

# BAUM 714XLT-2C, 4C, 4Z & 8Z Gluing Systems

**A unique self-mailer solution for compact and affordable folding & gluing to produce multiple self-mailer impositions.**

These complete folder/gluer machines use the durable Baum 714XLT Ultrafold air/vacuum feed folder combined with the easy to use and maintain GMS Microglue control and glue head system. These systems are affordable and use much less floor space than other self-mailer solutions.

One of the unique features being offered is the capability to create “Z” and Double Parallel self-mailers in just one pass complete with glue on three sides and perforations on two ends parallel to each other.

There are four models available, the 714XLT- 2C, 4C, 4Z and the 714XLT- 8Z [shown].

**714XLT 2C** has a two-head cold glue system mounted on the feed table and can produce parallel glue lines on the far right and left hand ends of the sheet. This is good for letter and half-fold self-mailers. There is no capability to add glue dots in the middle.

**714XLT 4C** has a four-head cold glue system mounted on the feed table and can produce parallel glue lines on the far right and left hand ends of the sheet and add two dots in the panel area between the lines to make a more secure self-mailer. This is good for letter and half fold self mailers that require personal information being secured.

**714XLT 4Z** has a two-head cold glue system mounted on the feed table and 2 cold glue heads mounted to the #1 fold plate. This model can produce parallel glue lines on the far right and left hand ends of the sheet. The glue can be applied to both sides of the sheet. This machine can produce all of the folds of the 714XLT 2C and can also create self mailers in a “Z” and double parallel fold imposition. This folder does not provide dots in the middle for secured data.

**714XLT 8Z** has a four-head cold glue system mounted on the feed table and 4 cold glue heads mounted to the #1 fold plate. This model can produce parallel glue lines on the far right and left hand ends of the sheet and add two dots in the panel area between the lines to make a more secure self mailer. The glue can be applied to both sides of the sheet. This machine can produce all of the folds of the 714XLT 2C, 4C and 4Z while also completing the ability to provide dots in the middle for secured data.



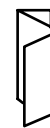
## Examples of possible self-mailers



**HALF FOLD** Self-mailers that can have a line of glue on the righthand and lefthand edges and two dots to seal the piece closed on the third side parallel to the folded edge. Two lines of perforation for easy tear-off are also possible on the righthand and lefthand edges using the perforating tooling provided with the Baum 714XLT folder.



**LETTER FOLD** Self-mailers that can have a line of glue on the righthand and lefthand edges and two dots to seal the piece closed on the third open side. Two lines of perforation for easy tear-off are also possible on the righthand and lefthand edges using the perforating tooling provided with the Baum 714XLT folder.



**“Z” FOLD** Self-mailers that can have a line of glue on the righthand and lefthand edges on all panels on the inside and two dots to seal the piece closed on the third and fourth open sides. Two lines of perforation for easy tear-off are also possible on the righthand and lefthand edges using the perforating tooling provided with the Baum 714XLT folder.



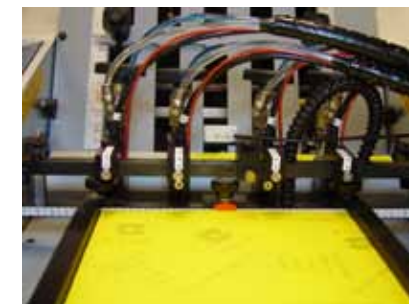
**DOUBLE PARALLEL FOLD** Self-mailers that can have a line of glue on the righthand and lefthand edges on all panels on the inside and two dots to seal the piece closed on the third and fourth open sides. Two lines of perforation for easy tear-off are also possible on the righthand and lefthand edges using the perforating tooling provided with the Baum 714XLT folder.



## GMS HP Series Glue Head

This valve allows the applicator to be purged of glue and cleaned with fresh water in a matter of seconds with the HP’s electric purge switch located directly on the gun. The HP’s shutter mechanism automatically opens and closes whenever the machine starts and stops. This design dramatically reduces the need for wiping or cleaning the nozzle orifice between uses.

The pneumatically powered shutter’s rubber pad securely covers the orifice so that any glue within remains ready to use. The HP’s ability to operate with a wide range of adhesive viscosities makes it equally at home in a broad range of applications.



## BAUM 714XLT Folder

Baum tabletop folders have been the industry leaders for over 3 decades, and the new 714XLT is no exception. Designed for operator convenience and high-productivity, the 714XLT is built for long-lasting performance, and features 1/4” thick tooling plate side frames, rigidly connected with 3/4” steel cross bars, solid steel stacker wheels and sealed ball bearings, ensuring stability, reduced maintenance, and increased service life. And it’s fast, at over 35,000 8-1/2” x 11” sheets per hour.

The 714XLT can handle coated or uncoated paper sizes from 3” x 5” up to 14” x 20”, with an extra-long feed table to accommodate the larger sheets. Rack-and-pinion side guides with bias adjustments improve handling out-of-square paper. Also, the positive, dual-locking paper guides help maintain positive sheet registration.

## Maintenance Free Sealed Ball Bearings:

There is no need to spend valuable time lubricating the bearings on the 714XLT. The use of sealed ball bearings eliminates lubrication and provides long-lasting drive train life.

## Space and Energy Saving Design:

The operator can load the feed table and unload the folded sheets on the same end of the folder. This saves valuable space and helps eliminate operator fatigue.

## Completely Mobile:

The unique and compact design allows for complete mobility of the entire system. The glue and purge tanks are conveniently mounted on the side of the mobile cart. The glue system controller and all distribution lines are also mounted securely to the cart and the folder.

## Third Perforation:

All models are capable of providing two perforations that are parallel to each other at opposite ends of the folded sheet perpendicular to the folds. For a third perforation that is at a right angle in relationship to the lines of perforation mentioned, the optional BAUM 714XLT 8-page 2nd station right angle folder is needed.



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Model Capabilities Chart Self Mailer Fold Type	714XLT 2C 2 heads on feed table	714XLT 4C 4 heads on feed table	714XLT 4Z 2 heads on feed table 2 heads on fold plate	714XLT 8Z 4 heads on feed table 4 heads on fold plate
Half fold side seams only	YES	YES	YES	YES
Half fold side seams and dots	NO	YES	NO	YES
Letter fold side seams only	YES	YES	YES	YES
Letter fold side seams and dots	NO	YES	NO	YES
Z fold side seams only	NO	NO	YES	YES
Z fold with side seams and dots	NO	NO	NO	YES
Double Parallel fold side seams only	NO	NO	YES	YES
Double Parallel fold side seams & dots	NO	NO	NO	YES

The sheet size capabilities for self-mailers where the folding and gluing can be used include standard sizes of 8-1/2 x 11 letter, 8-1/2 x 14 legal, A4 letter and Legal. All self-mailer or other folding and gluing applications outside of these sheet sizes need to be

confirmed with Baum for capability. All models of the 714XLT folder with gluing can be used as folding machine to produce a wide variety of different folds in addition to self-mailers when the glue system is left inoperative.

## Baum 714XLT Specifications:

Type folder.....Air/ Vacuum feed, bottom feed  
Maximum sheet size parallel..... 14" x 20" (35.5 x 50.8 cm)  
Maximum sheet size right angle..... 13.5" x 14" (34.2 x 35.5 cm)  
Minimum sheet size..... 3" x 5" (7.6 x 12.7 cm)  
Maximum size fold – #1 or #2 plate ..... 13.5" (34.3 cm)  
Minimum size fold ..... 2.25" (5.7 cm)  
Maximum paper weight..... 65 lb cover  
Feeder pile height..... 2" (5.1 cm)  
Fold roll diameter..... 1.5" (3.8 cm)  
Fold roll material ..... Polyurethane  
Fold roll speed..... Variable between 0"/min and 7200"/min  
(0 to 18,288 cm/min or 182 m/min)

Operating voltage..... 110 VAC - 60 Hz or 220/1/50 Hz.

Note that production speeds for self-mailers are determined by the efficiencies of the glue system. Production folding speeds for self-mailers with glue will be less than production speeds of non-glued folded products. Consult your BAUM sales representative for more information on production speeds.

Customer must supply compressed air source for the glue system. Air/vacuum pump for the folder is not used for the glue system.

Additional information on the 714XLT is available in a separate brochure.

Specifications subject to change without notice.



### GMS Controller

The Microglue® 428 is the simplest and easiest to use 4-channel pattern controller available on the market today. Each channel is capable of being programmed for two separate events each - a line, dot or stitch pattern. The 428 high power constant current outputs can be configured to allow you to operate many different types of glue or tape applicators. The 428 allows real time adjustments to its outputs, making it simple for operators to get the exact pattern needed. The systems distance-based pattern stitching capability allows each event to be programmed to apply multiple glue patterns.

Features such as four optical sensor inputs, dual encoder inputs, proportional control of glue pressure, and shutter and pump controls make the 428 a very versatile controller. Like all GMS pattern controls, the 428 incorporates patented speed compensation, output cutoff speed and optical sensor lockout features.

## Baum 2C, 4C, 4Z & 8Z Gluing Systems Standard Features:

- 3 Segmented urethane folding rollers for all idler rollers
- 2 Lines of perforating tooling
- 10 Perforating blades, 64-tooth
- 8 Pullout tire assemblies for the exit shafts
- Mobile cart to enclose folder air/vacuum pump and mount glue tanks
- Pre-assembled glue system with minimal installation time
- GMS controller with mounting post
- Easy purge system to clean valves
- Gear-driven folding rollers
- Total sheet counter
- Can be used to create self-mailers and or regular non-glued folds
- Available in either 110/1/60Hz or 220/1/50Hz electrical configuration
- Loading and unloading at the same end of the folder
- Rack and Pinion gearing side guides on the feed table

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**FOLDERS • CUTTERS • DRILLS • PRESS • FINISHING • GENUINE PARTS**

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