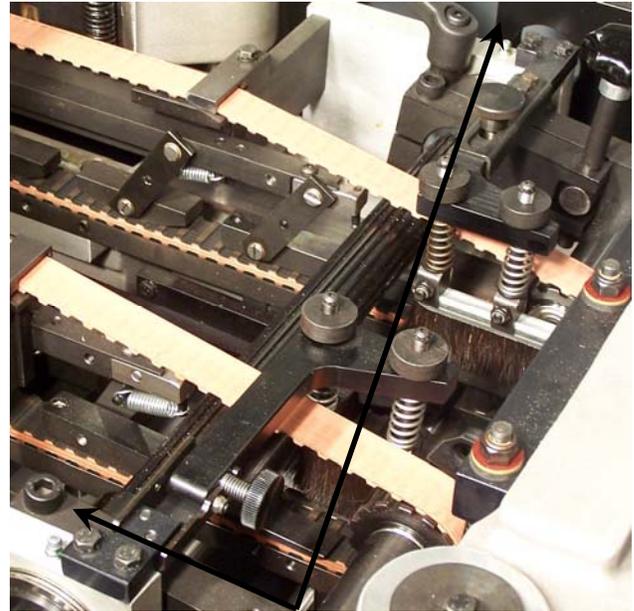
- 1) For all ball bearing or cam followers:
Use NLGI grade #1 or #2 Lithium base grease or equivalent [as provided with the machine] Zeniplex 2 NLGI-2.

- 2) For roller chains:
Use any quality machine oil, SAE 30.
- 3) For gear boxes:
Use SAE 90 HD gear oil if adding or changing gear oil.

TRIMMER

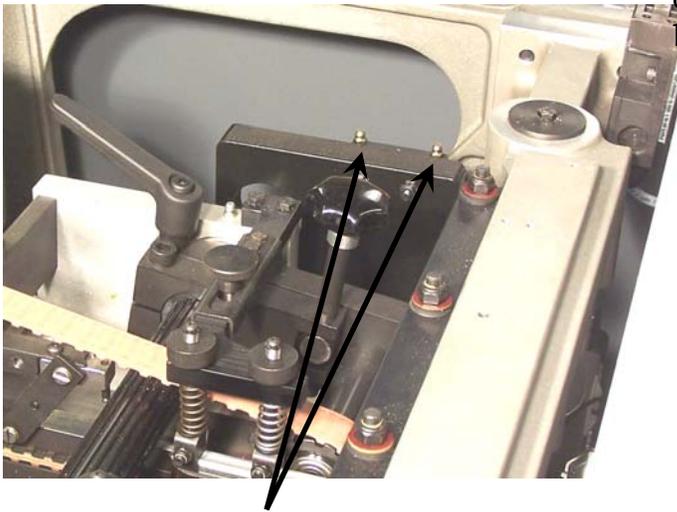
The trimmer section has 9 lube points:

- 1) In manifold block on “non-operator” side of trimmer frame near the face knife area, (see picture below). Use type {1} lube.



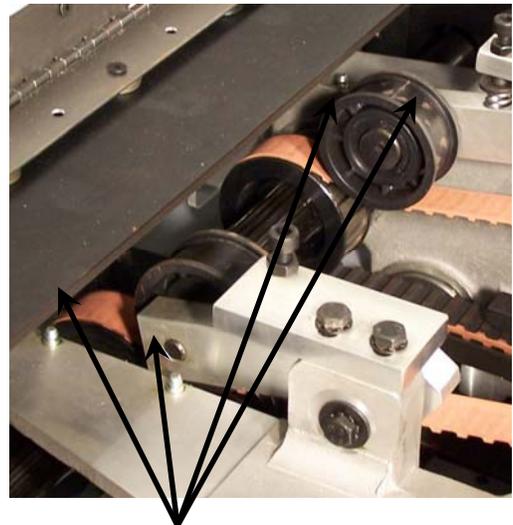
Lubrication Points

- 4) Two on each rear trimmer transfer belt “spline” shaft drive bearing, (see picture below). Use type {1} lube.



Lubrication Points

- 2) One on each front trimmer transfer belt “spline” shaft drive bearings, (see picture below). Use type {1} lube.



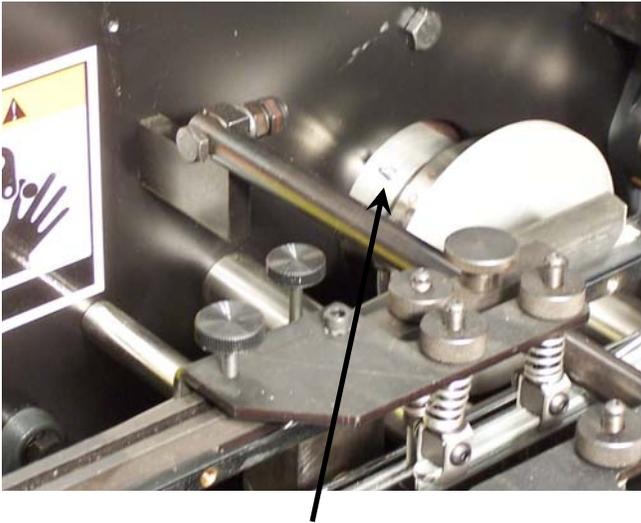
Lubrication Points

- (1) – Gearbox, only when necessary. Use type {3} lube.

INFEED

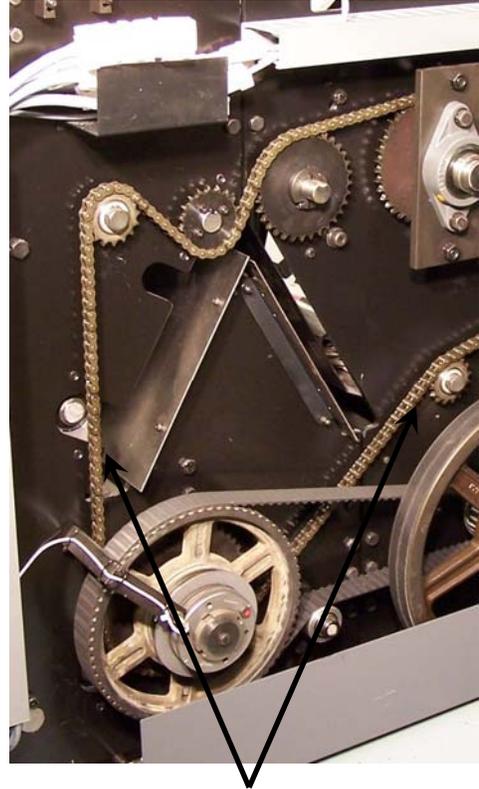
The infeed section has (2) lubrication points:

- (1) At the infeed chain V-band clamp adjustment, (see picture below). Use type {1} lube.



Lubrication Point

- (1) – On “non-operator” side of infeed behind large guard, infeed drive chain, (see picture below). Use type {2} lube.

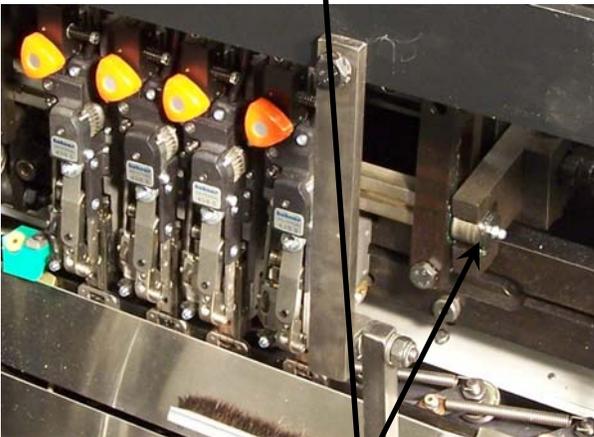
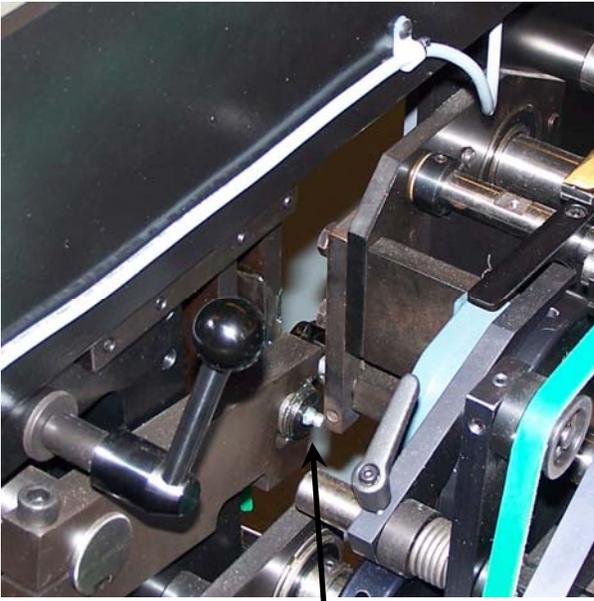


Lubricate chain

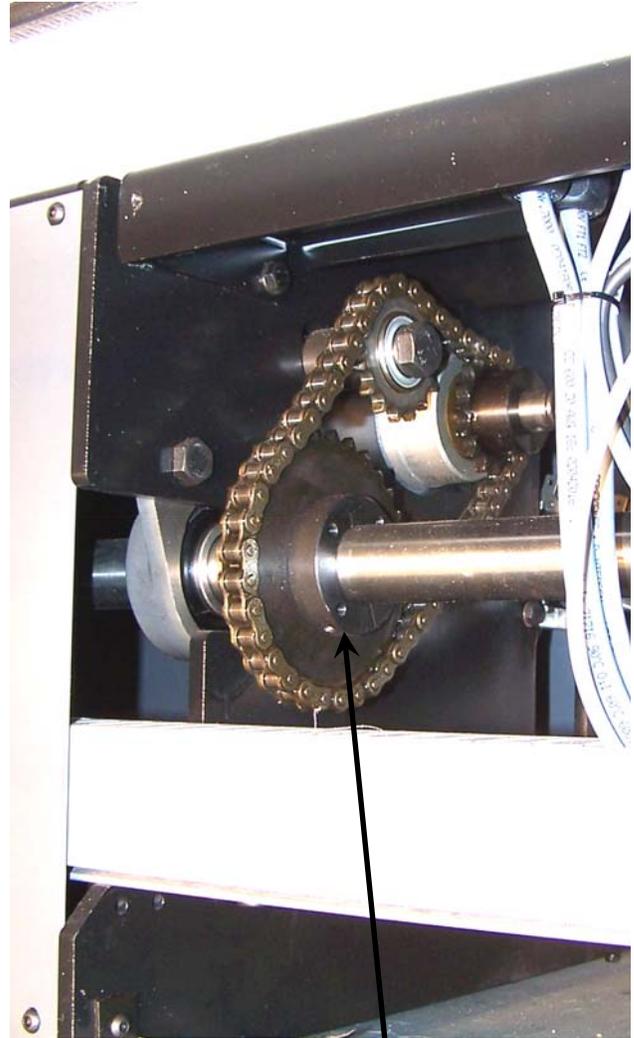
STITCHER

The stitcher section has (3) lubrication points:

- (2) – One at each end of the stitcher head drive bar, (see pictures below). Use type {1} lube.



Lubrication Point



Lubricate chain

(1) – Below the main electrical enclosure behind the small guard is the inspector drive chain, (see picture below). Use type {2} lube.

COVER FOLDER FEEDER

The cover folder feeder section has (3) lube points:

(1) – On the sucker arm lever “operators” side under top guard, (see picture below). Use type {1} lube.



Lubrication Point under Guard

(1) – CFF chain drive at the V-band drive clamp, (see picture below). Use type {2} lube.

(1) – Gearbox, only when necessary. Use type {3} lube.



Lubricate chain

SIGNATURE FEEDERS

No grease fittings in this section.

After lubrication – acknowledge the linear bearing lube alarm to reset alarm and timer by pressing the maintenance performed button.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

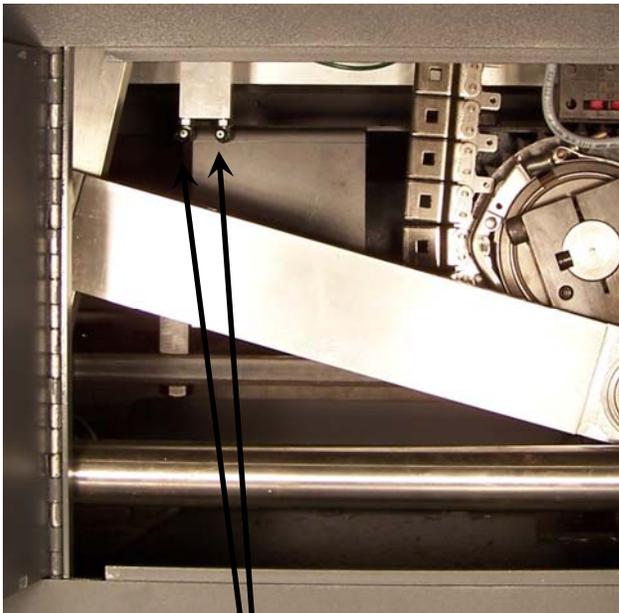
MAINTENANCE LINEAR BEARING LUBRICATION

The ST-90 is completely lubricated at the factory, but for long service life the Linear Guide way Bearing is to be lubricated every 20 hours of operation. Use NLGI Grade "1" Lithium base grease.

Use Make Ready X-position and set machine to 290 degrees. Open front stitcher door and the two lubrication points are shown in picture below

After lubrication – acknowledge the linear bearing lube alarm to reset alarm and timer by pressing the maintenance performed button.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

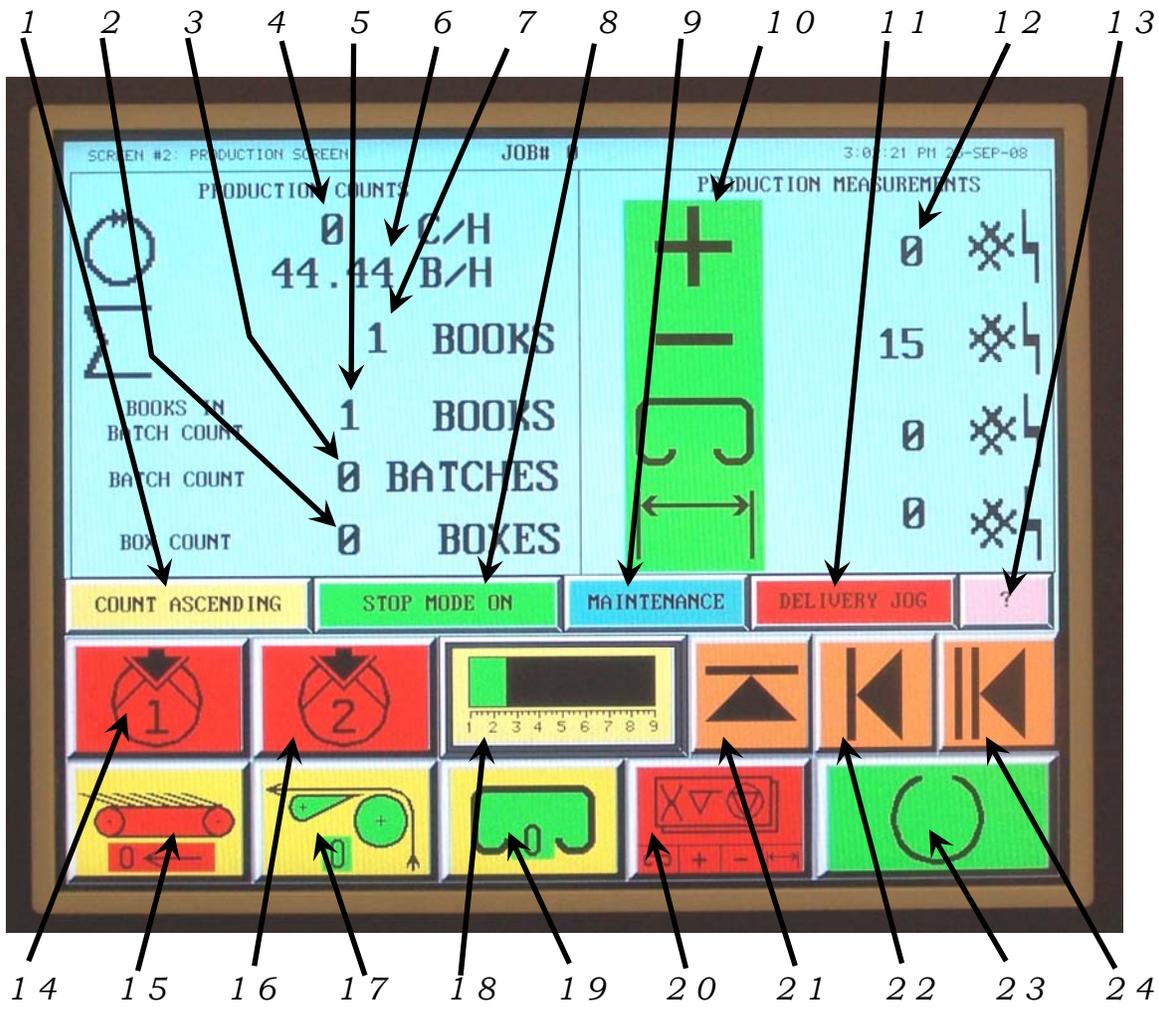


Lubrication Points

HELP - SCREEN 2
PRODUCTION

The “Production Screen” is the main screen of the operator interface.

This screen displays production counts, production faults, and mode controls.



1) **Count Ascending or Descending Button:** Controls the direction of the production counters. This button will not be displayed if counter mode in the production setup screen is in “Simple” mode.

2) **Box Count:** Displays the number of boxes filled. This count only displays when “Batch counting” mode is turned on in the production setup screen.

3) **Batch Count:** Displays the batch count total. This count only displays

when the “Batch Counting” mode is turned on in the production setup screen.

- 4) **Cycles per Hour:**
Displays machine speed.
- 5) **Books in Batch Count:**
Displays the book count per current batch. This count only displays when the “Batch Counting” mode is turned on in the production setup screen.
- 6) **Books per Hour:**
Displays the current books per hour based off of current production totals and the current production run time.
- 7) **Total Books per Hour:**
Displays the current good book output for the job.
- 8) **Stop Mode Button:**
Turns stop mode on or off. Stop mode stops the pumps and rejects all signatures when the predetermined job of good book count is reached then when all signatures are rejected the machine stops.
- 9) **Maintenance Indicator:**
This indicator only displays when a maintenance item is set. This indicator will display when either of

the lube timers time out or when a sensor bypass is being used.

- 10) **Production measurement indicator**
– displays a production fault has occurred and the indicator will display red. When the book fault is rejected it will turn back to green. The inspector faults + and - will always be displayed. The Missing Stitch or the Book Length faults will only be displayed when that option is turned on.
- 11) **Delivery Jog Button:**
Jogs delivery at full speed when pressed and indicator will change from red to green.
- 12) **Production Measurement Faults:**
Displays the fault count per job. The screen displayed is for consecutive counts only. If the fault mode in the production measurement setup is changed to non-consecutive counting mode then two numbers columns will be displayed. The left Column will be the number of faults and the right Column will be the number of books since the first fault. If the left Column reaches its set point before the right

Column then an x-book fault will occur. If the right Column reaches the set point first then the counters for that fault will be reset to zero.

13) **?**: This will retrieve the help screen either for the screen of a particular screen section that it is associated with.

14) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.

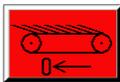


c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.

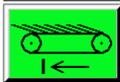


d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

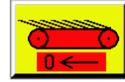
15) **Delivery Mode Button:**



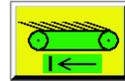
a) Delivery is turned off.



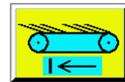
b) Delivery is in continuous on mode at the speed setting of the potentiometer on the delivery.



c) Delivery is in auto mode, but not running due to a book under the delivery photo eye.



d) Delivery is in auto mode and is running at potentiometer speed set at the delivery, until book under the photo eye is not seen any more.



e) Delivery is in auto mode and is running at max speed due to a batch or box count set in production set up to create batch spacing of books.

16) **Pump 2 Mode Button:**



a) Pump 2 is turned off.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.

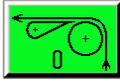


c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

17) **Reject Solenoid Mode Button:**



a) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.

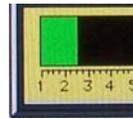


c) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

18) **Machine Speed**



Control: The indicator on the button indicates the speed setting of the machine when it is running. When the button is pressed the screen will change to the speed control screen.

19) **Stop Stitch Mode Button:**



a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.



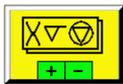
d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is

controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

20) X-Book Stop Mode Button:



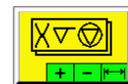
a) This indicates the X-book stop mode is off.



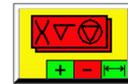
b) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken place and the machine was commanded to stop. The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping only the inspector + and - is being used to determine faults.



c) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken place and the

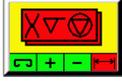


d) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken place and the machine was commanded to stop. The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping only the inspector + and - and the long book detector is being used to determine faults.





e) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken place and the machine was commanded to stop. The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping the inspector + and - and missing stitch and long book detector is being used to determine faults.



21) **Main Menu Button:**

When pressing this button, screen will change to the main menu screen.

22) **Previous Screen**

Button: When pressed this button will change to the previous screen. A maximum of five screens are remembered.

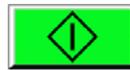
23) **Machine Start and Stop Button / Status**

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the

machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated

but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



l) Indicates that machine is in cycle position.

24) **Production Screen**

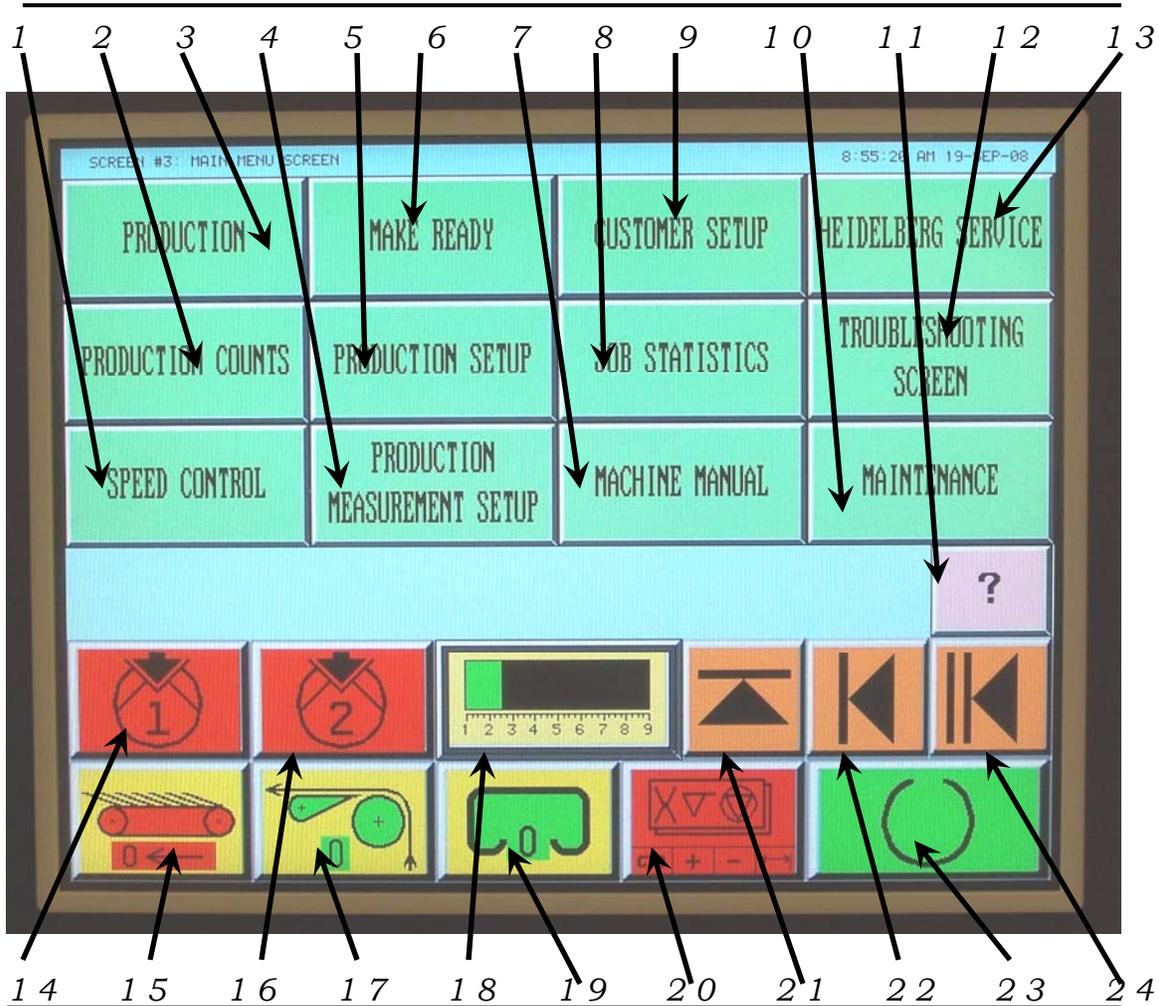
Button: this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 3 MAIN MENU

The “Main Menu” is the screen that displays go to screen buttons that

allows access to all the functions of the operator interface.



1) **Machine Speed Control Screen Button:** When the button is pressed the screen will change to the speed control screen. This screen control machine run speed.

2) **Production Counts Screen Button:** When the button is pressed the screen will change to the production counts screen. This screen displays large count numbers for production

viewing from either the feeders or delivery.

3) **Production Screen**

Button: When the button is pressed the screen will change the screen to the production screen.

4) **Production**

Measurement Setup

Screen Button: When the button is pressed the screen will change the screen to the production measurement setup screen. This screen requires a production password to access. In this screen production fault set points can be set. Measurement options, missing stitch, and long book can be turned on and off if the option is turned on.

5) **Production Setup**

Screen Button: When the button is pressed the screen will change the screen to the production setup screen. This screen requires a production password to access. In this screen the job number can be set, job counters can be reset then type of counting can be set.

6) **Make Ready Screen**

Button: When the button is pressed the screen will change the

screen to the Make ready menu screen. In this screen the operator has access to the entire make ready position buttons.

7) **Machine Manual**

Screen Button: When the button is pressed the screen will change the screen to the Machine manual menu screen. In this screen the operator can view any of the machine operator or parts manuals.

8) **Job Statistics Screen**

Button: When the button is pressed the screen will change the screen to the job statistics screen. In this screen the operator can view the current job statistics.

9) **Customer Setup Screen**

Button: When the button is pressed the screen will change to the customer setup screen. This screen requires a customer password to access. In this screen all customer passwords can be set. Pump off timers can be set. Basic machine operations can be set.

10) **Maintenance Screen**

Button: When the button is pressed the screen will change to the

maintenance screen. This screen requires a maintenance password to access. In this screen lube maintenance, sensor by-pass, sensor setup buttons, and manual actuation of plc outputs are available.

11) **?**: This will retrieve the help screen either for the screen of a particular screen section that it is associated with.

12) **Troubleshooting Menu Screen:** When the button is pressed the screen will change to the troubleshooting menu screen. These screen displays a menu of buttons that allow the operator see PLC input and outputs.

13) **Heidelberg Service Screen Button:** This button is password protected. Only Heidelberg service technicians should enter this screen.

14) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



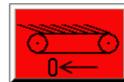
c) Pump 1 in auto mode and is running. The

pump will turn when machine is started or jogged.

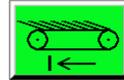


d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

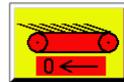
15) **Delivery Mode Button:**



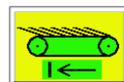
a) Delivery is turned off.



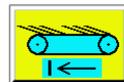
b) Delivery is in continuous on mode at the speed setting of the potentiometer on the delivery.



c) Delivery is in auto mode, but not running due to a book under the delivery photo eye.



d) Delivery is in auto mode and is running at potentiometer speed set at the delivery, until book under the photo eye is not seen any more.



e) Delivery is in auto mode and is running at max speed due to a batch or box count set in production set up to create batch spacing of books.

16) Pump 2 Mode Button:



a) Pump 2 is turned off.



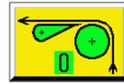
b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.



g) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



h) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

17) Reject Solenoid Mode Button:



e) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



f) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.

18) Machine Speed

Control: The indicator on the button indicates the speed setting of the machine when it is running. When the button is pressed the screen will change to the speed control screen.

19) Stop Stitch Mode Button:



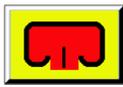
a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.

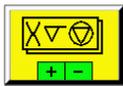


d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

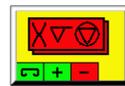
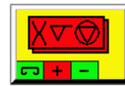
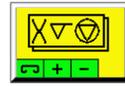
20) **X-Book Stop Mode Button:**



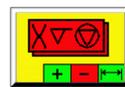
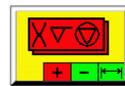
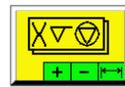
a) This indicates the X-book stop mode is off.



b) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book



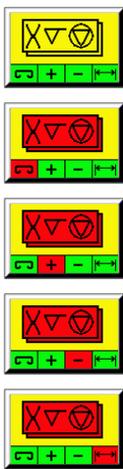
c) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken place and the machine was commanded to stop. The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping only the inspector + and - is being used to determine faults.



d) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken

signifies that an x-book fault has taken place and the machine was commanded to stop. The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping only the inspector + and - is being used to determine faults.

place and the machine was commanded to stop. The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping only the inspector + and – and the long book detector is being used to determine faults.



- e) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken place and the machine was commanded to stop. The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping the inspector + and – and missing stitch and long book detector is being used to determine faults.

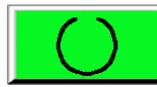
- 21) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

- 22) **Previous Screen Button:** When pressed this button will change

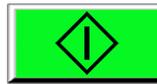
to the previous screen. A maximum of five screens are remembered.

23) **Machine Start and Stop Button / Status**

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



- a) Indicates that machine is ready for start, all guards and faults are reset.



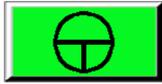
- b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



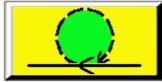
- c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



- d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



l) Indicates that machine is in cycle position.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

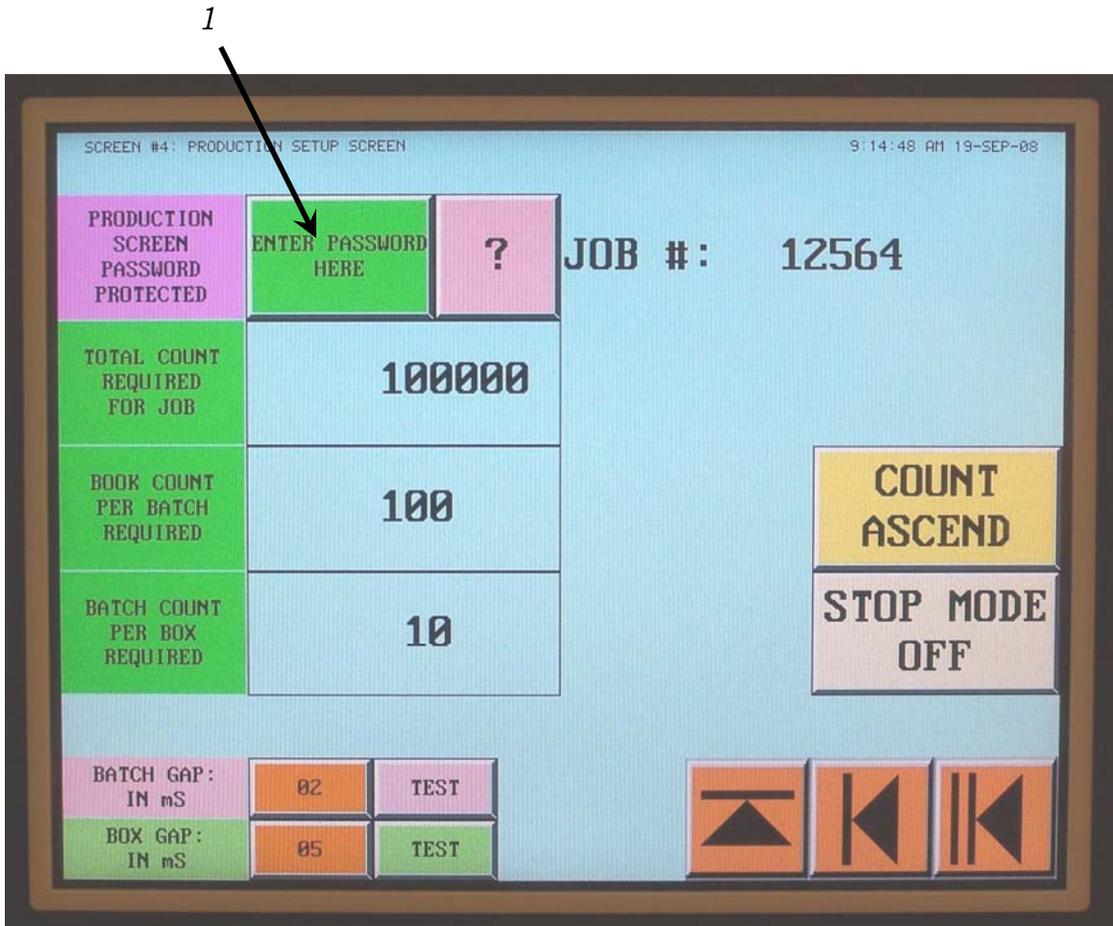
24) **Production Screen**

Button: this button will change the screen to the production screen.

HELP - SCREEN 4:
PRODUCTION SETUP

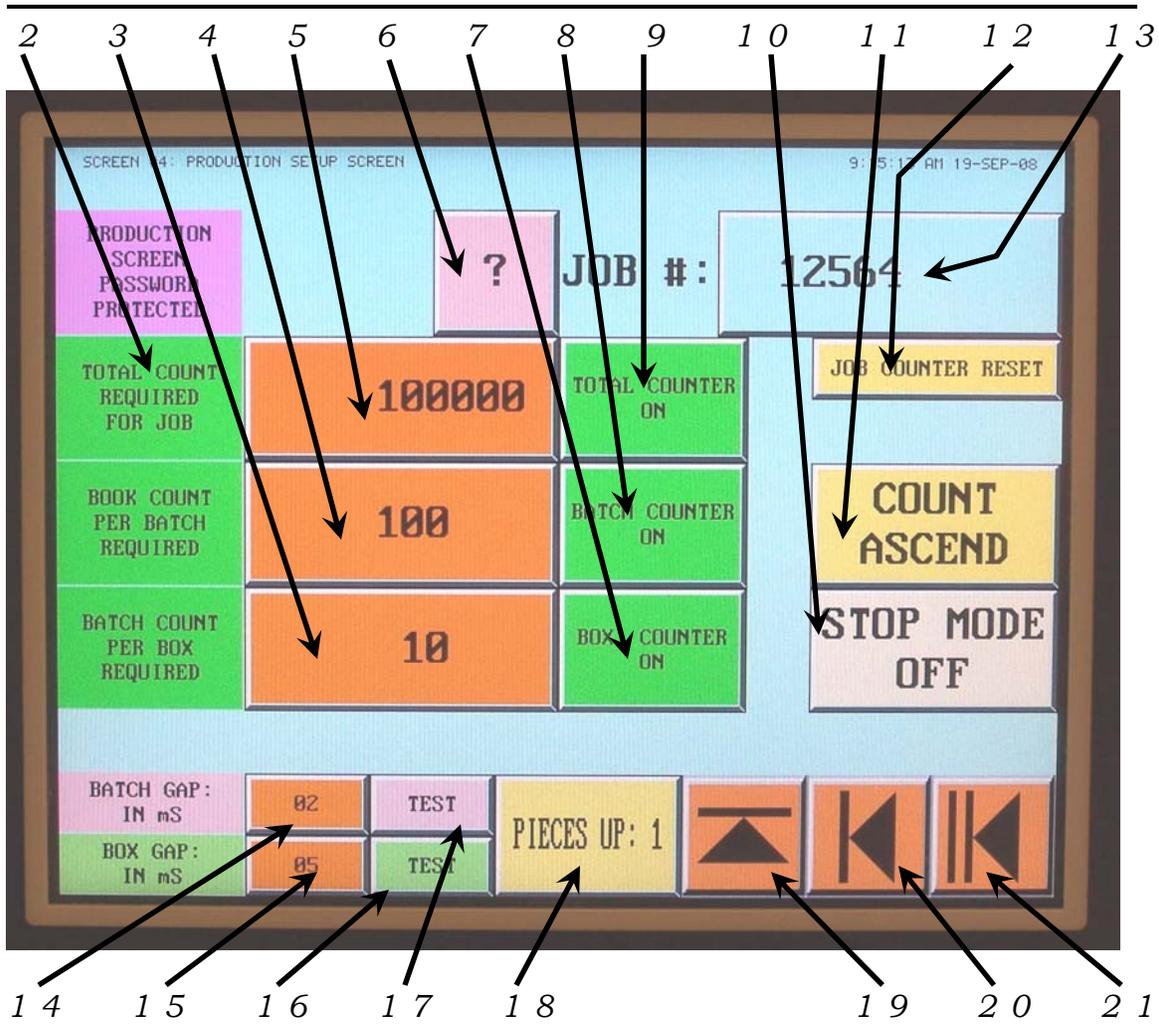
The “Production Setup” is the screen that displays production setup functionality. When screen opens up, the enter password here must be

pressed and the production password must be entered to access and modify job counters (see picture below).



After the password is entered correctly the screen

will look like this (see picture below).



- 1) **Enter Password Here Button:** This brings up the password screen, enter the production password.
- 2) Counter blocks that show which counter information needs to be entered depending which

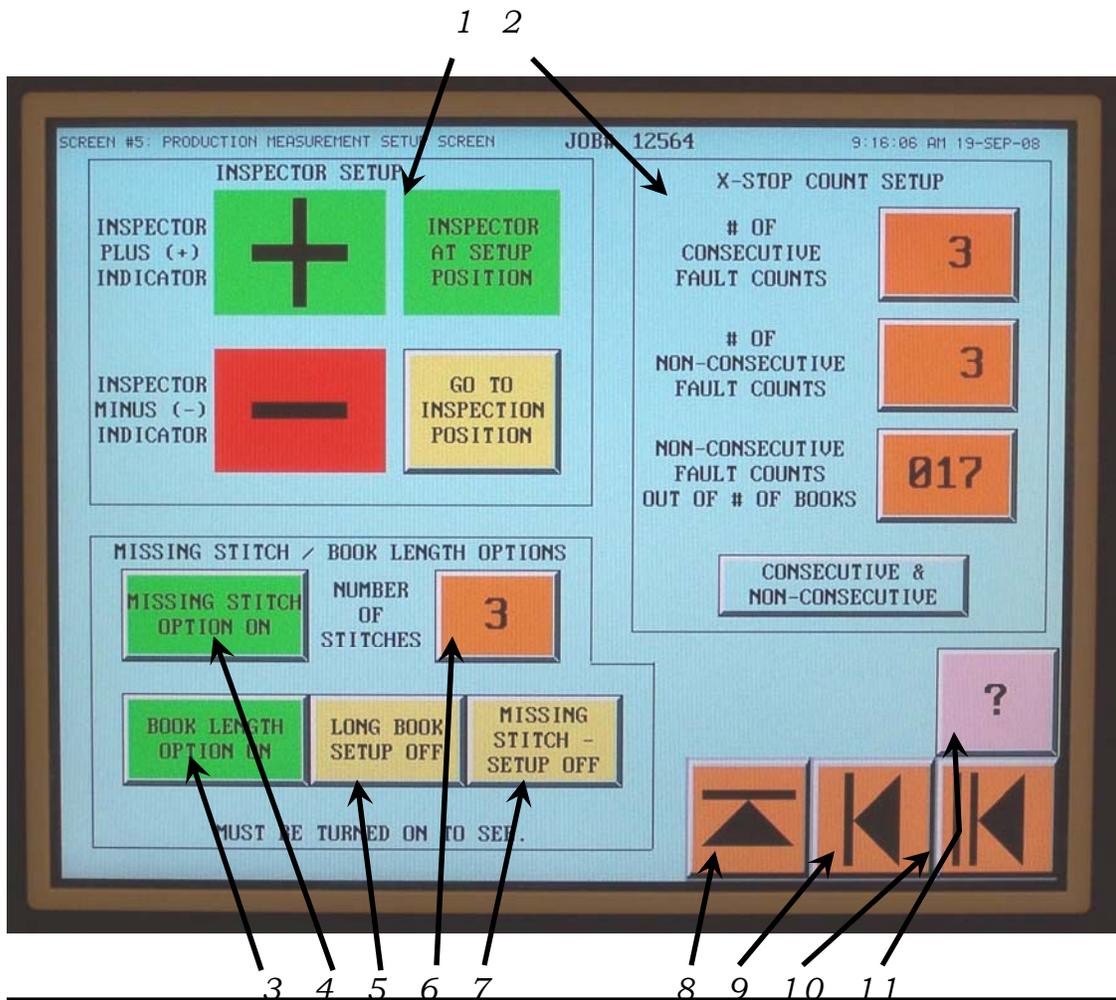
- counter mode is turned on.
- 3) Enter the amount of batches per box if the box count is activated.
- 4) Enter the amount of books per batch if the batch count is activated.

- 5) Enter the amount of books for the entire job requirement if the total book counter is turned on.
- 6) **?**: This will retrieve the help screen for this screen.
- 7) **Box Counter On / Off:** When this counter mode is on, a batch count per box can be entered. When this count is met a box count gap is put on the delivery table.
- 8) **Batch Counter On / Off:** When this counter mode is on, a batch count can be entered. When this count is met a batch count gap is put on the delivery table.
- 9) **Total Counter On / Off:** When this counter mode is on, the total book count for the job can be entered in. With this mode on the operator can pick if he wants the counts to ascend or descend. Also the stop mode can be activated.
- 10) **Stop Mode On / Off:** This button toggles the stop mode on and off. The stop mode is when the count in the total counter is reached the machine goes into a shut down mode. First the stop stitch is turned on then and all unstitched books will be rejected. The pumps will be stopped. The machine will deliver all the signatures on the machine into the reject basket. The amount of cycles will be different depending on how many pumps are on at the time of the stop mode activation. When the cycle count is reached then the machine will stop.
- 11) **Count Ascend or Descend Toggle Button:** This button toggles between the two count directions.
- 12) **Job Counter Reset Button:** When this button is pressed a yes and no button will be displayed under this button. Press yes to reset the counters for the new job.
- 13) **Job Number Input:** This button allows the job number to input. This will display on the production screen and in the job statistics.
- 14) **Batch Gap:** This is the batch gap timing input. The number that is input is the amount of milliseconds the delivery will be on when a batch gap is called for by the PLC.

- 15) **Box Gap:** This is the box gap timing input. The number that is input is the amount of milliseconds the delivery will be on when a box gap is called for by the PLC.
- 16) **Batch Gap Test Button:** This button test the batch gap timing. Press the button and a batch gap is sent to the delivery.
- 17) **Box Gap Test Button:** This button test the box gap timing. Press the button and a box gap is sent to the delivery.
- 18) **Pieces Up Button:** This button toggles between pieces up of 1 or 2. When the pieces up is set to 2, the machine assumes the trimmer is set for two up operation. The counter will enter 2 piece count for every good book output signal.
- 19) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 20) **Previous Screen Button:** When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 21) **Production Screen Button:** this button will change the screen to the production screen.
- To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 5 PRODUCTION MEASUREMENT SETUP

The “Production Measurement Setup” is the screen that displays production measurement setup functionality.



1) **Inspector Setup:** The inspector can be setup or checked without needing to go back to the make ready screens. Just press the go to inspector position button. Then press the

start button to move machine into position. Check or setup inspector.

2) **X-stop Count Setup:** There are three modes for the X-book stop setup. Consecutive, Non-

consecutive and Both. Consecutive is where it take X many faults in a row to stop production operation and create an X-book fault. When the non-consecutive mode is picked then it takes X many faults non-consecutively out of so many books to stop production operation and create an X-book fault. The consecutive and non-consecutive combination will create the X-book stop if either condition is met.

- 3) **Book Length Option On / Off:** This button turns on or off the book length inspection option. This button is only displayed when this option is turned on in the Heidelberg service screens.
- 4) **Missing Stitch Option On / Off:** This button turns on or off the missing stitch inspection option. This button is only display when this option is turned on in the Heidelberg service screens.
- 5) **Long Book Setup Button:** This button turns on or off the long book setup. This button is only displayed when this option is turned on. When on, the operator

can put a book before the stationary sensor and start the machine and it will stop the book in position to set the movable sensor.

- 6) **Missing Stitch Number of Stitches:** This input allows the operator to enter in the amount of stitches per book. This input is only displayed when this option is turned on in the Heidelberg service screens.
- 7) **Missing Stitch Option Setup button:** When this button is turned on an alarm will pulse when a stitch is seen by the missing stitch detector.
- 8) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 9) **Previous Screen Button:** When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 10) **Production Screen Button:** this button will change the screen to the production screen.

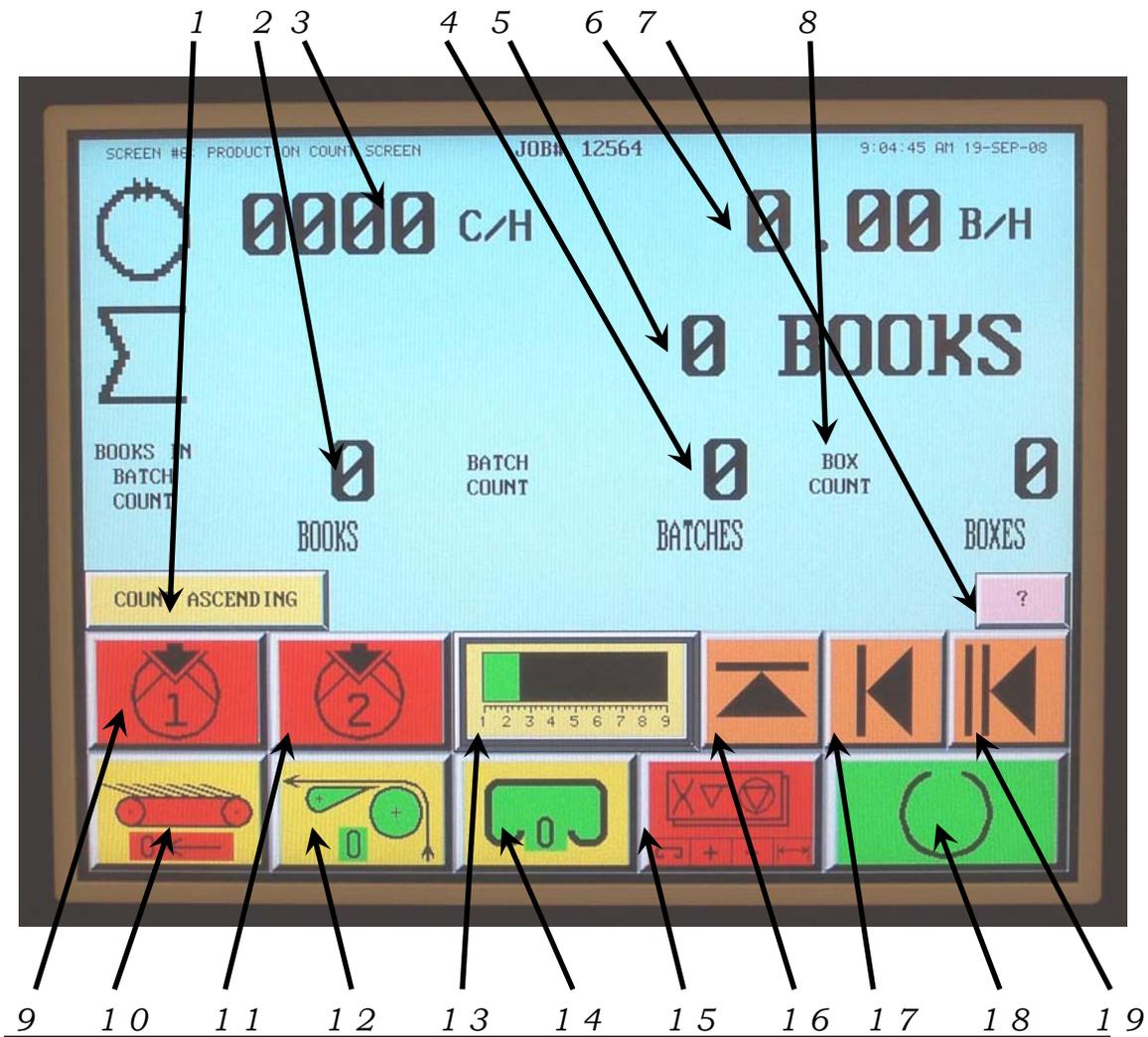
11) **?**: This will retrieve the help screen for this screen.

HELP - SCREEN 6 PRODUCTION COUNT

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

The "Production Count" is the screen that displays large production

count numbers that can be seen from the delivery or the feeder sections.



- 1) **Count Ascending or Descending Button:** Controls the direction of the production counters. This button will not be displayed if counter mode in the production setup screen is in "Simple" mode.
- 2) **Books in Batch Count:** Displays the book count per current batch. This count only displays when the "Batch Counting" mode is turned on in the production setup screen.
- 3) **Cycles per Hour:** Displays machine speed.
- 4) **Batch Count:** Displays the batch count total. This count only displays when the "Batch Counting" mode is turned on in the production setup screen.
- 5) **Production Setup Screen Button:** When the button is pressed the screen will change the screen to the production setup screen. This screen requires a production password to access. In this screen the job number can be set, job counters can be reset

then type of counting can be set.

- 6) **Books per Hour:** Displays the current books per hour based off of current production totals and the current production run time.
- 7) **?:** This will retrieve the help screen either for the screen of a particular screen section that it is associated with.
- 8) **Box Count:** Displays the number of boxes filled. This count only displays when "Batch counting" mode is turned on in the production setup screen.

9) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



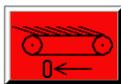
c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



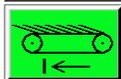
d) Pump 1 in auto mode and is turned off. The pump will turn off when the

machine stops plus a delay setting set in the customer setup screen.

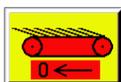
10) Delivery Mode Button:



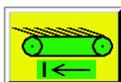
a) Delivery is turned off.



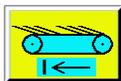
b) Delivery is in continuous on mode at the speed setting of the potentiometer on the delivery.



c) Delivery is in auto mode, but not running due to a book under the delivery photo eye.



d) Delivery is in auto mode and is running at potentiometer speed set at the delivery, until book under the photo eye is not seen any more.



e) Delivery is in auto mode and is running at max speed due to a batch or box count set in production set up to create batch spacing of books.

11) Pump 2 Mode Button:



a) Pump 2 is turned off.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.

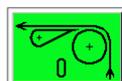


c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

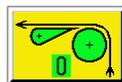
12) Reject Solenoid Mode Button:



a) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.



c) This indicates that the reject solenoid is in auto mode. The

solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

13) Machine Speed

Control: The indicator on the button indicates the speed setting of the machine when it is running. When the button is pressed the screen will change to the speed control screen.

14) Stop Stitch Mode

Button:

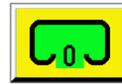


a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



b) This indicates that the stop stitch solenoid is in the on

mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.



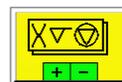
d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

15) X-Book Stop Mode

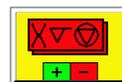
Button:



a) This indicates the X-book stop mode is off.

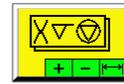


b) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process.



The red book signifies that an x-

book fault has taken place and the machine was commanded to stop. The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping only the inspector + and - is being used to determine faults.



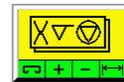
d) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken place and the machine was commanded to stop.



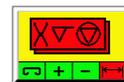
The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping only the inspector + and - and the long book detector is being used to determine faults.



c) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken place and the machine was commanded to stop. The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping only the inspector + and - and the missing stitch detector is being used to determine faults.



e) This indicates that the X-book stop mode is in auto. The yellow book signifies that there are no faults in process. The red book signifies that an x-book fault has taken place and the machine was commanded to stop.



The green indicates that this fault was good, red indicator indicates which fault set the x-book fault. In this grouping the inspector + and - and missing stitch and long book detector is being

used to determine faults.

16) **Main Menu Button:**

When pressing this button, screen will change to the main menu screen.

17) **Previous Screen Button:**

When pressed this button will change to the previous screen. A maximum of five screens are remembered.

18) **Machine Start and Stop Button / Status Indicator:**

When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendant stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendant stations. The indicators in this button are as follows:



m) Indicates that machine is ready for start, all guards and faults are reset.



n) Indicates that machine has passed the three

second arming warning and is ready for start button press to start machine motion.



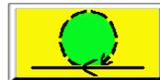
o) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



p) Indicates that jog motion is arming.



q) Indicates that jog motion is armed and jog motion will start with the next jog button press.



r) Indicates jog motion is active.



s) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



t) Indicates that an emergency stop button is activated.



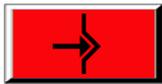
u) Indicates that a guard door is open.



v) Indicates that a jam switch is activated.



w) Indicates that a fault has taken place.



x) Indicates that machine is in cycle position.

change the screen to the production screen.

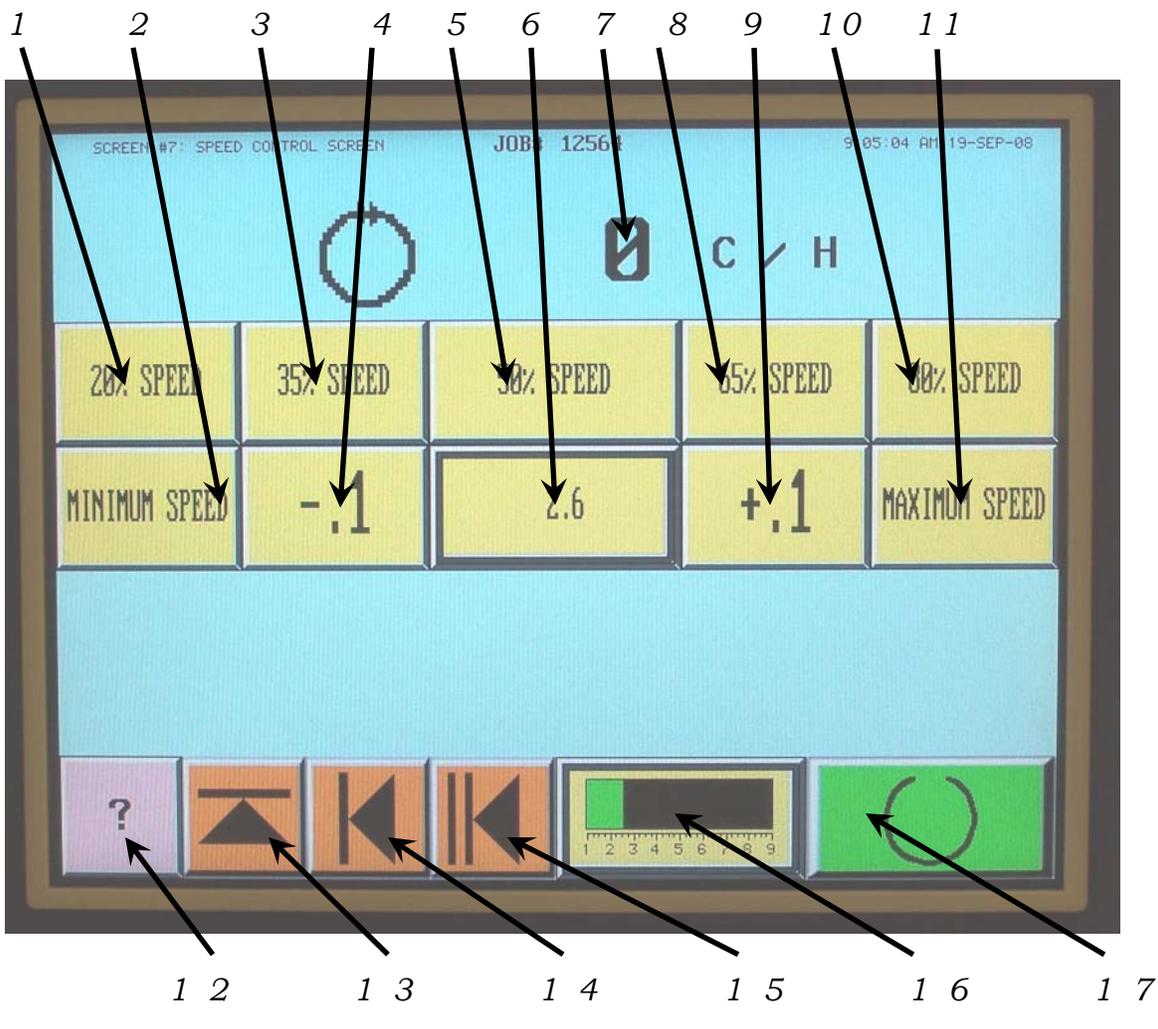
To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 7 SPEED CONTROL

The “Speed Control” is the screen that displays machine speed control functionality.

19) Production Screen

Button: this button will

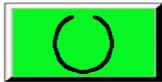


- 1) **20% Speed Button:**
When pressed the machine speed would be set at 20% speed.
- 2) **Minimum Speed Button:** When pressed the machine speed would be set to minimum speed.
- 3) **35% Speed Button:**
When pressed the machine speed would be set at 35% speed.
- 4) **-.1 Button:** This button when pressed will subtract .1 off of the speed setting in the display.
- 5) **50% Speed Button:**
When pressed the machine speed would be set at 50% speed.
- 6) **Speed setting display:**
Minimum speed (1) to maximum speed (9).
- 7) **Cycles per Hour:**
Displays machine speed.
- 8) **65% Speed Button:**
When pressed the machine speed would be set at 65% speed.
- 9) **+.1 Button:** This button when pressed will add .1 off of the speed setting in the display.
- 10) **80% Speed Button:**
When pressed the machine speed would be set at 80% speed.
- 11) **Maximum Speed Button:** When pressed the machine speed would be set to maximum speed.
- 12) **?:** This will retrieve the help screen either for the screen of a particular screen section that it is associated with.
- 13) **Main Menu Button:**
When pressing this button, screen will change to the main menu screen.
- 14) **Previous Screen Button:** When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 15) **Production Screen Button:** this button will change the screen to the production screen.
- 16) **Machine Speed Control:** The indicator on the button indicates the speed setting of the machine when it is running. When the button is pressed the screen will change to

the speed control screen.

17) **Machine Start and Stop Button / Status Indicator:**

When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



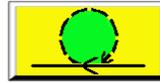
c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



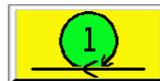
d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.

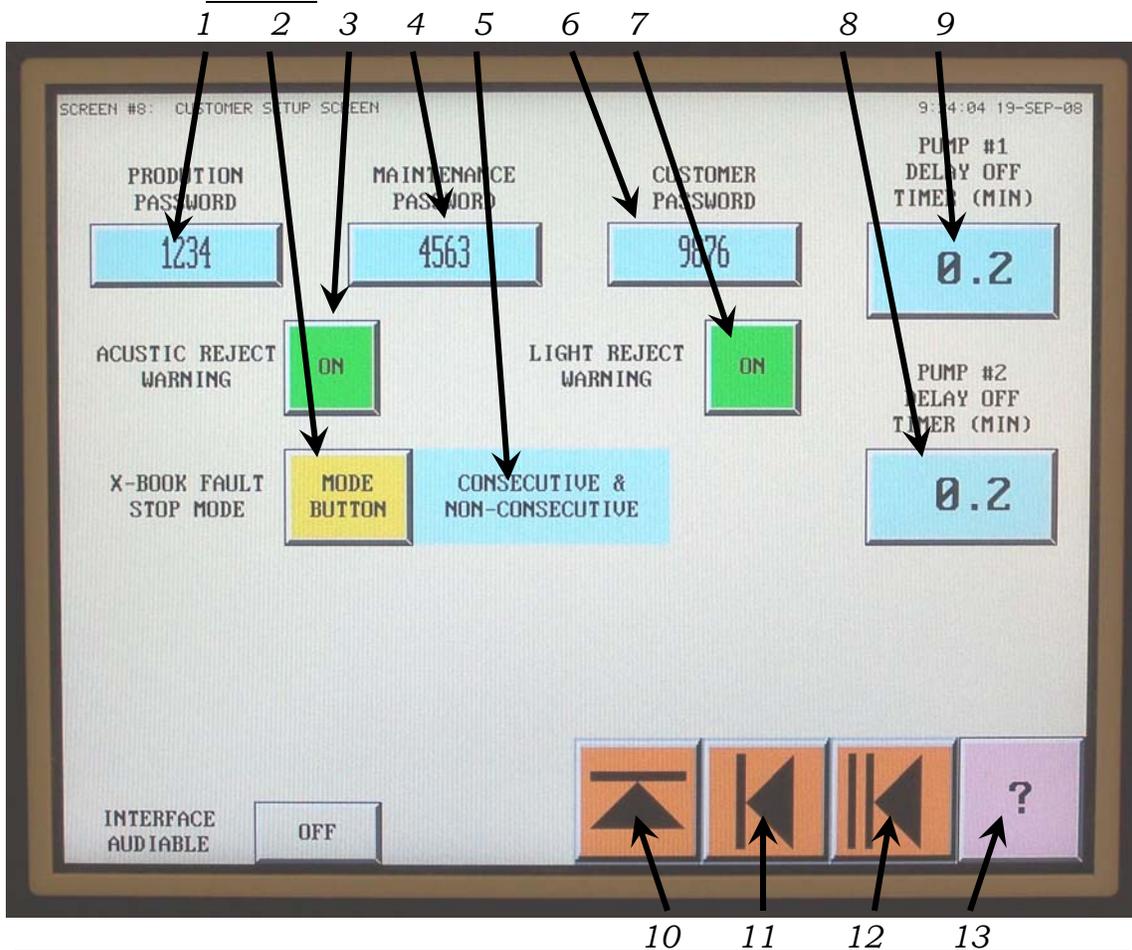


1) Indicates that machine is in cycle position.

The "Customer Setup" is the screen that displays customer setup functionality.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

HELP - SCREEN 8 CUSTOMER SETUP



1. **Production Password:**
This in put displays and can change the
- 2.
3. production password.

- 2) **X-stop Mode Button:**
There are three modes for the X-book stop setup. Consecutive, Non-

consecutive and Both. Consecutive is where it take X many faults in a row to stop production operation and create an X-book fault. When the non-consecutive mode is picked then it takes X many faults non-consecutively out of so many books to stop production operation and create an X-book fault. The consecutive and non-consecutive combination will create the X-book stop if either condition is met.

3) **Acoustic Reject**

Warning Button: This button turns on and off the Acoustic warning when a product is rejected to a production fault measurement.

4) **Maintenance**

Password: This input displays and can change the maintenance password.

5) **X-Stop mode display.**

6) **Customer Password:**

This in put displays and can change the customer password.

7) **Light Reject Warning**

Button: This button turns on and off the light warning when a product is rejected to a production fault measurement.

8) **Pump #2 Delay Off**

Timer: This input changes the delay time of the pump off when the pump is in automatic.

9) **Pump #1 Delay Off**

Timer: This input changes the delay time of the pump off when the pump is in automatic.

10) **Main Menu Button:**

When pressing this button, screen will change to the main menu screen.

11) **Previous Screen**

Button: When pressed this button will change to the previous screen. A maximum of five screens are remembered.

12) **Production Screen**

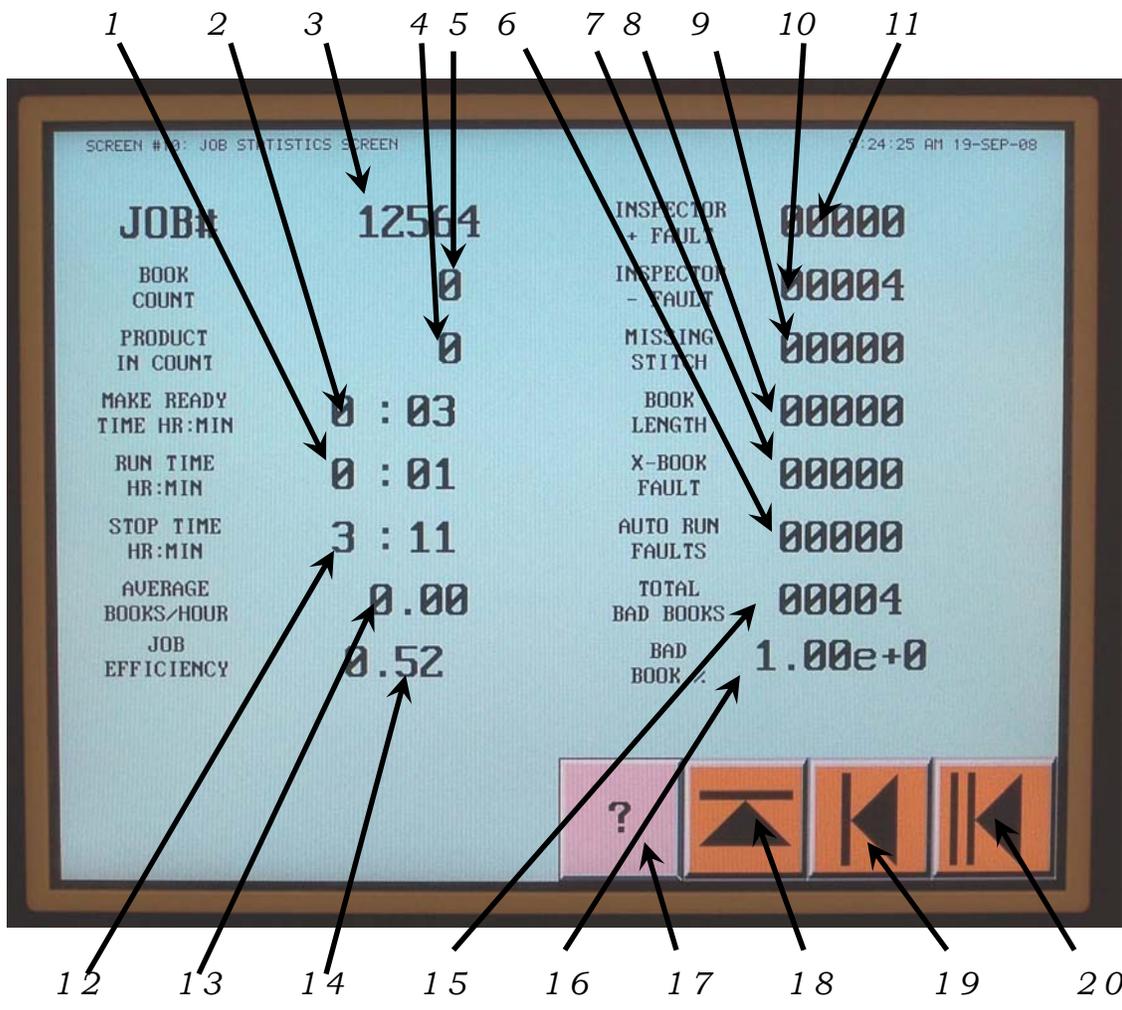
Button: this button will change the screen to the production screen.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

13) **?:** This will retrieve the help screen either for the screen of a particular screen section that it is associated with.

HELP - SCREEN 10 JOB STATISTICS

The "Job Statistics" is the screen that displays current job information.



1) **Run Time in Hours -**

Minutes: Run time is based on machine running plus reject and stop stitch

solenoids in automatic modes.

- 2) **Make Ready Time in Hours – Minutes:** Time is based on machine job reset to when the machine is in auto mode again.
- 3) Job Number of current job.
- 4) Product In Count is based on machine cycles in auto mode or on the book length sensor when on.
- 5) Good Book Count base on delivery sensor.
- 6) Number of machine faults that stop the machine during the job period.
- 7) Number of X-book stop faults.
- 8) Number of book length faults.
- 9) Number of missing stitch faults.
- 10) Number of – inspector faults.
- 11) Number of + inspector faults.
- 12) **Stop Time in Hours – Minutes:** Stop time is based on machine NOT-running plus reject and stop stitch solenoids in automatic modes.
- 13) **Average Books per hour:** Is base on run time and book count.
- 14) Job Efficiency is based on run time divided by total time multiply by 100.
- 15) Total bad books that were rejected.
- 16) Bad Book percentage is based on bad books divided by total books multiply by 100.
- 17) ?: This will retrieve the help screen for this screen.
- 18) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 19) **Previous Screen Button:** When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 20) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

**HELP – SCREEN 13 MACHINE
STATUS**

The “Machine Status” is the screen that displays

current machine status if one of the monitored status changes condition.



- 1) **?:** This will retrieve the machine status help screen.
- 2) **Machine Status:** This window displays the current machine status change.
- 3) **Machine Status Action:** This window displays the action that can or can not take place at this machine status time.
- 4) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 5) **Previous Screen Button:** When pressed this button will change to the previous screen. A

maximum of five screens are remembered.

6) **Production Screen**

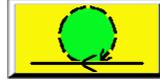
Button: this button will change the screen to the production screen.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.

7) **Machine Start and Stop Button / Status**

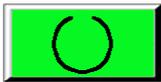
Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



a) Indicates that machine is ready for start, all guards and faults are reset.



h) Indicates that an emergency stop button is activated.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



l) Indicates that machine is in cycle position.



d) Indicates that jog motion is arming.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

HELP – SCREEN 14 RUN ERROR

The “**Run Error**” is the screen that displays run error message. This message comes up every time the machine is dropped

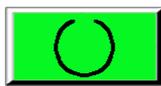
out of run mode and displays the operation (button or error) that cause the machine to drop out of run mode.



- 1) **?:** This will retrieve the run error help screen.
- 2) **Run Error:** This window displays the run error that caused the machine to drop out of run mode.
- 3) **Production Screen Button:** this button will change the screen to the production screen.
- 4) **Machine Start and Stop Button / Status Indicator:** When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent

stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendant stations. The indicators in this button are as follows:

but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



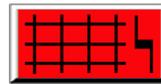
f) Indicates jog motion is active.



g) Indicates that jog motion is activated



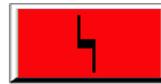
h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



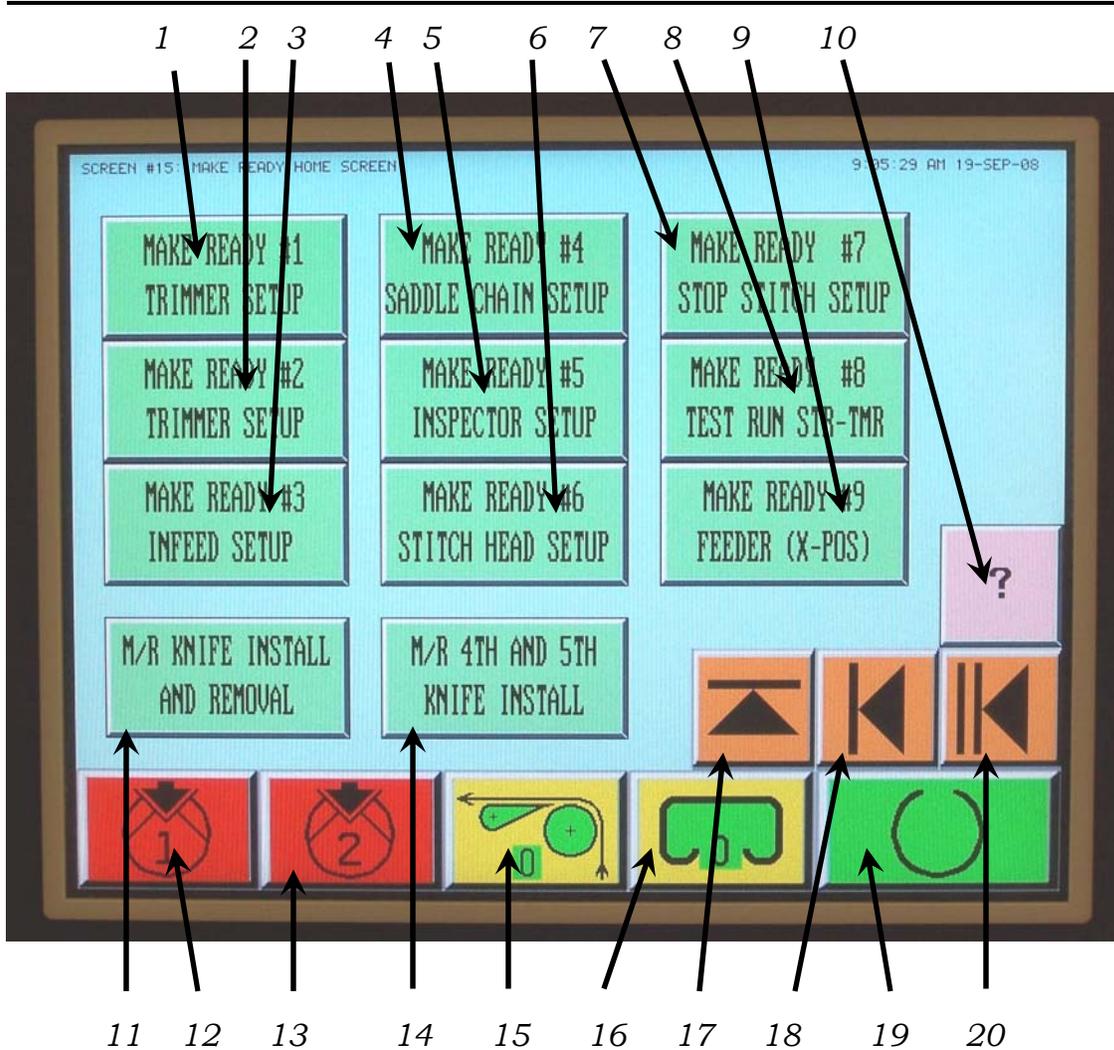
l) Indicates that machine is in cycle position.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 15 MAKE READY HOME

The “Mark Ready Home” is the screen that displays go to screen

buttons that allows access to the entire make ready functions of the operator interface.



- 1) **Make Ready #1 Trimmer Setup:** When button is pressed the screen will change to

The make ready #1 trimmer setup screen.

This screen sets the machine in the make ready #1 position.

- 2) **Make Ready #2 Trimmer Setup:** When button is pressed the screen will change to the make ready #2 trimmer setup screen. This screen sets the machine in the make ready #2 position.
- 3) **Make Ready #3 Infeed Setup:** When button is pressed the screen will change to the make ready #3 infeed setup screen. This screen sets the machine in the make ready #3 position.
- 4) **Make Ready #4 Saddle Chain Setup:** When button is pressed the screen will change to the make ready #4 saddle chain setup screen. This screen sets the machine in the make ready #4 position.
- 5) **Make Ready #5 Inspector Setup:** When button is pressed the screen will change to the make ready #5 infeed setup screen. This screen sets the machine in the make ready #5 position.
- 6) **Make Ready #6 Stitch Head Setup:** When button is pressed the screen will change to the make ready #6 stitch head setup screen. This screen sets the machine in the make ready #6 position.
- 7) **Make Ready #7 Stop Stitch Setup:** When button is pressed the screen will change to the make ready #7 stop stitch setup screen. This screen sets the machine in the make ready #7 position.
- 8) **Make Ready #8 Test Run Setup:** When button is pressed the screen will change to the make ready #8 test run list setup screen.
- 9) **Make Ready #9 Feeder (X-POS):** When button is pressed the screen will change to the make ready #9 feeder (X-pos) screen. This screen sets the machine in the make ready #9 position.
- 10) **?:** This will retrieve the help screen for the make ready home screen.
- 11) **Make Ready Knife Install and Removal:** When button is pressed the screen will change to the make ready knife removal instruction list screen.

12) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

13) **Pump 2 Mode Button:**



a) Pump 2 is turned off.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

14) **Make Ready 4th & 5th Knife Install:**

When button is pressed the screen will change to the make ready 4th & 5th knife install instruction list screen.

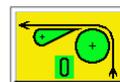
15) **Reject Solenoid Mode Button:**



e) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



f) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.



g) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



h) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.



g) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.

16) Machine Speed

Control: The indicator on the button indicates the speed setting of the machine when it is running. When the button is pressed the screen will change to the speed control screen.



h) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

17) Stop Stitch Mode Button:



e) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



f) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.

18) Main Menu Button:

When pressing this button, screen will change to the main menu screen.

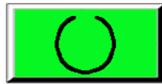
19) Previous Screen

Button: When pressed this button will change to the previous screen. A maximum of five screens are remembered.

20) Machine Start and Stop Button / Status

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pending stations. When

the machine is running it acts as a stop button with the same functionality as the stop button on the pendant stations. The indicators in this button are as follows:



m) Indicates that machine is ready for start, all guards and faults are reset.



n) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



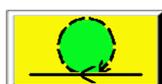
o) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



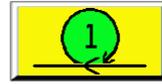
p) Indicates that jog motion is arming.



q) Indicates that jog motion is armed and jog motion will start with the next jog button press.



r) Indicates jog motion is active.



s) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



t) Indicates that an emergency stop button is activated.



u) Indicates that a guard door is open.



v) Indicates that a jam switch is activated.



w) Indicates that a fault has taken place.



x) Indicates that machine is in cycle position.

21) Production Screen

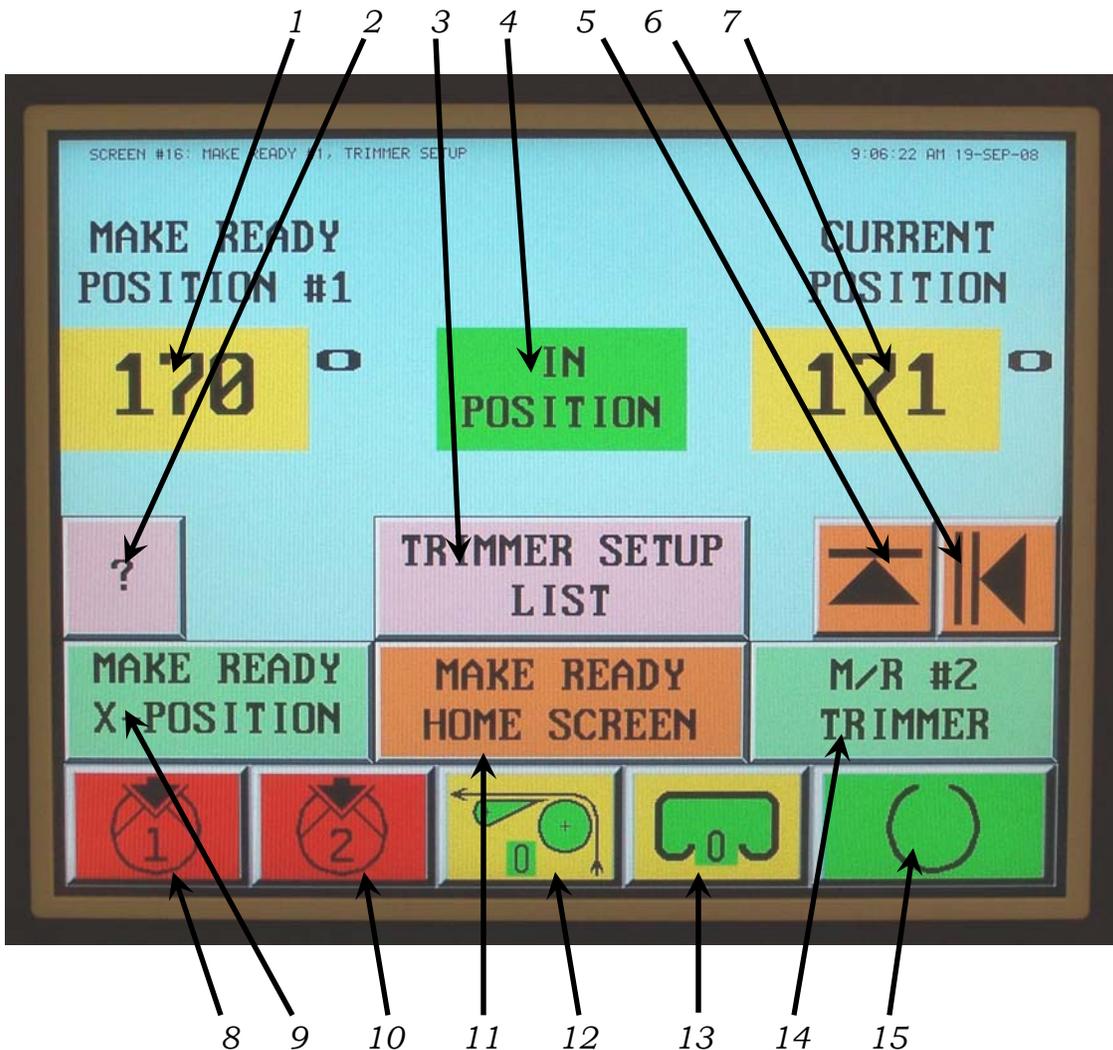
Button: this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

**HELP - SCREEN 16 MAKE
READY #1 POSITION**

The “Make Ready #1
Position” is the screen that
displays current machine

position, and make ready
#1 position. The machine
can be jogged or ran into
its make ready position



Make Ready #1 setup
position required.

2) ?: This will retrieve the
help screen for the make
ready home screen.

3) **Trimmer Setup List:** This
button will only appear

after the machine is in make ready #1 position. When this button is pressed the screen will change to the make ready position #1 setup list.

- 4) Indicator button that flashes red when not in make ready #1 position. Turns green when machine is at make ready #1 position.

- 5) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

- 6) **Production Screen Button:** this button will change the screen to the production screen.

- 7) **Machine current position readout:** When machine is + or - 2 degrees of the make ready position it is considered in position.

- 8) **Pump 1 Mode Button:**



- a) Pump 1 is turned off.



- b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



- c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



- d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

- 9) **Make Ready X-Position:**

when pressed the screen will change to make ready #9 X-position screen.

- 10) **Pump 2 Mode Button:**



- a) Pump 2 is turned off.



- b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



- c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.

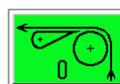


- d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

- 11) **Make Ready Home Screen:**

When button is pressed the screen will change to the make ready home screen.

- 12) **Reject Solenoid Mode Button:**



- a) This indicates that the reject solenoid is in off mode. The solenoid

itself is de-energized. The green signifies that all books will be passed through the reject area.



b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.



c) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

13) **Stop Stitch Mode Button:**



a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.

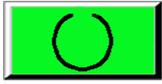


d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

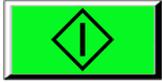
14) **Make Ready #2 Trimmer Setup Position:** When pressed the screen will change to the make ready #2 position screen.

15) **Machine Start and Stop Button / Status Indicator:** When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pending stations. When the machine is running it acts as a stop button with the

same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog

and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



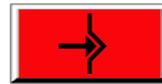
i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



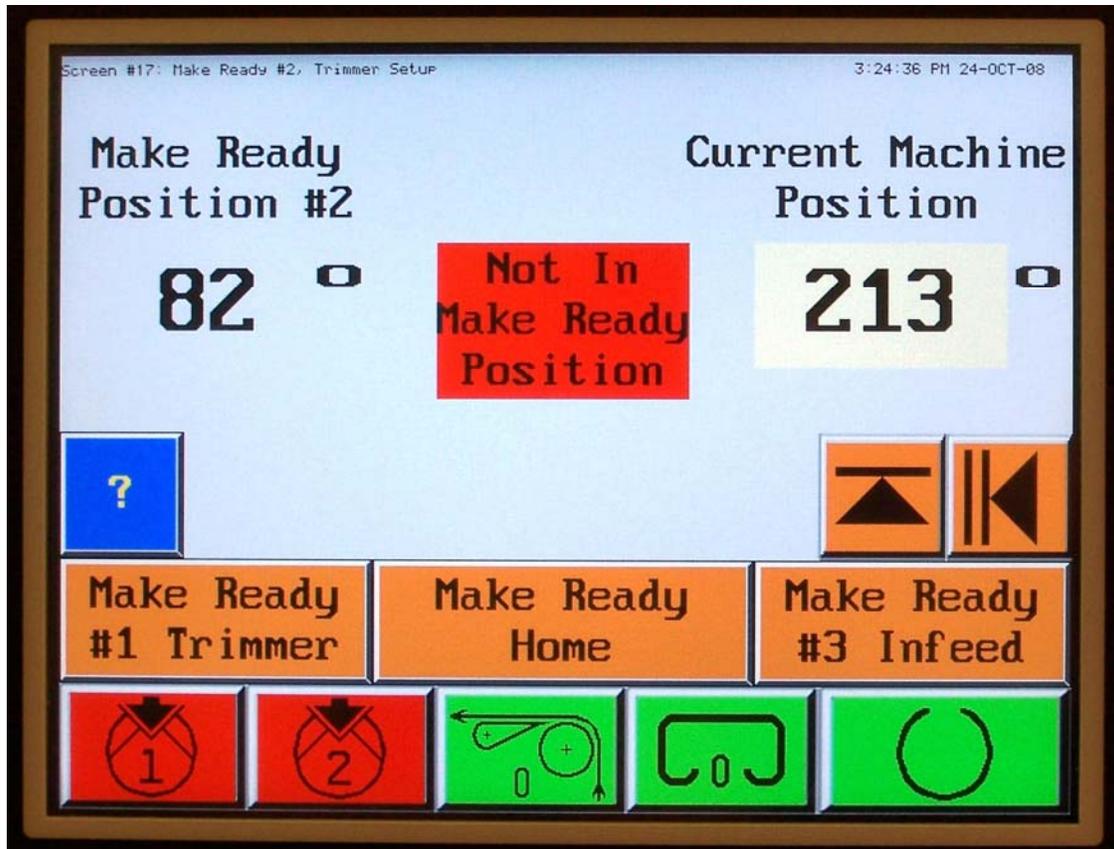
l) Indicates that machine is in cycle position.

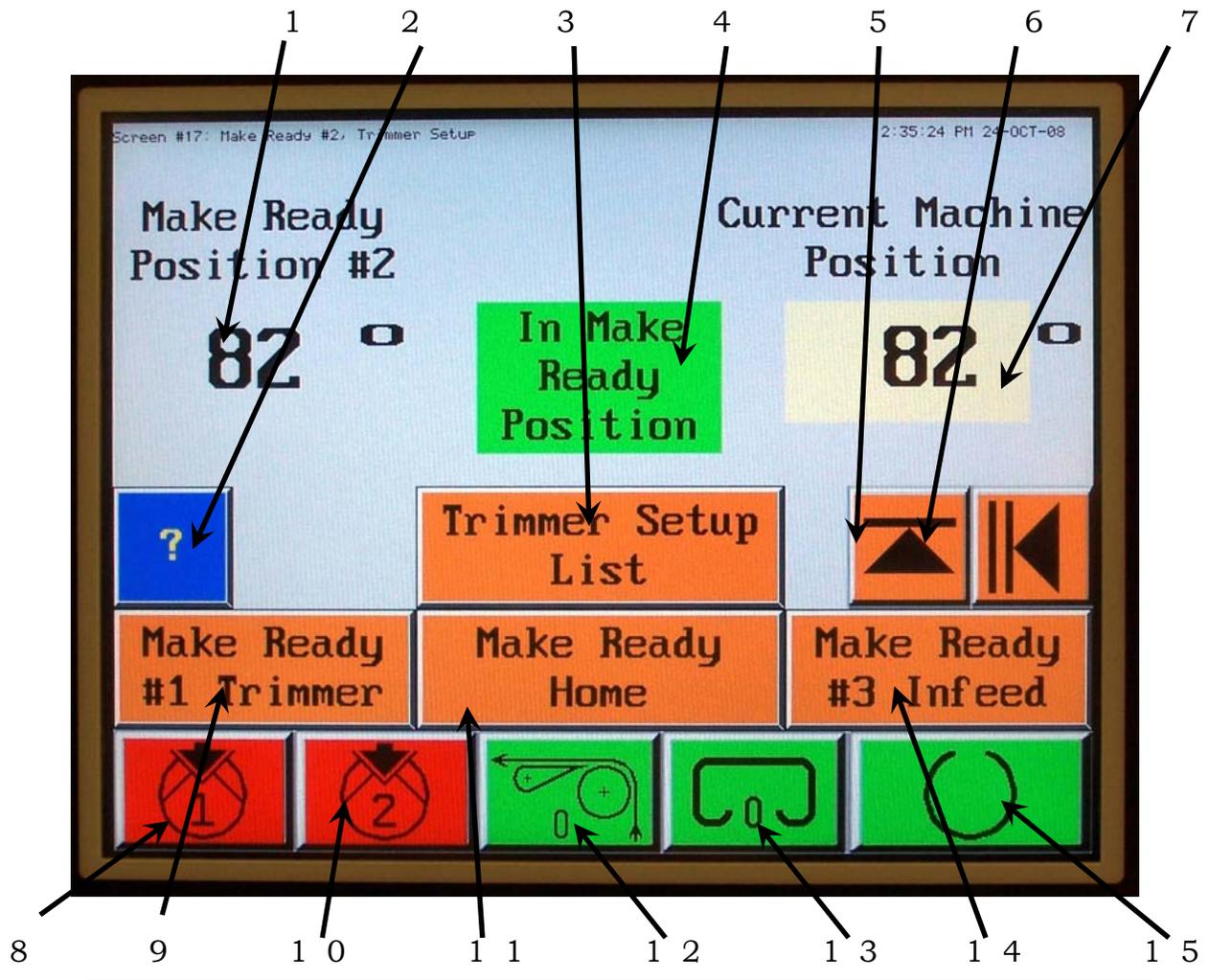
To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP - SCREEN 17 MAKE READY
#2 POSITION

The “Make Ready #2 Trimmer Setup Position” is the screen that displays current machine position,

and make ready #2 trimmer setup position. The machine can be jogged or ran into its make ready position.





- 1) Make ready #2 trimmer setup position required.
- 2) ?: This will retrieve the help screen for the make ready #2 trimmer setup position screen.
- 3) **Trimmer Setup List:** This button will only appear after the machine is in make ready #2 trimmer setup position. When this button is pressed the screen will change to
 - 4) the make ready position #2 trimmer setup list.
- 5) Indicator button that flashes red when not in make ready #2 trimmer setup position. Turns green when machine is at make ready #2 trimmer setup position.
- 6) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

7) **Production Screen Button:** this button will change the screen to the production screen.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.

8) Machine current position readout. When machine is + or - 2 degrees of the make ready position it is considered in position.



c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.

9) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.



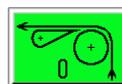
d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

12) **Make Ready Home Screen:**

When button is pressed the screen will change to the make ready home screen.

13) **Reject Solenoid Mode Button:**

10) **Make Ready Position #1 Trimmer:** when pressed the screen will change to make ready position #1 trimmer screen.



i) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.

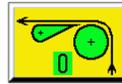


j) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.

11) **Pump 2 Mode Button:**



a) Pump 2 is turned off.



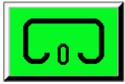
k) This indicates that the reject solenoid is in auto mode. The

solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



l) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

14) **Stop Stitch Mode Button:**



e) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.

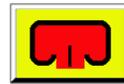


f) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



g) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-

energized and is stitching good books.



h) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

15) **Make Ready #3 Infeed Setup Position:** When pressed the screen will change to the make ready #3 infeed setup position screen.

16) **Machine Start and Stop Button / Status Indicator:** When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:

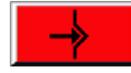


a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start

button press to start machine motion.



l) Indicates that machine is in cycle position.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



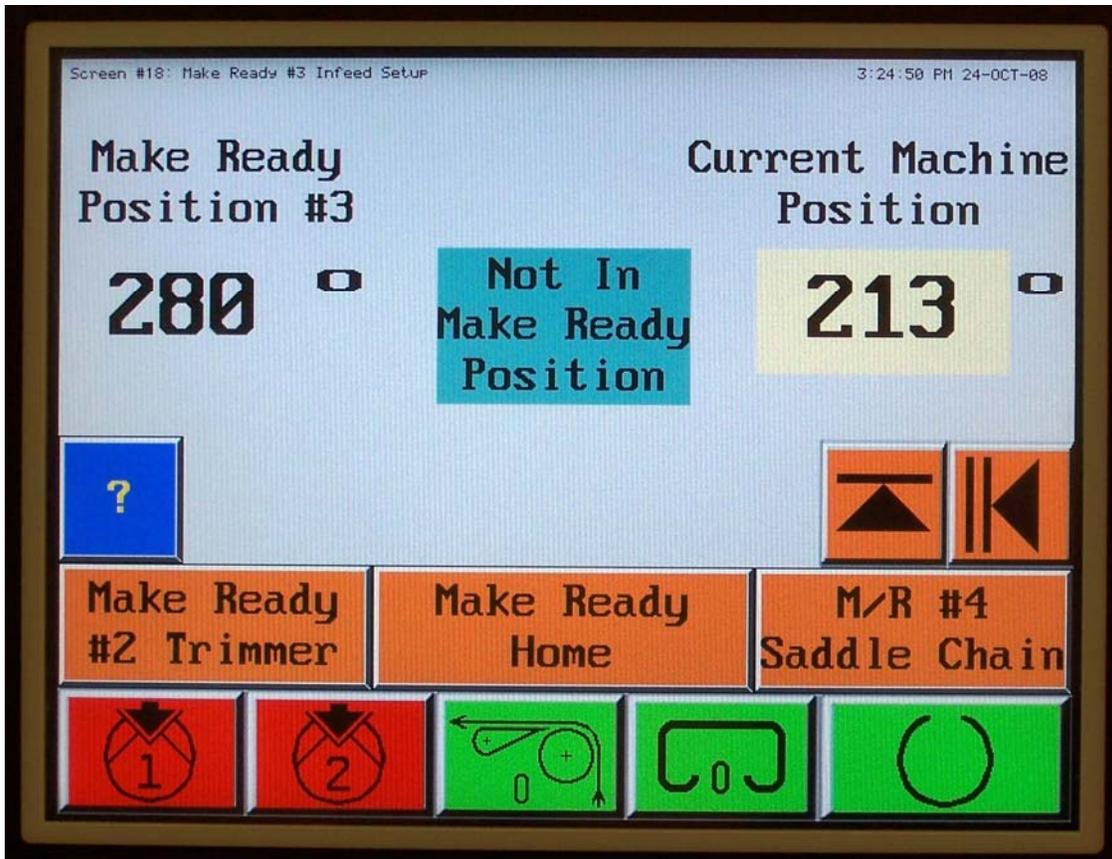
k) Indicates that a fault has taken place.

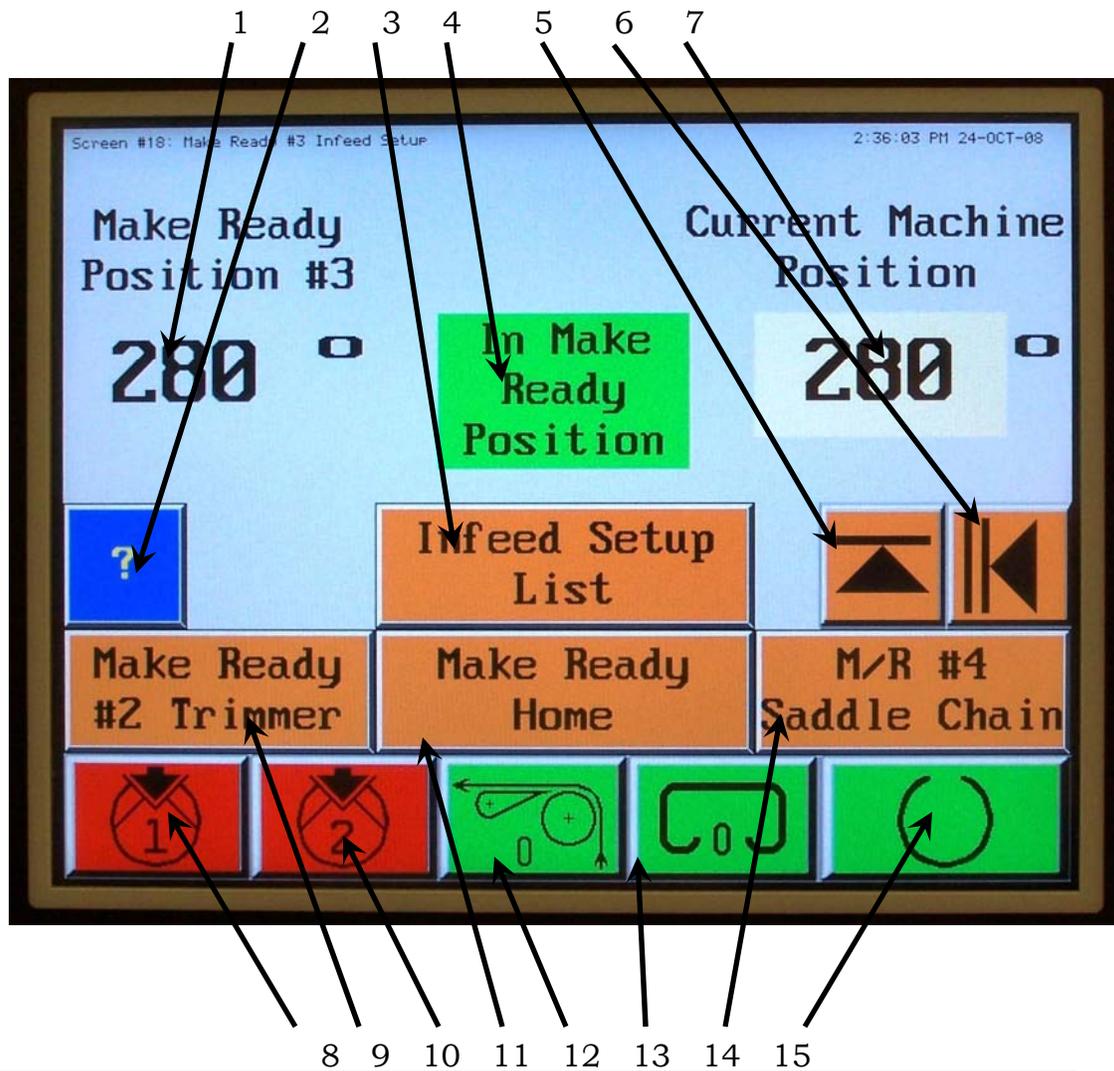
To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP - SCREEN 18 MAKE READY
#3 POSITION

The “Make Ready #3 Infeed Setup Position” is the screen that displays current

machine position, and make ready #3 infeed setup position. The machine can be jogged or ran into its make ready position.





- 1) Make ready #3 infeed setup position required.
- 2) **?:** This will retrieve the help screen for the make ready #3 infeed setup position screen.
- 3) **Infeed Setup List:** This button will only appear after the machine is in make ready #3 infeed setup position. When this button is pressed the screen will change to the make ready position #3 infeed setup list.
- 4) Indicator button that flashes red when not in make ready #3 infeed setup position. Turns green when machine is at make ready #3 infeed setup position.

5) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

6) **Production Screen Button:** this button will change the screen to the production screen.

7) Machine current position readout. When machine is + or - 2 degrees of the make ready position it is considered in position.

8) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

9) **Make Ready Position #2 Trimmer:** when pressed the screen will change to make ready position #2 trimmer screen.

10) **Pump 2 Mode Button:**



a) Pump 2 is turned off.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



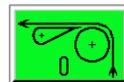
c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

11) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

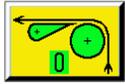
12) **Reject Solenoid Mode Button:**



a) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.

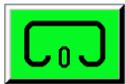


c) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

13) **Stop Stitch Mode Button:**



a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled

by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.



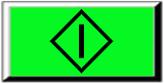
d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

14) **Make Ready #4 Saddle Chain Setup Position:**
When pressed the screen will change to the make ready #4 saddle chain setup position screen.

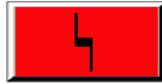
15) **Machine Start and Stop Button / Status Indicator:** When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



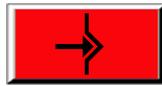
a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



k) Indicates that a fault has taken place.



l) Indicates that machine is in cycle position.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.

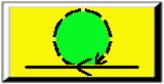
To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.

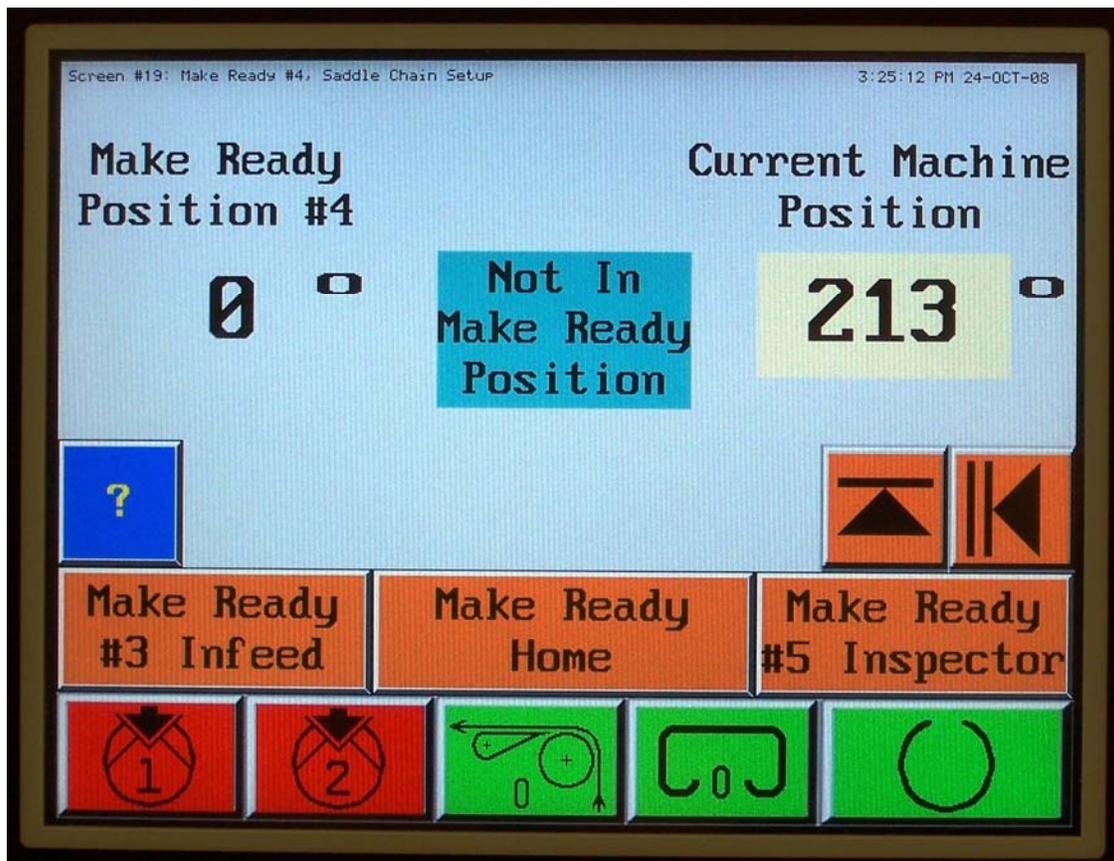


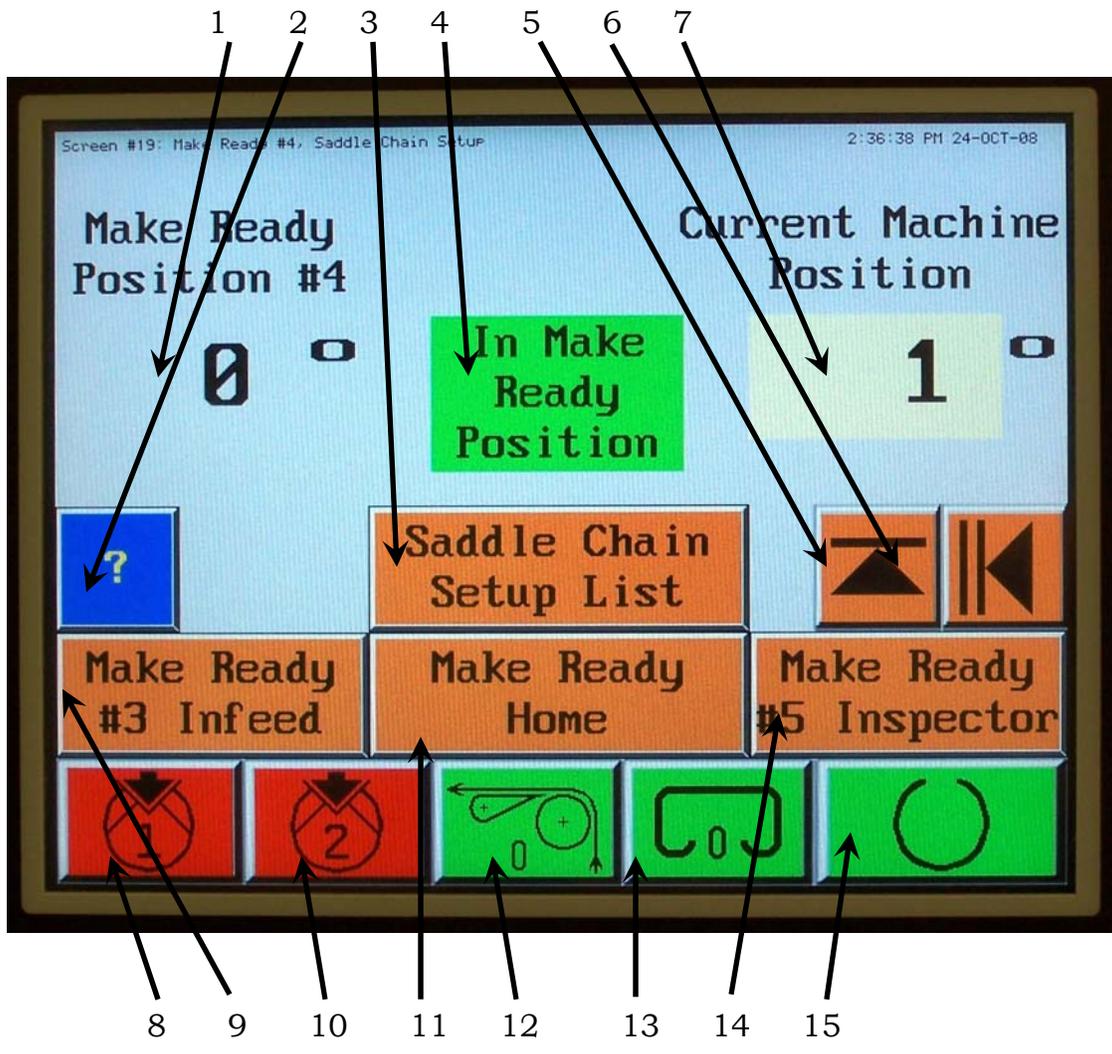
j) Indicates that a jam switch is activated.

HELP – SCREEN 19 MAKE READY
#4 POSITION

The “Make Ready #4 Saddle Chain Setup Position” is the screen that displays current machine position, and

make ready #4 saddle chain setup position. The machine can be jogged or ran into its make ready position.





- 1) Make ready #4 saddle chain setup position required.
- 2) **?**: This will retrieve the help screen for the make ready #4 saddle chain setup position screen.
- 3) **Infeed Setup List**: This button will only appear after the machine is in make ready #4 saddle chain setup position. When this button is pressed the screen will change to the make ready position #4 saddle chain setup list.
- 4) Indicator button that flashes red when not in make ready #4 saddle chain setup position. Turns green when machine is at make ready

#4 saddle chain setup position.

ready position #3 infeed screen.

5) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

6) **Production Screen Button:** this button will change the screen to the production screen.

7) **Machine current position readout.** When machine is + or - 2 degrees of the make ready position it is considered in position.

8) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

9) **Make Ready Position #3 Infeed:** when pressed the screen will change to make

10) **Pump 2 Mode Button:**



a) Pump 2 is turned off.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.

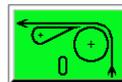


d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

11) **Make Ready Home**

Screen: When button is pressed the screen will change to the make ready home screen.

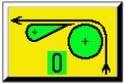
12) **Reject Solenoid Mode Button:**



a) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.



c) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

13) **Stop Stitch Mode Button:**

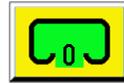


a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.

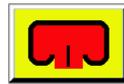


b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red

signifies that all books will not be stitched.



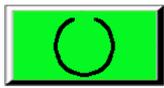
c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.



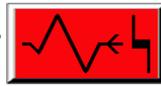
d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

14) **Make Ready #5 Inspector Setup Position:** When pressed the screen will change to the make ready #5 Inspector setup position screen.

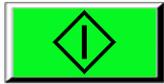
15) **Machine Start and Stop Button / Status Indicator:** When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



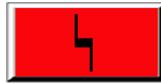
a) Indicates that machine is ready for start, all guards and faults are reset.



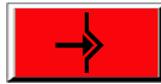
j) Indicates that a jam switch is activated.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



k) Indicates that a fault has taken place.



l) Indicates that machine is in cycle position.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



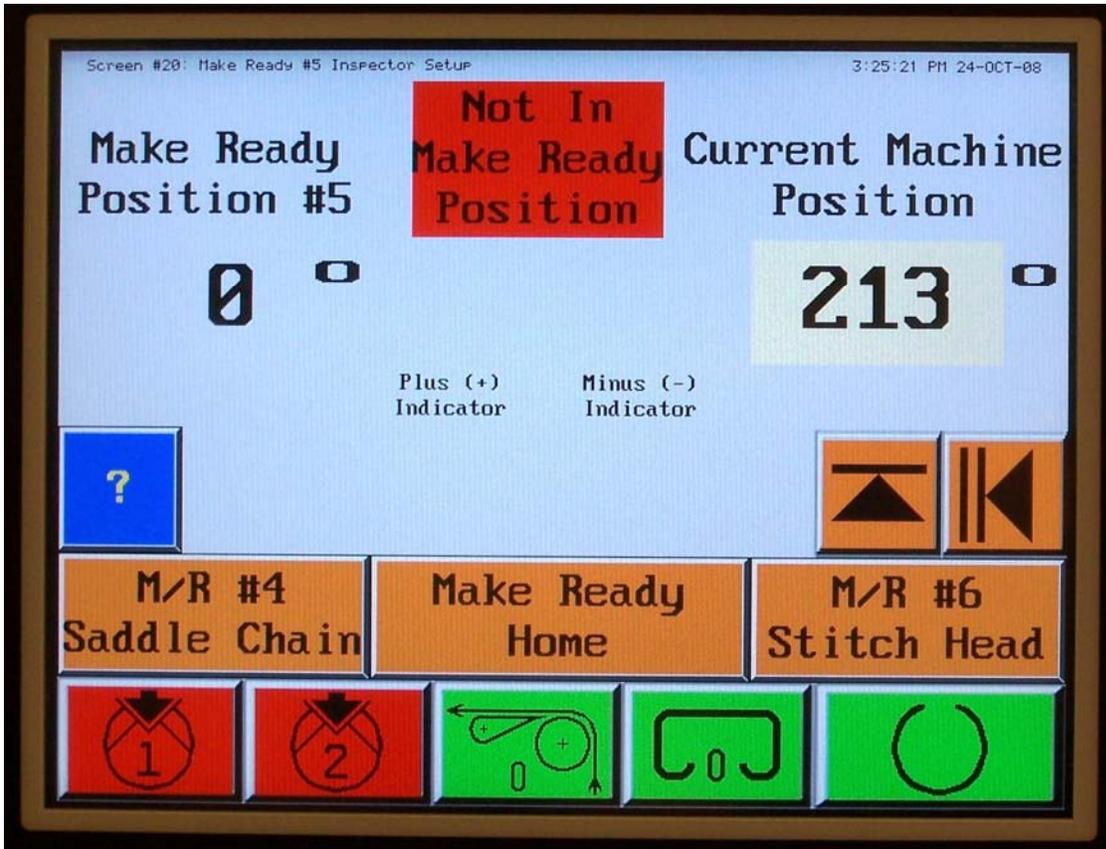
i) Indicates that a guard door is open.

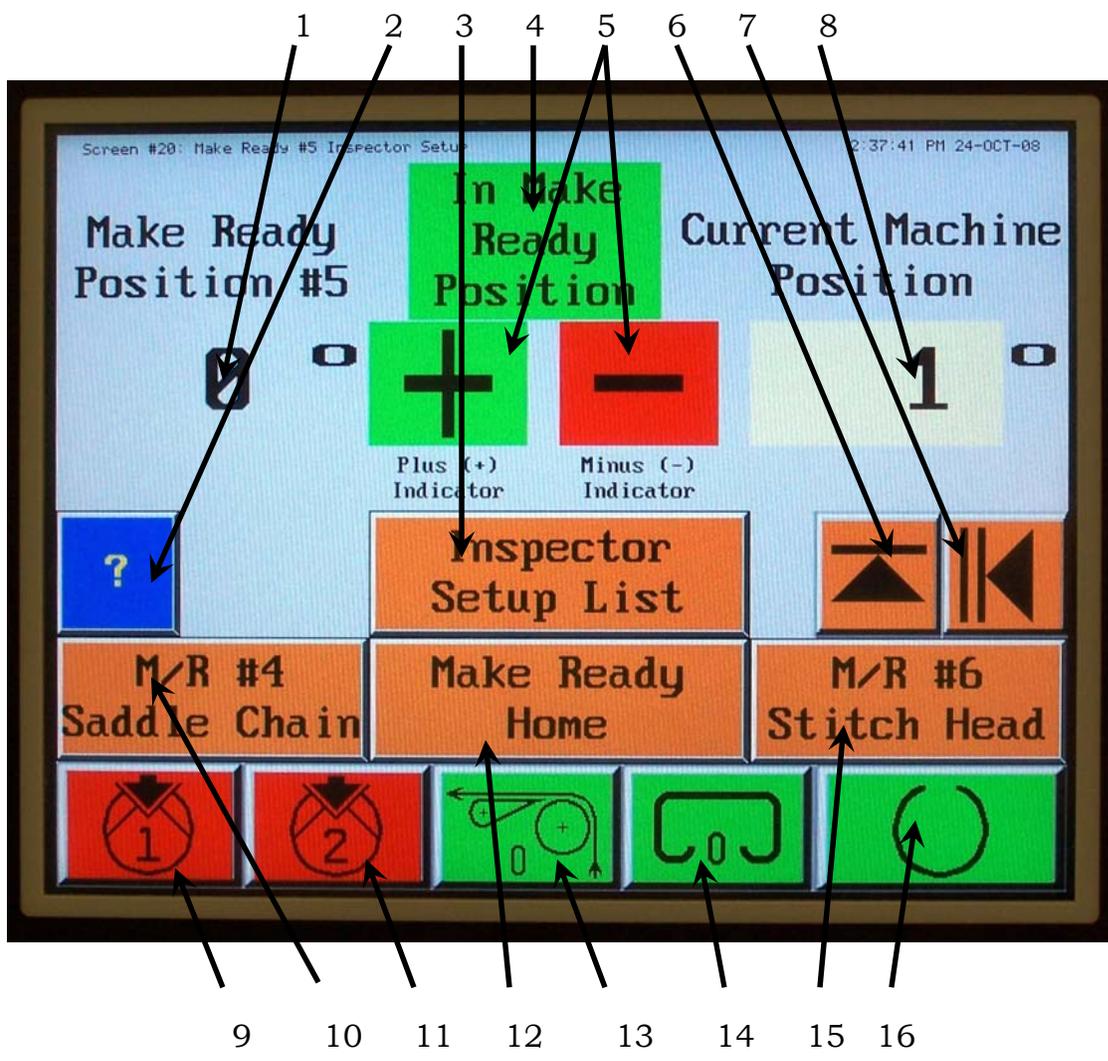
To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP - SCREEN 20 MAKE READY
#5 POSITION

The “Make Ready #5 Inspector Setup Position” is the screen that displays current machine position, and the

make ready #5 inspector setup position. The machine can be jogged or ran into its make ready position.





- 1) Make ready #5 inspector setup position required.
- 2) **?**: This will retrieve the help screen for the make ready #5 inspector setup position screen.
- 3) **Infeed Setup List**: This button will only appear after the machine is in make ready #5 inspector setup position. When this button is pressed the screen will change to the
- 4) Indicator button that flashes red when not in make ready #5 inspector setup position. Turns green when machine is at make ready #5 inspector setup position.
- 5) **+ & - Inspection Indicators**: These indicators display when machine is in make ready
- 6) make ready position #5 inspector setup list.
- 7) M/R #4 Saddle Chain
- 8) M/R #6 Stitch Head
- 9) M/R #4 Saddle Chain
- 10) M/R #4 Saddle Chain
- 11) Make Ready Home
- 12) Make Ready Home
- 13) Make Ready Home
- 14) Make Ready Home
- 15) M/R #6 Stitch Head
- 16) M/R #6 Stitch Head

#5 inspector setup position. These indicators reflect the status of the inspection switches.

pressed the screen will change to make ready position #4 saddle chain screen.

6) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

7) **Production Screen Button:** this button will change the screen to the production screen.

8) Machine current position readout. When machine is + or - 2 degrees of the make ready position it is considered in position.

9) Pump 1 Mode Button:



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

11) **Pump 2 Mode Button:**



a) Pump 2 is turned off.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.

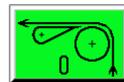


d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

12) **Make Ready Home**

Screen: When button is pressed the screen will change to the make ready home screen.

13) **Reject Solenoid Mode Button:**

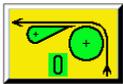


a) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.

10) Make Ready Position #4 Saddle Chain: when



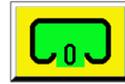
b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.



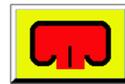
c) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.



c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.



d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

14) **Stop Stitch Mode Button:**



a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.

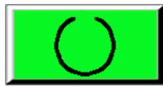


b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.

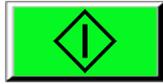
15) **Make Ready #6 Stitch Head Setup Position:** When pressed the screen will change to the make ready #6 stitch head setup position screen.

16) **Machine Start and Stop Button / Status**

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



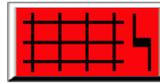
f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



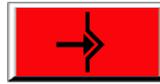
i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



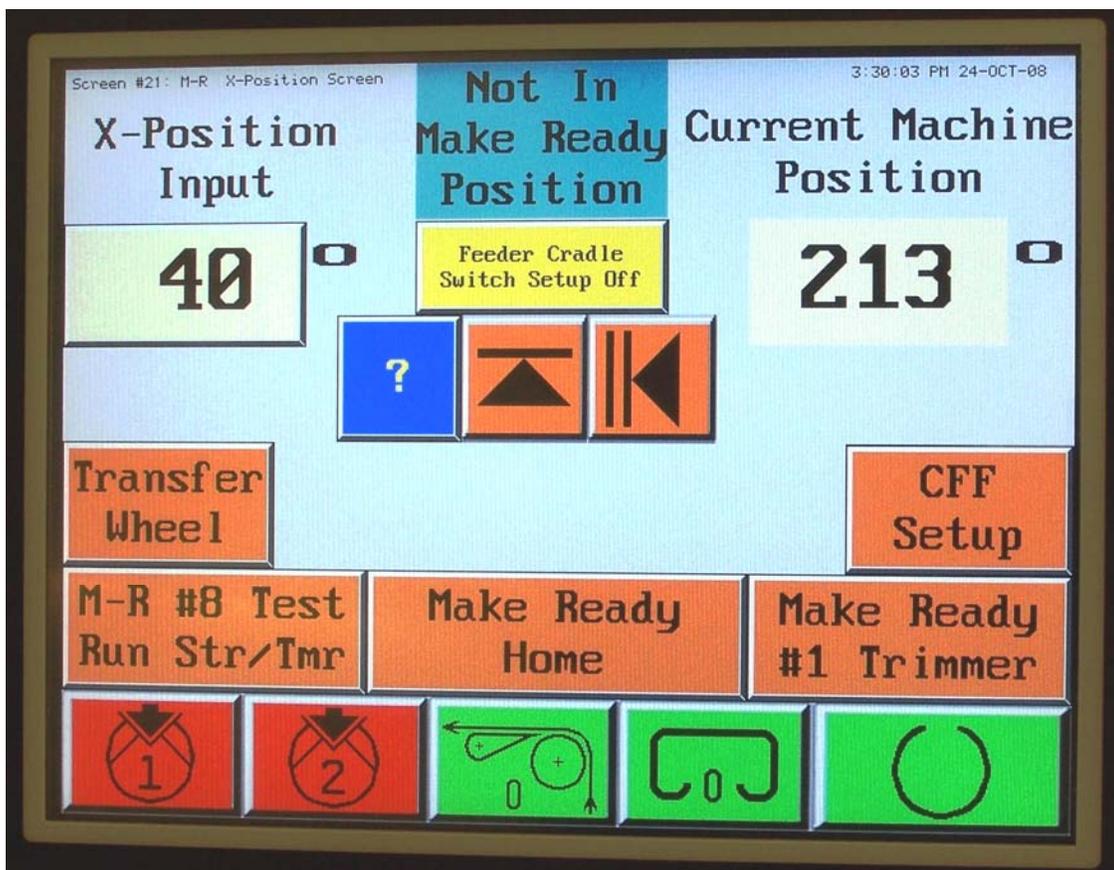
l) Indicates that machine is in cycle position.

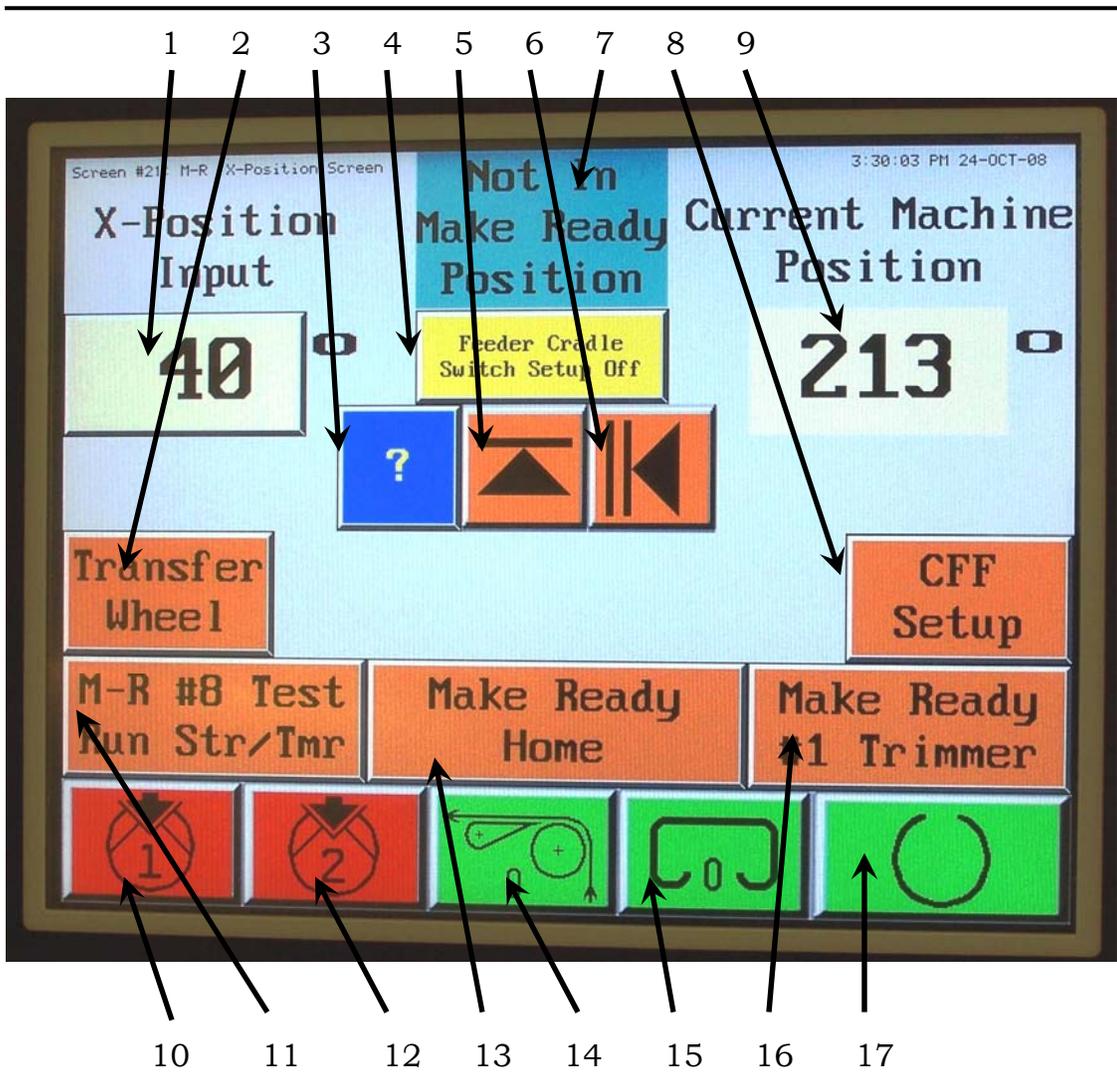
To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 21 MAKE READY
#9 POSITION

The “Make Ready #9 X-Position Position” is the screen that displays current machine

position, and make ready #9 x-position. The machine can be jogged or ran into its make ready position.





1) Make ready #9 x-position setup position input. When pressed a numeric input screen will appear. Input the desired machine degree angle and press enter.

2) **Transfer Wheel Setup Button:** This button will bring up the transfer wheel setup list screen.

3) ?: This will retrieve the help screen for the make ready

#9 x-position setup position screen.

4) **Feeder Cradle Setup Mode**

Button: This button will turn on a mode that will automatically reset the feeder relays.

5) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

6) **Production Screen Button:** this button will change the screen to the production screen.

7) Indicator button that flashes red when not in make ready #9 position. Turns green when machine is at make ready #9 position.

8) **CFF Setup Button:** This button will bring up the CFF setup list screen.

9) Machine current position readout. When machine is + or - 2 degrees of the make ready position it is considered in position.

10) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

11) **Make Ready Position #8**

Test Run: When pressed the screen will change to make ready position #8 Test Run screen.

12) **Pump 2 Mode Button:**



a) Pump 2 is turned off.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.



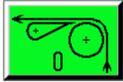
d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

13) **Make Ready Home**

Screen: When button is pressed the screen will

change to the make ready home screen.

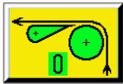
14) **Reject Solenoid Mode Button:**



a) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



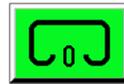
b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.



c) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.



a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.



d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

16) **Make Ready #1 Trimmer Setup Position:**

When pressed the screen will change to the make ready #1 Trimmer setup position screen.

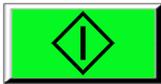
15) **Stop Stitch Mode Button:**

17) **Machine Start and Stop Button / Status**

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



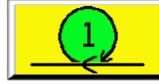
d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



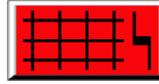
f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



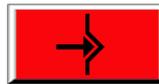
i) Indicates that a guard door is open.



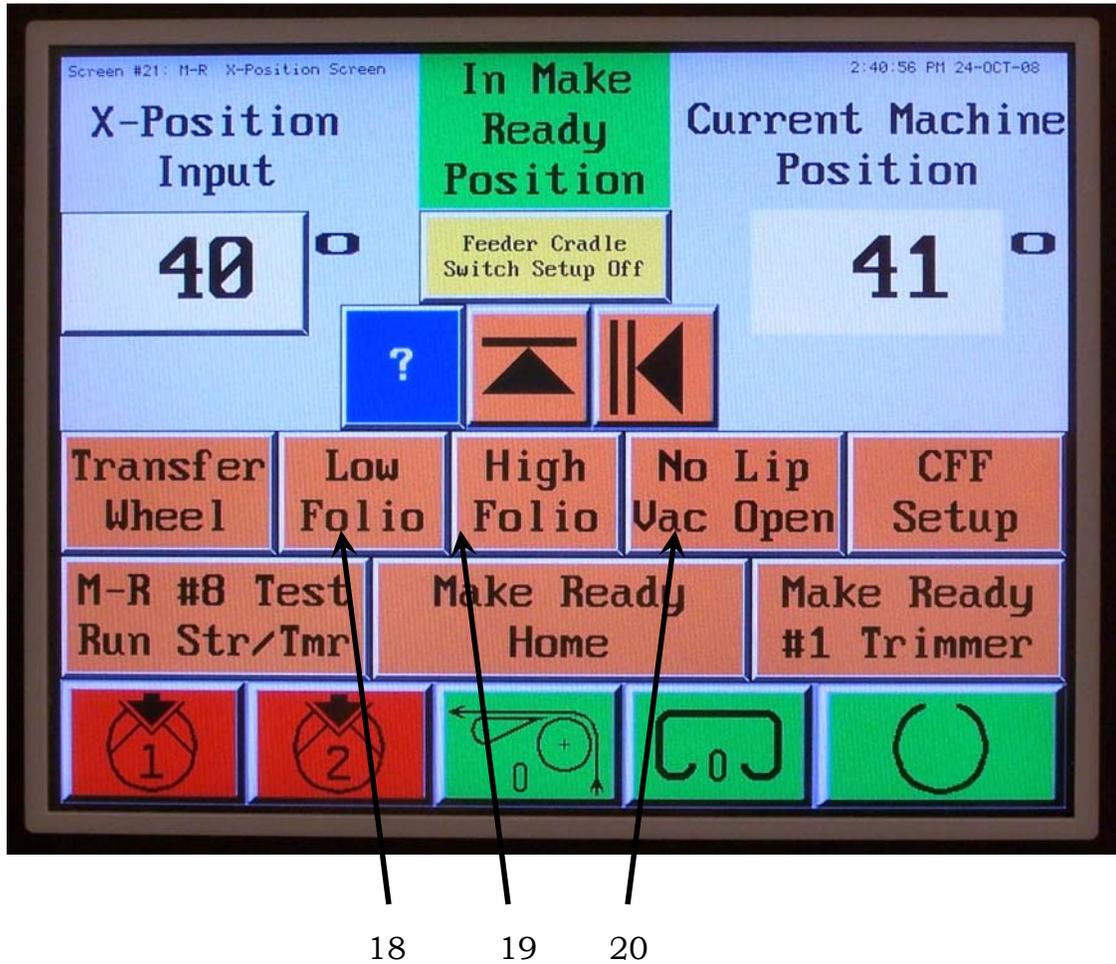
j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



l) Indicates that machine is in cycle position.



18) **Low Folio Button:** When pressed this button will bring up the low folio setup list screen.

19) **High Folio Button:** When pressed this button will bring up the high folio setup list screen.

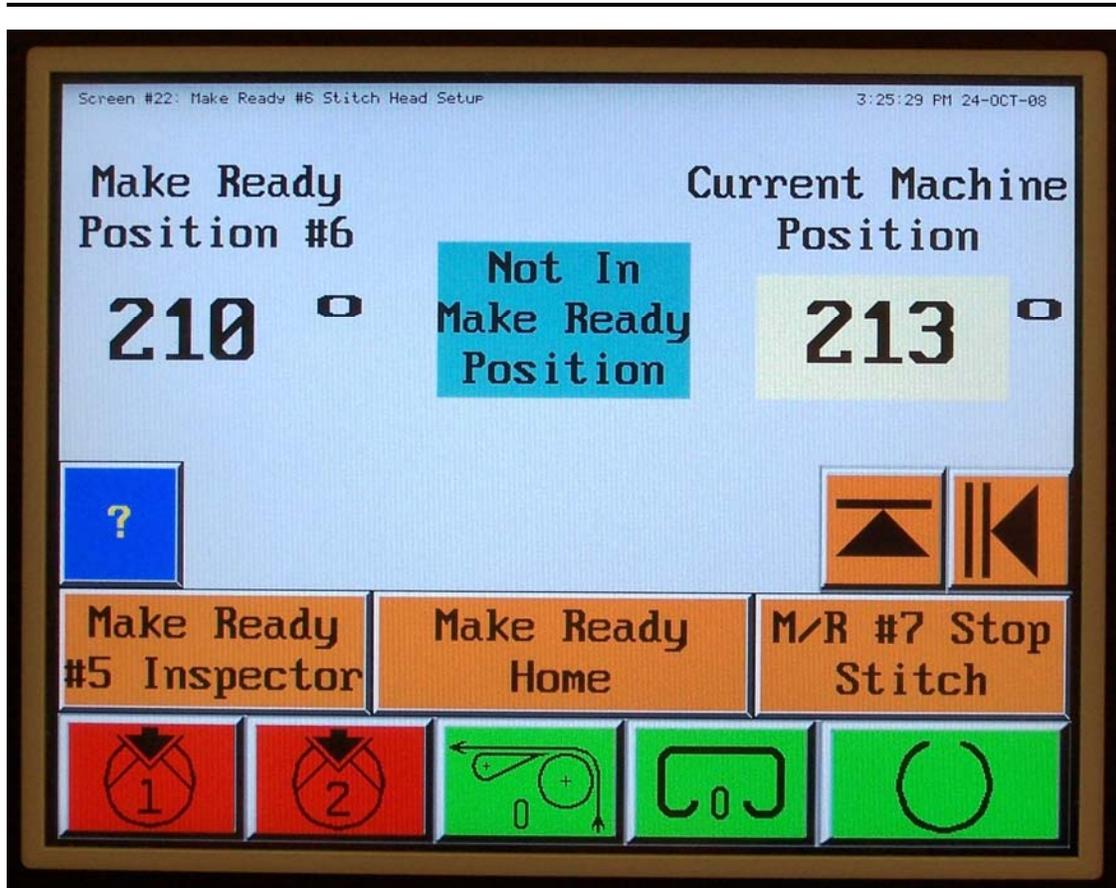
20) **No Lip Vacuum Open Button:** When pressed this button will bring up the no lip vacuum open setup list screen.

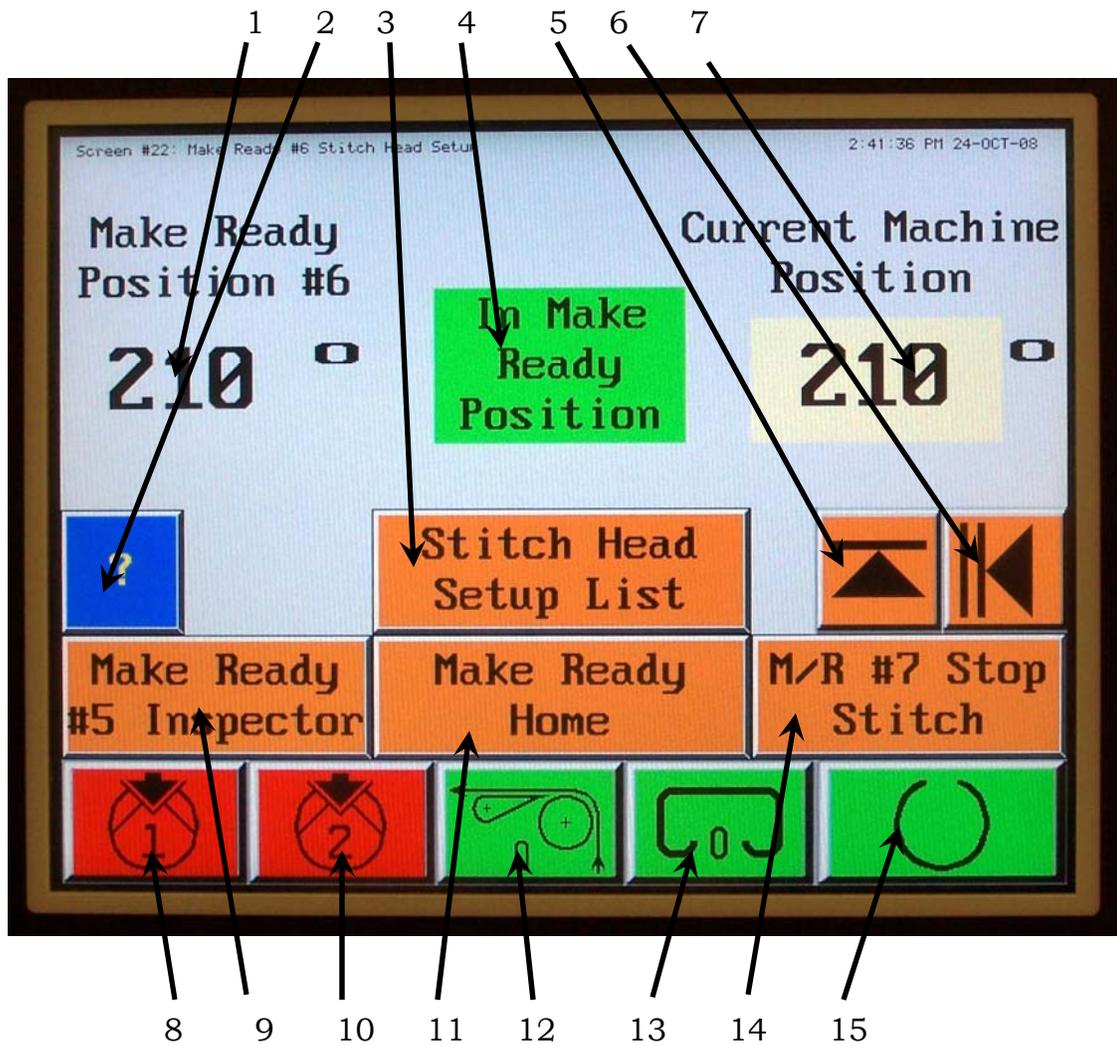
To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

HELP – SCREEN 22 MAKE READY
#6 POSITION

The “Make Ready #6
Stitch Head Setup Position” is
the screen that displays
current machine position, and

make ready #6 stitch head setup
position. The machine can be jogged
or ran into its make ready position.





- 1) Make ready #6 stitch head setup position required.
- 2) **?**: This will retrieve the help screen for the make ready #6 stitch head setup position screen.
- 3) **Stitch Head Setup List:** This button will only appear after the machine is in make ready #6 stitch head setup position. When this button is pressed the screen will change to the make ready position #6 stitch head setup list.

4) Indicator button that flashes red when not in make ready #6 stitch head setup position. Turns green when machine is at make ready #6 stitch head setup position.

5) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

6) **Production Screen Button:** this button will change the screen to the production screen.

7) **Machine current position readout:** When machine is + or - 2 degrees of the make ready position it is considered in position.

8) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

9) **Make Ready Position #5 Inspector:** when pressed the screen will change to make ready position #5 inspector screen.

10) **Pump 2 Mode Button:**



a) Pump 2 is turned off.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



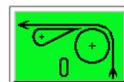
c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

11) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

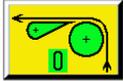
12) **Reject Solenoid Mode Button:**



a) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.



c) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

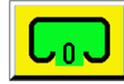
13) Stop Stitch Mode Button:



a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.



d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

14) Make Ready #7 Stop

Stitch Setup Position:

When pressed the screen will change to the make ready #7 Stop Stitch setup position screen.

15) Machine Start and Stop Button / Status

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:

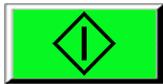


a) Indicates that machine is ready for start, all

guards and faults are reset.



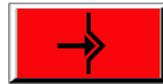
j) Indicates that a jam switch is activated.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



k) Indicates that a fault has taken place.



l) Indicates that machine is in cycle position.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.

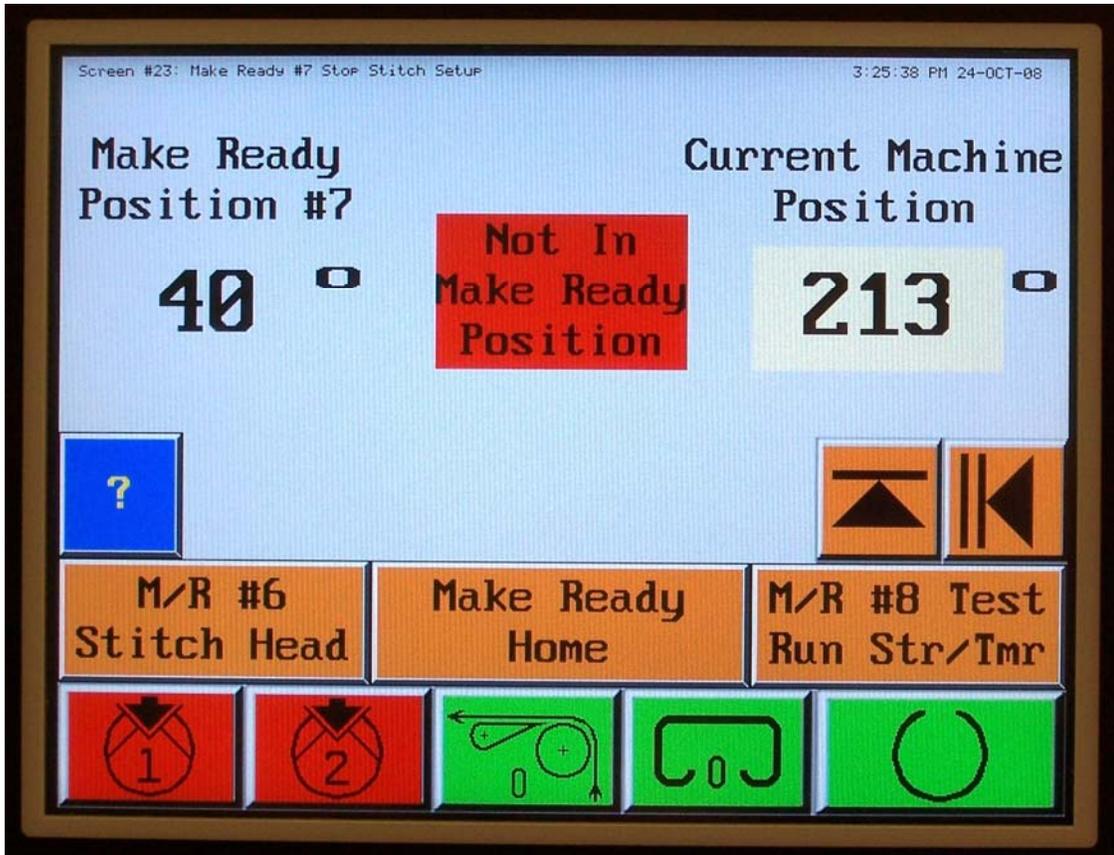


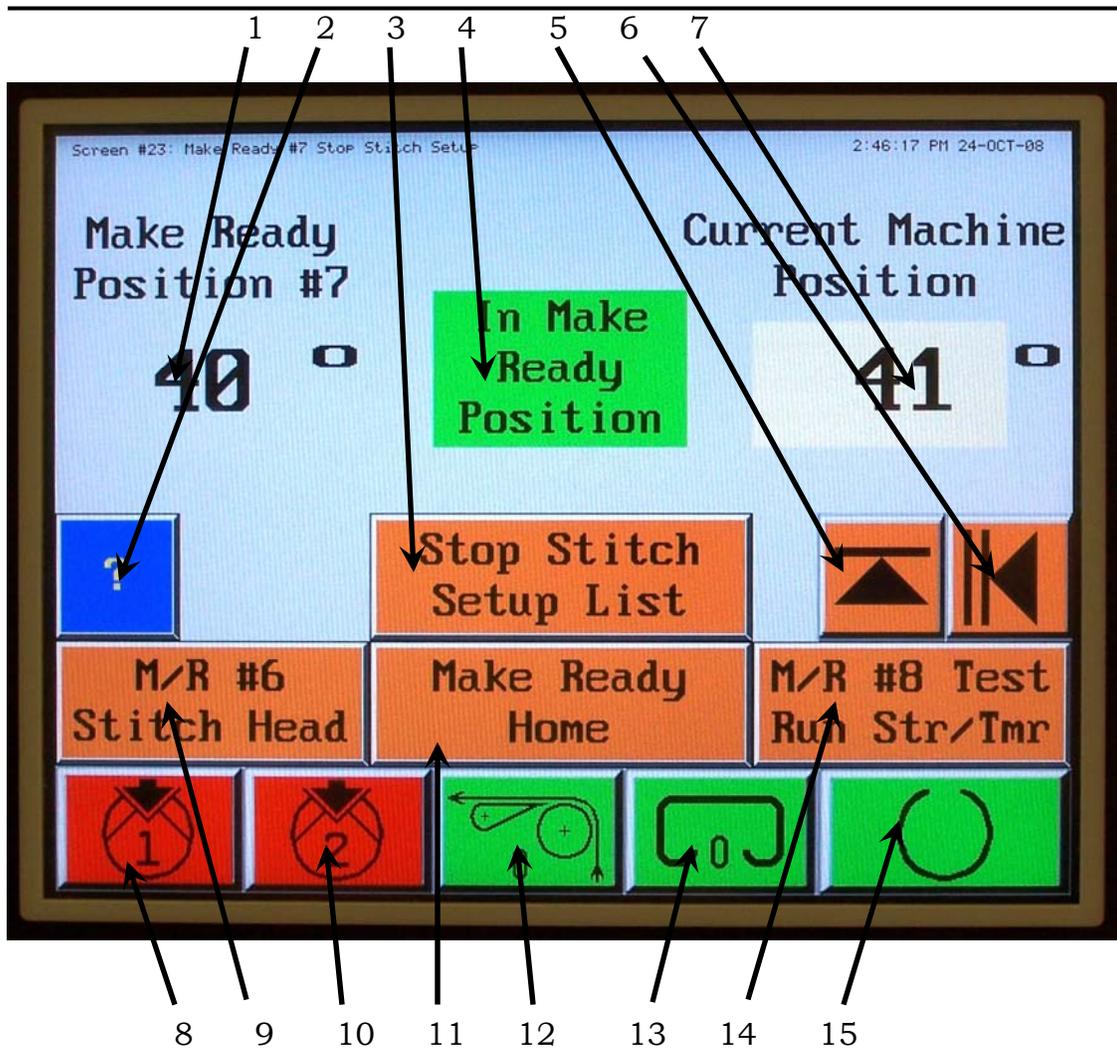
i) Indicates that a guard door is open.

HELP – SCREEN 23 MAKE READY
#7 POSITION

The “Make Ready #7 Stop Stitch Setup Position” is the screen that displays current machine position, and

make ready #7 stop stitch setup position. The machine can be jogged or ran into its make ready position.





- | | |
|---|---|
| <ol style="list-style-type: none"> 1) Make ready #7 stop stitch setup position required. 2) ?: This will retrieve the help screen for the make ready #7 stop stitch setup position screen. 3) Stop Stitch Setup List: This button will only appear after the machine is in make ready #7 stop stitch setup position. When this button is pressed the screen will change to the | <ol style="list-style-type: none"> 4) Indicator button that flashes red when not in make ready #7 stop stitch setup position. Turns green when machine is at make ready #7 stop stitch setup position. 5) Main Menu Button: When pressing this button, screen will change to the main menu screen. |
|---|---|

- 6) **Production Screen Button:** this button will change the screen to the production screen.

- 7) **Machine current position readout:** When machine is + or - 2 degrees of the make ready position it is considered in position.

- 8) **Pump 1 Mode Button:**



- a) Pump 1 is turned off.



- b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



- c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



- d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

- 9) **Make Ready Position #6 Stitch Head:** when pressed the screen will change to make ready position #6 Stitch Head screen.

- 10) **Pump 2 Mode Button:**



- a) Pump 2 is turned off.



- b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



- c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.

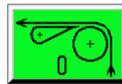


- d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

- 11) **Make Ready Home Screen:**

- When button is pressed the screen will change to the make ready home screen.

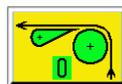
- 12) **Reject Solenoid Mode Button:**



- a) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



- b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not pass through the reject area.



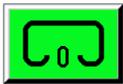
- c) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green

signifies that the solenoid is de-energized and is passing good books into the trimmer.



- d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

13) **Stop Stitch Mode Button:**



- a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



- b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



- c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.



- d) This indicates that the stop stitch solenoid is in auto mode. The solenoid

is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

14) **Make Ready #8 Test Run Setup Position:**

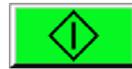
Setup Position: When pressed the screen will change to the make ready #8 Test Run setup position screen.

15) **Machine Start and Stop Button / Status**

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the **stop button on the pendent stations. The indicators in this button are as follows:**



- a) Indicates that machine is ready for start, all guards and faults are reset.



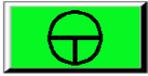
- b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



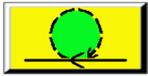
- c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



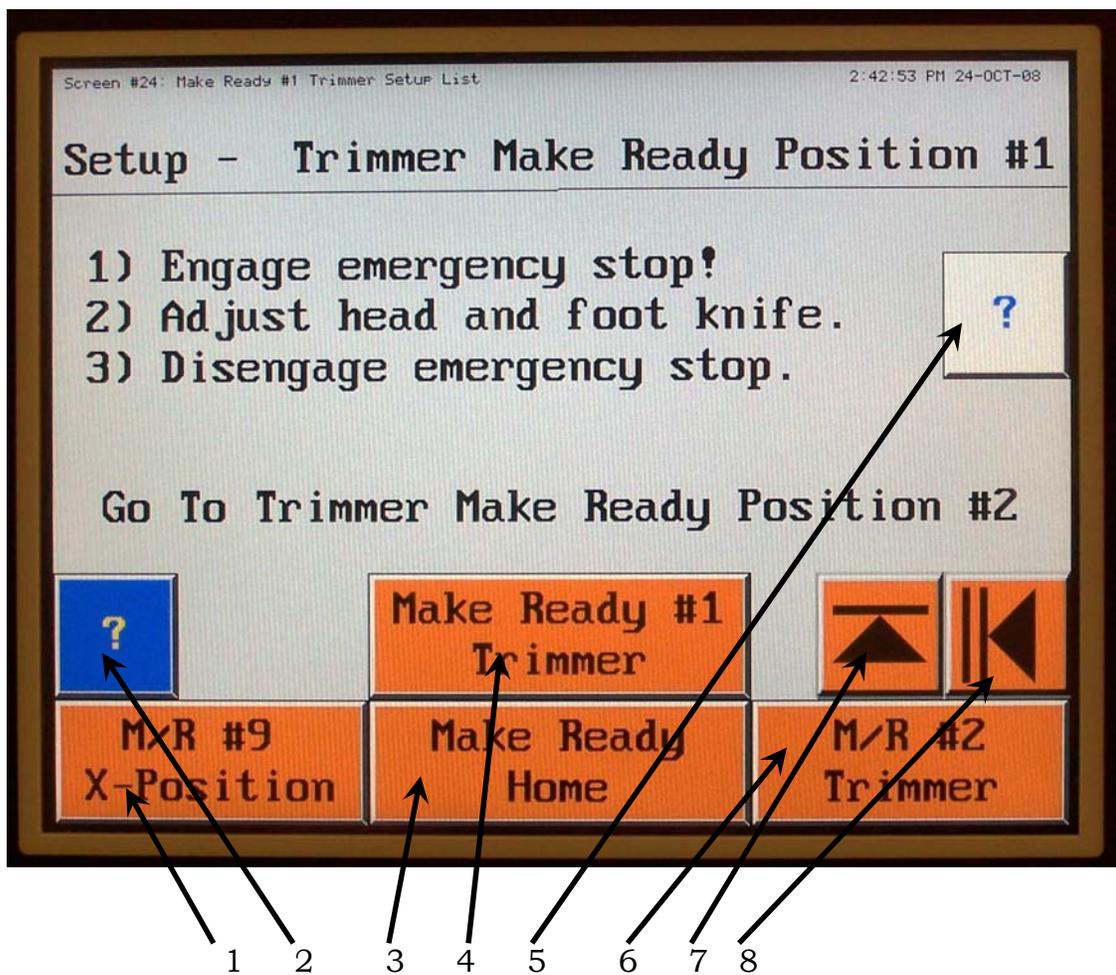
l) Indicates that machine is in cycle position.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 24 MAKE READY
#1 SETUP

The “Make Ready #1 Trimmer Setup List” is the screen that displays the setup

list for trimmer make ready position #1.



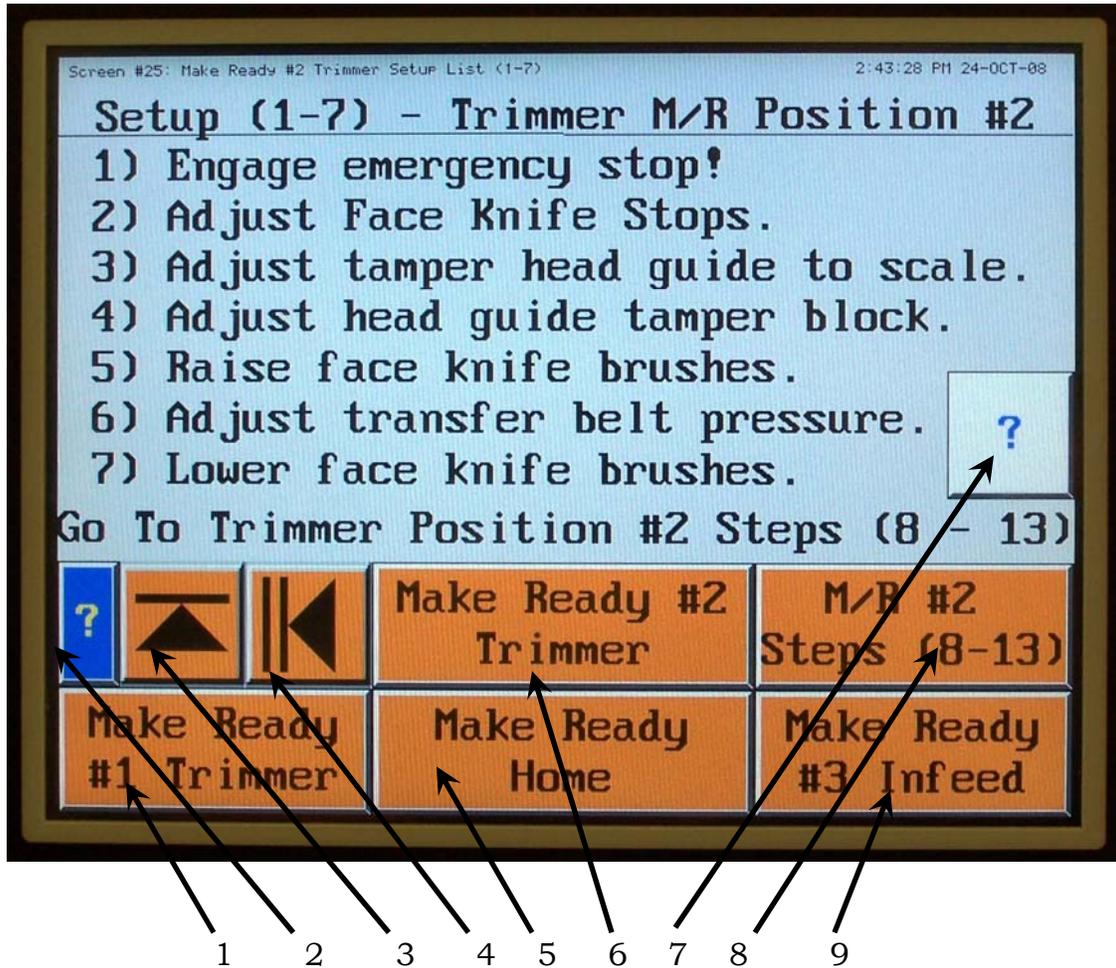
- 1) **Make Ready Position #9 X-Position:** when pressed the screen will change to make ready position #9 X-Position screen.
- 2) **?:** This will retrieve the help screen for the make ready #1 trimmer setup list screen.
- 3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.
- 4) **Make Ready #1 Trimmer Screen:** When button is pressed the screen will change to the make ready #1 trimmer screen.

- 5) **?**: This will retrieve the help screen for the make ready #1 setup list.
- 6) **Make Ready Position #2 Trimmer Screen:** When button is pressed the screen will change to the make ready position #2 trimmer position screen.
- 7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 25 MAKE READY #2 SETUP

The “Make Ready #2 Trimmer Setup List (1-7)” is the screen that displays the setup list for trimmer make ready position #2.



- | | |
|---|---|
| <ol style="list-style-type: none"> 1) Make Ready Position #1 Trimmer: when pressed the screen will change to make ready position #1 trimmer screen. 2) ?: This will retrieve the help screen for the make ready #2 trimmer setup list screen. 3) Main Menu Button: When pressing this button, | <p>screen will change to the main menu screen.</p> <ol style="list-style-type: none"> 4) Production Screen Button: this button will change the screen to the production screen. 5) Make Ready Home Screen: When button is pressed the screen will change to the make ready home screen. |
|---|---|

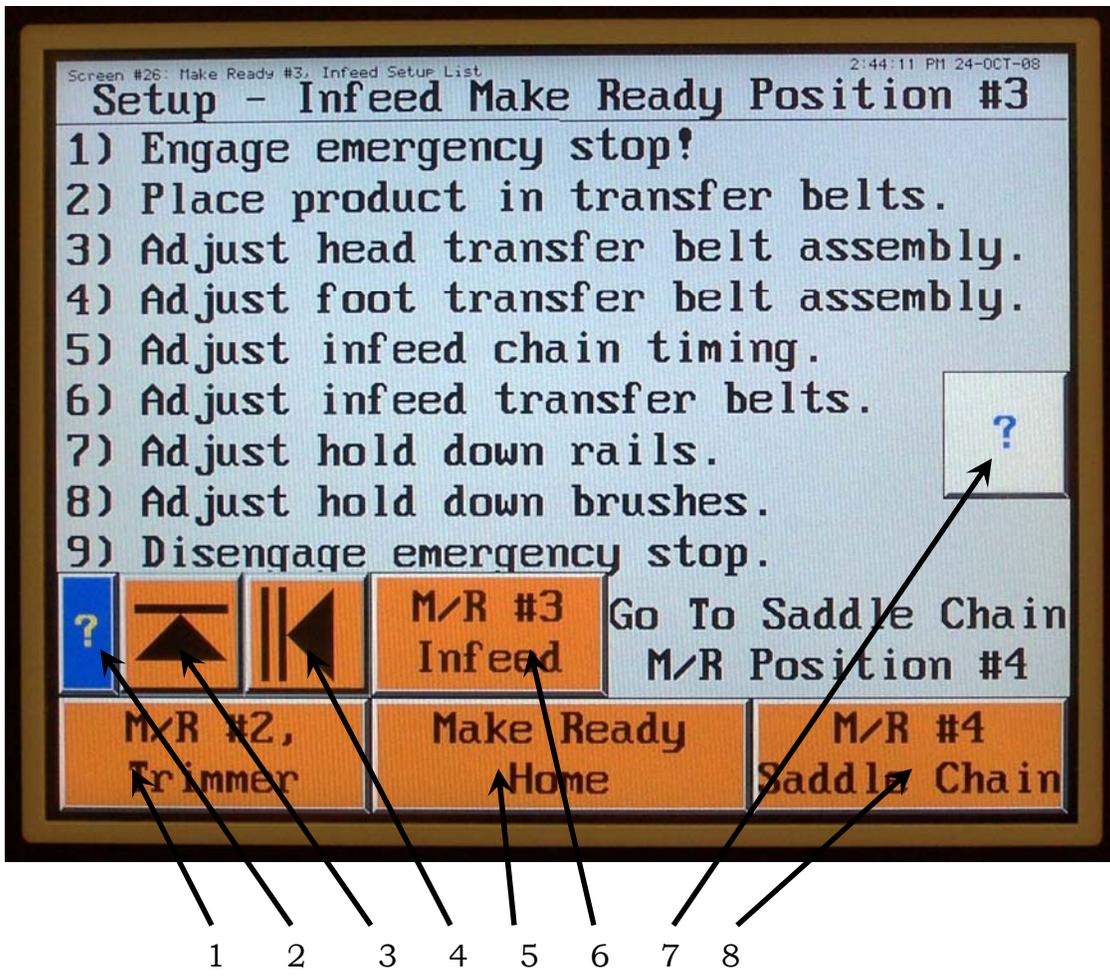
- 6) **Make Ready Position #2 Trimmer:** when pressed the screen will change to make ready position #2 trimmer screen.
- 7) **?**: This will retrieve the help screen for the make ready #2 setup list.
- 8) **Make Ready #2 Trimmer Setup List (8-13):** When button is pressed the screen will change to the make ready #2 trimmer setup list (8-13).
- 9) **Make Ready Position #3 Infeed:** when pressed the screen will change to make ready #1 infeed position screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 26 MAKE READY
#3 SETUP

The “Make Ready #3 Infeed Setup List” is the screen that displays the setup

list for infeed make ready position #3.



1) **Make Ready Position #2 Trimmer:** when pressed the screen will change to make ready position #2 trimmer screen.

2) **?:** This will retrieve the help screen for the make ready #3 infeed setup list screen.

3) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

4) **Production Screen Button:** this button will change the screen to the production screen.

- 5) **Make Ready Home**
Screen: When button is pressed the screen will change to the make ready home screen.

- 6) **Make Ready Position #3**
Infeed: when pressed the screen will change to make ready position #3 infeed position screen.

- 7) **?:** This will retrieve the help screen for the make ready #3 infeed setup list.

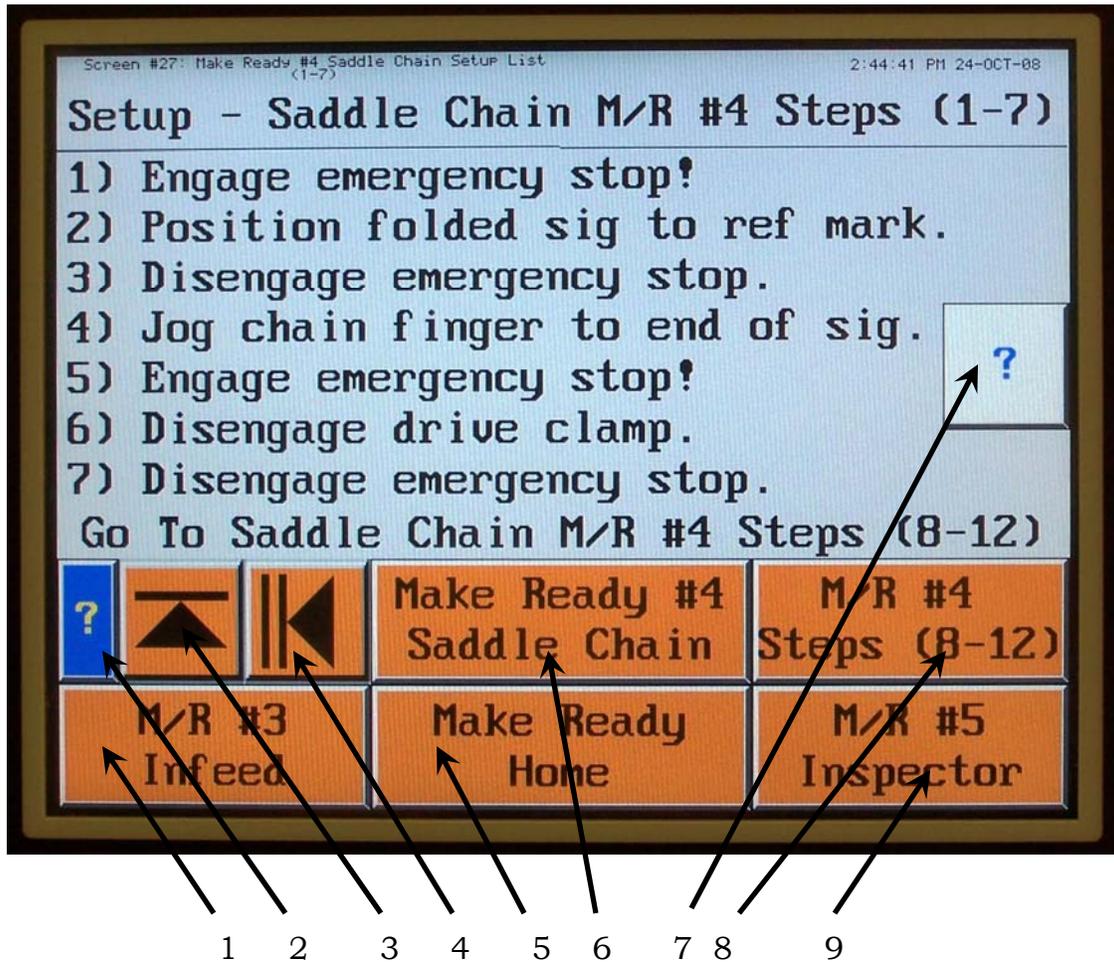
- 8) **Make Ready Position #4 Saddle Chain setup :**
When button is pressed the screen will change to the make ready position #4 saddle chain.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

**HELP – SCREEN 27 MAKE READY
#4 SETUP**

The “Make Ready #4 Saddle Chain Setup List (1-7)”

is the screen that displays the setup list for saddle chain make ready position #2.



- 1) **Make Ready Position #3 Infeed:** when pressed the screen will change to make ready position #3 infeed position screen.
- 2) **?:** This will retrieve the help screen for the make ready #4 saddle chain setup list screen.
- 3) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 4) **Production Screen Button:** this button will change the screen to the production screen.

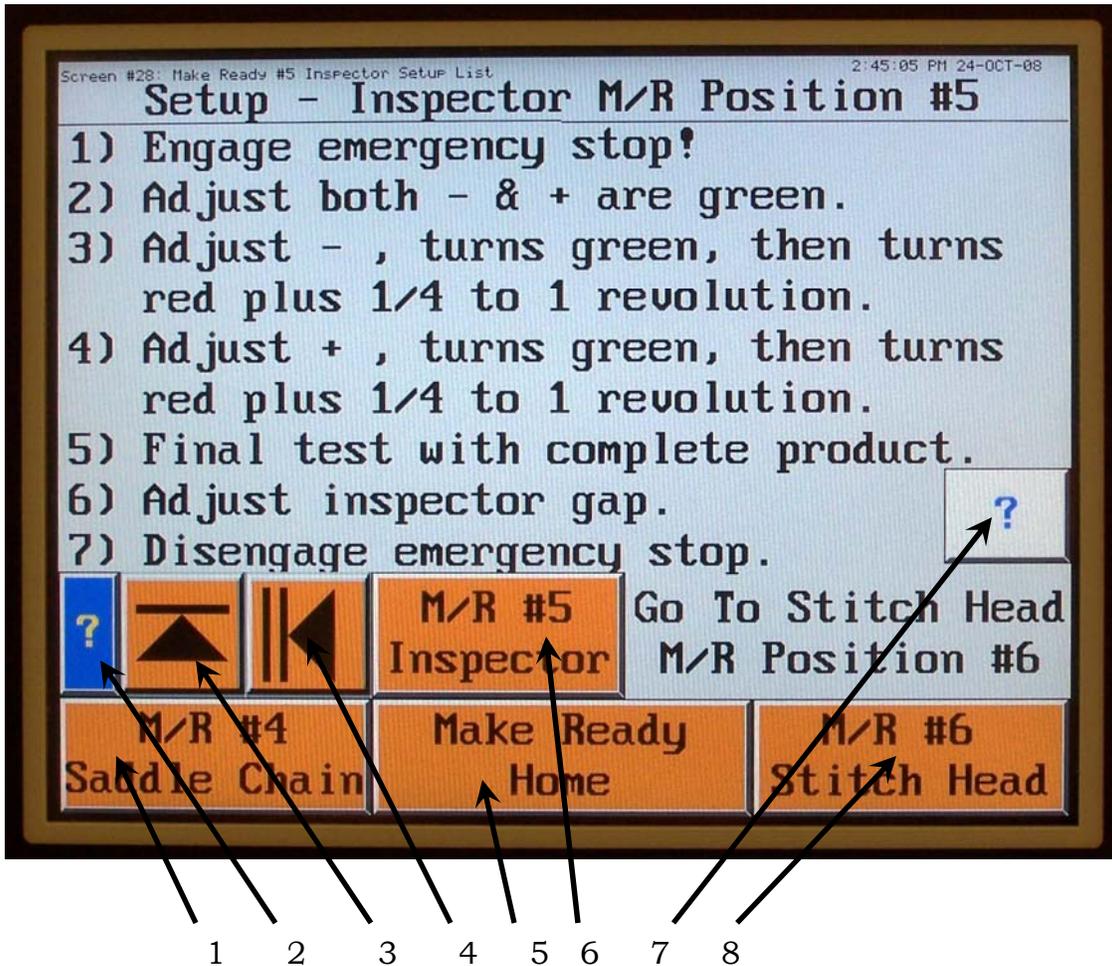
- 5) **Make Ready Home**
Screen: When button is pressed the screen will change to the make ready home screen.
- 6) **Make Ready Position #4 Saddle Chain:** when pressed the screen will change to make ready position #4 saddle chain position screen.
- 7) **?:** This will retrieve the help screen for the make ready #4 saddle chain setup list.
- 8) **Make Ready #4 Saddle Chain Setup List (8-12):** When button is pressed the screen will change to the make ready #4 saddle chain setup list (8-12).
- 9) **Make Ready Position #5 Inspector:** when pressed the screen will change to make ready #5 inspector position screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 28 MAKE READY
#5 SETUP

The “Make Ready #5 Inspector Setup List” is the

screen that displays the setup list for inspector make ready position #5.



1) **Make Ready Position #4**

Saddle Chain: when pressed the screen will change to make ready position #4 saddle chain position screen.

2) **?:** This will retrieve the help screen for the make ready #5 inspector setup list screen.

3) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

4) **Production Screen Button:** this button will change the screen to the production screen.

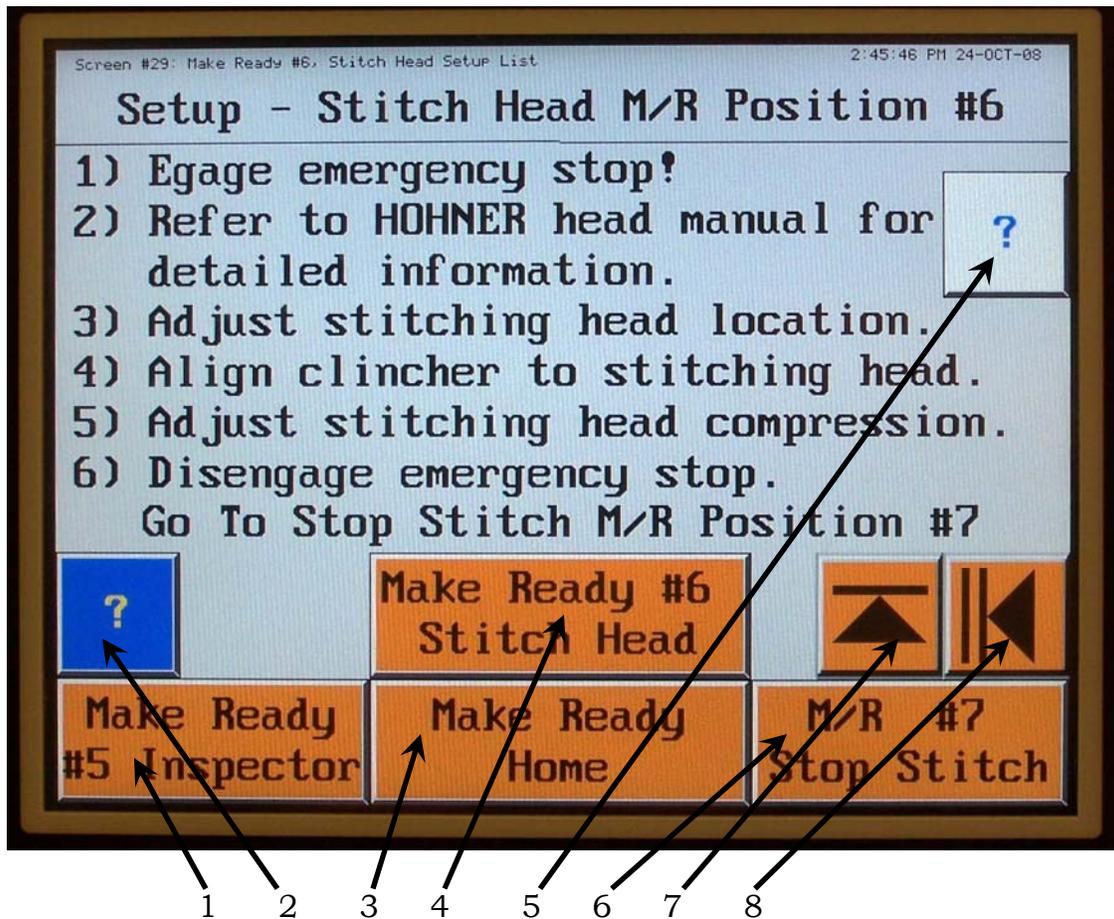
- 5) **Make Ready Home**
Screen: When button is pressed the screen will change to the make ready home screen.
- 6) **Make Ready Position #5**
Inspector: when pressed the screen will change to make ready position #5 inspector position screen.
- 7) **?:** This will retrieve the help screen for the make ready #5 inspector setup list.
- 8) **Make Ready Position #6**
Stitch Head Setup : When button is pressed the screen will change to the make ready position #6 stitch head position screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 29 MAKE READY
#6 SETUP

The “Make Ready #6
 Stitch Head Setup List” is the

screen that displays the setup
 list for stitch head make ready
 position #6.



1) **Make Ready Position #5 Inspector:** when pressed the screen will change to make ready position #5 Inspector position screen.

2) **?:** This will retrieve the help screen for the make ready #6 stitch head setup list screen.

3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

4) **Make Ready position #6 Stitch Head Screen:** When button is pressed the screen will change to the make ready position

#6 stitch head position screen.

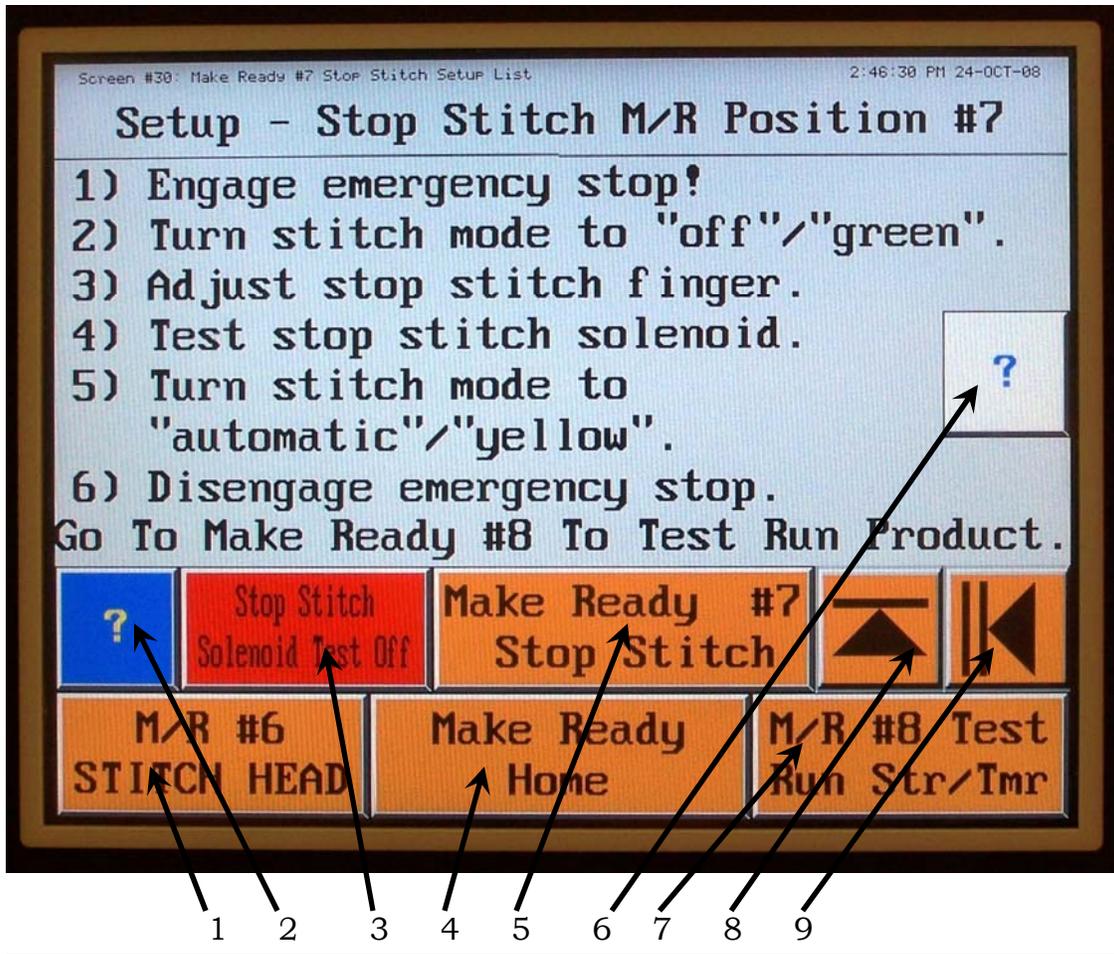
- 5) **?**: This will retrieve the help screen for the make ready #6 stitch head setup list.
- 6) **Make Ready Position #7 Stop Stitch Screen:** When button is pressed the screen will change to the make ready position #7 stop stitch position screen.
- 7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 30 MAKE READY #7 SETUP

The “Make Ready #7 Stop Stitch Setup List” is the

screen that displays the setup list for stop stitch make ready position #7.



- 1) **Make Ready Position #6 Stitch Head:** when pressed the screen will change to make ready position #6 stitch head position screen.
- 2) **?:** This will retrieve the help screen for the make

ready #7 stop stitch setup list screen.

- 3) **Stop Stitch Solenoid Test On/Off Button:** when pressed the stop stitch solenoid will energize.

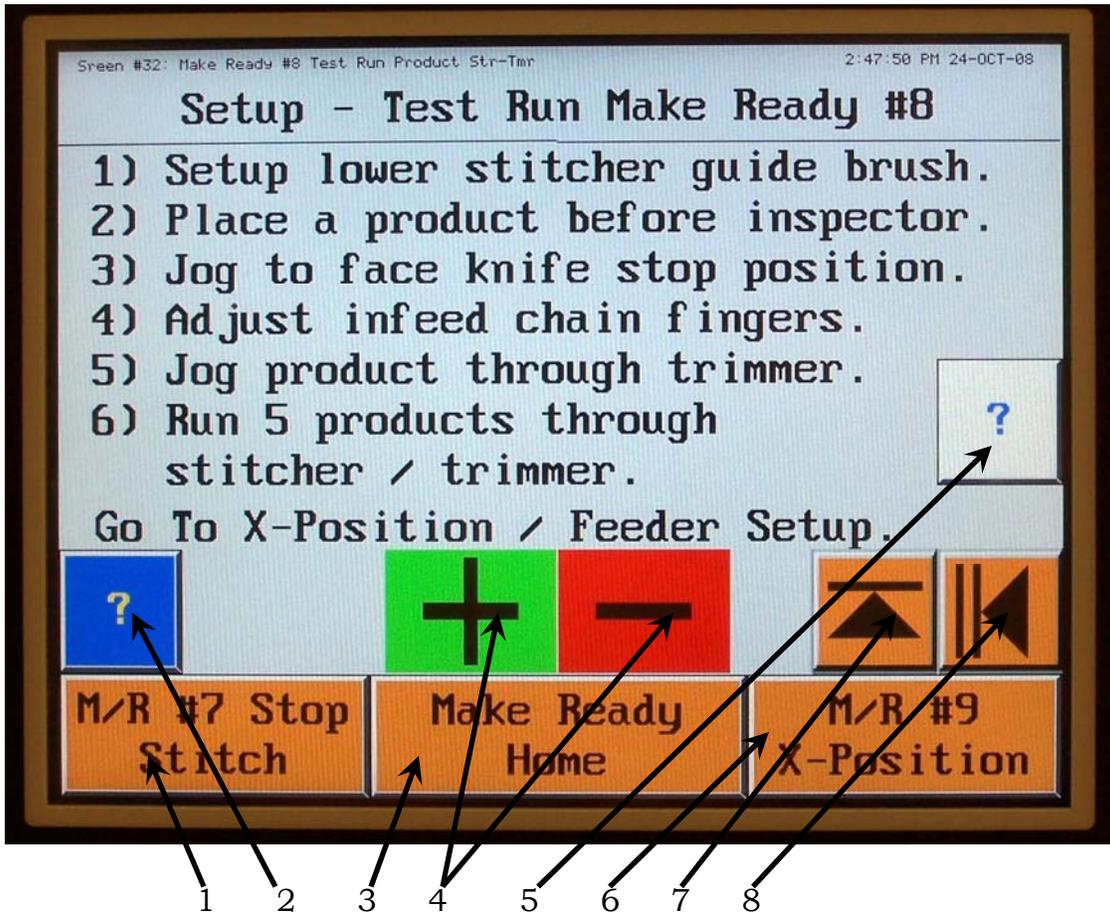
- 4) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.
- 5) **Make Ready position #7 Stop Stitch Screen:** When button is pressed the screen will change to the make ready position #7 stop stitch position screen.
- 6) **?:** This will retrieve the help screen for the make ready #7 stop stitch setup list.
- 7) **Make Ready Position #8 Test Run Screen:** When button is pressed the screen will change to the make ready position #8 test run screen.
- 8) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 9) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 32 MAKE READY
#8 SETUP

The “Make Ready #8 Test Run Setup List” is the screen that displays the setup

list for test run make ready position #8.



1) **Make Ready Position #7 Stop Stitch:** when pressed the screen will change to make ready position #7 stop stitch position screen.

2) **?:** This will retrieve the help screen for the make ready #8 test run setup list screen.

3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

4) **+ & - Inspection Indicators:** These indicators reflect the status of the inspection switches.

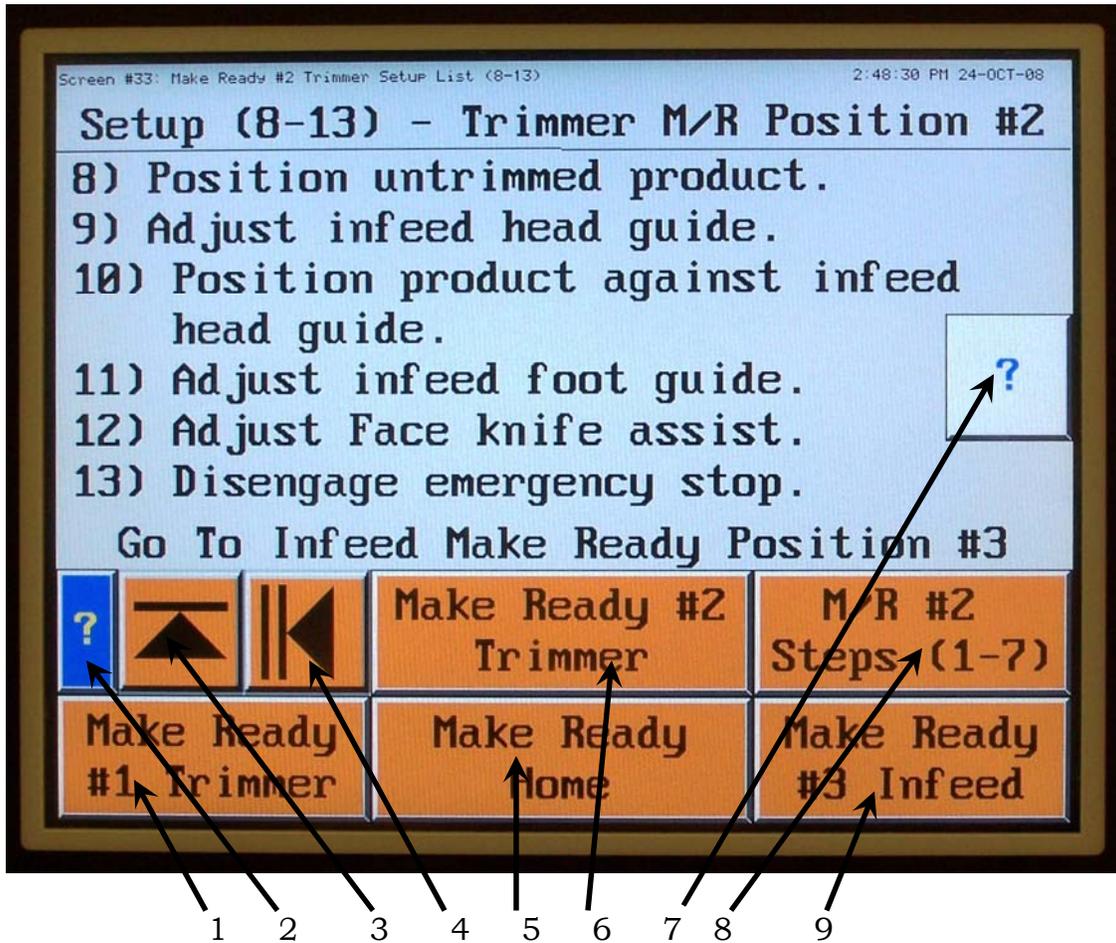
- 5) **?**: This will retrieve the help screen for the make ready #8 test run setup list.
- 6) **Make Ready Position #9 X-Position Screen**: When button is pressed the screen will change to the make ready position #9 x-position screen.
- 7) **Main Menu Button**: When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button**: this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

**HELP – SCREEN 33 MAKE READY
#2 SETUP**

The “Make Ready #2 Trimmer Setup List (8-12)” is the screen that displays the

setup list for trimmer make ready position #2.



- 1) **Make Ready Position #1 Trimmer:** when pressed the screen will change to make ready position #1 trimmer screen.
- 2) **?:** This will retrieve the help screen for the make ready #2 trimmer setup list screen.
- 3) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 4) **Production Screen Button:** this button will change the screen to the production screen.

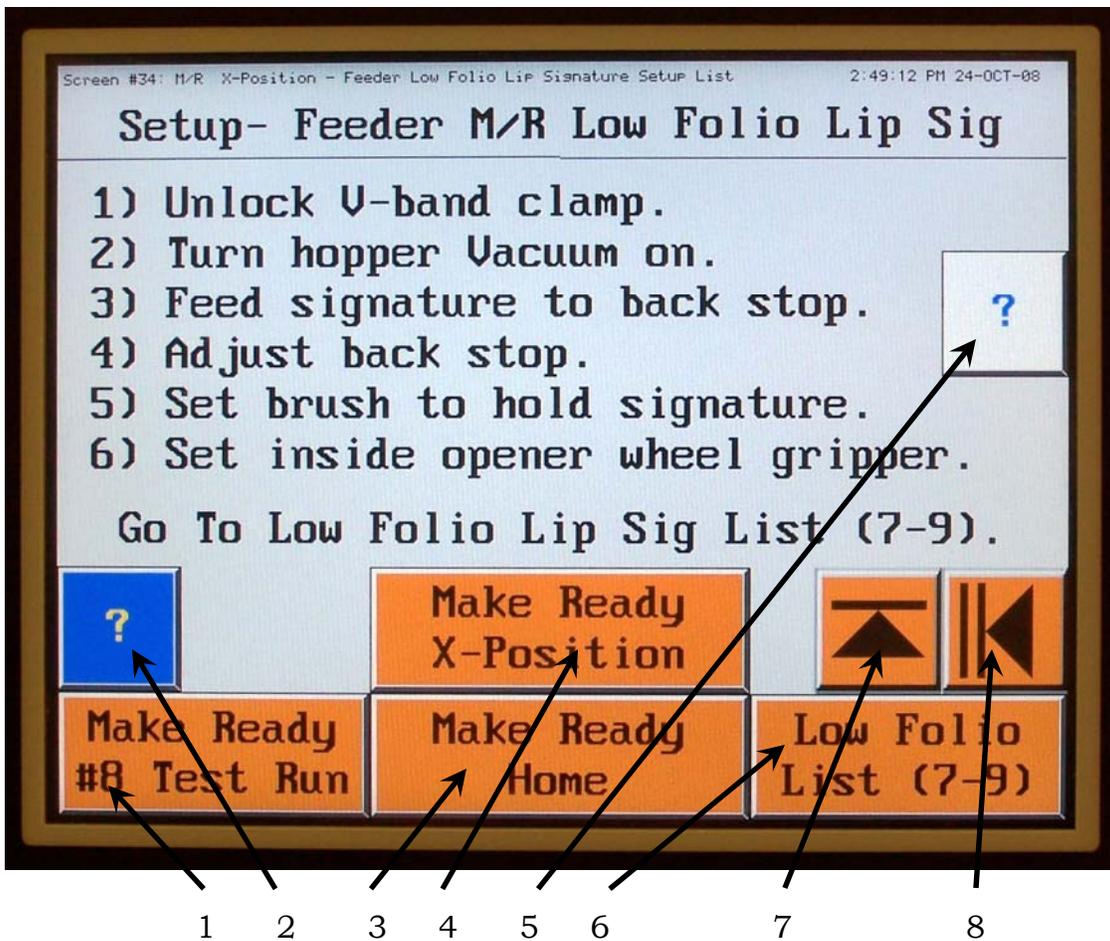
- 5) **Make Ready Home**
Screen: When button is pressed the screen will change to the make ready home screen.
- 6) **Make Ready Position #2**
Trimmer: when pressed the screen will change to make ready position #2 trimmer screen.
- 7) **?:** This will retrieve the help screen for the make ready #2 setup list.
- 8) **Make Ready #2 Trimmer Setup List (1-7):** When button is pressed the screen will change to the make ready #2 trimmer setup list (1-7).
- 9) **Make Ready Position #3**
Infeed: when pressed the screen will change to make ready #1 infeed position screen.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

HELP – SCREEN 34 MAKE READY
#9 SETUP

The “Make Ready #9 Low Folio Lip Signature Setup List” is the screen that

displays the setup list for low folio lip signature make ready position #9.



- 1) **Make Ready Position #8 Test Run:** when pressed the screen will change to make ready position #8 test run position screen.
- 2) **?:** This will retrieve the help screen for the make ready #9 low folio lip signature setup list screen.

- 3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.
- 4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready

position #9 x-position
screen.

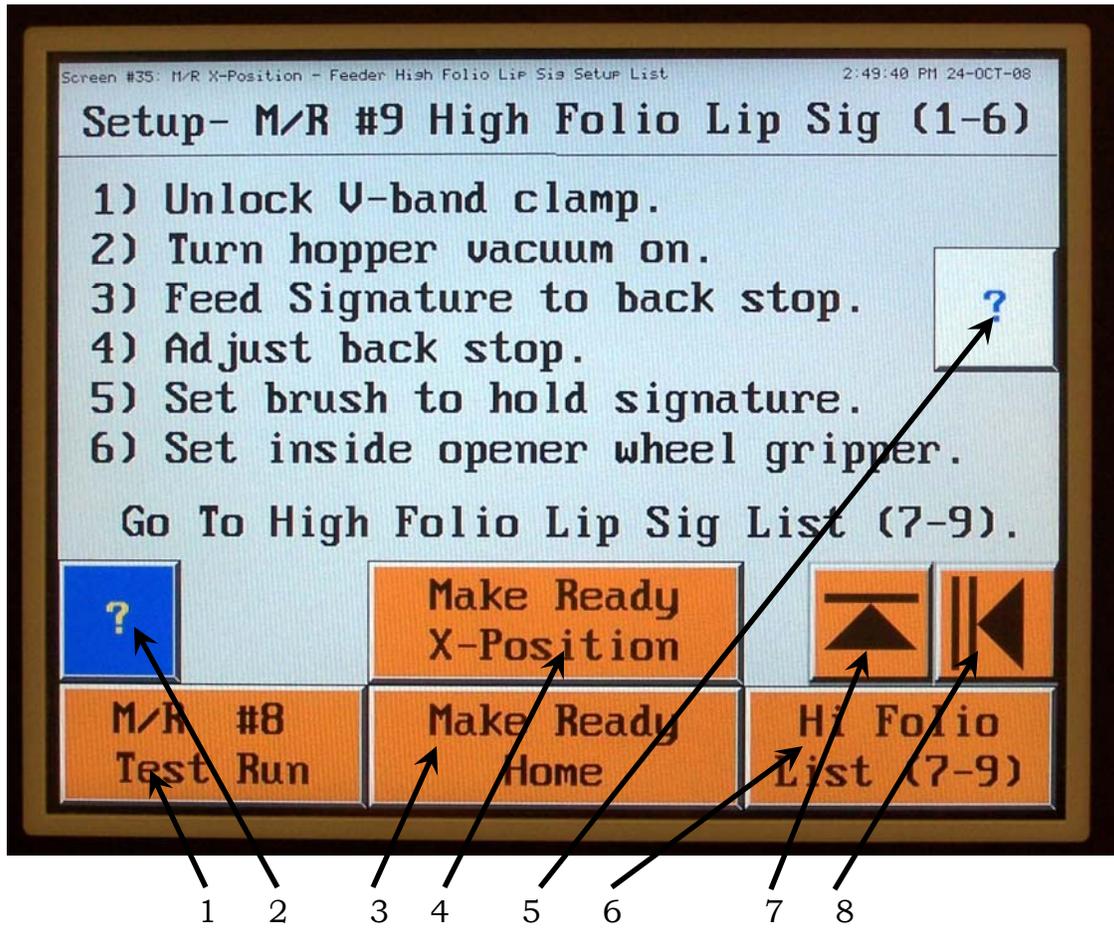
- 5) **?**: This will retrieve the help screen for the make ready #9 low folio lip signature setup list.
- 6) **Low Folio Lip Signature Setup List (7-9) Screen:**
When button is pressed the screen will change to the low folio lip signature setup list (7-9) screen.
- 7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

**HELP – SCREEN 35 MAKE READY
#9 SETUP**

The “Make Ready #9 High Folio Lip Signature Setup List” is the screen that

displays the setup list for high folio lip signature make ready position #9.



1) **Make Ready Position #8 Test Run:** when pressed the screen will change to make ready position #8 test run position screen.

2) **?:** This will retrieve the help screen for the make ready #9 high folio lip signature setup list screen.

3) **Make Ready Home Screen:** When button is

pressed the screen will change to the make ready home screen.

4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.

5) **?:** This will retrieve the help screen for the make

ready #9 high folio lip signature setup list.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

6) **High Folio Lip Signature Setup List (7-9) Screen:**

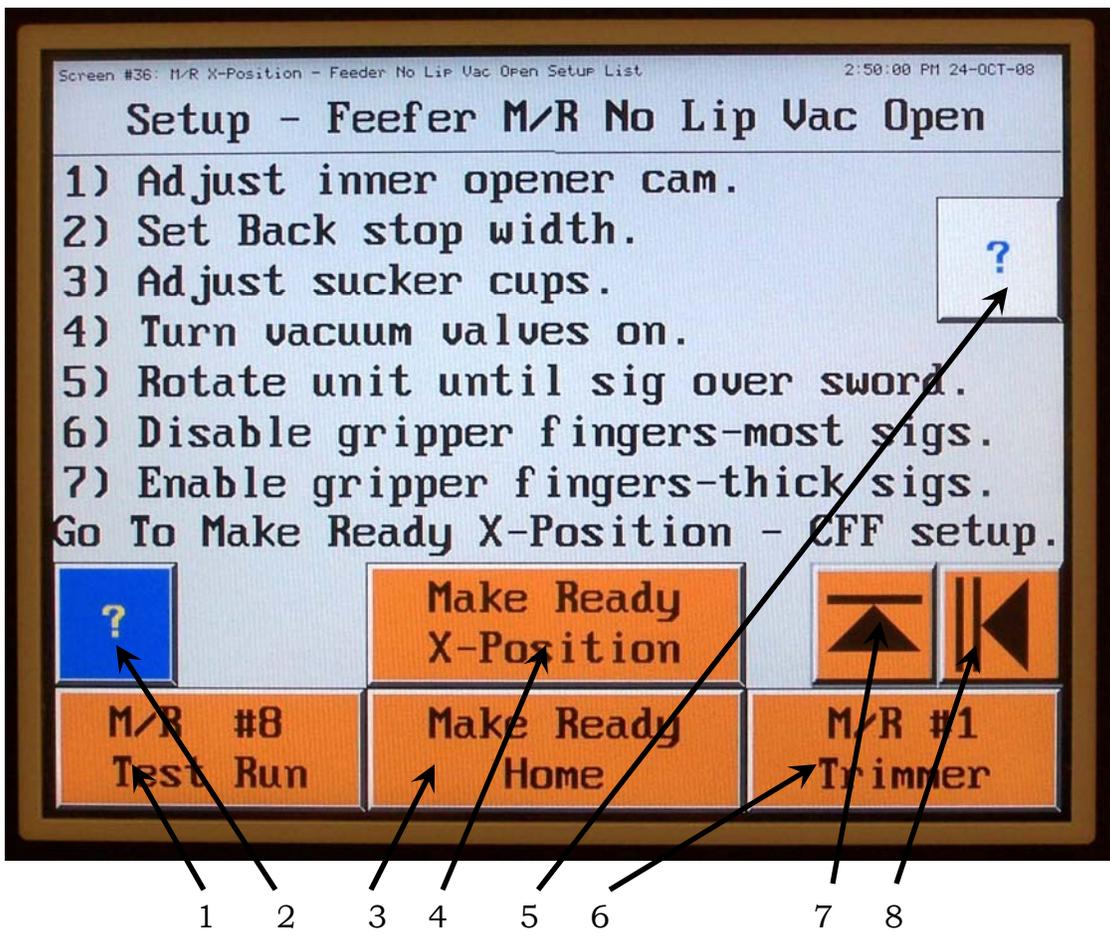
When button is pressed the screen will change to the high folio lip signature setup list (7-9) screen.

HELP - SCREEN 36 MAKE READY #9 SETUP

The "Make Ready #9 No Lip Vacuum Open Setup List" is the screen that displays the setup list for no lip vacuum open make ready position #9.

7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

8) **Production Screen Button:** this button will change the screen to the production screen.



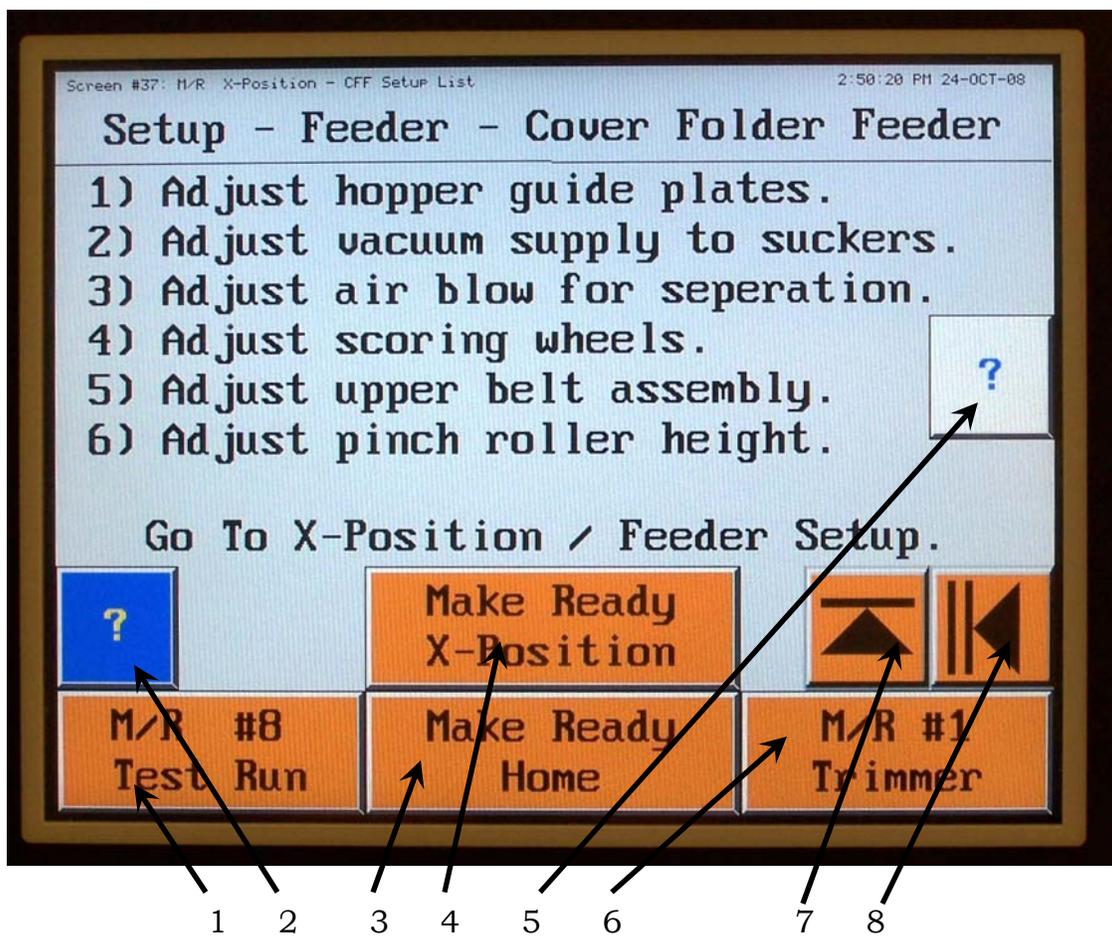
- 1) **Make Ready Position #8 Test Run:** when pressed the screen will change to make ready position #8 test run position screen.
- 2) **?:** This will retrieve the help screen for the make ready #9 no lip vacuum open setup list screen.
- 3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.
- 4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.
- 5) **?:** This will retrieve the help screen for the make ready #9 no lip vacuum open setup list.

- 6) **Make Ready Position #1 Trimmer:** when pressed the screen will change to make ready position #1 trimmer position screen.
- 7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP - SCREEN 37 MAKE READY #9 SETUP

The “Make Ready #9 Cover Folder Feeder Setup List” is the screen that displays the setup list for cover folder feeder make ready position #9.



1) **Make Ready Position #8 Test Run:** when pressed the screen will change to make ready position #8 test run position screen.

2) **?:** This will retrieve the help screen for the make ready #9 cover folder feeder setup list screen.

3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.

5) **?:** This will retrieve the help screen for the make ready #9 cover folder feeder setup list.

6) **Make Ready Position #1 Trimmer:** when pressed the screen will change to make ready position #1 trimmer position screen.

7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

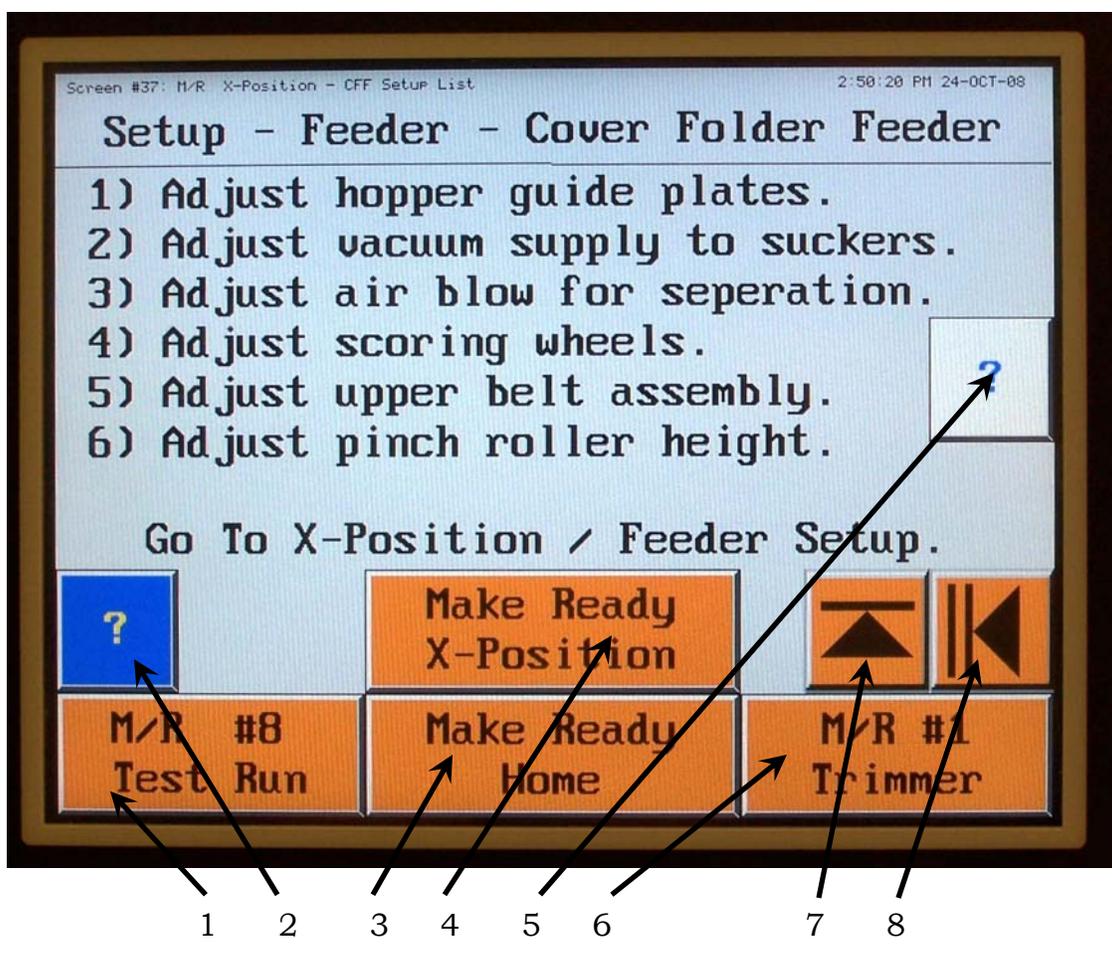
corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 38 MAKE READY #9 SETUP

8) **Production Screen Button:** this button will change the screen to the production screen.

The “Make Ready #9 Knife Removal Setup List” is the screen that displays the setup list for knife removal make ready position #9.

To close this file pick “File” “Close” in the upper left hand



1) **Make Ready Position #8 Test Run:** when pressed the screen will change to make ready position #8 test run position screen.

2) **?:** This will retrieve the help screen for the make ready #9 knife removal setup list screen.

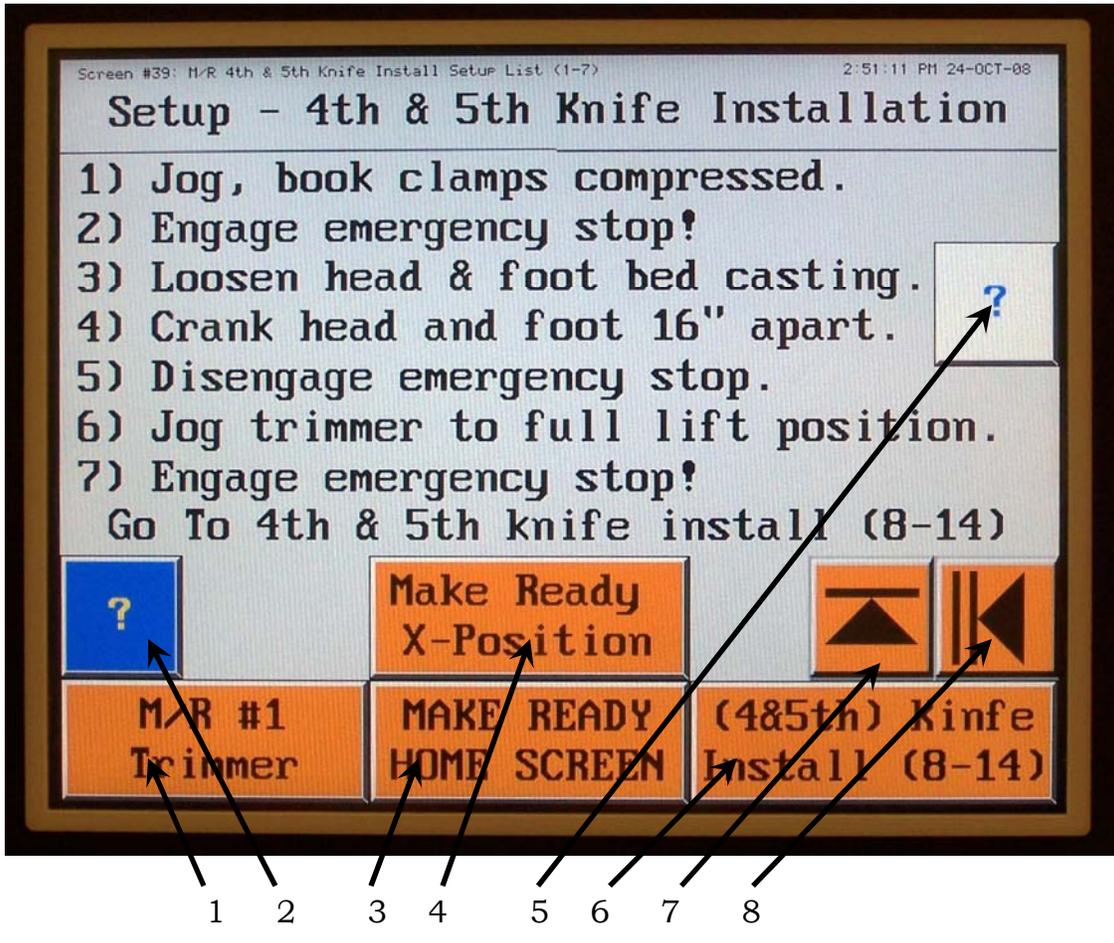
- 3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.
- 4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.
- 5) **?:** This will retrieve the help screen for the make ready #9 knife removal setup list.
- 6) **Make Ready Knife Installation:** when pressed the screen will change to make ready knife installation setup list screen.
- 7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

**HELP – SCREEN 39 MAKE READY
#9 SETUP**

The “Make Ready 4th & 5th Knife Installation Setup

List” is the screen that displays the setup list for 4th & 5th knife installation make ready.



- 1) **Make Ready Position #1 Trimmer:** when pressed the screen will change to make ready position #1 trimmer position screen.
- 2) **?:** This will retrieve the help screen for the make ready 4th & 5th knife installation setup list screen.
- 3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.
- 4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.

5) **?**: This will retrieve the help screen for the make ready 4th & 5th knife installation setup list.

6) **4th & 5th Knife Installation (8-14)**: when pressed the screen will change to make ready 4th & 5th knife installation setup (8-14) list screen.

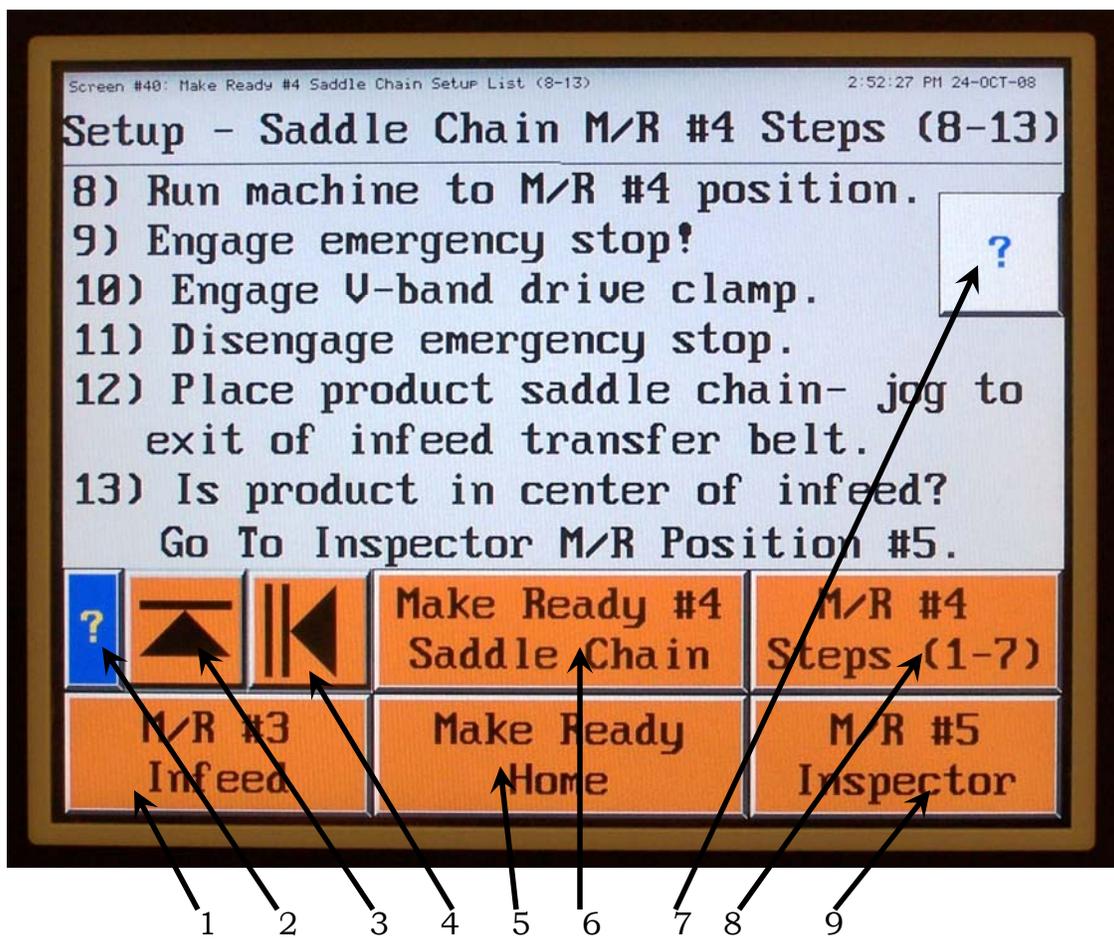
7) **Main Menu Button**: When pressing this button, screen will change to the main menu screen.

8) **Production Screen Button**: this button will change the screen to the production screen.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

HELP - SCREEN 40 MAKE READY #4 SETUP

The "Make Ready #4 Saddle Chain Setup List (8-13)" is the screen that displays the setup list (8-13) for saddle chain make ready position #4.



- 1) **Make Ready Position #3 Infeed:** when pressed the screen will change to make ready position #3 infeed screen.
- 2) **?:** This will retrieve the help screen for the make ready #2 saddle chain setup list (8-13) screen.
- 3) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 4) **Production Screen Button:** this button will change the screen to the production screen.
- 5) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.
- 6) **Make Ready Position #4 Saddle Chain:** when pressed the screen will change to make ready position #4 saddle chain screen.
- 7) **?:** This will retrieve the help screen for the make ready #4 saddle chain setup list.
- 8) **Make Ready #4 Saddle Chain Setup List (1-7):** When button is pressed the screen will change to the make ready #4 saddle chain setup list (1-7).

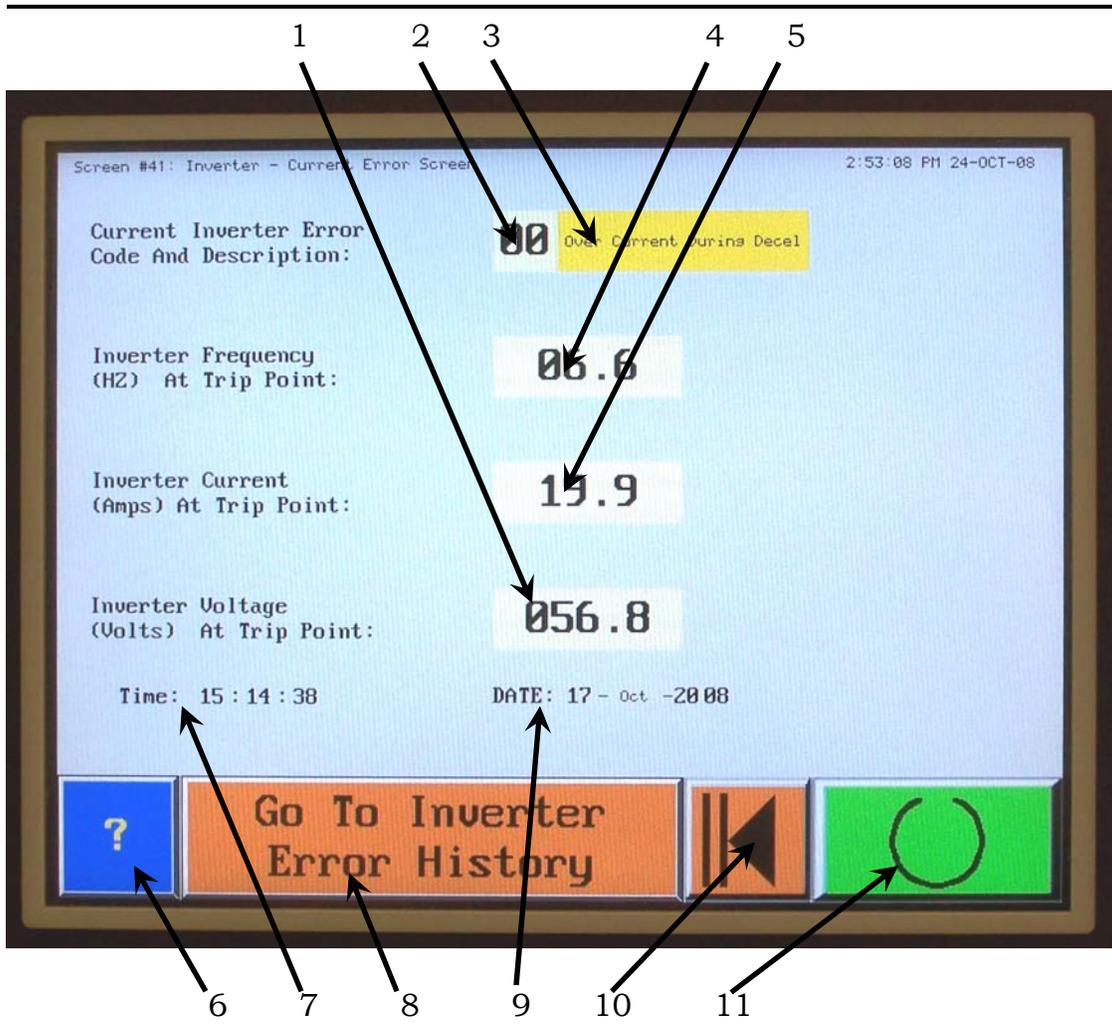
- 9) **Make Ready Position #5 Inspector:** when pressed the screen will change to make ready #5 inspector position screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

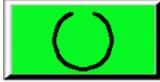
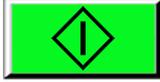
HELP – SCREEN 41 INVERTER- ERROR

The “Inverter- Current Error” is the screen that

displays the current or last inverter error information.



- 1) **Inverter Output Voltage:**
At error trip point. This information is retrieved from an inverter data register to be displayed here.
- 2) **Inverter Error Trip Code:**
This information is retrieved from an inverter data register to be displayed here.
- 3) **Inverter Error Trip Code Description:** This description information is based on the trip code.
- 4) **Inverter Output Frequency:** At error trip point. This information is retrieved from an inverter data register to be displayed here.

- 5) **Inverter Output Current:** At error trip point. This information is retrieved from an inverter data register to be displayed here.
- 6) **?:** This will retrieve the inverter error screen help.
- 7) Inverter error trip point time. This is based on a 24 hour clock (Hour – Minute – Second).
- 8) **Go To Inverter Error History:** when pressed the screen will change to the inverter history screen where past errors are displayed.
- 9) Inverter error trip point date (Day – Month – Year).
- 10) **Production Screen Button:** this button will change the screen to the production screen.
- 11) **Machine Start and Stop Button / Status Indicator:** When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:
- a)  Indicates that machine is ready for start, all guards and faults are reset.
- b)  Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.
- c)  Indicates that the machine is running. If operator presses button at this time, the machine will stop.
- d)  Indicates that jog motion is arming.
- e)  Indicates that jog motion is armed and jog motion will start with the next jog button press.
- f)  Indicates jog motion is active.
- g)  Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.
- h)  Indicates that an emergency stop button is activated.

 i) Indicates that a guard door is open.

 j) Indicates that a jam switch is activated.

 k) Indicates that a fault has taken place.

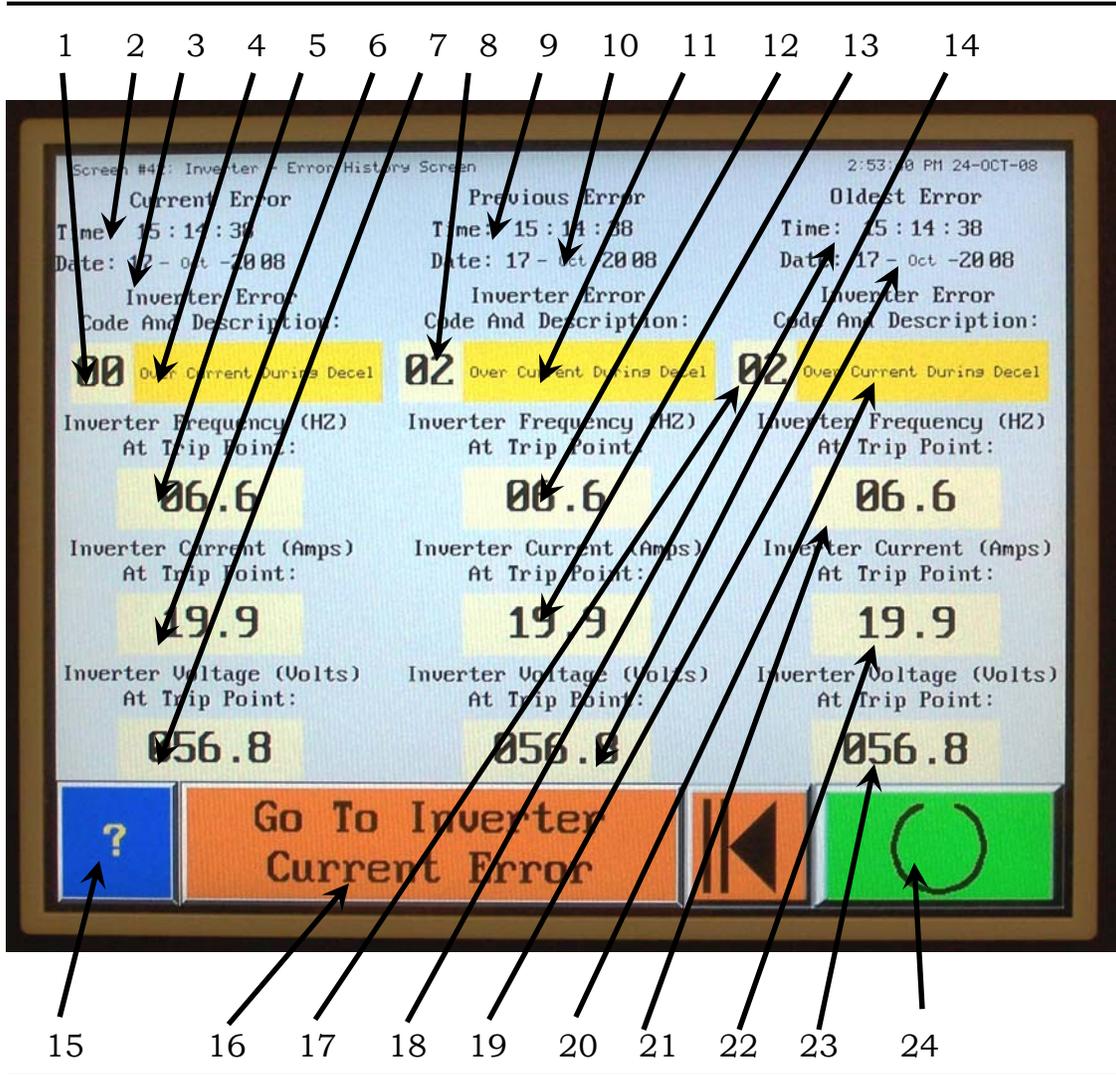
 l) Indicates that machine is in cycle position.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

**HELP – SCREEN 42 INVERTER-
ERROR**

The “Inverter- Error History” is the screen that

displays the current, previous and oldest inverter error information.



1) **Current Inverter Error Trip Code:** This information is retrieved from an inverter data register to be displayed here.

2) **Current inverter error trip point time:** This is

based on a 24 hour clock (Hour – Minute – Second).

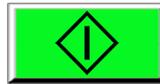
3) Current inverter error trip point date (Day – Month – Year).

4) **Current Inverter Error Trip Code Description:** This description

- information is based on the trip code.
- 5) **Current Inverter Output Frequency:** At error trip point. This information is retrieved from an inverter data register to be displayed here.
 - 6) **Current Inverter Output Current:** At error trip point. This information is retrieved from an inverter data register to be displayed here.
 - 7) **Current Inverter Output Voltage:** At error trip point. This information is retrieved from an inverter data register to be displayed here.
 - 8) **Previous Inverter Error Trip Code:** This information is retrieved from an inverter data register to be displayed here.
 - 9) **Previous inverter error trip point time:** This is based on a 24 hour clock (Hour – Minute – Second).
 - 10) Previous inverter error trip point date (Day – Month – Year).
 - 11) **Previous Inverter Error Trip Code Description:** This description information is based on the trip code.
 - 12) **Previous Inverter Output Frequency:** At error trip point. This information is retrieved from an inverter data register to be displayed here.
 - 13) **Previous Inverter Output Current:** At error trip point. This information is retrieved from an inverter data register to be displayed here.
 - 14) **Previous Inverter Output Voltage:** At error trip point. This information is retrieved from an inverter data register to be displayed here.
 - 15) **?:** This will retrieve the inverter error history screen help.
 - 16) **Go To Inverter Current Error:** when pressed the screen will change to the inverter current error screen.
 - 17) **Oldest Inverter Error Trip Code:** This information is retrieved from an inverter data register to be displayed here.
 - 18) **Oldest inverter error trip point time:** This is based on a 24 hour clock (Hour – Minute – Second).
 - 19) Oldest inverter error trip point date (Day – Month – Year).

20) **Oldest Inverter Error Trip Code Description:**

This description information is based on the trip code.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.

21) **Oldest Inverter Output Frequency:** At error trip point. This information is retrieved from an inverter data register to be displayed here.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.

22) **Oldest Inverter Output Current:** At error trip point. This information is retrieved from an inverter data register to be displayed here.

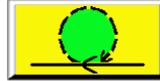


d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.

23) **Oldest Inverter Output Voltage:** At error trip point. This information is retrieved from an inverter data register to be displayed here.



f) Indicates jog motion is active.

24) **Machine Start and Stop Button / Status**

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



a) Indicates that machine is ready for start, all guards and faults are reset.

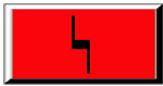


i) Indicates that a guard door is open.

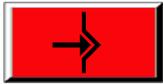


j) Indicates that a jam switch is activated.

corner, or pick the “X” in the upper right hand corner.



k) Indicates that a fault has taken place.

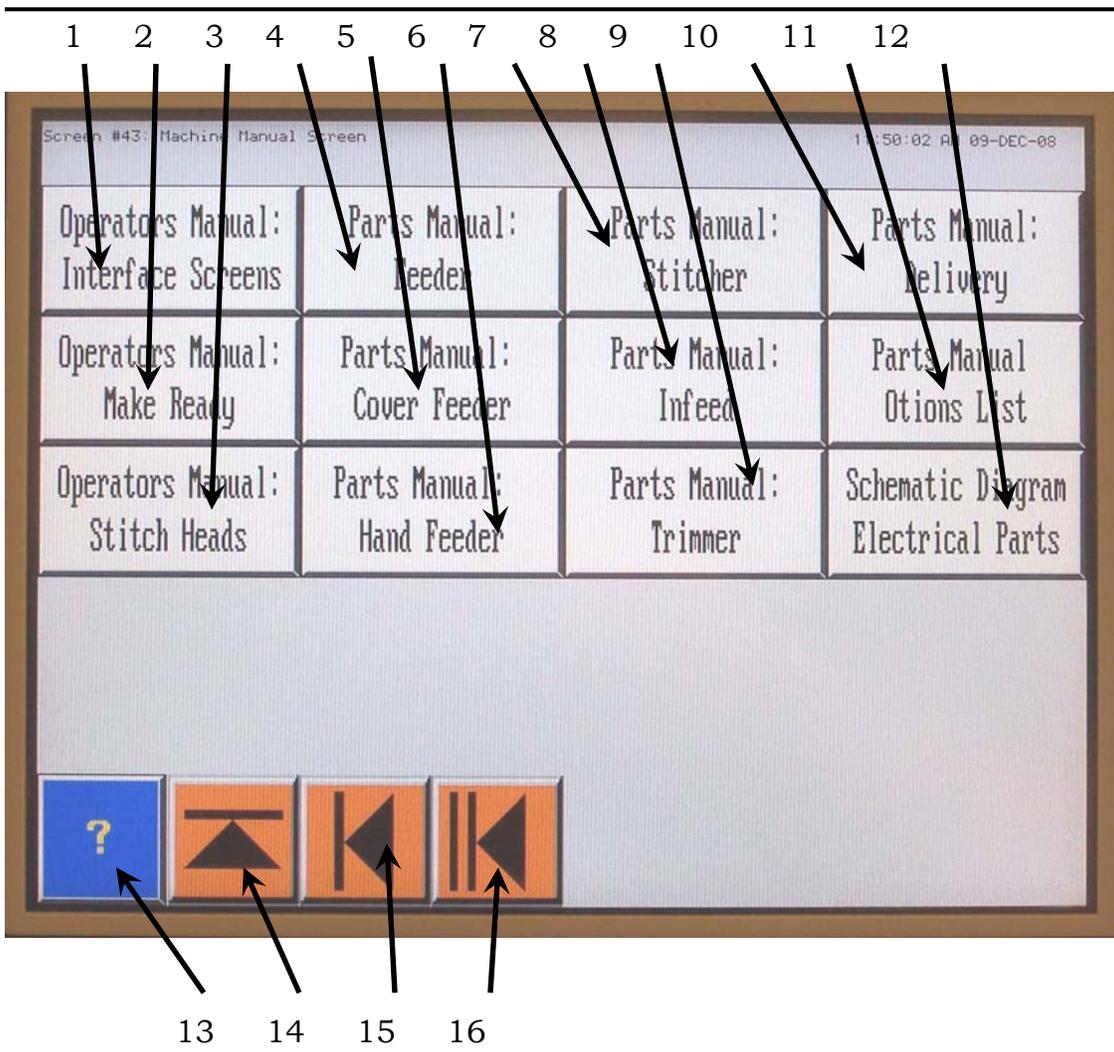


l) Indicates that machine is in cycle position.

HELP – SCREEN 43 MACHINE MANUAL

The “Machine Manual” is the screen that displays button access to all machine manuals.

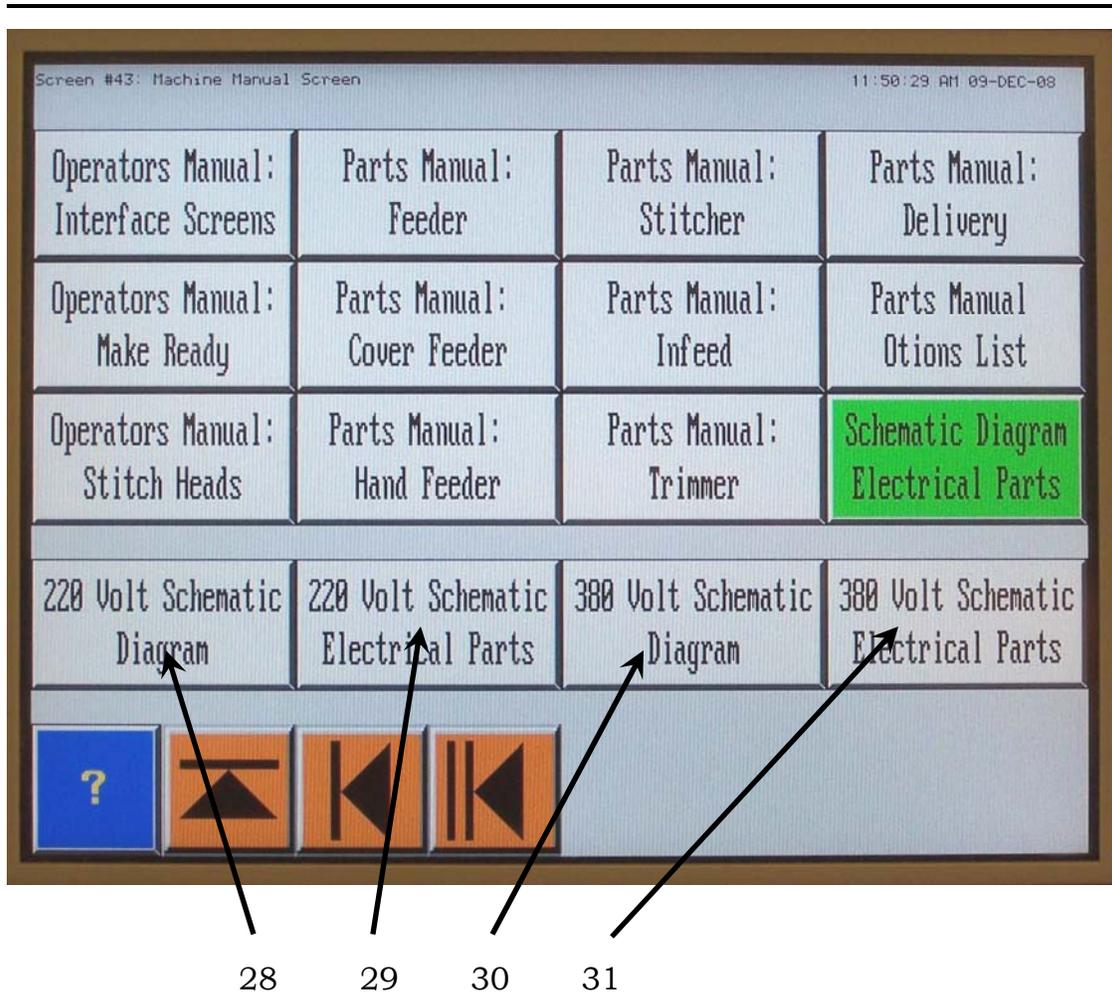
To close this file pick “File” “Close” in the upper left hand



1) **Operators Manual-Interface Screens:** When pressing this button, screen will change to the

operators manual – interface screens PDF file containing help screens for all interface screens.

- 2) **Operators Manual- Make Ready:** When pressing this button, screen will change to the operator's manual – make ready PDF file containing all make ready help screens.
- 3) **Operators Manual- Stitching Head:** When pressing this button, screen will change to the operator's manual – Stitching Head PDF file containing stitching head manual.
- 4) **Parts Manual- Feeder:** When pressing this button, screen will change to the parts manual – feeder PDF file containing assembly drawings and parts list for the feeder section.
- 5) **Parts Manual- Cover Feeder:** When pressing this button, screen will change to the parts manual – cover feeder PDF file containing assembly drawings and parts list for the cover feeder section.
- 6) **Parts Manual- Hand Feeder:** When pressing this button, screen will change to the parts manual – hand feeder PDF file containing assembly drawings and parts list for the hand feeder section.
- 7) **Parts Manual- Stitcher:** When pressing this button, screen will change to the parts manual – stitcher PDF file containing assembly drawings and parts list for the stitcher section.
- 8) **Parts Manual- Infeed:** When pressing this button, screen will change to the parts manual – infeed PDF file containing assembly drawings and parts list for the infeed section.
- 9) **Parts Manual- Trimmer:** When pressing this button, screen will change to the parts manual – trimmer PDF file containing assembly drawings and parts list for the infeed section.
- 10) **Parts Manual- Delivery:** When pressing this button, screen will change to the parts manual – delivery PDF file containing assembly drawings and parts list for the infeed section.
- 11) **Parts Manual- Option List:** When pressing this button, screen will change to add the machine option buttons. Then press any of the option buttons to bring up its manual.



13) **?**: This will retrieve the help screen either for the screen of a particular screen section that it is associated with.

14) **Main Menu Button**: When pressing this button, screen will change to the main menu screen.

15) **Previous Screen Button**: When pressed this button will change to the previous screen. A maximum of five screens are remembered.

16) **Production Screen Button**: this button will change the screen to the production screen.

17) **Parts Manual- Long and Skewed Book**: When pressing this button, screen will change to the parts manual – long and skewed book PDF file containing assembly drawings and parts list for the long and skewed book option.

18) **Parts Manual- Missing Stitch**: When pressing this button, screen will change

to the parts manual – missing stitch PDF file containing assembly drawings and parts list for the missing stitch option.

19) **Parts Manual- 4th and 5th Knife:** When pressing this button, screen will change to the parts manual – 4th and 5th knife PDF file containing assembly drawings and parts list for the 4th and 5th knife option.

20) **Parts Manual- Pump Add On:** When pressing this button, screen will change to the parts manual – pump add on PDF file containing assembly drawings and parts list for the pump add on option.

21) **Parts Manual- Rema Cable:** When pressing this button, screen will change to the parts manual – Rema cable PDF file containing assembly drawings and parts list for the Rema cable option.

22) **Parts Manual- Stahl Cable:** When pressing this button, screen will change to the parts manual – stahl cable PDF file containing assembly drawings and parts list for the stahl cable option.

23) **Parts Manual- Rema - Stahl Cable:** When pressing this button, screen will change to the

parts manual – Rema - stahl cable PDF file containing assembly drawings and parts list for the Rema - stahl cable option.

24) **Parts Manual- Hopper Feed Attachment:** When pressing this button, screen will change to the parts manual – hopper feed attachment PDF file containing assembly drawings and parts list for the hopper feed attachment option.

25) **Parts Manual- Small Book:** When pressing this button, screen will change to the parts manual – small book PDF file containing assembly drawings and parts list for the small book option.

26) **Parts Manual- Hopper Card Attachment:** When pressing this button, screen will change to the parts manual – hopper card attachment PDF file containing assembly drawings and parts list for the hopper card attachment option.

27) **Parts Manual- Pocket Side Stripper:** When pressing this button, screen will change to the parts manual – pocket side stripper PDF file containing assembly drawings and parts list for

the pocket side stripper option.

28) **220 Volt Schematic**

Diagram: When pressing this button, screen will change to the 220 volt schematic diagram PDF file containing the 220 volt schematic diagram.

29) **220 Volt Schematic**

Electrical Parts: When pressing this button, screen will change to the 220 volt schematic diagram PDF file containing the 220 volt schematic electrical parts list.

30) **380 Volt Schematic**

Diagram: When pressing this button, screen will change to the 380 volt schematic diagram PDF file containing the 380 volt schematic diagram.

31) **380 Volt Schematic**

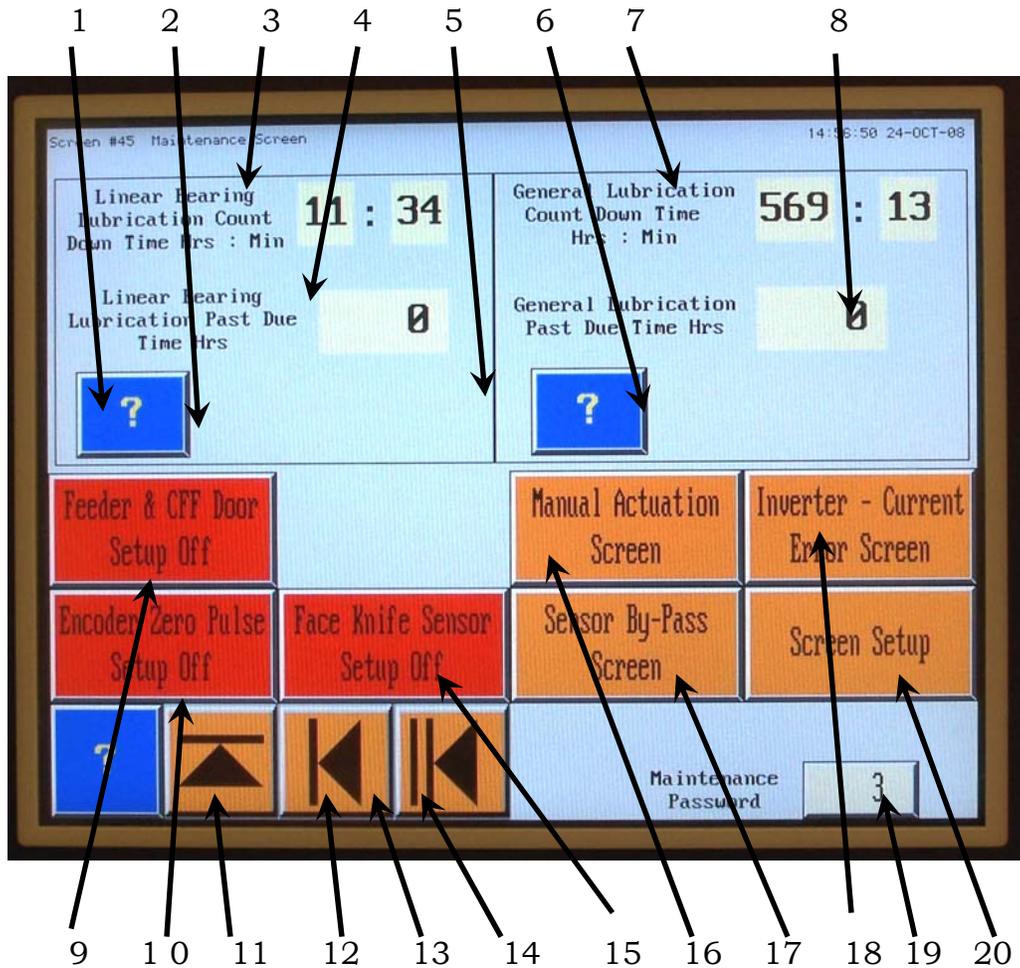
Electrical Parts: When pressing this button, screen will change to the 380 volt schematic diagram PDF file containing the 380 volt schematic electrical parts list.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP - SCREEN 45
MAINTENANCE

The "Maintenance" is the screen that displays

maintenance lube timing and functionalities.



- 1) **?**: This will retrieve the help screen for the linear bearing lubrication.
- 2) **Maintenance Performed Button**: This button will appear when the linear bearing lubrication count down timer counts down to zero. When the button is pressed the past due timer will stop timing and the linear bearing lubrication count down timer will reset.
- 3) **Linear bearing lubrication count down timer**: (in hours and minutes) This Counts down from 20 hours of machine running.
- 4) **Linear Bearing**

- Lubrication Past Due:**
Displays the amount of hours the linear bearing lubrication is past due. Time is based on the count down timer reaching zero, this starts the past due timer until the maintenance performed button is pressed.
- 5) **?:** This will retrieve the help screen for the general lubrication.
 - 6) **Maintenance Performed Button:** This button will appear when the general lubrication count down timer counts down to zero. When the button is pressed the past due timer will stop timing and the general lubrication count down timer will reset.
 - 7) **General lubrication count down timer:** in hours and minutes. Counts down from 600 hours of machine running.
 - 8) **General Lubrication Past Due:** Displays the amount of hours the general lubrication is past due. Time is based on the count down timer reaching zero, this starts the past due timer until the maintenance performed button is pressed.
 - 9) **Feeder and CFF Setup Button:** When this button is pressed the feeder and CFF setup mode is on. At this time the feeder and CFF reset output from the PLC will stay high until it is turned off or when the operator leaves this screen.
 - 10) **Encoder Zero Pulse Setup Button:** When this button is pressed the encoder zero pulse setup mode is on. At this time the encoder zero point can be set by putting the machine at zero degree position. Adjust encoder until the alarm sounds. Encoder positioning is now set. Press button again to turn mode off or leave maintenance screen.
 - 11) **?:** This will retrieve the help screen for the maintenance screen.
 - 12) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
 - 13) **Previous Screen Button:** When pressed this button will change to the previous screen. A maximum of five screens are remembered.
 - 14) **Production Screen Button:** this button will change the screen to the production screen.
 - 15) **Face Knife Sensor Setup Button:** When this button is pressed the face knife setup mode is on. At this time the face knife sensor

can be set by putting the machine at 260 degree position. Adjust face knife sensor until the alarm stop sounding. Face knife positioning is now set. Press button again to turn mode off or leave maintenance screen.

16) **Manual Actuation Screen**

Button: When button is pressed the screen will change to the manual actuation screen.

17) **Sensor By-Pass Screen**

Button: When button is pressed the screen will change to the sensor by-pass screen.

18) **Inverter Current Error Screen Button:**

When button is pressed the screen will change to the inverter current error screen.

19) **Maintenance Password:**

This input displays and can change the maintenance password.

20) **Screen Setup Screen**

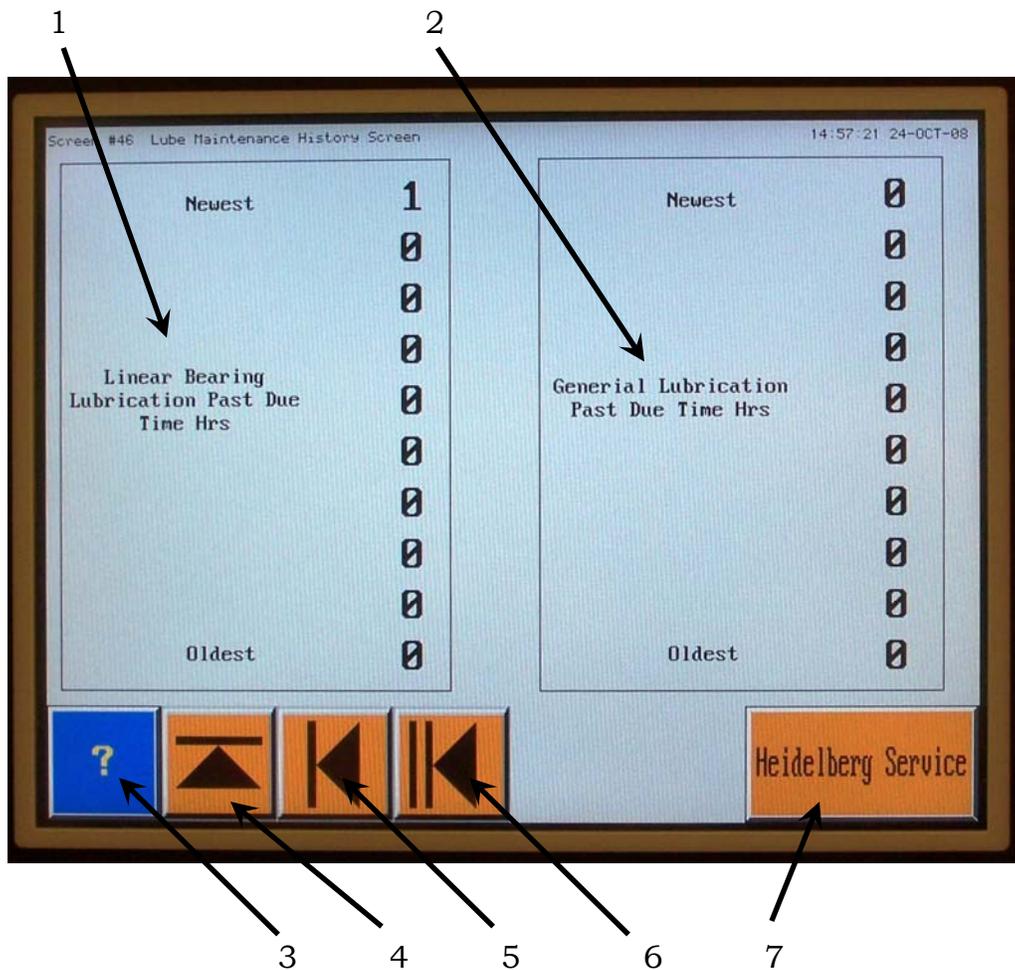
Button: When button is pressed the screen will change to the screen setup screen.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

HELP – SCREEN 46 LUBE MAINTENANCE HISTORY

The “Lube Maintenance History” is the screen that displays lube maintenance history for the linear bearing

and general lubrication past due hours.



- 1) **Linear Bearing Past Due Time Hours:** When the linear bearing lubrication timer times out a second timer is initiated to record the amount of hours between the lubrication notification

and the acknowledgment is recorded. The last 10 lube maintenance from the newest to the oldest past due hours are recorded.

- 2) **General Lubrication Past Due Time Hours:** When the

general lubrication timer times out a second timer is initiated to record the amount of hours between the lubrication notification and the acknowledgment is recorded. The last 10 lube maintenance from the newest to the oldest past due hours are recorded.

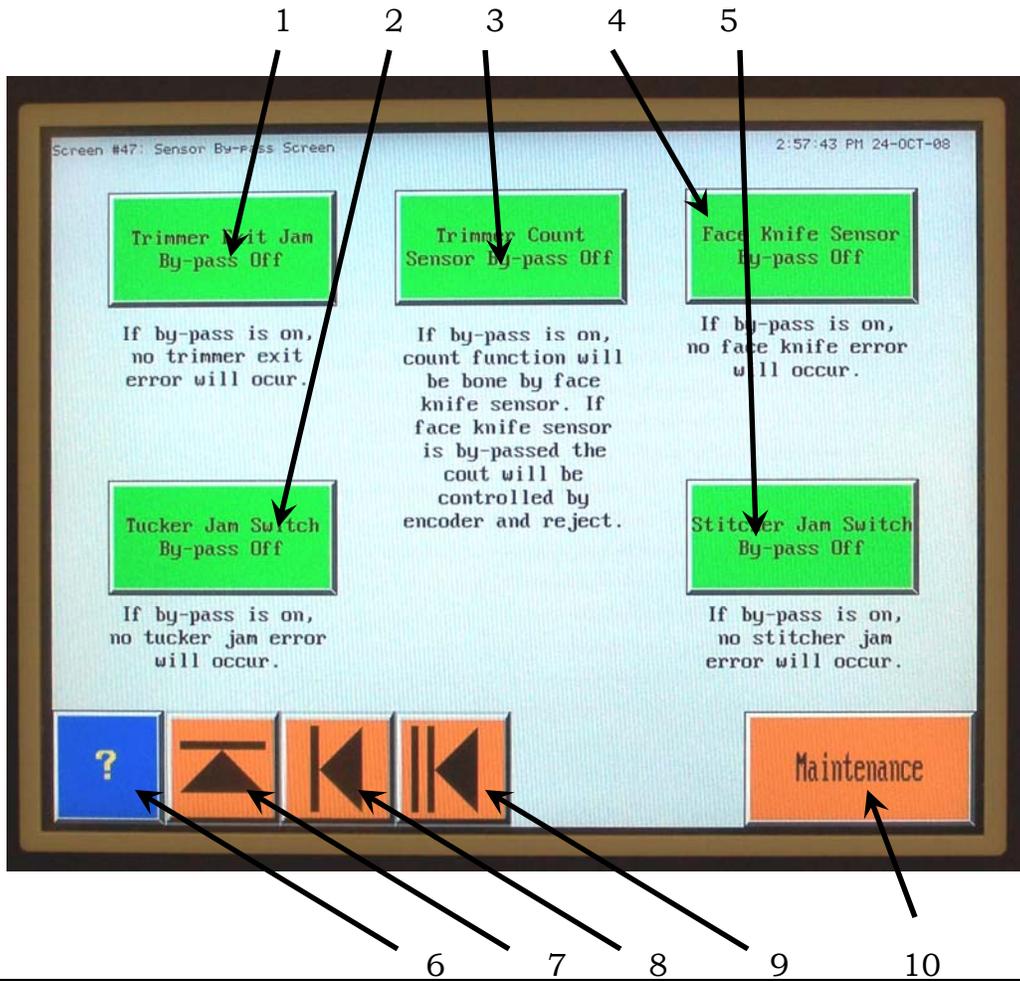
- 3) **?**: This will retrieve the help screen either for the screen of a particular screen section that it is associated with.
- 4) **Main Menu Button**: When pressing this button, screen will change to the main menu screen.
- 5) **Previous Screen Button**: When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 6) **Production Screen Button**: this button will change the screen to the production screen.
- 7) **Heidelberg Service Button**: This button will change the screen to the Heidelberg Service screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 47 SENSOR BY-PASS

The “Sensor By-Pass” is the screen that displays the

sensors that can be by-passed and their ramifications if they are by-passed.



- 1) **Trimmer Exit Jam By-Pass:** When the trimmer exit jam by-pass button is on, the trimmer exit jam sensor will not work and jams will not be detected until jam switch is replaced and this button is turned off.
- 2) **Tucker Jam By-Pass:** When the tucker jam by-pass button is on, the tucker jam sensor will not work and jams will not be detected until jam switch is replaced and this button is turned off.
- 3) **Trimmer Count Sensor By-Pass:** When the trimmer count sensor by-pass button is on, the

trimmer count is replaced by a logic count controlled by the encoder and the reject control.

- 4) **Face Knife Jam By-Pass:**
When the face knife jam by-pass button is on, the face knife sensor will not work and jams will not be detected until face knife sensor is replaced and this button is turned off.

- 5) **Stitcher Jam By-Pass:**
When the stitcher jam by-pass button is on, the stitcher jam sensor will not work and jams will not be detected until jam switch is replaced and this button is turned off.

- 6) **?:** This will retrieve the help screen for the sensor by-pass.

- 7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

- 8) **Previous Screen Button:**
When pressed this button will change to the previous screen. A maximum of five screens are remembered.

- 9) **Production Screen Button:** this button will change the screen to the production screen.

- 10) **Maintenance:** This button will change the screen to

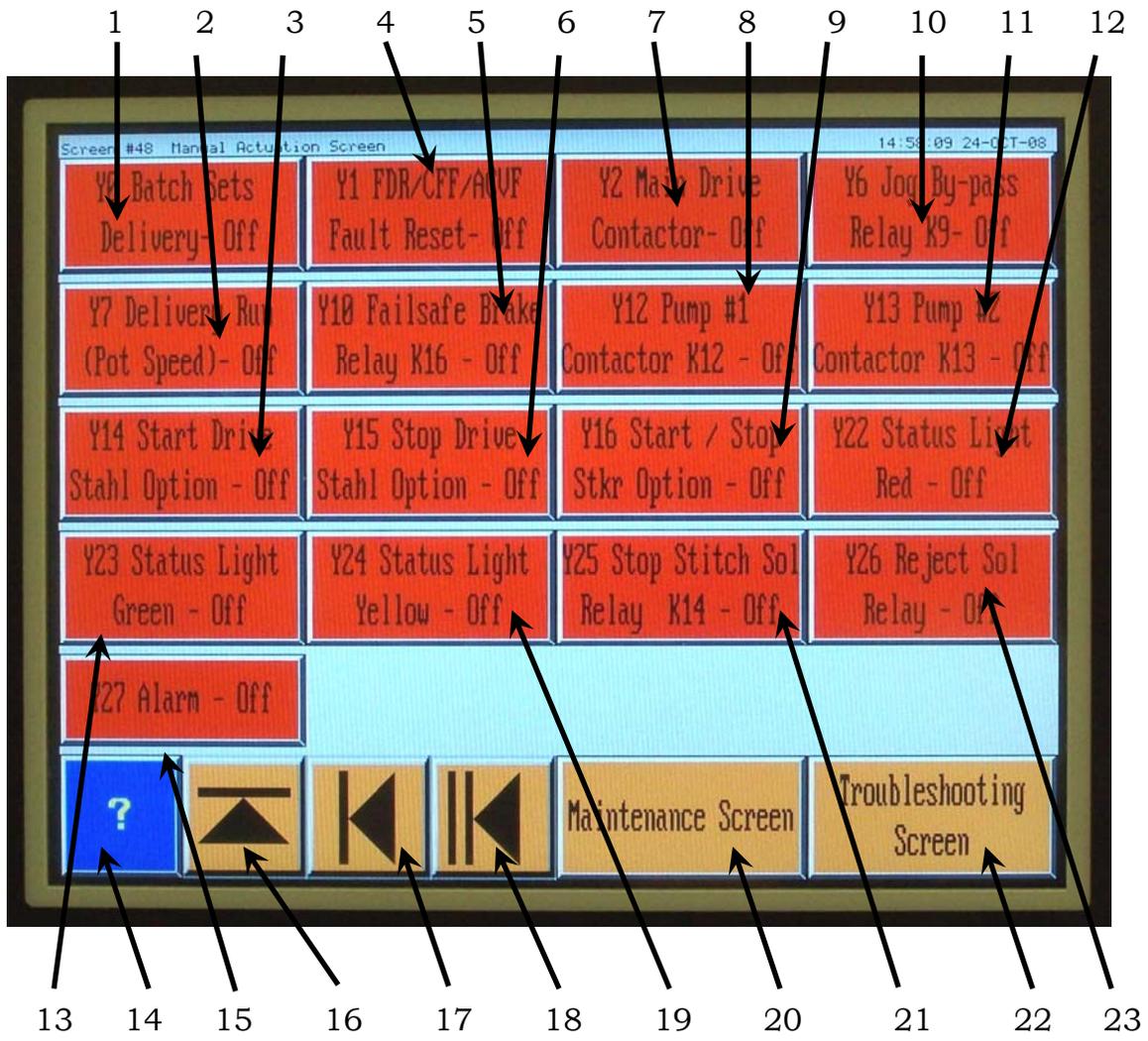
the maintenance screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 48 MANUAL ACTUATION

The “Manual Actuation” is the screen that allows manual actuation of the PLC

outputs for troubleshooting the output control circuits.



- 1) **Y0 Batch Sets - Delivery:**
When button is pressed, PLC output Y0 will turn on, delivery will run at full speed.
- 2) **Y7 Delivery Run:** When button is pressed, PLC

output Y7 will turn on, delivery will run at potentiometer speed setting.

- 3) **Y14 Drive Start – Stahl Option:** When button is pressed, PLC output Y14 will turn on.

- 4) **Y1 Feeder & CFF Reset:**
When button is pressed, PLC output Y1 will turn on.
- 5) **Y10 Fail Safe Brake:**
When button is pressed, PLC output Y10 will turn on. Note: trimmer and infeed guard doors must be closed for output Y10 to turn on.
- 6) **Y15 Drive Stop - Stahl Option:** When button is pressed, PLC output Y15 will turn on.
- 7) **Y2 Main Drive Contactor:**
When button is pressed, PLC output Y2 will turn on. Contactor K11 will turn on.
- 8) **Y12 Pump #1:** When button is pressed, PLC output Y12 will turn on. Contactor K12 will turn on, pump #1 will turn on.
- 9) **Y16 Start / Stop Stacker Option:** When button is pressed, PLC output Y16 will turn on.
- 10) **Y6 Jog By-Pass Relay:**
When button is pressed, PLC output Y6 will turn on. Relay K9 relay will turn on.
- 11) **Y13 Pump #2:** When button is pressed, PLC output Y13 will turn on. Contactor K13 will turn on, pump #2 will turn on.
- 12) **Y22 Status Light - Red:**
When button is pressed, PLC output Y22 will turn on. Status light will light red.
- 13) **Y23 Status Light - Green:**
When button is pressed, PLC output Y23 will turn on. Status light will light green.
- 14) **Y27 Alarm:** When button is pressed, PLC output Y27 will turn on. Auditable alarm will sound.
- 15) **?:** This will retrieve the help screen for the manual actuation screen.
- 16) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 17) **Previous Screen Button:**
When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 18) **Production Screen Button:** this button will change the screen to the production screen.
- 19) **Y24 Status Light - Yellow:** When button is pressed, PLC output Y24 will turn on. Status light will light yellow.
- 20) **Maintenance Screen:**
When this button is pressed the screen will

change to the maintenance screen.

21) **Y25 Stop Stitch**

Solenoid: When button is pressed, PLC output Y25 will turn on. Relay K14 will turn on, stop stitch solenoid will activate.

22) **Troubleshooting Screen:**

When this button is pressed the screen will change to the troubleshooting screen.

23) **Y26 Reject Solenoid:**

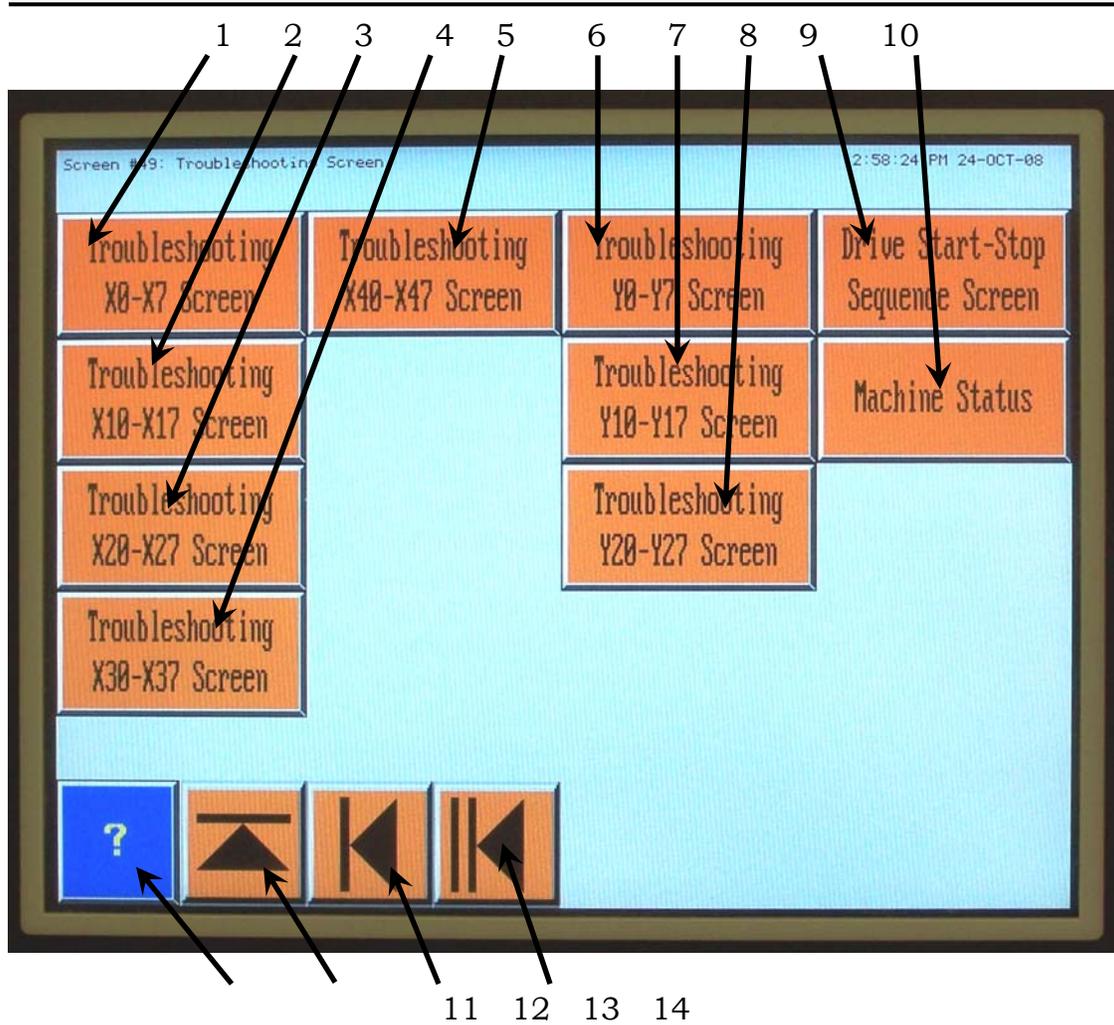
When button is pressed, PLC output Y26 will turn on. Relay K15 will turn on, reject solenoid will activate.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 49 **TROUBLESHOOTING**

The “Troubleshooting Main Menu” is the screen that displays go to screen buttons

that allows access to all the PLC I/O status and information.



24) **Troubleshooting X0 – X7**

Screen Button: When pressed the screen will change to the troubleshooting PLC inputs X0 – X7 screen.

25) **Troubleshooting X10 – X17**

Screen Button: When pressed the screen will change to the troubleshooting PLC inputs X10 – X17 screen.

- 26) **Troubleshooting X20 – X27 Screen Button:**
When pressed the screen will change to the troubleshooting PLC inputs X20 – X27 screen.
- 27) **Troubleshooting X30 – X37 Screen Button:**
When pressed the screen will change to the troubleshooting PLC inputs X30 – X37 screen.
- 28) **Troubleshooting X40 – X47 Screen Button:**
When pressed the screen will change to the troubleshooting PLC inputs X40 – X47 screen.
- 29) **Troubleshooting Y0 – Y7 Screen Button:** When pressed the screen will change to the troubleshooting PLC outputs Y0 – Y7 screen.
- 30) **Troubleshooting Y10 – Y17 Screen Button:** When pressed the screen will change to the troubleshooting PLC outputs Y10 – Y17 screen.
- 31) **Troubleshooting Y20 – Y27 Screen Button:** When pressed the screen will change to the troubleshooting PLC outputs Y20 – Y27 screen.
- 32) **Troubleshooting Drive Start / Stop Screen**

Button: When pressed the screen will change to the troubleshooting drive start / stop screen.

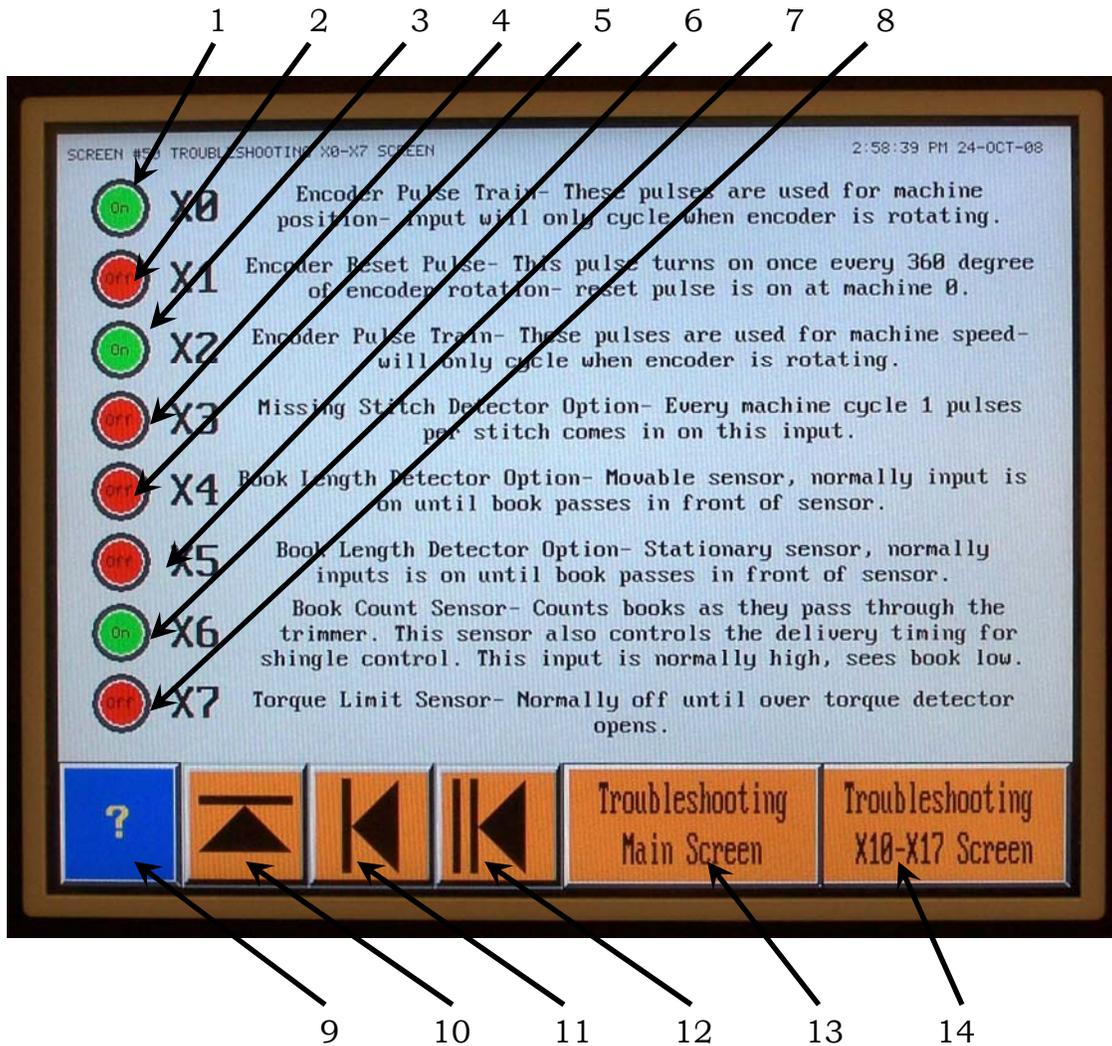
- 33) **Machine Status Screen:**
When the button is pressed the screen will change to the machine status screen. In this screen all machine drive inhibit faults will be shown at the same time.
- 34) **?:** This will retrieve the troubleshooting help screen.
- 35) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 36) **Previous Screen Button:**
When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 37) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 50 T-SHOOTING
X0-X7

The “Troubleshooting X0-X7” is the screen that

displays PLC input status of inputs X0 through X7.



1) **X0 Encoder Pulse Train:**
 These pulses are used for machine position- input will only cycle when encoder is rotating. Pulse input range is from 0 to 1.25 KHZ.

2) **X1 Encoder Reset Pulse:**
 This pulse turns on once every 360 degree of encoder rotation- reset pulse is on at machine 0. Pulse input range is from 0 to 4.5 HZ.

- 3) **X2 Encoder Pulse Train:**
These pulses are used for machine speed- will only cycle when encoder is rotating. Pulse input range is from 0 to 1.25 KHZ.
- 4) **X3 Missing Stitch Detector**
Option: Every machine cycle 1 pulse per stitch comes in on this input. Pulse input range is from 0 to 180 HZ.
- 5) **X4 Book Length Detector**
Option: Movable sensor, normally input is on until book passes in front of sensor.
- 6) **X5 Book Length Detector**
Option: Stationary sensor, normally inputs is on until book passes in front of sensor.
- 7) **X6 Book Count Sensor:**
Counts books as they pass through the trimmer. This sensor also controls the delivery timing for shingle control. This input is normally high, sees book low.
- 8) **X7 Torque Limit Sensor:**
Normally off until over torque detector opens.
- 9) **?:**This will retrieve the help screen for the troubleshooting X0 – X7 screen.
- 10) **Main Menu Button:** When pressing this button, screen

will change to the main menu screen.

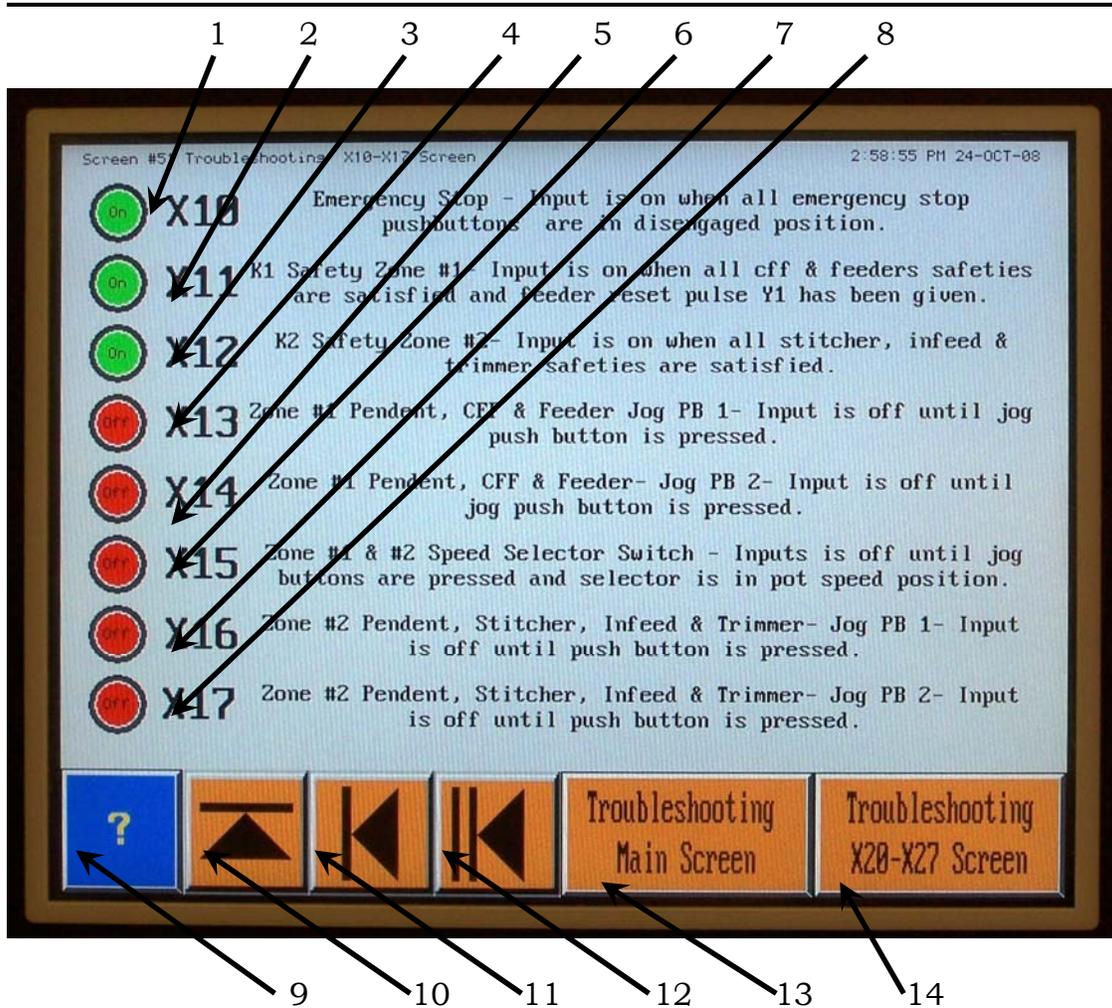
- 11) **Previous Screen Button:**
When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 12) **Production Screen Button:**
this button will change the screen to the production screen.
- 13) **Troubleshooting Main Screen:** when pressed the screen will change to troubleshooting main screen.
- 14) **Troubleshooting X10 – X17 Screen:** when pressed the screen will change to troubleshooting X10 – X17 screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 51 T-SHOOTING
X10-X17

The “Troubleshooting X10-X17” is the screen that

displays PLC input status of inputs X10 through X17.



- 1) **X10 Emergency Stop** -
 Input is on when all emergency stop pushbuttons are in disengaged position. Input is off when any of the emergency stop buttons are pressed.

- 2) **X11 K1 Safety Zone #1**- Input is on when all cff & feeders safeties are

satisfied and feeder reset pulse Y1 has been given. Input is off if any of the cff (K22) or feeder (K24) door relays are not energized. Look at feeder lights, any lights that are on – there is a safety fault in that feeder section. If further troubleshooting is needed turn on feeder

- door reset switch in the maintenance screen. This will keep his will keep Y1 on so that each door can be easily checked.
- 3) **X12 K2 Safety Zone #2-** Input is on when all stitcher, infeed & trimmer safeties are satisfied. Input is off if any of zone #2 safety switches S16, S17, S18, or S19 are open. All these switches are normally open held closed switches.
 - 4) **X13 Zone #1 Pendent, CFF & Feeder Jog PB 1-** Input is off until jog push button is pressed and relay K3 is energized then K3 normally open contact closes and X13 goes high.
 - 5) **X14 Zone #1 Pendent, CFF & Feeder- Jog PB 2-** Input is off until jog push button is pressed and relay K4 is energized then K4 normally open contact closes and X14 goes high.
 - 6) **X15 Zone #1 & #2 Speed Selector Switch-** Inputs is off until jog buttons are pressed and selector is in pot speed position.
 - 7) **X16 Zone #2 Pendent, Stitcher, Infeed & Trimmer- Jog PB 1-** Input is off until push button is pressed and relay K5 is energized then K5 normally open contact closes and X16 goes high.
 - 8) **X17 Zone #2 Pendent, Stitcher, Infeed & Trimmer- Jog PB 2-** Input is off until push button is pressed and relay K6 is energized then K6 normally open contact closes and X17 goes high.
 - 9) **?:** This will retrieve the help screen for the troubleshooting X10 – X17 screen.
 - 10) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
 - 11) **Previous Screen Button:** When pressed this button will change to the previous screen. A maximum of five screens are remembered.
 - 12) **Production Screen Button:** this button will change the screen to the production screen.
 - 13) **Troubleshooting Main Screen:** when pressed the screen will change

to troubleshooting main screen.

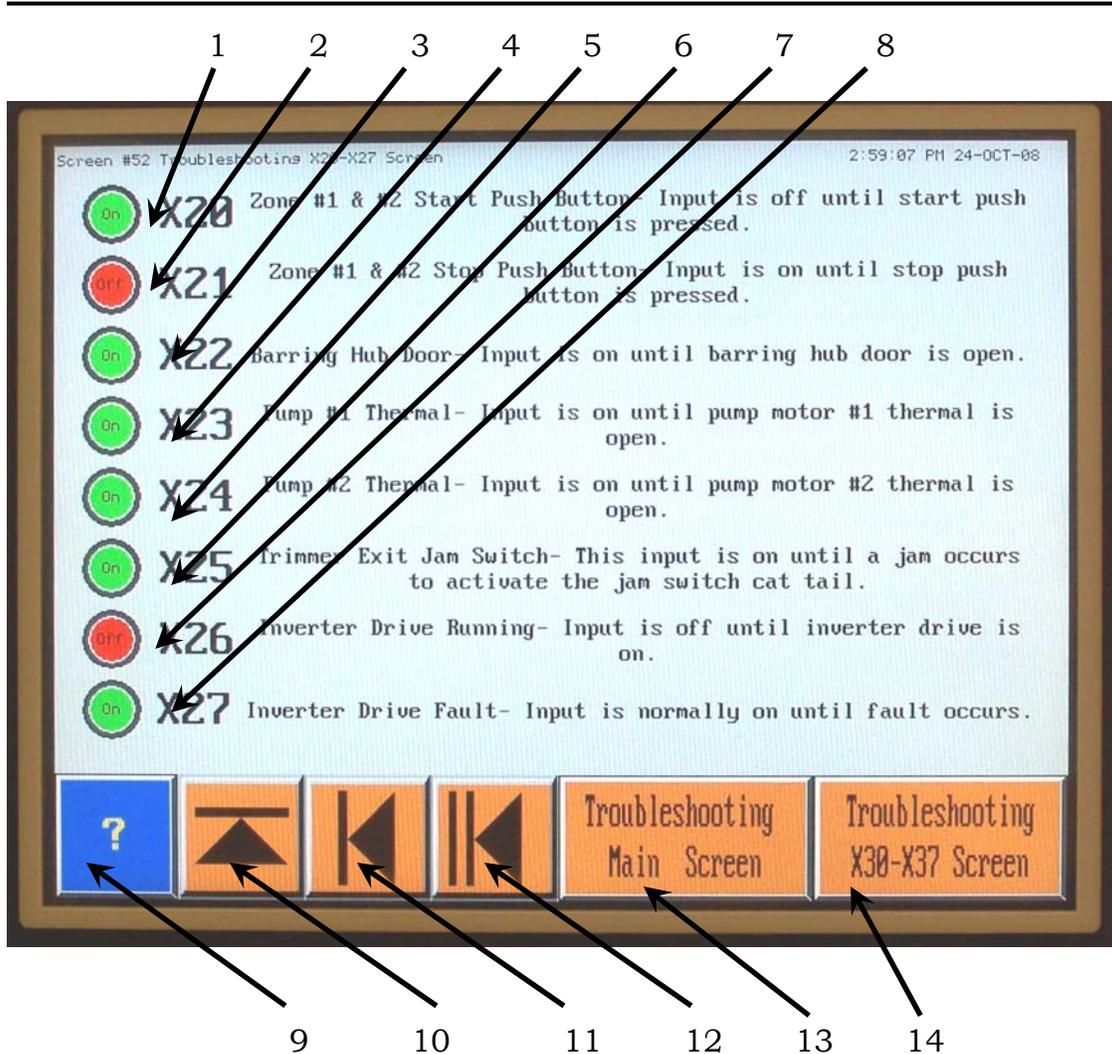
- 14) **Troubleshooting X20 – X27 Screen:** when pressed the screen will change to troubleshooting X20 – X27 screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 52 T-SHOOTING
X20-X27

The “Troubleshooting X20-X27” is the screen that

displays PLC input status of inputs X20 through X27.



- 1) **X20 Zone #1 & #2 Stop Push Button-** Input is on until stop push button is pressed.
- 2) **X21 Zone #1 & #2 Start Push Button-** Input is off until start push button is pressed.
- 3) **X22 Barring Hub Door-** Input is on until barring hub door is open. This input is also off when any of the e-stops are pressed.
- 4) **X23 Pump #1 Thermal-** Input is on until pump motor #1 thermal is open.

- 5) **X24 Pump #2 Thermal-**
Input is on until pump motor #2 thermal is open.
- 6) **X25 Trimmer Exit Jam Switch-** This input is on until a jam occurs to activate the jam switch cat tail.
- 7) **X26 Inverter Drive Running-** Input is off until inverter drive is on.
- 8) **X27 Inverter Drive Fault-** Input is normally on until fault occurs.
- 9) **?:** This will retrieve the help screen for the troubleshooting X20 – X27 screen.
- 10) **Main Menu Button:**
When pressing this button, screen will change to the main menu screen.
- 11) **Previous Screen Button:** When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 12) **Production Screen Button:** this button will change the screen to the production screen.
- 13) **Troubleshooting Main Screen:** when pressed the screen will change to troubleshooting main

screen.

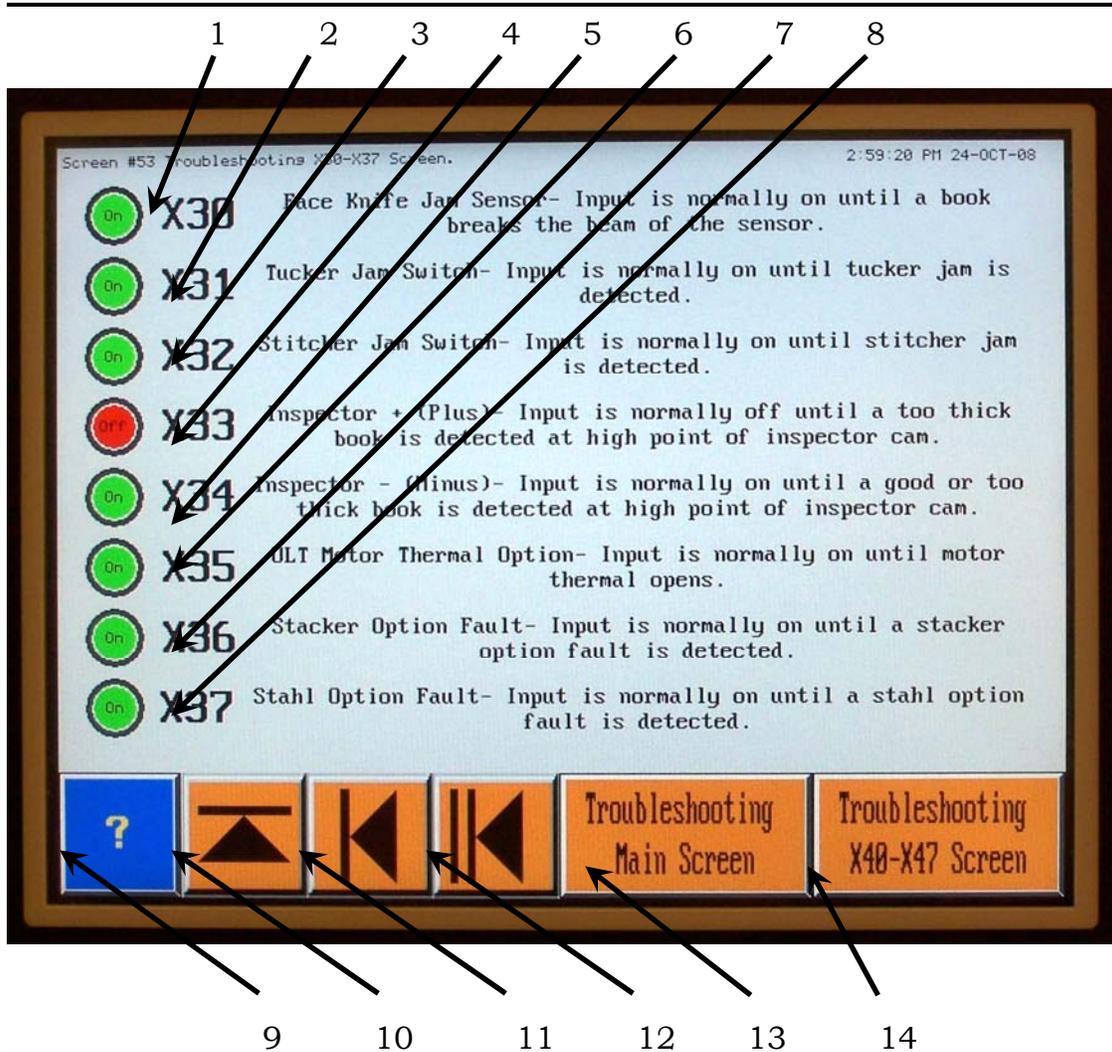
- 14) **Troubleshooting X30 – X37 Screen:** when pressed the screen will change to troubleshooting X30 – X37 screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 53 T-SHOOTING
X30-X37

The “Troubleshooting X30-X37” is the screen that

displays PLC input status of inputs X30 through X37.



- 1) **X30 Face Knife Jam Sensor-** Input is normally on until a book breaks the beam of the sensor. Jam occurs when the beam is broken between 260 to 285 degrees machine position. If face knife jam occurs during run with no books going through.

Sensor position must be adjusted away from knife until jamming stops.

- 2) **X31 Tucker Jam Switch-** Input is normally on until tucker jam is detected.
- 3) **X32 Stitcher Jam Switch-** Input is

normally on until
stitcher jam is detected.

- 4) **X33 Inspector + (Plus)-**
Input is normally off
until a too thick book is
detected at high point of
inspector cam.
- 5) **X34 Inspector -
(Minus)-** Input is
normally on until a good
or too thick book is
detected at high point of
inspector cam.
- 6) **X35 ULT Motor
Thermal Option-** Input
is normally on until
motor thermal opens. If
error occurs and the ULT
option is not installed,
check blind plug X33 at
infeed. If error occurs
with option installed but
motor is not connected to
the system check blind
plug x6 at the trimmer
exit.
- 7) **X36 Stacker Option
Fault-** Input is normally
on until a stacker option
fault is detected. If error
occurs and the option is
not installed, check blind
plug X35 at the infeed. Is
option is installed but
not connected, check
blind plug X3 at trimmer
exit.
- 8) **X37 Stahl Option Fault-**
Input is normally on
until a STAHL option
fault is detected. If error

occurs and the option is
not installed, check blind
plug X36 at the infeed. Is
option is installed but
not connected, check
blind plug X2 at trimmer
exit.

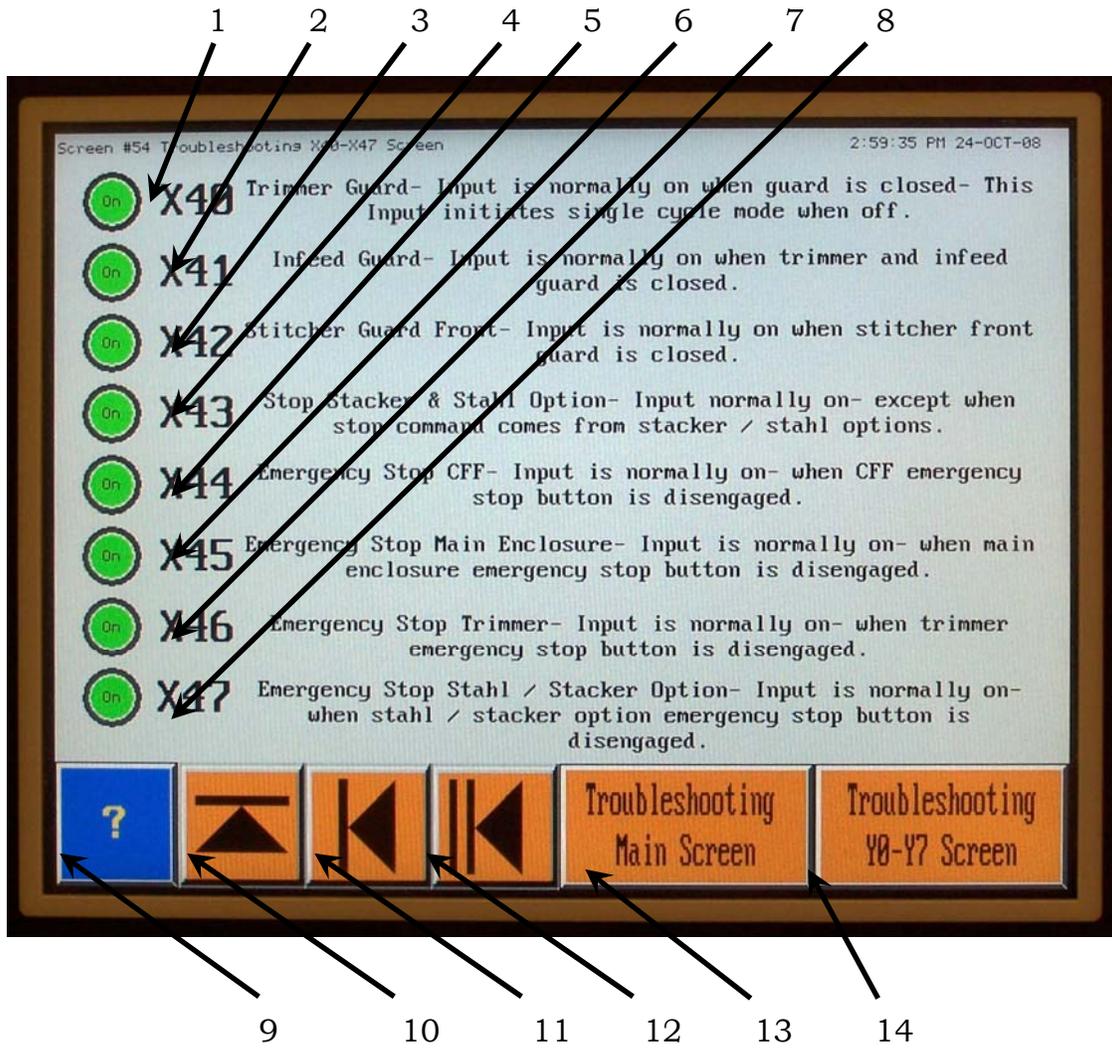
- 9) **?:** This will retrieve the
help screen for the
troubleshooting X30 –
X37 screen.
- 10) **Main Menu Button:**
When pressing this
button, screen will
change to the main
menu screen.
- 11) **Previous Screen
Button:** When pressed
this button will change
to the previous screen. A
maximum of five screens
are remembered.
- 12) **Production Screen
Button:** this button will
change the screen to the
production screen.
- 13) **Troubleshooting Main
Screen:** when pressed
the screen will change to
troubleshooting main
screen.
- 14) **Troubleshooting X40 –
X47 Screen:** when
pressed the screen will
change to
troubleshooting X40 –
X47 screen.

To close this file pick “File”
“Close” in the upper left hand

corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 54 T-SHOOTING
X40-X47

The “Troubleshooting X40-X47” is the screen that displays PLC input status of inputs X40 through X47.



1) **X40 Trimmer Guard-** Input is normally on when guard is closed- This Input initiates single cycle mode when off (trimmer guard open).

2) **X41 Infeed Guard-** Input is normally on when trimmer and infeed guard is closed. This input is off if either the trimmer or infeed guard is open.

3) **X42 Stitcher Guard Front-** Input is normally

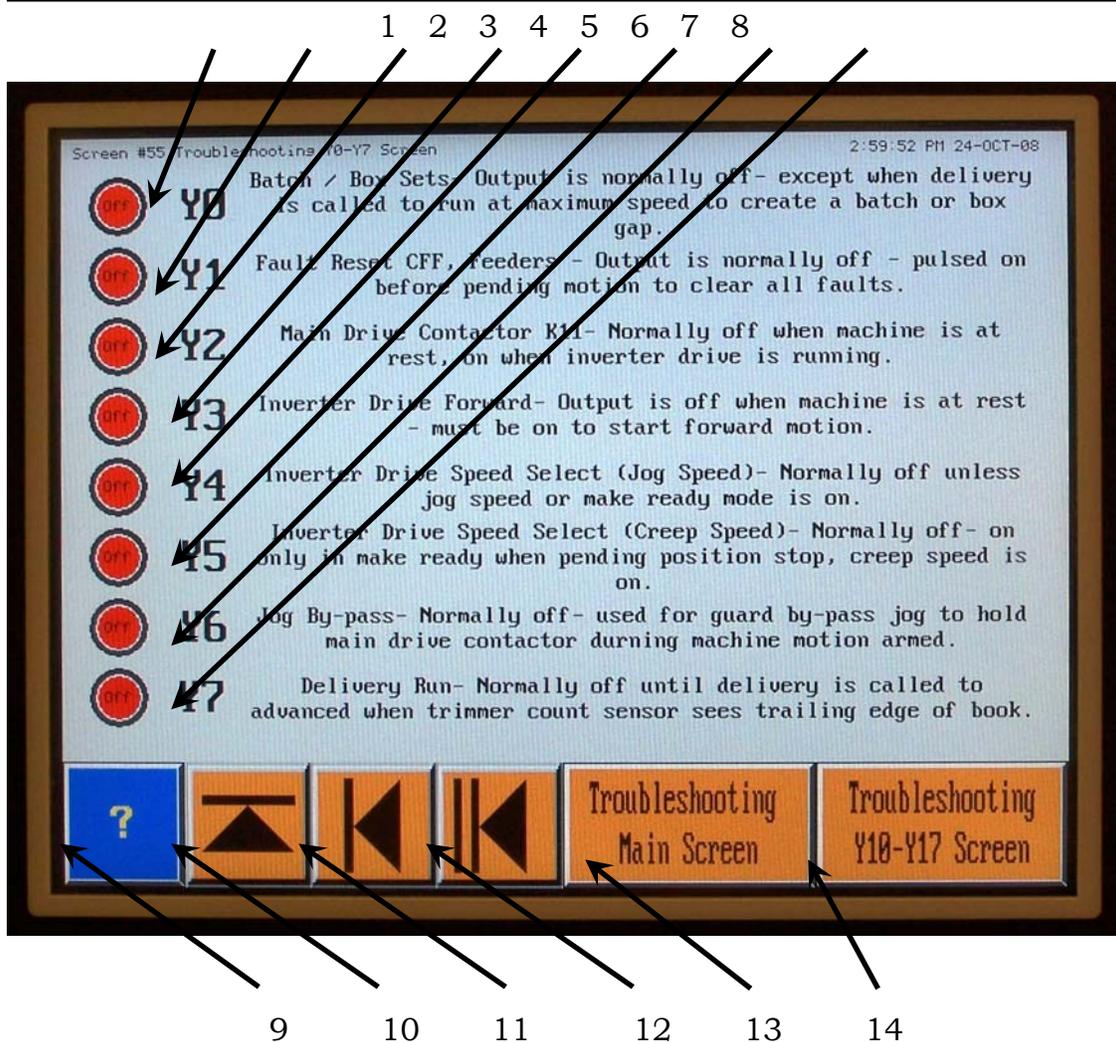
- on when stitcher front guard is closed. This input is off if trimmer guard, infeed guard or stitcher front guard is opened.
- 4) **X43 Stop Stacker & Stahl Option-** Input normally on- except when stop command comes from stacker / stahl options.
 - 5) **X44 Emergency Stop CFF-** Input is normally on- when CFF emergency stop button is disengaged. This input is off when the CFF emergency stop button is pressed.
 - 6) **X45 Emergency Stop Main Enclosure-** Input is normally on- when main enclosure emergency stop button is disengaged. This input is off when the CFF or the main enclosure emergency stop button is pressed.
 - 7) **X46 Emergency Stop Trimmer-** Input is normally on- when trimmer emergency stop button is disengaged. This input is off when the CFF, main enclosure or the trimmer emergency stop button is pressed.
 - 8) **X47 Emergency Stop Stahl / Stacker Option-** Input is normally on- when stahl / stacker option emergency stop button is disengaged. This input is off when the CFF, main enclosure, trimmer or the Stahl / stacker option emergency stop button is pressed. If Stahl / stacker option has not been installed, check blind plugs X35 and X36 at the infeed. If Stahl / stacker option has been installed but option not connected, check blind plugs X2 and X3 at the trimmer exit.
 - 9) **?**: This will retrieve the help screen for the troubleshooting X40 – X47 screen.
 - 10) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
 - 11) **Previous Screen Button:** When pressed this button will change to the previous screen. A maximum of five screens are remembered.
 - 12) **Production Screen Button:** this button will change the screen to the production screen.
 - 13) **Troubleshooting Main Screen:** when pressed the screen will change to troubleshooting main screen.
 - 14) **Troubleshooting Y0 – Y7 Screen:** when pressed the screen will change to troubleshooting Y0 – Y7 screen.

To close this file pick “File”
 “Close” in the upper left hand
 corner, or pick the “X” in the
 upper right hand corner.

HELP – SCREEN 55 T-SHOOTING
Y0-Y7

The “Troubleshooting
 Y0-Y7” is the screen that

displays PLC output status of
 outputs Y0 through Y7.



1) **Y0 Batch / Box Sets-
 Output is normally off-
 except when delivery is**

called to run at maximum
 speed to create a batch or
 box gap. The length of time

this output is on, can be adjusted in the Production Setup Screen.

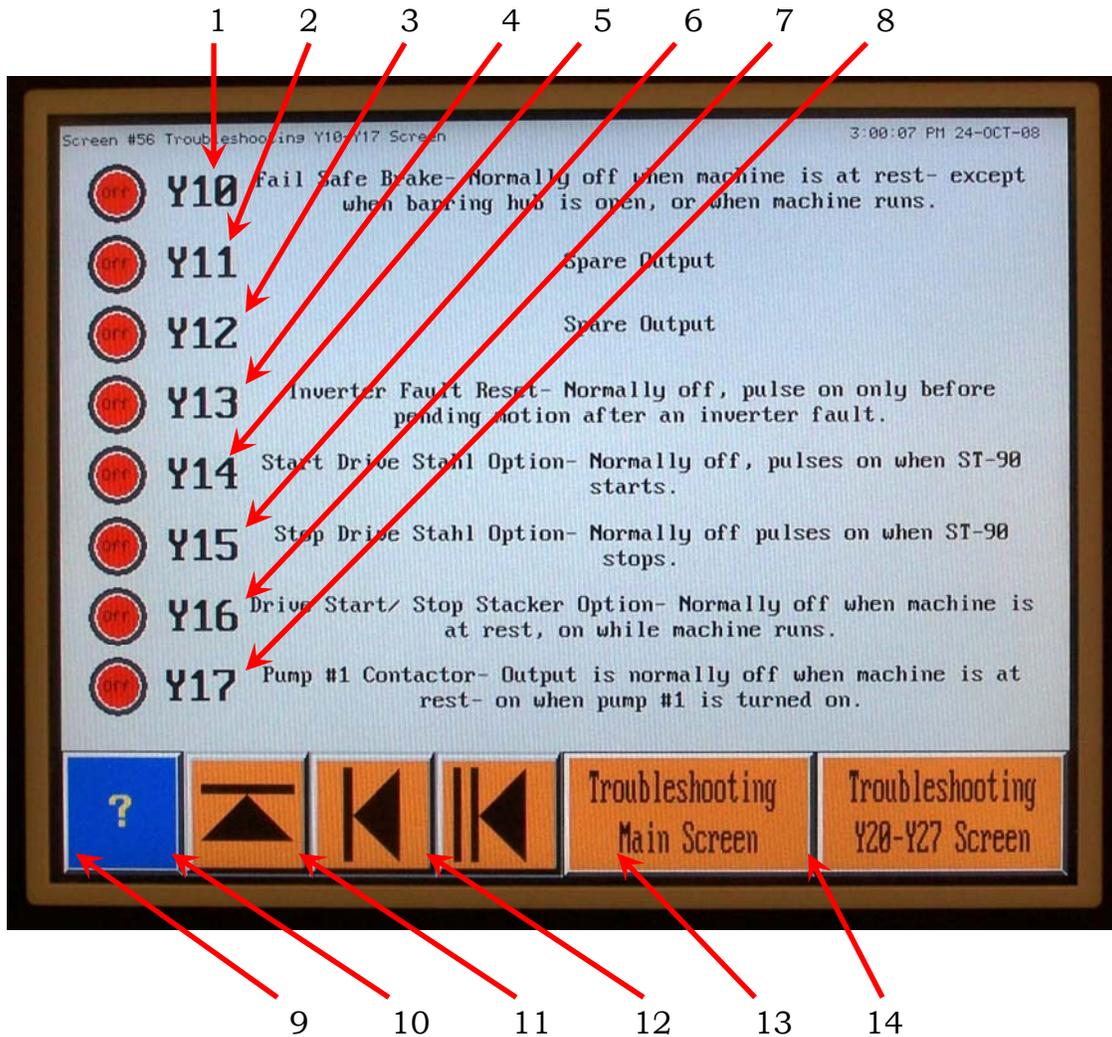
- 2) **Y1 Fault Reset CFF, Feeders** - Output is normally off - pulsed on before pending motion to clear all faults.
- 3) **Y2 Main Drive Contactor K11**- Normally off when machine is at rest, on when inverter drive is running.
- 4) **Y3 Inverter Drive Forward**- Output is off when machine is at rest - must be on to start machine forward motion.
- 5) **Y4 Inverter Drive Speed Select (Jog Speed)**- Normally off unless jog speed or make ready mode is on.
- 6) **Y5 Inverter Drive Speed Select (Creep Speed)**- Normally off- on only in make ready when pending position stop, creep speed is on.
- 7) **Y6 Jog By-pass**- Normally off- used for guard by-pass jog to hold main drive contactor during machine motion armed.
- 8) **Y7 Delivery Run**- Normally off until delivery is called to advanced when trimmer count sensor sees trailing edge of book.
- 9) **?**: This will retrieve the help screen for the troubleshooting Y0 – Y7 screen.
- 10) **Main Menu Button**: When pressing this button, screen will change to the main menu screen.
- 11) **Previous Screen Button**: When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 12) **Production Screen Button**: this button will change the screen to the production screen.
- 13) **Troubleshooting Main Screen**: when pressed the screen will change to troubleshooting main screen.
- 14) **Troubleshooting Y10 – Y17 Screen**: when pressed the screen will change to troubleshooting Y10 – Y17 screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 56 T-SHOOTING
Y10-Y17

The “Troubleshooting Y10-Y17” is the screen that

displays PLC output status of outputs Y10 through Y17.



1) **Y10 Fail Safe Brake-**
 Output is normally off when machine is at rest. Output is on when barring hub door only is open, or when machine runs and jogs.

3) **Y12 Spare Output**
 4) **Y13 Inverter Fault Reset-**
 Normally off, pulse on only before pending motion after an inverter fault.

2) **Y11 Spare Output-**

5) **Y14 Start Drive Stahl Option-** Normally off,

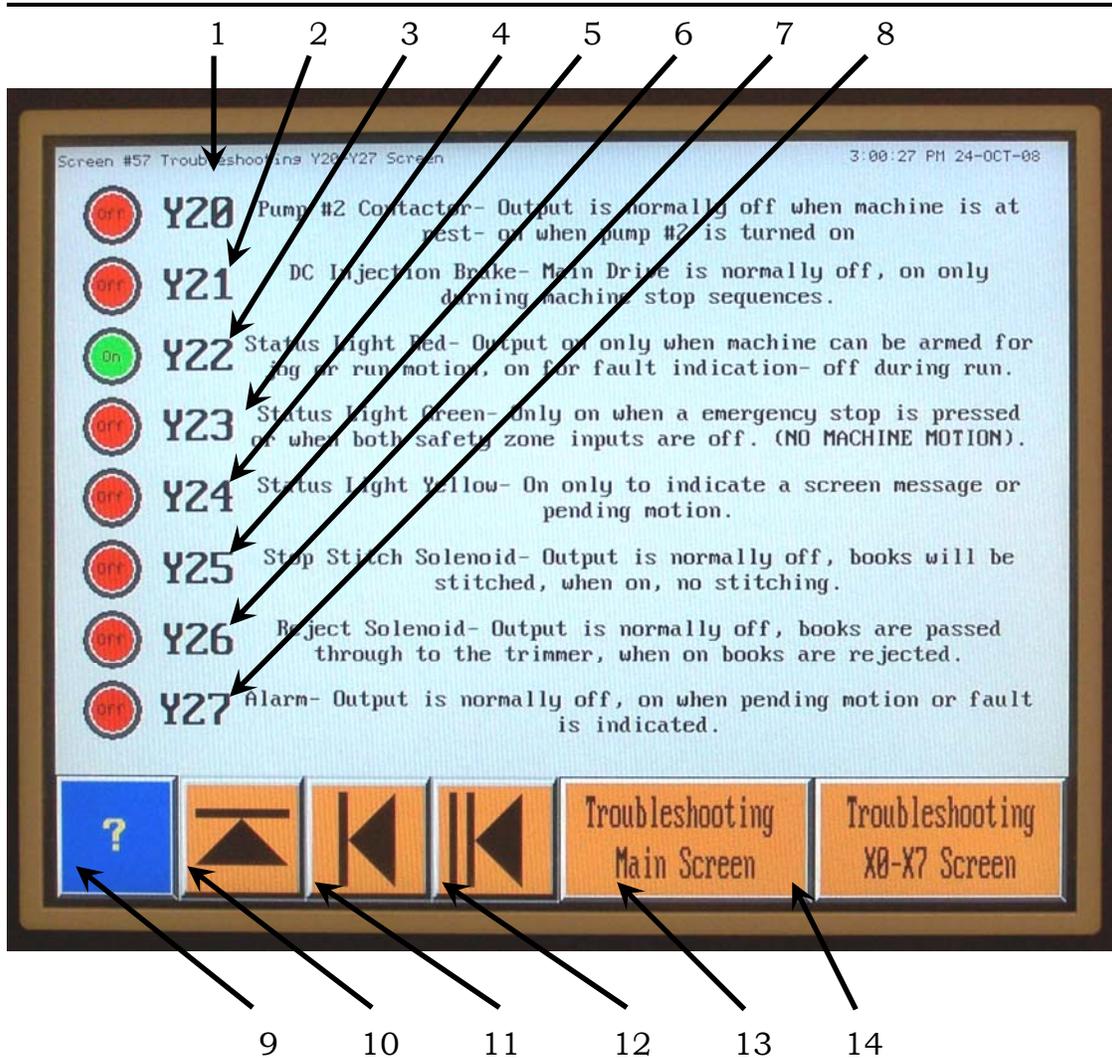
- pulses on when ST-90 starts.
- 6) **Y15 Stop Drive Stahl Option-** Normally off pulses on when ST-90 stops.
 - 7) **Y16 Drive Start/ Stop Stacker Option-** Normally off when machine is at rest, on while machine runs or jogs.
 - 8) **Y17 Pump #1 Contactor-** Output is normally off when machine is at rest- on when pump #1 is turned on.
 - 9) **?:** This will retrieve the help screen for the troubleshooting Y10 – Y17 screen.
 - 10) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
 - 11) **Previous Screen Button:** When pressed this button will change to the previous screen. A maximum of five screens are remembered.
 - 12) **Production Screen Button:** this button will change the screen to the production screen.
 - 13) **Troubleshooting Main Screen:** when pressed the screen will change to troubleshooting main screen.
 - 14) **Troubleshooting Y20 – Y27 Screen:** when pressed the screen will change to troubleshooting Y20 – Y27 screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 57 T-SHOOTING
Y20-Y27

The “Troubleshooting Y20-Y27” is the screen that

displays PLC output status of outputs Y20 through Y27.



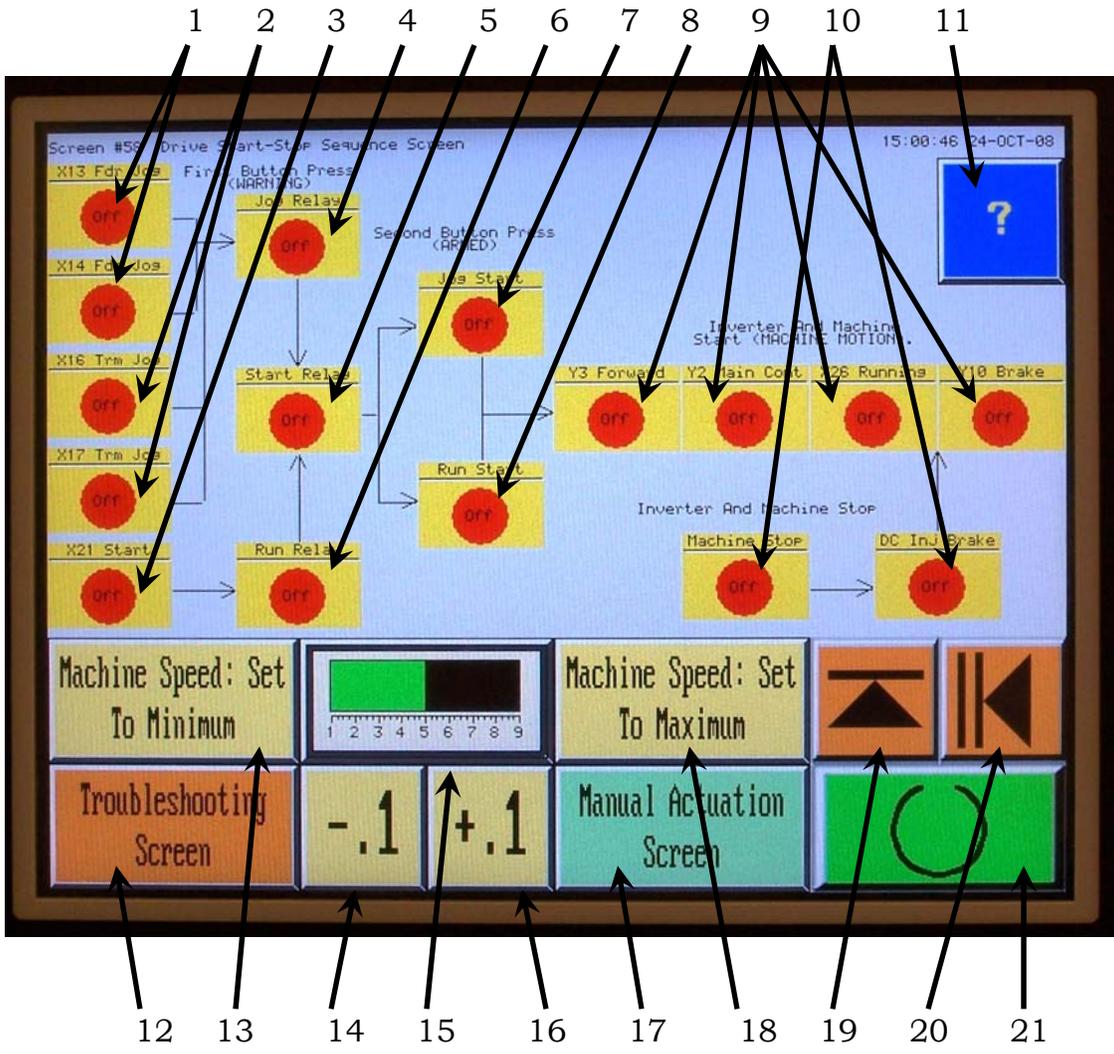
- | | |
|--|---|
| <p>1) Y20 Pump #2 Contactor-
Output is normally off when machine is at rest- on when pump #2 is turned on</p> <p>2) Y21 DC Injection Brake-
Main Drive is normally off, on only during machine stop sequences.</p> | <p>3) Y22 Status Light Red-
Output on only when machine can be armed for jog or run motion, on for fault indication- off during run.</p> <p>4) Y23 Status Light Green-
Only on when an emergency stop button is</p> |
|--|---|

- pressed or when both safety zone inputs are off. **(NO MACHINE MOTION ALLOWED).**
- 5) **Y24 Status Light Yellow-**
On only to indicate a screen message or pending motion.
 - 6) **Y25 Stop Stitch Solenoid-**
Output is normally off, books will be stitched. When output is on, no stitching.
 - 7) **Y26 Reject Solenoid-**
Output is normally off, books are passed through to the trimmer. When output is on, books are rejected.
 - 8) **Y27 Alarm-** Output is normally off. When output is on, pending motion or fault is indicated.
 - 9) **?:** This will retrieve the help screen for the troubleshooting Y20 – Y27 screen.
 - 10) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
 - 11) **Previous Screen Button:**
When pressed this button will change to the previous screen. A maximum of five screens are remembered.
 - 12) **Production Screen Button:** this button will change the screen to the production screen.
 - 13) **Troubleshooting Main Screen:** when pressed the screen will change to troubleshooting main screen.
 - 14) **Troubleshooting X0 – X7 Screen:** when pressed the screen will change to troubleshooting X0 – X7 screen.
- To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 58 DRIVE
START-STOP SEQUENCE

The “Drive Start – Stop Sequence” is the screen that

displays machine drive start – stop logic sequence.



1) **Feeder pendent station jog button indicators:**
 These indicators will turn on when feeder jog buttons are pressed.

2) **Trimmer pendent station jog button indicators:**
 These indicators will turn on when trimmer jog buttons are pressed.

- 3) **Feeder / trimmer pendent station start button indicator:** This indicator will turn on when feeder or trimmer station start button is pressed.
- 4) **Jog relay indicator:** turns on when machine is being armed for jog motion.
- 5) **Start relay indicator:** turns on when machine is armed and ready for jog or run motion.
- 6) **Run relay indicator:** turns on when machine is being armed for run motion.
- 7) **Jog start relay indicator:** turns on when the machine is armed and the jog buttons are pressed for the second time. Jog motion will start.
- 8) **Run start relay indicator:** turns on when the machine is armed and the start button is pressed for the second time. Run motion will start.
- 9) **Motion start sequence:** will start by Y3 inverter drive forward output and the Y2 main contactor output will turn on. Then when the inverter drive starts X26 inverter drive running will go high. Then Y10 drive motor brake output will turn on to release the brake. Machine motion will start.
- 10) When stop button is pressed or a guard open in run mode or a fault occurs, machine stop sequence occurs, the dc injection brake will turn and item 9 indicators will sequence off. Machine motion will stop.
- 11) **?:** This will retrieve the help screen for drive start – stop sequence.
- 12) **Troubleshooting Screen:** When pressed the screen will change to troubleshooting main screen.
- 13) **Minimum Speed Button:** When pressed the machine speed would be set to minimum speed.
- 14) **-.1 Button:** This button when pressed will subtract .1 off of the speed setting in the display.
- 15) **Machine Speed Control:** The indicator on the button indicates the speed setting of the machine when it is running. When the button is pressed the screen will change to the speed control screen.
- 16) **+.1 Button:** This button when pressed will add .1 off of the speed setting in the display.

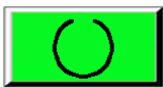
17) **Manual Actuation**
Screen: when pressed the screen will change to manual actuation screen.

18) **Maximum Speed Button:**
 When pressed the machine speed would be set to maximum speed.

19) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

20) **Production Screen**
Button: this button will change the screen to the production screen.

21) **Machine Start and Stop Button / Status**
Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start

button press to start machine motion.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



1) Indicates that machine is in cycle position.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 59 START ERROR

The “Start Error” is the screen that displays start error message. This message comes up when the machine appear.

is requested to start, if a fault condition exists on the machine, this screen will



- 1) **?:** This will retrieve the start error help screen.
- 2) **Start Error:** This window displays the start error that exists on the machine that will keep the machine from starting.
- 3) **Production Screen:** When this button is pressed the screen will change to the production screen.
- 4) **Machine Start and Stop Button / Status**

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



m) Indicates that machine is ready for start, all guards and faults are reset.



n) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



o) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



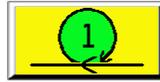
p) Indicates that jog motion is arming.



q) Indicates that jog motion is armed and jog motion will start with the next jog button press.



r) Indicates jog motion is active.



s) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



t) Indicates that an emergency stop button is activated.



u) Indicates that a guard door is open.



v) Indicates that a jam switch is activated.



w) Indicates that a fault has taken place.



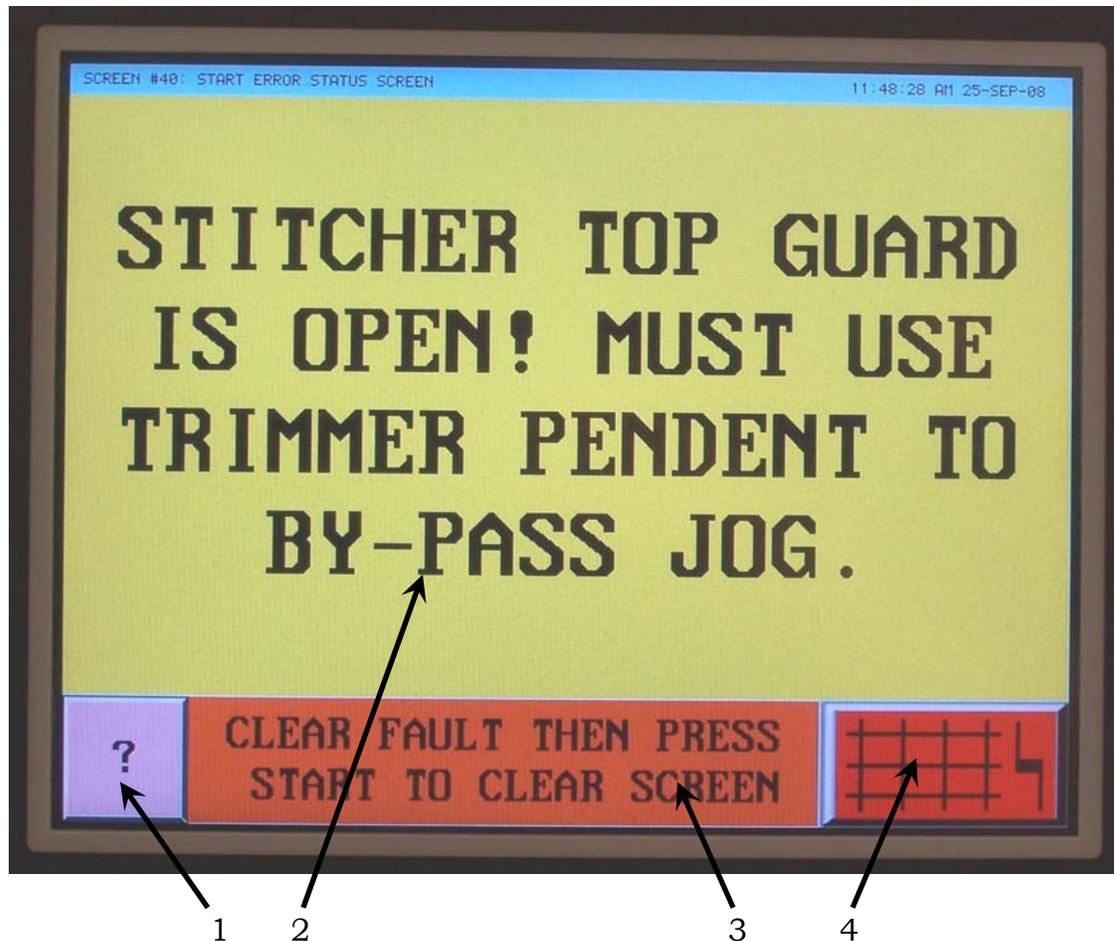
x) Indicates that machine is in cycle position.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

HELP – SCREEN 59 START ERROR

The “Start Error” is the screen that displays start error message. This message comes up when the machine

is requested to start, if a fault condition exists on the machine, this screen will appear.



- 1) **?:** This will retrieve the start error help screen.
- 2) **Start Error:** This window displays the start error that exists on the machine that will keep the machine from starting.
- 3) **Production Screen:** When this button is pressed the screen will change to the production screen.
- 4) **Machine Start and Stop Button / Status Indicator:** When the machine is at rest this

button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but

in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



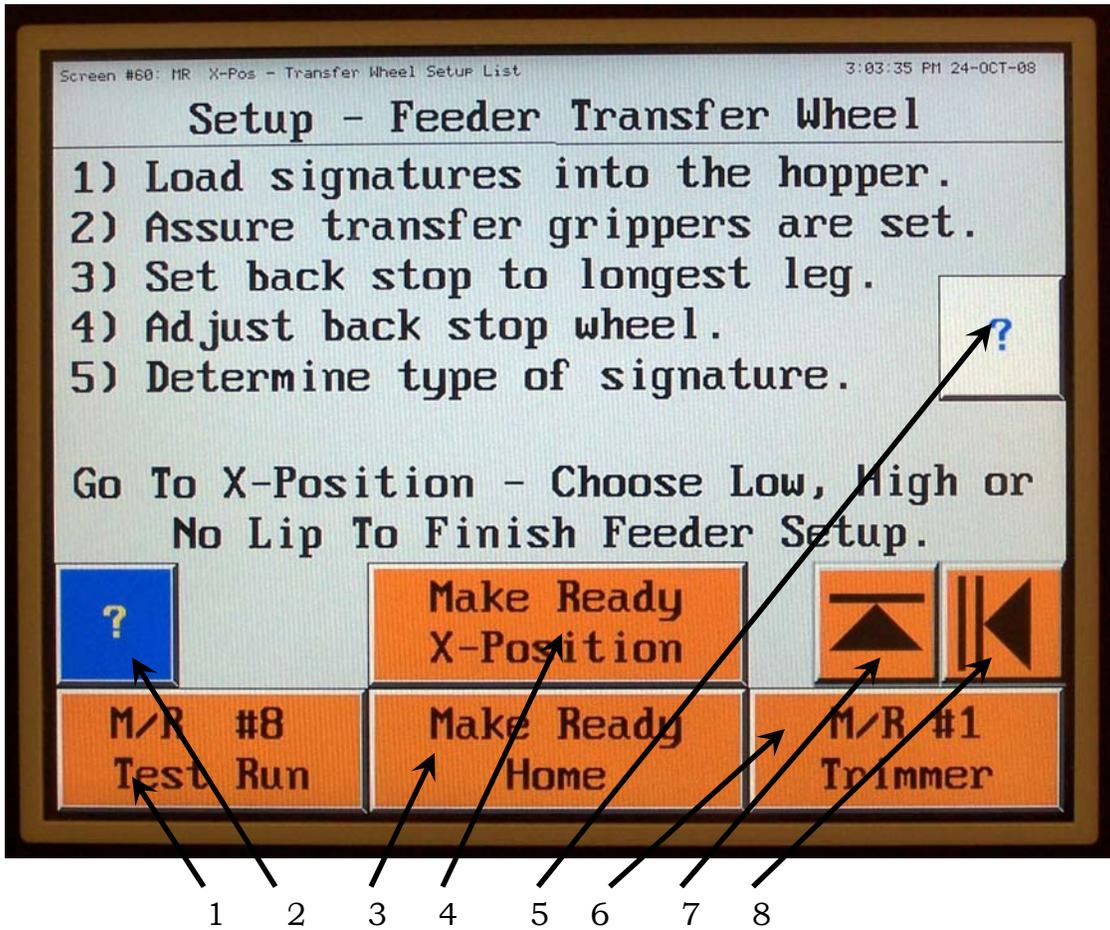
l) Indicates that machine is in cycle position.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 60 MAKE READY
#9 SETUP

The “Make Ready # 9 Feeder Transfer Wheel Setup

List” is the screen that displays the setup list for feeder transfer wheel make ready # 9.



1) **Make Ready Position #8 Test Run:** when pressed the screen will change to make ready position #8 test run position screen.

2) **?:** This will retrieve the help screen for the make ready feeder transfer wheel setup list screen.

3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.

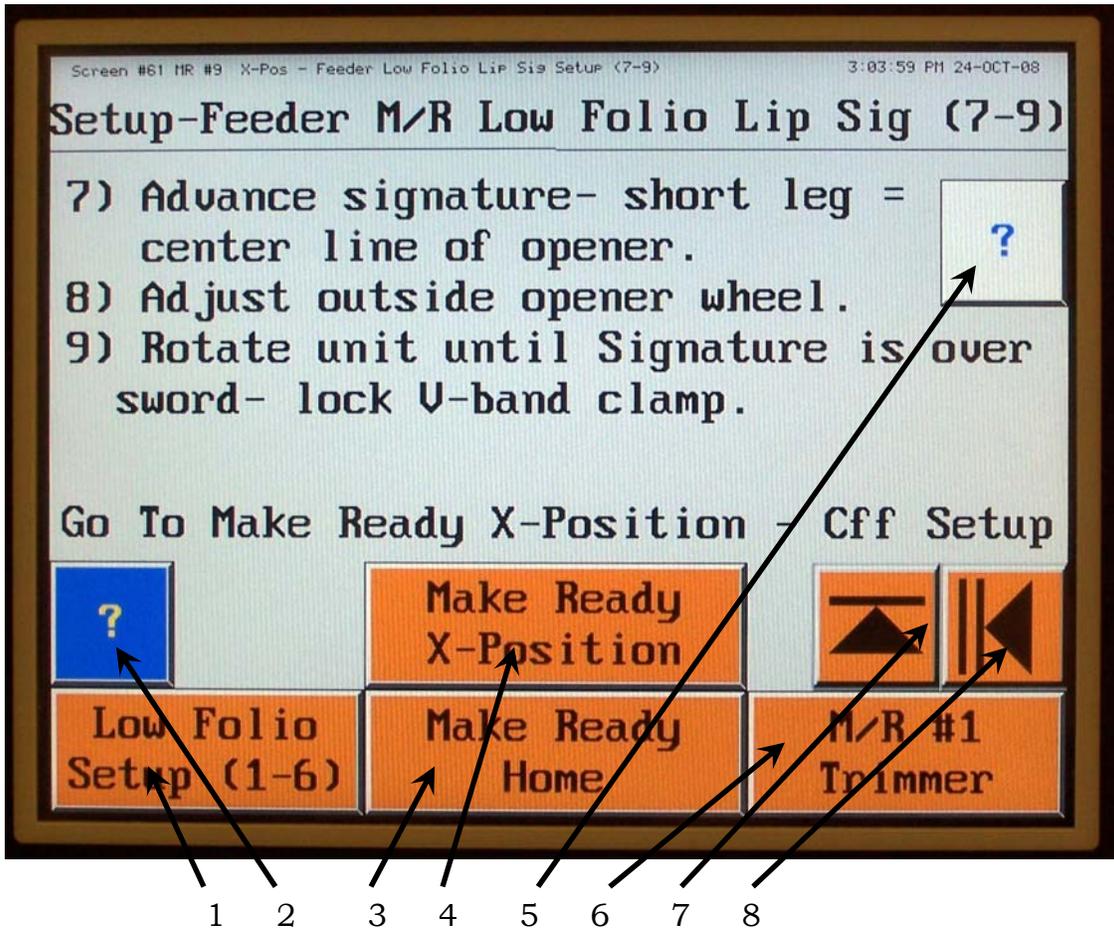
- 5) **?**: This will retrieve the help screen for the make ready # 9 feeder transfer wheel setup list.
- 6) **Make Ready Position #1 Trimmer**: when pressed the screen will change to make ready position #1 trimmer position screen.
- 7) **Main Menu Button**:
When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button**: this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 61 MAKE READY
#9 SETUP

The “Make Ready # 9
 Low Folio Lip Signatures (7-9)

Setup List” is the screen that
 displays the setup list for low folio
 lip signature (7-9) make ready # 9.



- 1) **Make Ready Position #9 Low Folio Setup (1-6):** when pressed the screen will change to make ready position #9 low folio setup (1-6) screen.
- 2) **?:** This will retrieve the help screen for the make ready low folio lip signature setup (7-9) list screen.
- 3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.
- 4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready

position #9 x-position
screen.

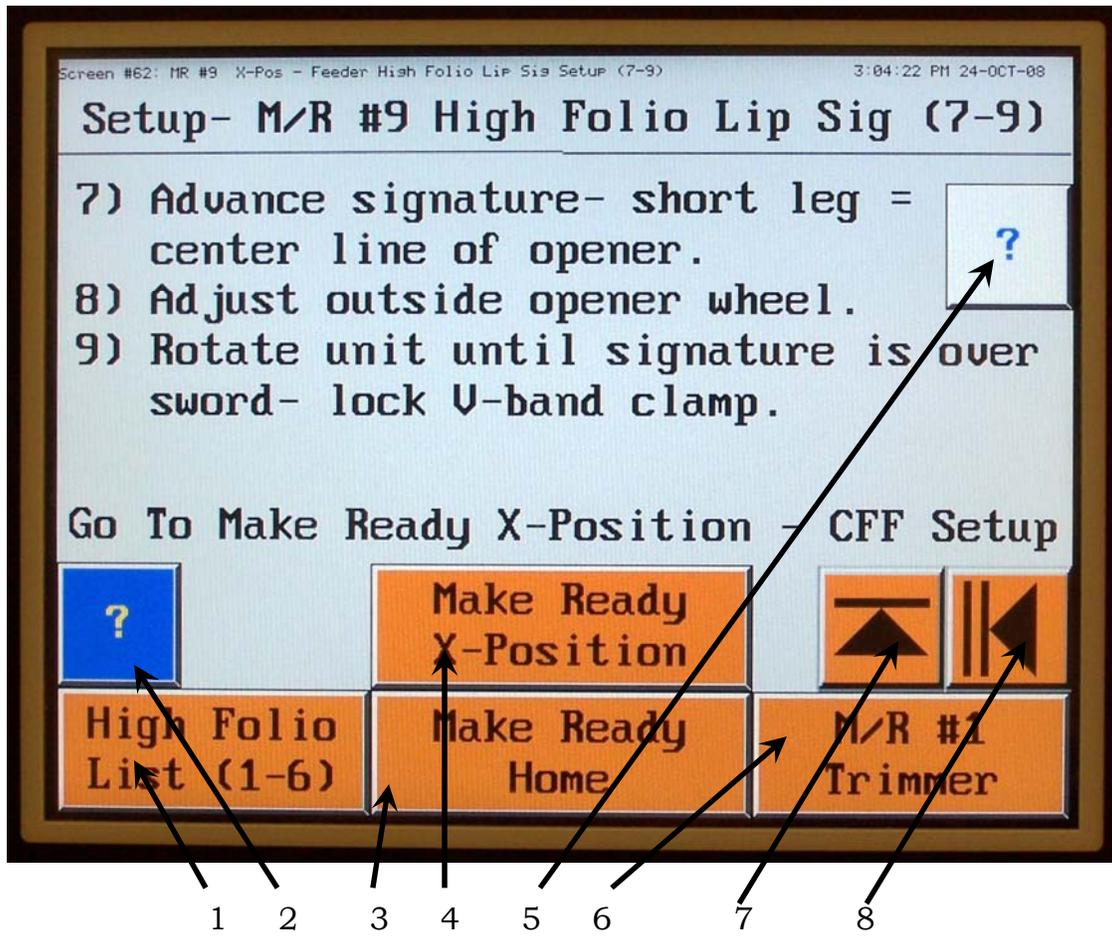
- 5) **?**: This will retrieve the help screen for the make ready # 9 low folio lip signature setup (7-9) list.
- 6) **Make Ready Position #1 Trimmer**: when pressed the screen will change to make ready position #1 trimmer position screen.
- 7) **Main Menu Button**:
When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button**: this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

**HELP – SCREEN 62 MAKE READY
#9 SETUP**

Setup List” is the screen that displays the setup list for high folio lip signature (7-9) make ready # 9.

The “Make Ready # 9 High Folio Lip Signature (7-9)



1) **Make Ready Position #9 High Folio Setup (1-6):** when pressed the screen will change to make ready position #9 high folio setup (1-6) screen.

2) **?:** This will retrieve the help screen for the make ready high folio lip signature setup (7-9) list screen.

3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

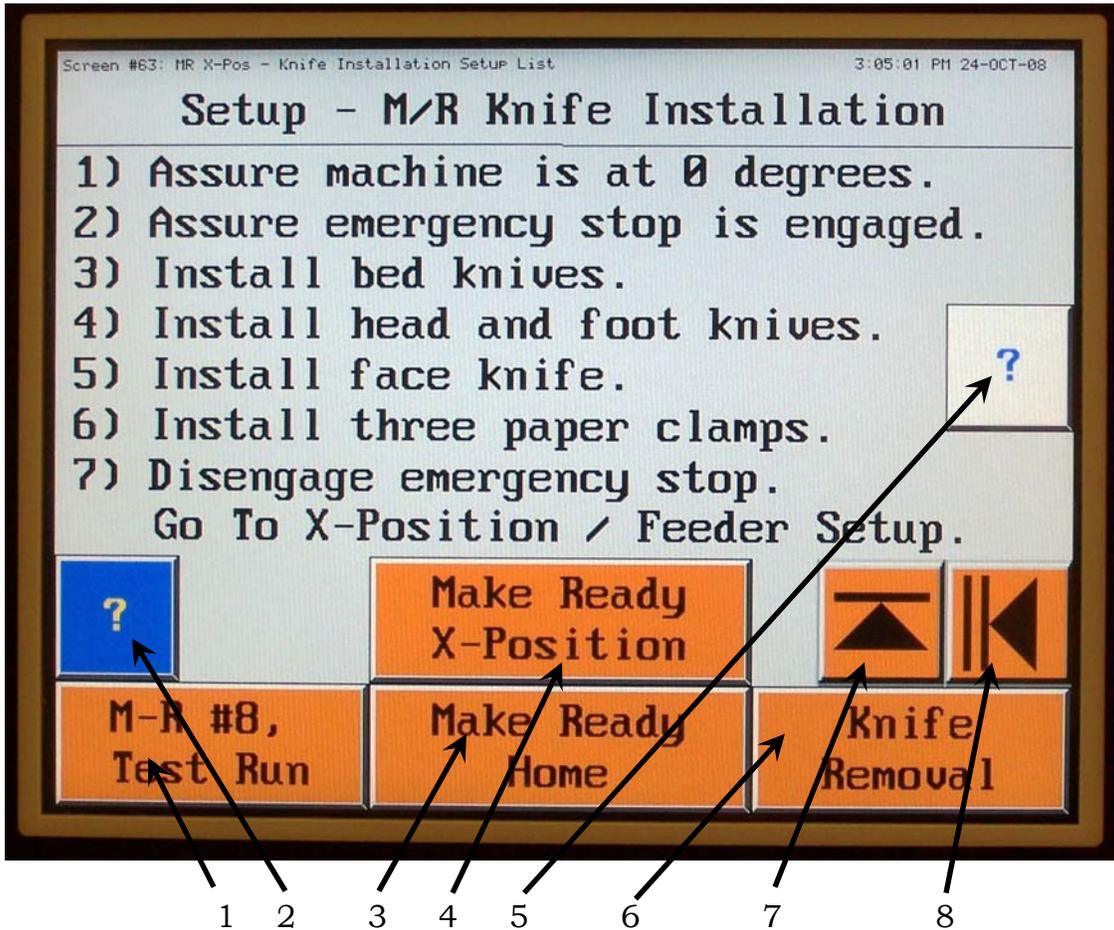
- 4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.
- 5) **?:** This will retrieve the help screen for the make ready # 9 high folio lip signature setup (7-9) list.
- 6) **Make Ready Position #1 Trimmer:** when pressed the screen will change to make ready position #1 trimmer position screen.
- 7) **Main Menu Button:**
When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

**HELP – SCREEN 63 MAKE READY
SETUP**

The “Make Ready Knife Installation Setup List” is the

screen that displays the setup list for knife installation make ready.



1) **Make Ready Position #8 Test Run:** when pressed the screen will change to make ready position #8 test run position screen.

2) **?:** This will retrieve the help screen for the make ready knife installation setup list screen.

3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.

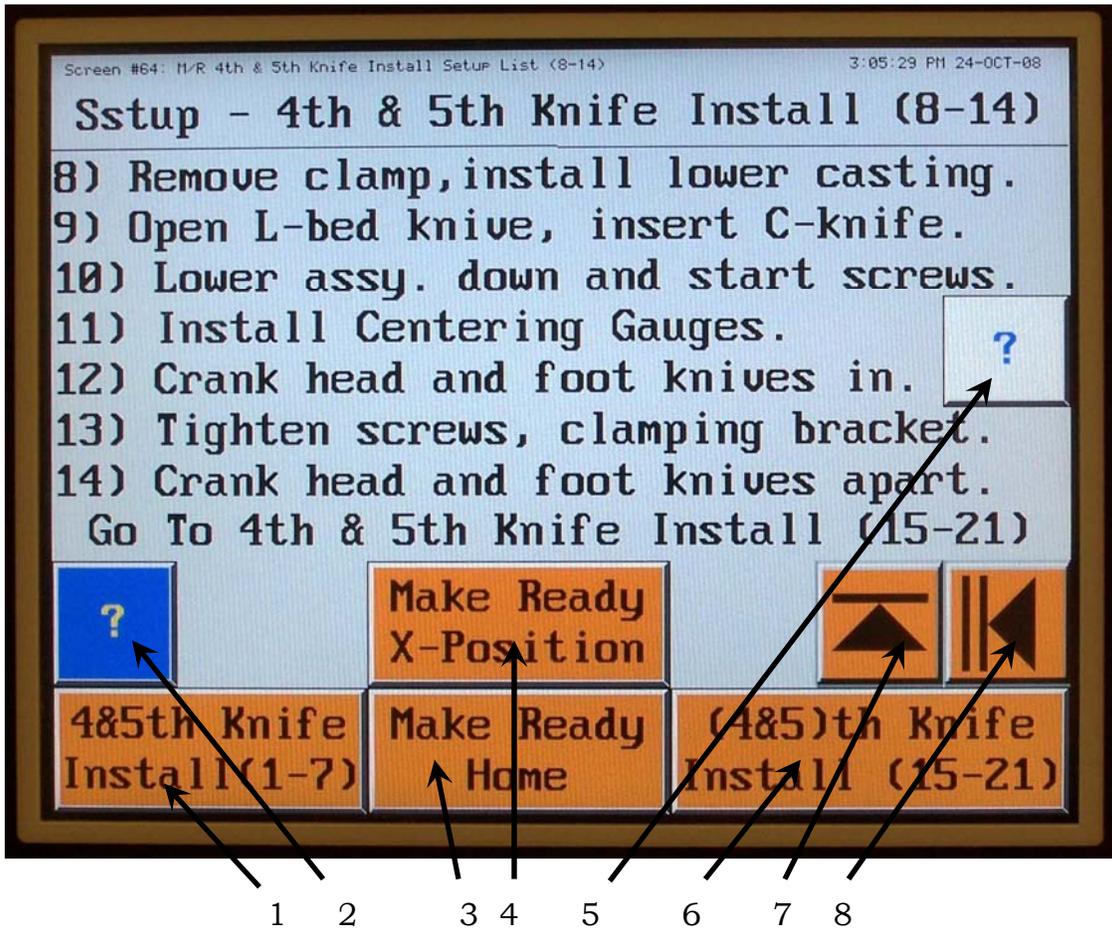
- 5) **?**: This will retrieve the help screen for the make ready knife installation setup list.
- 6) **Make Ready Knife Removal:** when pressed the screen will change to make ready knife removal setup list screen.
- 7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

**HELP – SCREEN 64 MAKE READY
SETUP**

The “Make Ready 4th & 5th Knife Installation (8-14) Setup List” is the screen that

displays the setup list for 4th & 5th knife installation (8-14) make ready.



1) **Make Ready 4th & 5th Knife Installation (1-7):** when pressed the screen will change to make ready 4th & 5th knife installation (1-7) screen.

2) **?:** This will retrieve the help screen for the make ready 4th & 5th knife

installation (8-14) setup list screen.

3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

4) **Make Ready Position #9 X-Position:** When button

is pressed the screen will change to the make ready position #9 x-position screen.

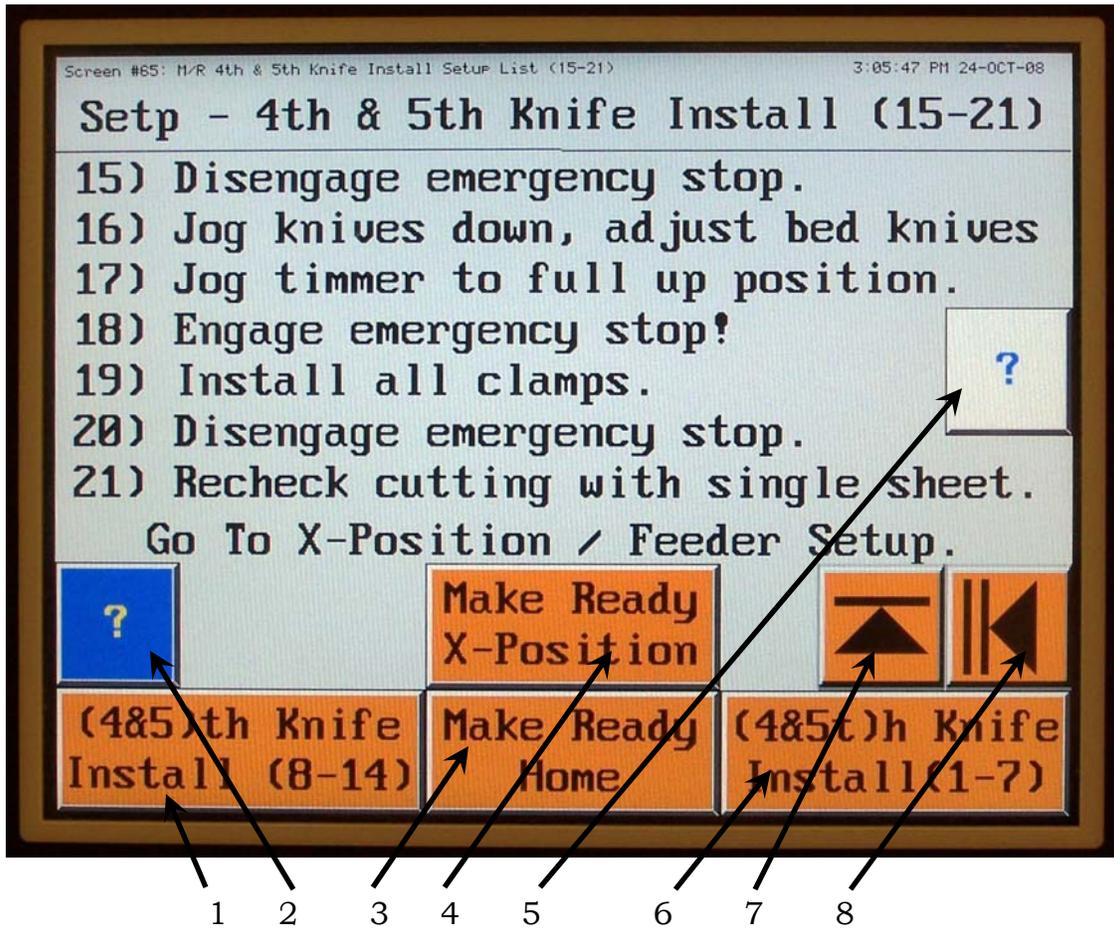
- 5) **?**: This will retrieve the help screen for the make ready 4th & 5th knife installation setup list.
- 6) **4th & 5th Knife Installation (15-21):**
when pressed the screen will change to make ready 4th & 5th knife installation setup (15-21) list screen.
- 7) **Main Menu Button:**
When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick "File" "Close" in the upper left hand corner, or pick the "X" in the upper right hand corner.

HELP – SCREEN 65 MAKE READY SETUP

The “Make Ready 4th & 5th Knife Installation (15-21) Setup List” is the screen that

displays the setup list for 4th & 5th knife installation (15-21) make ready.



1) **Make Ready 4th & 5th Knife Installation (8-14):** when pressed the screen will change to make ready 4th & 5th knife installation (8-14) screen.

2) **?:** This will retrieve the help screen for the make ready 4th & 5th knife installation (15-21) setup list screen.

3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.

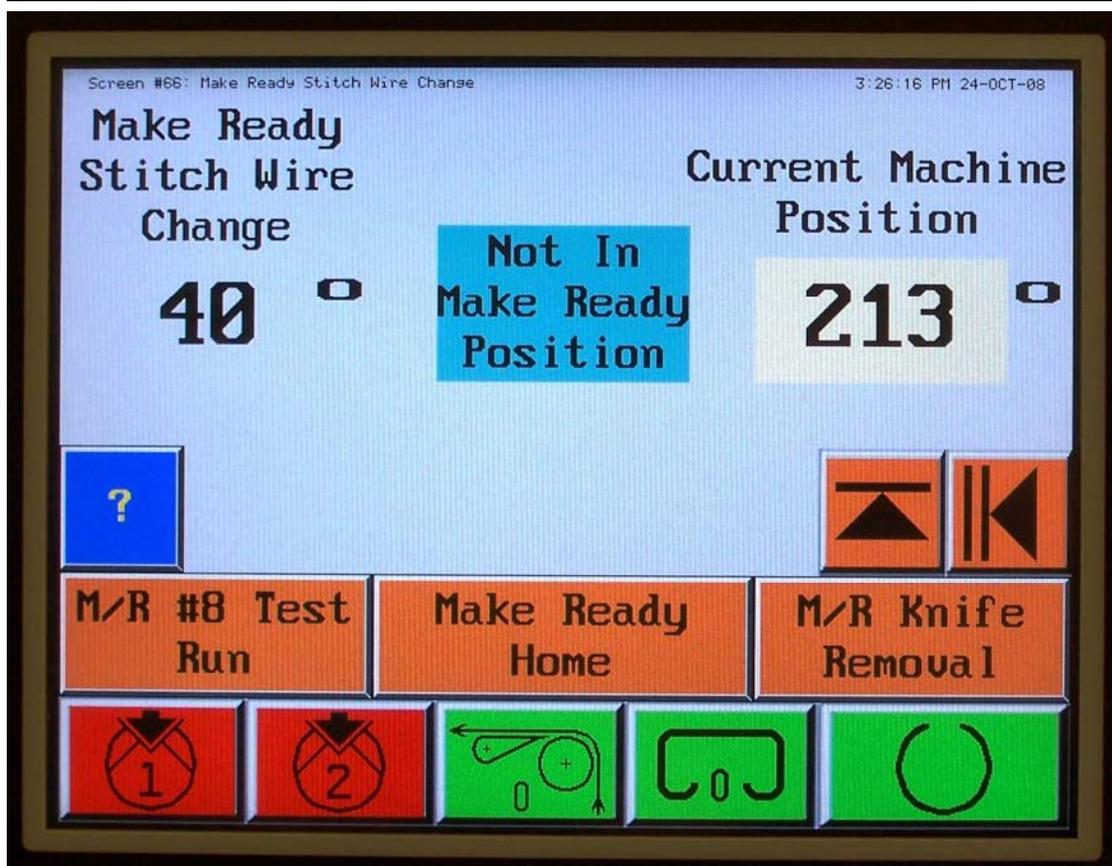
- 5) **?**: This will retrieve the help screen for the make ready 4th & 5th knife installation setup list.
- 6) **4th & 5th Knife Installation (1-7)**: when pressed the screen will change to make ready 4th & 5th knife installation setup (1-7) list screen.
- 7) **Main Menu Button**:
When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button**: this button will change the screen to the production screen.

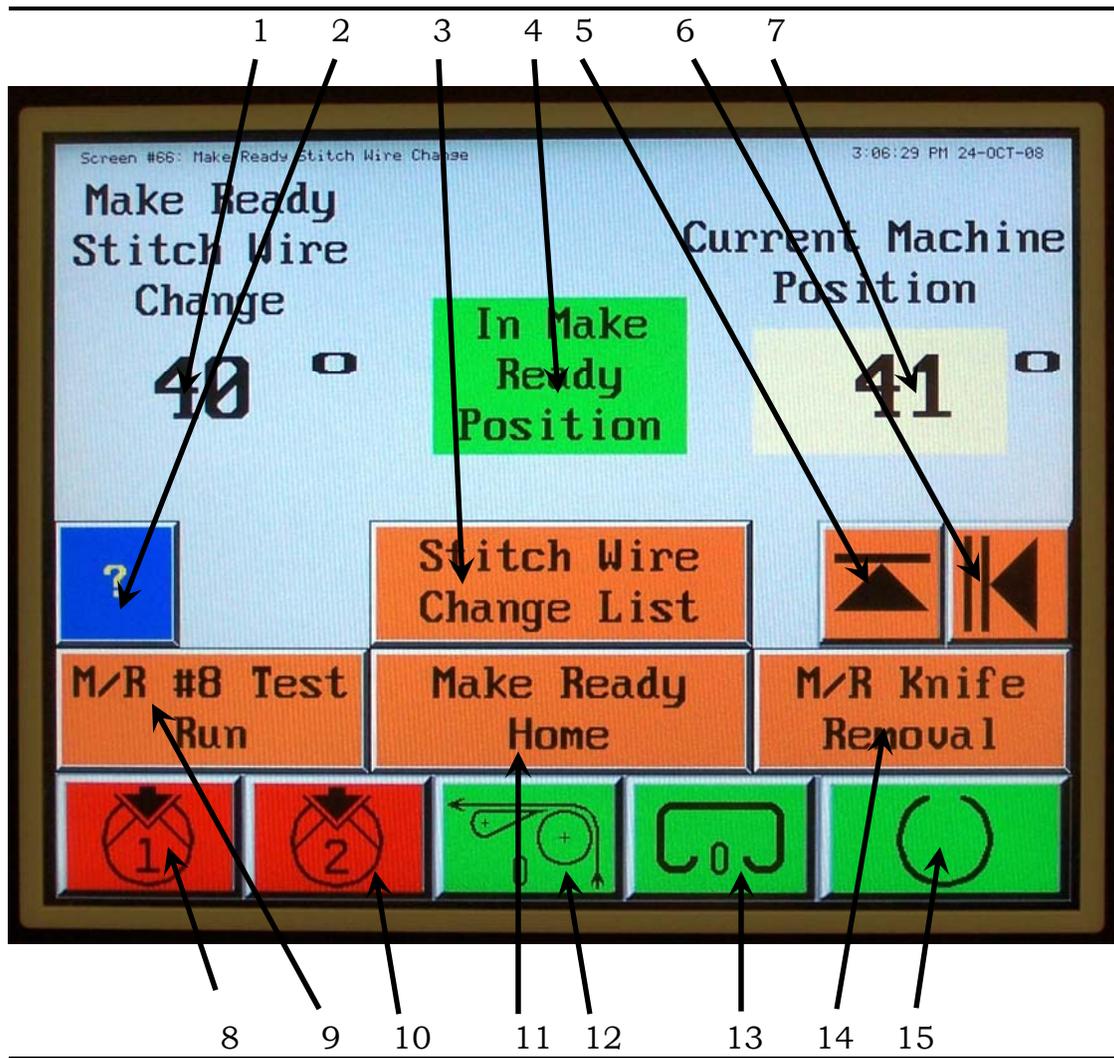
To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCREEN 66 MAKE READY POSITION

The “Make Ready Stitch Wire Change Setup Position” is the screen that displays current machine position, and

make ready stitch wire change setup position. The machine can be jogged or ran into its make ready position.





- 1) Make ready stitch wire change setup position required.
- 2) **?**: This will retrieve the help screen for the make ready stitch wire change setup position screen.
- 3) **Stitch Wire Change Setup List**: This button will only appear after the machine is in make ready stitch wire change setup position. When this

- button is pressed the screen will change to the make ready position stitch wire change setup list.
- 4) Indicator button that flashes red when not in make ready stitch wire change setup position. Turns green when machine is at make ready stitch wire change setup position.

5) **Main Menu Button:**
When pressing this button, screen will change to the main menu screen.

6) **Production Screen Button:** this button will change the screen to the production screen.

7) **Machine current position readout:** When machine is + or - 2 degrees of the make ready position it is considered in position.

8) **Pump 1 Mode Button:**



a) Pump 1 is turned off.



b) Pump 1 is turned on, will not turn off until pump 1 off mode is selected.



c) Pump 1 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 1 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

9) **Make Ready Position #8 Test Run:** when pressed the screen will change to make ready position #8 test run screen.

10) **Pump 2 Mode Button:**



a) Pump 2 is turned off.



b) Pump 2 is turned on, will not turn off until pump 2 off mode is selected.



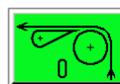
c) Pump 2 in auto mode and is running. The pump will turn when machine is started or jogged.



d) Pump 2 in auto mode and is turned off. The pump will turn off when the machine stops plus a delay setting set in the customer setup screen.

11) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

12) **Reject Solenoid Mode Button:**

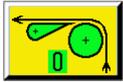


a) This indicates that the reject solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be passed through the reject area.



b) This indicates that the reject solenoid is in the on mode. The solenoid itself is energized. The

red signifies that all books will not pass through the reject area.



c) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is passing good books into the trimmer.



d) This indicates that the reject solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is rejecting bad books into the reject tray.

13) Stop Stitch Mode Button:



a) This indicates that the stop stitch solenoid is in off mode. The solenoid itself is de-energized. The green signifies that all books will be stitched.



b) This indicates that the stop stitch solenoid is in the on mode. The solenoid itself is energized. The red signifies that all books will not be stitched.



c) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The green signifies that the solenoid is de-energized and is stitching good books.



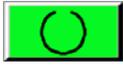
d) This indicates that the stop stitch solenoid is in auto mode. The solenoid is controlled by the machine logic. The red signifies that the solenoid is energized and is not stitching bad books.

14) Make Ready Knife

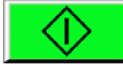
Removal: when pressed the screen will change to make ready knife removal screen.

15) Machine Start and Stop Button / Status

Indicator: When the machine is at rest this button acts as a start button with the same functionality as the start buttons in the pendent stations. When the machine is running it acts as a stop button with the same functionality as the stop button on the pendent stations. The indicators in this button are as follows:



a) Indicates that machine is ready for start, all guards and faults are reset.



b) Indicates that machine has passed the three second arming warning and is ready for start button press to start machine motion.



c) Indicates that the machine is running. If operator presses button at this time, the machine will stop.



d) Indicates that jog motion is arming.



e) Indicates that jog motion is armed and jog motion will start with the next jog button press.



f) Indicates jog motion is active.



g) Indicates that jog motion is activated but in single cycle mode. Single cycle mode is activated when the trimmer guard is open. This means if the operator starts jog and holds the jog the machine will stop at zero degree position.



h) Indicates that an emergency stop button is activated.



i) Indicates that a guard door is open.



j) Indicates that a jam switch is activated.



k) Indicates that a fault has taken place.



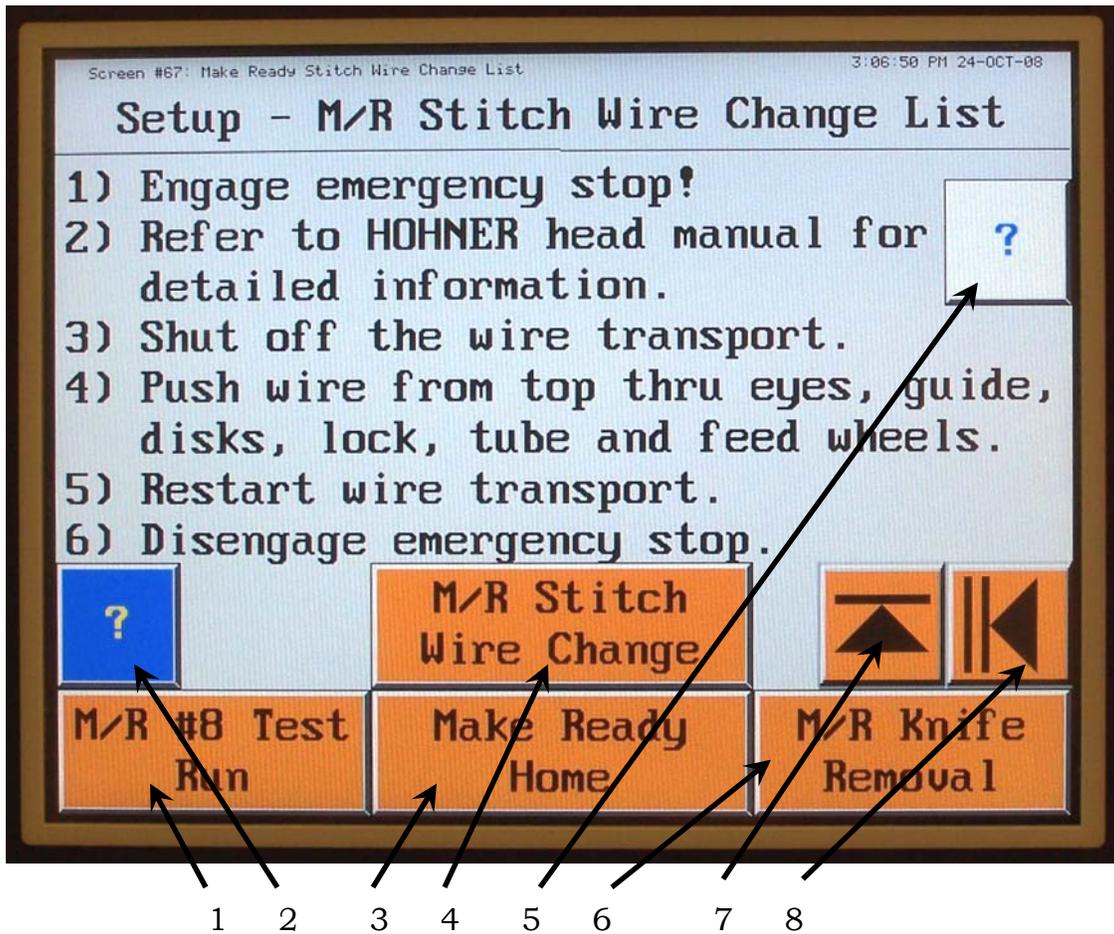
l) Indicates that machine is in cycle position.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

**HELP – SCREEN 67 MAKE READY
SETUP**

The “Make Ready Stitch Wire Change Setup List” is the screen that displays the setup

list for stitch wire change make ready.



1) **Make Ready Position #8 Test Run:** when pressed the screen will change to make ready position #8 test run position screen.

2) **?:** This will retrieve the help screen for the make ready stitch wire change setup list screen.

3) **Make Ready Home Screen:** When button is pressed the screen will change to the make ready home screen.

4) **Make Ready Position #9 X-Position:** When button is pressed the screen will change to the make ready position #9 x-position screen.

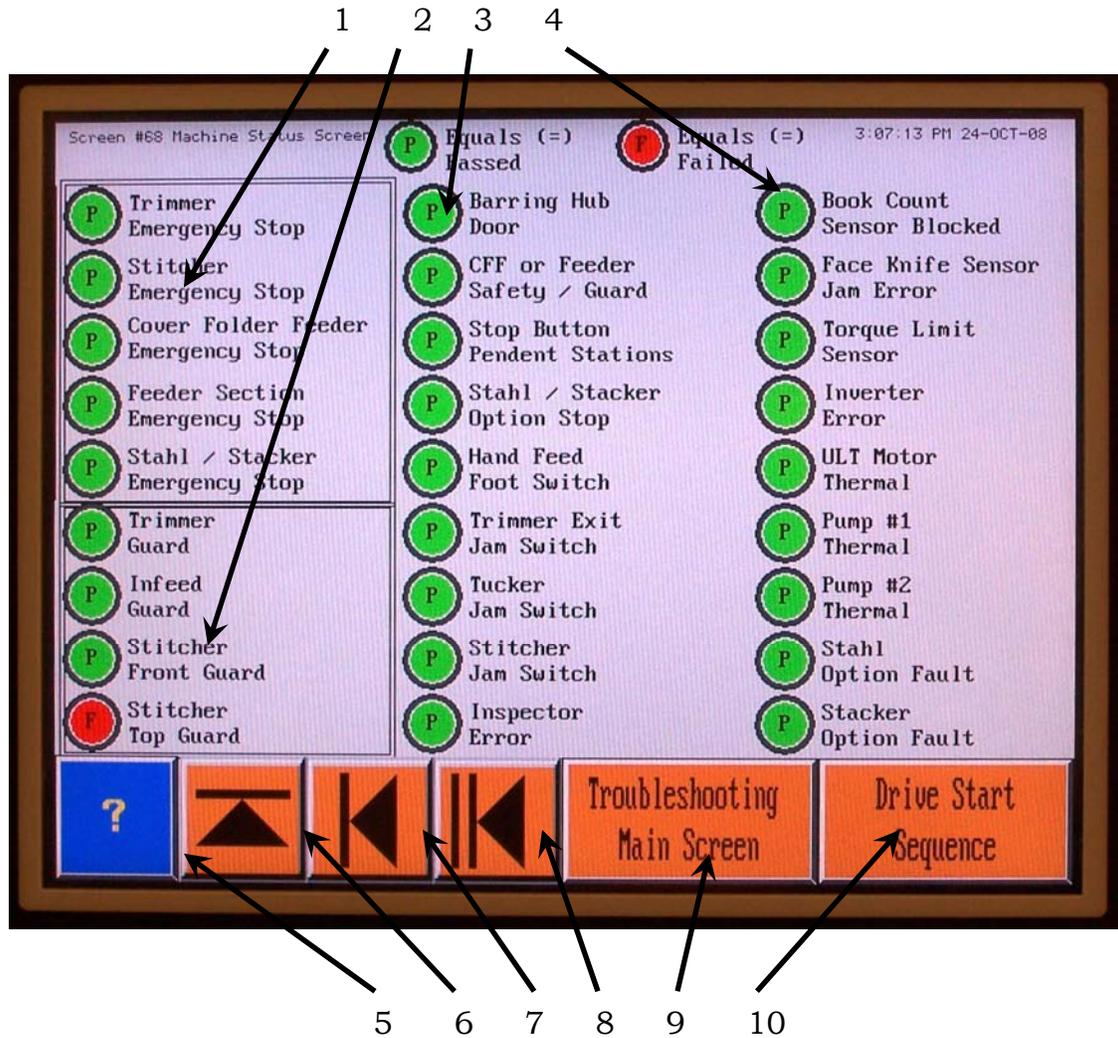
- 5) **?**: This will retrieve the HOHNER stitch head manual.
- 6) **Make Ready Knife Removal:** when pressed the screen will change to make ready knife removal setup list screen.
- 7) **Main Menu Button:** When pressing this button, screen will change to the main menu screen.
- 8) **Production Screen Button:** this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCR 68 MACHINE STATUS

The “Machine Status” is the screen that displays

current machine status information.



- 1) **Emergency stop group:** Displays emergency stop button status. NOTE: Only one emergency stop button is displayed at a time, the first failed emergency stop button from the top is the one indicated. Any lower emergency stop button

may or may not be pressed.

- 2) **Zone 2 (trimmer) safety guard group:** Displays trimmer guard group status. NOTE: Only one guard safety switch is displayed at a time, the first failed guard safety from the top is the one indicated. Any lower

guard safety may or may not be open.

drive start – stop sequence screen.

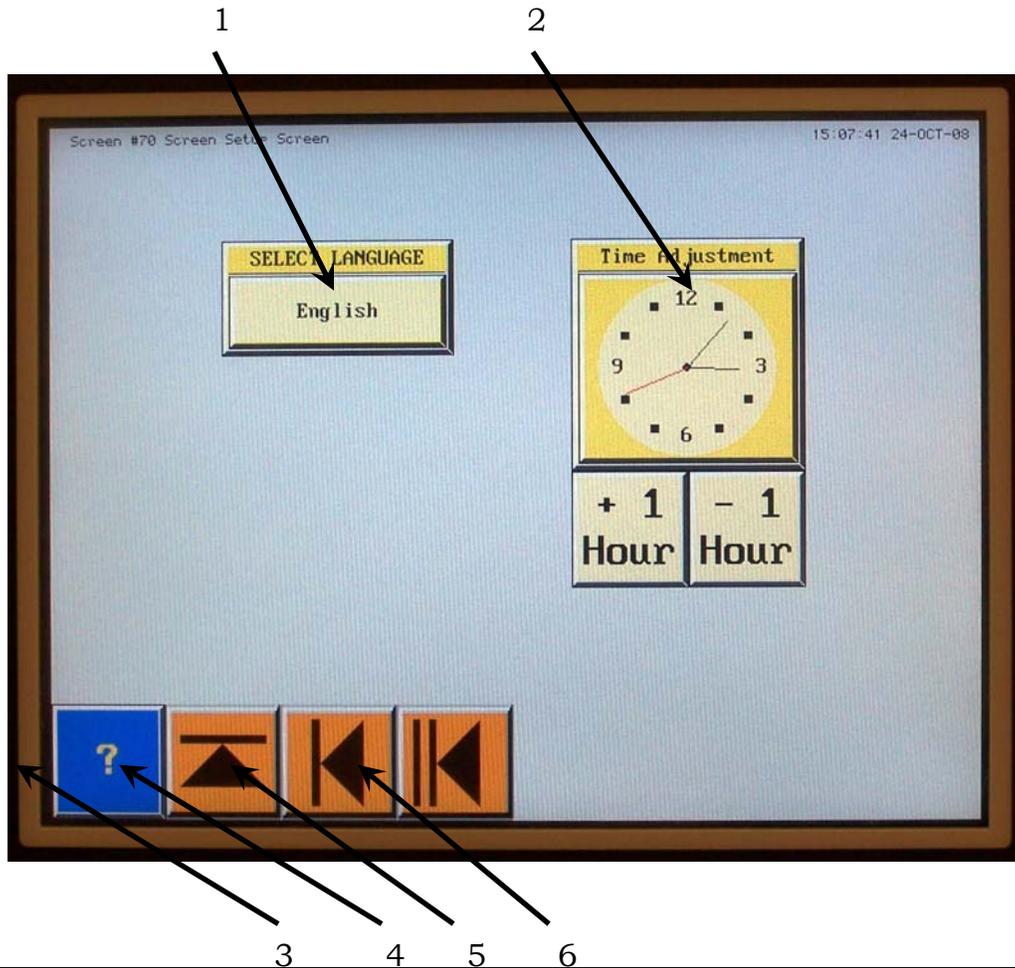
- 3) This machine status group is shown individually. Status change will not effect the status of another.
- 4) This machine status group is shown individually. Status change will not effect the status of another
- 5) **?**: This will retrieve the help screen for this screen.
- 6) **Main Menu Button:**
When pressing this button, screen will change to the main menu screen.
- 7) **Previous Screen Button:**
When pressed this button will change to the previous screen. A maximum of five screens are remembered.
- 8) **Production Screen Button:** this button will change the screen to the production screen.
- 9) **Troubleshooting Main Screen:** when pressed the screen will change to troubleshooting main screen.
- 10) **Drive Start Sequence Screen:** when pressed the screen will change to

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

HELP – SCRIN 70 SCREEN SETUP

The “Screen Setup” is the screen that displays

screen setup functionality, (screen languages and time adjustments).



1. **Select Language:** This Button changes the screen language.
2. **Time Adjustment:** These buttons adjust the time value up and down 1 hour per button press.
3. **?:** This will retrieve the screen setup help screen.
4. **Main Menu Button:** When pressing this button, screen will change to the main menu screen.

5. **Previous Screen**
Button: When pressed this button will change to the previous screen. A maximum of five screens are remembered.

6. **Production Screen**
Button: this button will change the screen to the production screen.

To close this file pick “File” “Close” in the upper left hand corner, or pick the “X” in the upper right hand corner.

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