714MP
AUTOFOLD
AIR FEED

INSTALLATION, OPERATION
&
MAINTENANCE MANUAL

Printed in U.S.A.

WARNING

- Do not operate this machine without all guarding in place.
- Do not make adjustments or perform maintenance on this machine with power on.
- Keep the machine and the work area clean and free of spills to prevent accidents.
- Be sure to replace any safety decals that may have been detached for any reason.

BAUMFOLDER reserves the right to make changes in design or to make additions or improvements in its products without imposing any obligation upon itself to install them on its products previously manufactured. It is recommended that modifications to this equipment not be made without the advice and express written consent of BAUMFOLDER.

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1.0 INTRODUCTION

Your new 714MP AUTOFOLD Air Feed Table Top Folder has been designed to give you many years of useful service provided it is installed, maintained, and operated according to the instructions in this manual.

Your 714MP AUTOFOLD Air Feed is a unique and versatile paper folding machine, capable of folding paper measuring between 3 x 5 inches (7.6 x 12.7 cm) and 14 x 20 inches (35.5 x 50.8 cm), at speeds up to 27,600 sheets per hour of 8 1/2 x 11 (21.6 x 27.9 cm) and up to 41,000 sheets per hour of 3x5 (7.6x12.7 cm). The AUTOFOLD will make six types of folds: single fold, letter fold, fan fold, semi-gate fold, double-parallel fold and an engineering fold, with the push of a button. (Note: There are also four (4) memory locations for special folds that you may require).

Your 714MP AUTOFOLD is built rigid enough to ensure years of trouble-free performance and, at the same time, is compact enough to fit any table or desk. It is portable so it can be moved anywhere it is needed.

2.0 SPECIFICATIONS

Model No.. 714MP
Minimum Sheet Size............. 3 x 5" (7.6 x 12.7 cm)
Maximum Sheet Size....... 14 x 20" (35.5 x 50.8 cm)
Minimum Size Fold........................... 2 " (5.1 cm)
Maximum Paper Weight...................... 65 lb. Cover
Stack Height..2" (5.1 cm)
Fold Roll Speed............Infinitely variable between
0"/min. and 7200"/min.
(18,288 cm/min. or 182 m/min.)
Fold Plate Depth...............#1 Plate, 13.5" (34.3 cm)
#2 Plate, 10.5" (27.7 cm)
Fold Roll Width............................. 14 1/8" (35.8 cm
Fold Roll Diameter...........................1 1/2" (3.8 cm)
Overall Physical Dimensions.....Height 26" (66 cm)
Length 34" (88 cm)
Width 23 1/2" (60 cm)
Operating Voltage.....................110 VAC/1PH/60Hz
Power Consumption (folder).....................250 Watts
Power Consumption (pump).................. 1500 Watts
Amperage (pump)......................................15 Amp

3.0 INSTALLATION

3.1 Unpacking & Inspection

The 714MP AUTOFOLD Air Feed is packaged in three cartons, crated together as two package. It is broken down into 11 major assemblies for shipment. These are:

A) Main Folder Assembly
B) Pump Assembly
C) Feed Table Assembly
D) Slitter Shaft Assembly
E) Accessory Package
F) Stacker Tray
G) Fold Pans (2)
H) Hose Assembly (2)
I) Literature Package
J) 1/2 Pint Surewash

NOTICE
Immediately upon unpacking, carefully inspect each of the above assemblies for shipping damage. If any damage is found, be sure to contact the delivery freight carrier to file a damage claim. Save all packaging material for the claims adjustor to inspect.

NOTE: To change from English to Metric and vice versa, see sections 11.5 and 11.6.

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WARNING

Do not plug the power cord into an AC outlet until the AUTOFOLD Air Feed is fully assembled, adjusted and ready to use. Unplug the AUTOFOLD any time disassembly is required.

4.0 ASSEMBLY

4.1 Main Unit

To assemble the AUTOFOLD Air Feed unit, first remove the four bolts holding it to the skid. Place the folder on the stand (See Figure 4.1-1).
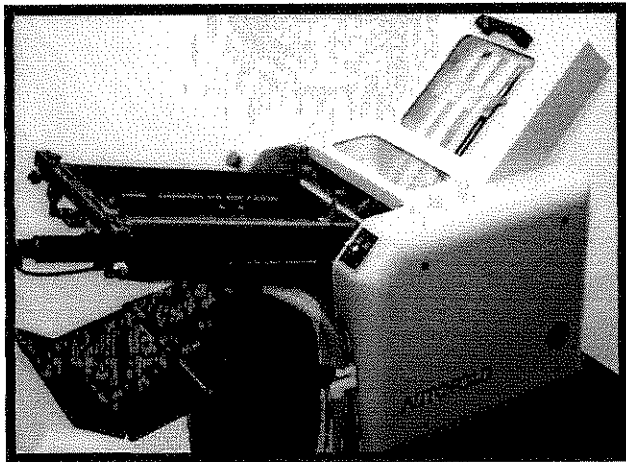
Figure 4.1-1

4.2 Pump Electrical Connections

The pump has a plug/cord set attached. This plug fits directly into the rear of the left-hand side cover. (See Figure 4.2-1)
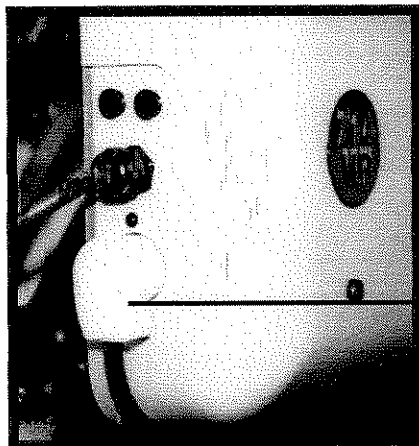
Pump
Plug/Cord Set

Figure 4.2-1

4.3 Pump Hose Connections

Two hoses come with your AUTOFOLD Air Feed. (See Figure 4.3-1)

Air
Vacuum

For
Pump
Hoses
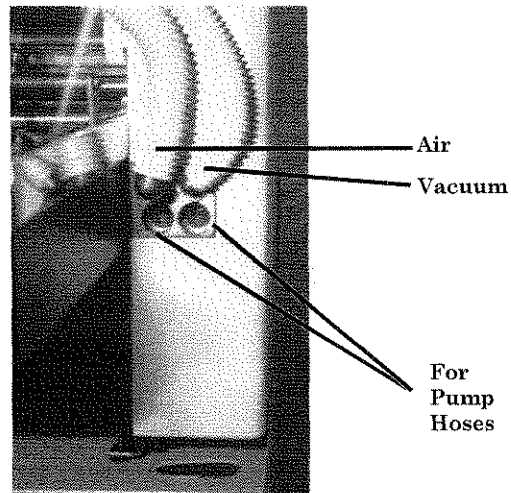
Figure
4.3-1

4.4 Slitter Shaft Installation

To install the slitter shaft, hold it with the grooves in the boxings down. Be sure the slitter shafts are free-turning.

Insert the slitter shaft and seat the grooves in the boxings on the lower locating pins in the side frames. (See Figure 4.4-1)

Check for proper gear engagement between the upper slitter shaft gear and the 19-tooth frame idler gear by turning the handwheel.

Slitter Shaft Assembly

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4.5 Delivery Table

To install the delivery table, loosen the knobs on either side of the stacker table. Drop the tray over the knobs and retighten.

Verify the delivery table is plugged in.(See Figure 4.5-1)
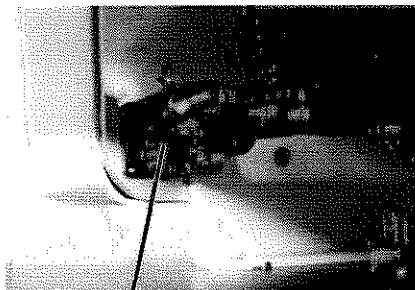
Delivery Table Plug **Figure 4.5-1**

Feed Table Hoses

Air

Vacuum

Pump Hoses
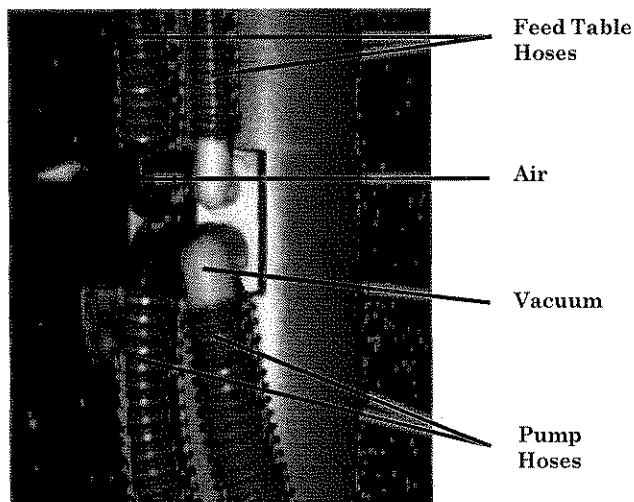
Figure 4.6-2

4.6 Feed Table Assembly Installation

Insert the feed table with the feed wheel toward the fold rolls. Slide the paper feed table over both sets of locating pins. (See Figure 4.6-1)

Figure 4.6-1

The first notch in the front part of the feed table should rest on the pins. Then drop the rear notch down on the upper dowel pins.

Rotate the handwheel to check that the gears are properly meshed.

Connect the feed table hoses. Push the fittings into the holes in the manifold block. (See Figure 4.6-2)

Plug the feed table into the side of the frame. (See Figure 4.6-3)

Figure 4.6-3

Feed Table Plug

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4.7 Fold Plate Installation

WARNING

Unplug the AC power cord when installing or removing fold plates.

The fold plates are marked #1 and #2 and are not interchangeable. The #1 fold plate is installed in the top position, the #2 fold plate in the lower position.

Each fold plate has an open end which faces toward the fold rolls.

To install the fold plates, pivot the fold plate hold-downs out of the way and slide the fold plate in position so that the slots in the leading edge of the fold plate engage the two locating pins in the side frames. (See Figure 4.7-1)

The center notches should seat on the second set of locating pins. Pivot the fold plate hold-downs back into position to secure the fold plates.

Turn the handwheel to be sure that the fold plates are properly installed and not rubbing on the fold rolls.

Plug the fold pan connectors into the side frame. (See figure 4.7-1)

#2 Fold Plate Plug   #2 Fold Plate
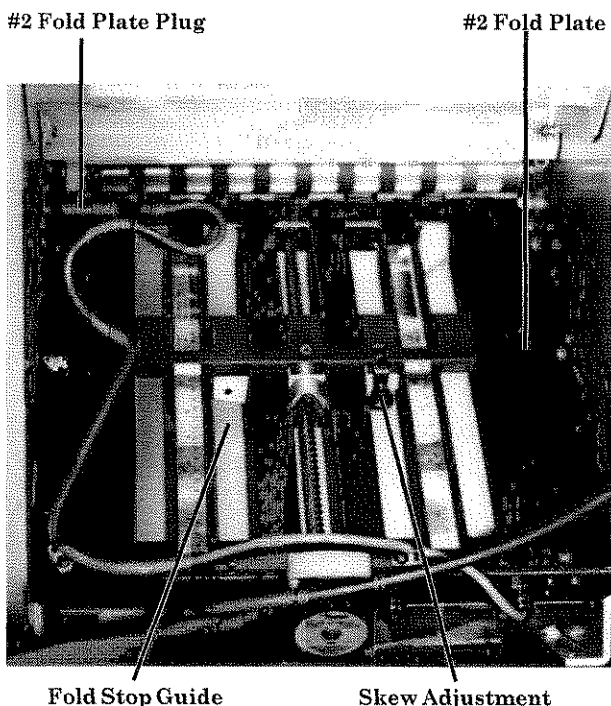
Fold Stop Guide   Skew Adjustment
Figure 4.7-1

5.0 ELECTRICAL ACCESS

WARNING
Unplug the AC power cord before attempting any electrical repair.

The electrical controls are located in the left-hand side cover. The handwheel must be removed for access to these controls.

The cover can be removed by taking out the four screws located on the inside of the frame.

6.0 FEED TABLE SETUP

6.1 Gap Adjustment

With the machine running, insert two sheets of paper between the tab and the sucker wheel. Turn the gap knob counterclockwise until there is a slight drag on the paper. Remove the paper. The correct gap is now set. (See Figure 6.1-1)

Gap Knob

Figure 6.1-1

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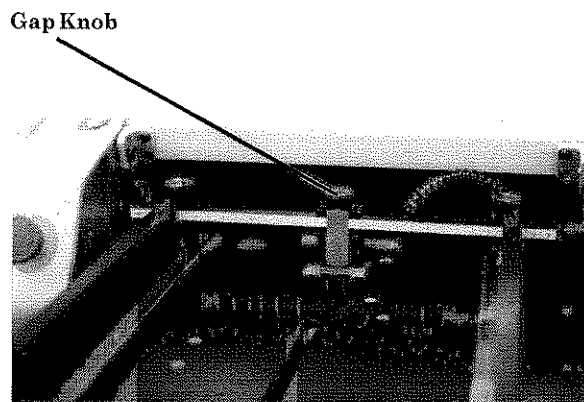
6.2 Feed Table Adjustment

On the paper feed table there are two guides which keep the stack of paper properly aligned for feeding into the folder. Adjust these guides to correspond with the different widths of paper being fed. (See Figure 6.2-1)

To adjust the paper feed guides, loosen the two side guide locking knobs on each guide. Slide the guides from side to side until the inside edge of each guide is aligned with the number corresponding to the width of the paper being folded.

Example: For an 8 1/2-in wide sheet, move the side guides until the inside edges align with the "8 1/2" on the feed table.

An additional check is to lay a sheet of paper on the feeder, close to but not touching the side guides. Push the sheet down into the nip of the fold rolls. Then align the guide by loosening the adjusting knobs and aligning the guide so that it is parallel to the edge of the paper. When one side is square, the other side can be moved into position.

Tighten the locking knobs to secure the paper guides in position.

When you load the actual job, you may have to move these guides slightly to take care of variations in sheet size. To feed properly, the paper must slide freely between these guides.

Side Guide Locking Knobs   Feeder Valve Knob (not shown)

Side Guide Adjustment Knobs   Side Guides
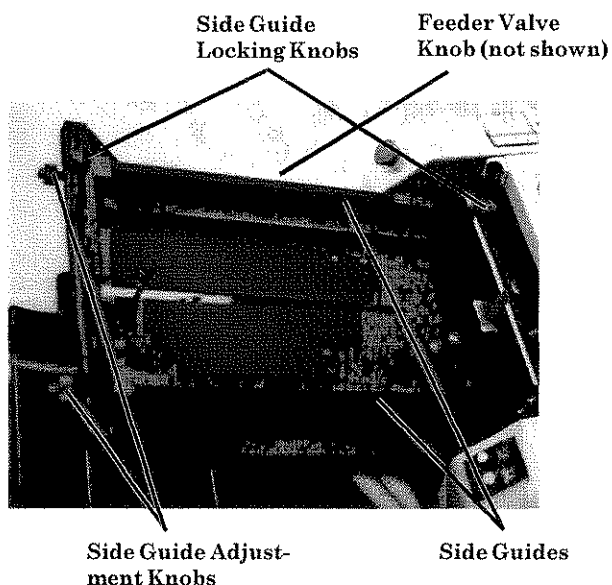
Figure 6.2-1

6.3 Air Blow Adjustment

Turn the air blow adjustment on the vacuum/air control panel fully counterclockwise to the + position. Except for when very small sheets are being run, the air blow adjustment is left adjusted for maximum air. (See Figure 6.3-1)

Once the amount of air blow has been selected using the air blow adjustment, the feeder valve knob may be used to direct the air (See Figure 6.2-1).

Turn the knob to the right to obtain more blow on the right side and front of the feed table. Turn the knob to the left to obtain more blow on the left side and lessen the front blow.

Turn the vacuum adjustment clockwise all the way down. This setting is used for most light and medium papers. Heavy paper will require more vacuum.

Blow   Vacuum

Figure 6.3-1

7.0 OPERATION

7.1 The emergency stop button

The emergency stop button (Figure 7.1-1) will completely shut off all power to the operating system. This will stop everything immediately. Turn the emergency stop button clockwise to release it and return to the operating mode.

Emergency Stop Button

Figure 7.1-1

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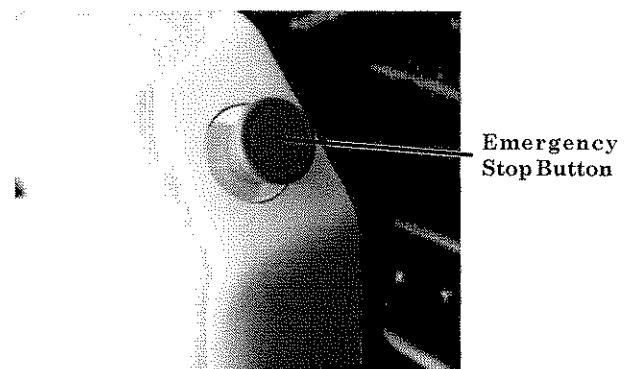
7.2 Loading of Feed Table

Before you can load the paper on the feed table, you must determine which way the paper is to be loaded by running a few sample sheets. (Example: printing face up or face down)
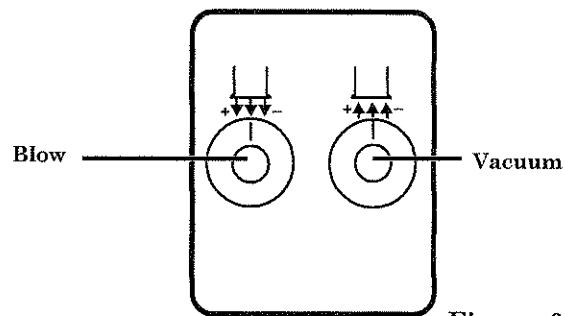
Then you can load a stack of paper no higher than two inches between the paper feed guides. Let the stack slide freely down into position between the side guides.

7.3 Starting the Vacuum/Air Feeder

After the vacuum and air adjustments have been made, start the folder, then start the vacuum/ pump.

Additional paper can be loaded on top of the stack of paper already in the feeder without stopping the machine.

If the feeder runs out of paper or if you want to stop the machine for any reason, first turn off the vacuum pump, then the folder.

7.4 Check Squareness of Fold

Examine the folded sheets on the stacker to make sure that you are getting an even and square fold.

There is a skew adjustment on each plate to adjust for a square fold on paper that is not cut square (See figure 4.7-1).

7.5 Use of Handwheel

The handwheel is used to help clear jams and for setup. To use the handwheel, shut off the folder, pull out the handwheel and turn it in either direction.

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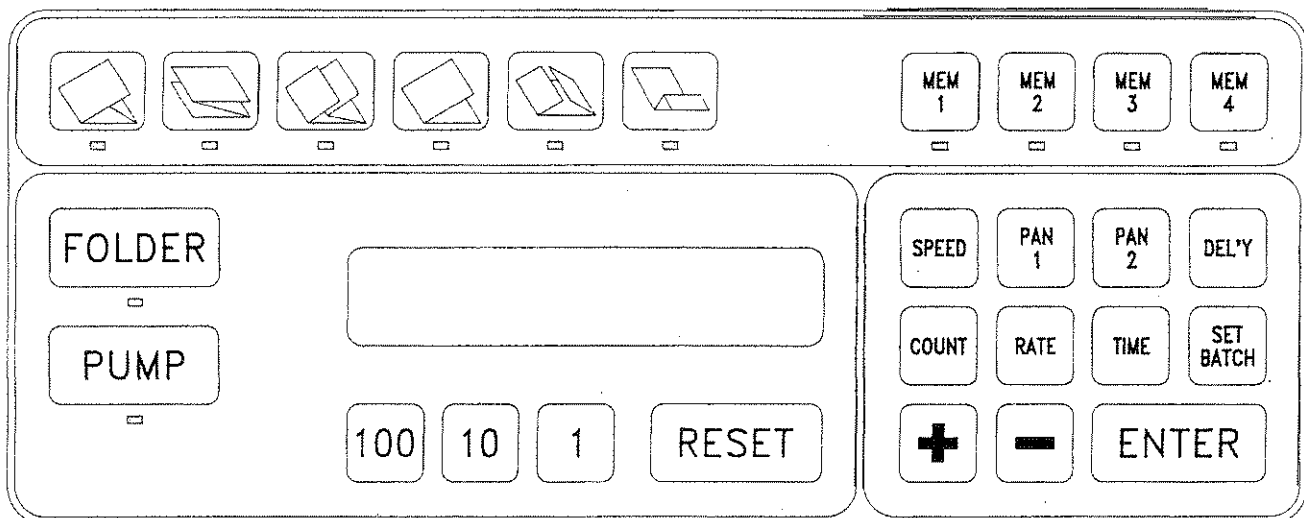
8.0 START UP

On start up the system will first test all L.E.D.s, memory and display characters for 3 seconds.

After the self diagnostic phase, the display will show the version number for 3 seconds.

If there are no error messages the display will go to the jam detector screen if one of the jam detectors is disabled. If none are disabled or after depressing enter, the display will go to the initialization screen.

The initialization screen will remain for 10 seconds. If the (+) button is not pressed during this time no initialization will occur. The display will go to the count screen.

L.E.D.s in the memory, or the fold type buttons will light to indicate the last setting.

NOTE : If the message "**NO CALIBRATION**" appears follow the calibration procedure in section (14.0)

9.0 SETUP

9.1 Setup for a standard fold

To set up for a new fold, just press a fold type button. For example, to set up a "**Z**" fold, press the "**Z**" fold button. The display will tell you to set the paper backstop and press enter. At this point check that the paper backstop is against the paper you want to fold, then press the **ENTER** button.

The plates and the stacker wheels will now move into position to make a "**Z**" fold for the paper on the feed table.

During axis motion, "PLEASE WAIT" will show in the display.

After the plate stops are in position, the display will return to the count screen. At this point you are ready for production.
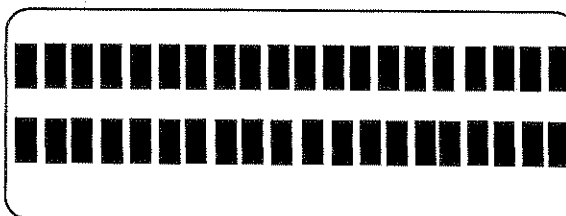
714MP
VER ****

FEEDER JAM DISABLED
DEPRESS ENTER

INITIALIZATION
YES(+)   NO(-)

TOTAL COUNT ########
BATCH   ###   #####

NOTE: If the folder is running the set up and memory buttons are ignored

---

SET THE PAPER BACK-
STOP, PRESS ENTER

PLEASE WAIT

A new job can be set up at any time the folder is off by pressing a fold type button then the **ENTER** button.

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The fold plates will be set per the location of the back stop at the time the enter button was pressed.

If you press the wrong fold type button you can either press the **RESET** button instead of the **ENTER** button to get back to the count screen, or press the correct fold type then press the **ENTER** button.

NOTE: After every new set up the machine speed will always be set to 60 %

NOTE: The L.E.D. in the selected fold type, will stay lit to indicate how the fold plates are set.

9.2 Setting up a special fold.

MEM 1

ENTER

This machine has 4 memory locations that can be used to store special fold settings. These will store the plate settings, the stacker wheel location, and the speed setting for a fold.

9.2.1 To save a nonstandard fold in a memory location

MEM 1

-

ENTER

Set up the fold as you normally would. Once the speed and folds are set the way you want, press a **MEMORY** location button. Recall will appear in the display. Press the (-) button to get to the **STORAGE** screen.

9.2.2 Recall a fold saved in memory location.

Press the **MEMORY** button that corresponds to the memory location you wish to recall. **RECALL** will appear. Press the **ENTER** button.

NOTE: If the folder is running the set up and memory buttons are ignored

RECALL

(N) -   (Y) ENTER

STORAGE

(N) -   (Y) ENTER

STORAGE

(N) -   (Y) ENTER

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The machine speed, the stacker wheel location and fold pan stops will be set to the previously programmed settings.

NOTE: The L.E.D. in the memory button will remain lit to indicate the folder is set up per this memory location. No other fold setup L.E.D.s should be lit.

10.0 COUNTER OPERATION

During normal operation the display should show the total count, and the batch count. The total count should go up to 9,999,999. The batch counter will have 3 digits to count down the pieces in each batch and 5 digits to count the total batches.

```
TOTAL COUNT  ########
BATCH      ###    #####
```

10.1 Resetting the total count.

RESET

COUNT

To reset the total count press the RESET button, then press the COUNT button. This also resets the batch counter, (# of batches & # in the batch).

10.2 Programing the batch counter.

SET BATCH

To program the batch counter. Press the SET BATCH button. At this point, enter a number using the 1, 10, or 100 buttons located under the display. Then enter the amount of time the batch solenoid is activated by pressing the "+" or "-" buttons.

1

Pressing the 1 button will increment the right hand digit shown in the left side of the display. If the digit is 9 pressing the 1 button will change it to zero (0).

10

Pressing the 10 button will increment the center digit shown in the left side of the display. If the digit is 9 pressing the 10 button will change it to zero (0).

```
RESET
```

```
TOTAL COUNT  ########
BATCH      ###    ######
```

```
SET  BATCH
 ###        #.#
```

NOTE: If a button is not pressed within 2 minutes the machine will return to the operating mode.

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100

Pressing the **100** button will increment the left hand digit shown in the left side of the display. If the digit is 9 pressing the **100** button will change it to zero (0).

10.3 Setting the dwell

+ **−**

You can set the dwell by pressing the "+" button to increase it or the "-" button to decrease it.

+

Pressing the "+" button will increment the dwell time .1 second if the dwell time is 9.9 seconds pressing the "+" button will have no affect.

−

Pressing the "-" button will decrease the dwell time .1 second. If the dwell time is 0.3 seconds pressing the "-" button will have no affect.

ENTER

Once you have entered the desired value press the **ENTER** button. This will store this number in memory, reset the total batch counter to zero (0) and return to the operating mode.

10.4 Resetting the batch count.

RESET

SET BATCH

To reset the batch counters press the **RESET** button, then press the **SET BATCH** button. This will reset the batch count and the total batches.

10.5 Rate

The **RATE** button is used to display the average pieces per hour, both current and average since the last total counter reset.

RATE

Pressing the **RATE** button will change the display to the rate screen consisting of two lines. The top line is the current rate. It will have a 5 digit display, and will refresh every 6 seconds. The second line will show the average pieces per hour since the last total counter reset. This line will also have a 5 digit display, and refresh every 30 seconds.

```
SET  BATCH
###        #.#
```

NOTE: If no changes are made to the batch size the counters are not reset.

NOTE: Set the batch size to 000 (zero) to disable batching.

NOTE: Dwell is the length of time the feeder is off between batches.

```
RESET
```

NOTE: If a button is not pressed within 2 minutes the machine will return to the operating mode.

```
TOTAL COUNT ########
BATCH        ###    #####
```

```
CURRENT RATE #####
AVERAGE RATE #####
```

$$\frac{\text{TOTAL \# SH}}{\text{TIME BASE}} \qquad \frac{\text{SH}}{\text{HR}}$$

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The display will stay in this mode until another mode button is pressed. The **ENTER** and **RESET** buttons will have no affect in this mode.

> NOTE: Every time the total
> count is reset the
> average rate per
> hour will also be
> reset.

11.0 FOLDER OPERATION

11.1 Time

TIME

The **TIME** button will display the time since the last total count reset and the total hours that the main drive has been on, the customer can not reset this meter.

Both hour meters will increment only when the folder is running. The pump operation or the main power will have no affect on these meters.

> NOTE: Every time the total
> count is reset the
> job run time
> should also be reset.

Pressing the **TIME** button will change the display to the time mode. In this mode the first line of the display will show job run time and have a 4 digit capability to show the number of hours since last reset. The second line will show total hours and have a 6 digit capability to show the total hours on the machine.
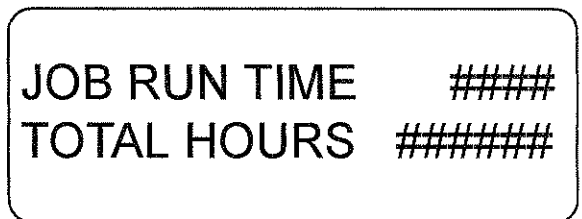
COUNT

The **COUNT** button can be used to go back into the count screen from the rate screen.
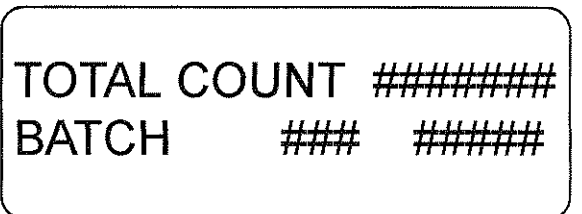
START STOP ①

11.2 START/STOP button

In the normal operating mode pressing the **START/STOP** button will activate the main drive motor and the L.E.D. in the button will come on. Pressing the **START/STOP** button again will deactivate the main drive motor and turn off the L.E.D..

```
┌─────────────────────────────────┐
│                                 │
│ JOB RUN TIME    ####            │
│ TOTAL HOURS   ######            │
│                                 │
└─────────────────────────────────┘
```

> NOTE: If a button is not pressed
> within 2 minutes the machine
> will return to the operating
> mode.

```
┌─────────────────────────────────┐
│                                 │
│ TOTAL COUNT ########            │
│ BATCH       ###   #####         │
│                                 │
└─────────────────────────────────┘
```

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11.3 PUMP button

PUMP ON/OFF ⏻

In the normal operating mode pressing the **PUMP** button will activate the pump motor, and the L.E.D. in the button will come on. Pressing the **PUMP** button again will deactivate the pump motor and turn off the L.E.D..

11.4 Speed

SPEED

+   **−**

+

−

The speed of the machine can be changed by pressing the **SPEED** button while the main drive motor is running or stopped.

Using the "+" and "−" buttons, to adjust the speed.

The "+" button will increase the speed gradually, as long as the button is depressed. Once the folder reaches it's maximum speed a message will be displayed until the **ENTER** button is pressed.

The "−" button will decrease the speed gradually, as long as the button is depressed.

Once the folder reaches it's minimum speed a message will be displayed until the **ENTER** button is pressed.

ENTER

It will take 10 seconds to travel the full speed range of the motor. Pressing the **ENTER** button will return you to normal operation.

11.5 Pans

The fold pans can be set at any time from the operating mode by pressing the pan button that corresponds to the fold pan which needs to be adjusted.

PAN 2

For example if you need to make an adjustment to the number 2 fold pan you would press the **PAN 2** button.

```
SPEED                60%

CHANGE WITH +/-
```

NOTE: If a button is not pressed within 2 minutes the machine will return to the operating mode.

```
MAXIMUM SPEED

CHANGE WITH +/-
```

```
MINIMUM SPEED

CHANGE WITH +/-
```

```
TOTAL COUNT  ########

BATCH      ###    #####
```

```
PAN 2 STOP      05.00 IN

CHANGE WITH +/-
```

NOTE: If a button is not pressed within 2 minutes the machine will return to the operating mode.

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Next use the "+" and "-" buttons to move the stop into position. Once either button is pressed the display will change to display the actual location of the plate stop.

Pressing the "+" button once will increment the plate stop .010". Holding it down for more than 2 seconds will increment the plate stop continuously at slow speed. Holding the "+" button down for more than 5 seconds will increment the plate stop continuously at high speed until you release the button or the plate stop hits the home position switch.

Pressing the "-" button once will decrement the plate stop position .010". Holding it down for more than 2 seconds will decrement the plate stop position at slow speed. Holding the "-" button down for more than 5 seconds will decrement the plate stop position at high speed until you release the button, or the plate stop hits the deflect position switch.

Pressing the **ENTER** button will return you to normal operation.

11.6 Stacker wheels

The stacker wheels can be set at any time from the operating mode by pressing the **DEL'Y** button.

For example if you need to make an adjustment to the stacker wheels, press the **DEL'Y** button during operation.

Next use the "+" and "-" buttons to move the stacker wheels into position.

```
PAN 2 STOP      05.00 IN

CHANGE WITH +/-
```

```
                ##.##
```

NOTE: To change from English to Metric, press any of the following buttons. **PAN 1**, **PAN 2** or **DEL'Y**, then the **RESET** button. Now all the dimensions will be in metric. The setting will remain until this procedure is repeated.

```
TOTAL COUNT  #######
BATCH       ###   #####
```

```
DELIVERY        04.00 IN

CHANGE WITH +/-
```

+

Pressing the "+" button will increment the stacker wheels continuously at slow speed. Holding the "+" button down for more than 2 seconds will increment the stacker wheels continuously at high speed until you release the button, or the stacker wheels reach their outer limit. The system will track the stacker wheel location and if they reach the stop, the drive will be disabled and a message will be displayed for 5 seconds after the "+" is released.

STACKER WHEELS
AT MAXIMUM LIMIT

–

Pressing the "-" button will decrement the stacker wheels position at slow speed. Holding the "-" button down for more than 2 seconds will decrement the stacker wheels position at high speed until you release the button or the stacker wheels hit the home position. Once the stacker wheels have reached the home switch the drive is disabled and a message will be displayed for 5 seconds after the "-" is released.

STACKER WHEELS
AT MINIMUM LIMIT

TOTAL COUNT ########
BATCH ### #####

ENTER

After the stacker wheels are in position press the **ENTER** button. This will return you to the operating mode.

11.7 Paper Jams

DEL'Y

RESET

Should a jam-up occur, the machine will shut off and display will indicate where the jam occurred. Anytime a jam indication is showing in the display you can press the **DEL'Y** button and the stacker wheels will move to the end of the table to make clearing any paper jammed in the machine easier. Try to determine the cause of the jam and correct it before pressing the **RESET** button. Pressing the **RESET** button will clear the jam message, return the stacker wheels to there original position and re-enable the drive.

FEEDER JAM

FOLDER JAM

DELIVERY JAM

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12.0 PERFORATING, SCORING & SLITTING

In addition to folding, your AUTOFOLD Air Feed can perforate, score and slit.

WARNING
Be careful when handling perforator and slitting blades. They are extremely sharp.

12.1 Perforating

The AUTOFOLD can be used to perforate either the folded sheet (to assist in making a right-angle fold) or to perforate sheets delivered flat. BAUMFOLDER supplies one standard 41-tooth perforator blade. Additional perforator blades are available through the BAUMFOLDER Parts Department.

The perforator blade should be mounted loosely to the blade holder with the retainer collar to give better support to the perforator blade. Always be sure that the flat side of the blade is against the blade holder. Loosen the brass-tipped set screws in the perforator collar and blade holder before attempting to place them on the slitter shafts.
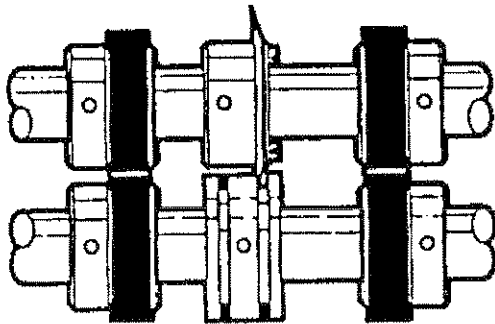

Figure 12.1-1

The perforating blade holder assembly is then slid onto the upper slitter shaft along with the necessary pull-out tire assemblies. Then tighten the screws holding the perforator blade to the blade holder, aligning the blade to the holder. This allows for free horizontal movement on the shaft.

Slide the grooved perforator collar onto the lower slitter shaft along with the other pull-out tire assemblies. The flat side of the perforator blade should just touch the side of the groove in the perforator collar. (See Figure 12.1-1)
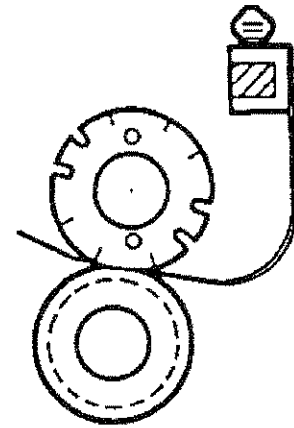

Figure 12.1-2

Slide the perforator collar and blade holder to the desired position on the slitter shaft. Then lock the blade holder and perforator collar into position with the brass-tipped set screw.

The perforator stripper fits onto the slitter shaft bar in between or next to the perforating blade. (See Figure 12.1-2) This strips the paper off for delivery and prevents it from wrapping around the perforator blade.

12.2 Scoring

The AUTOFOLD can be used to score a sheet and deliver it flat, or to score a sheet after a fold or folds have been made.

To ensure accuracy in making right-angle folds, always score the sheet where the fold is to be made. This applies in all instances when a perforator cannot be used.

Attach the scoring blade loosely to the blade holder for mounting on the slitter shaft. Scoring blades can be mounted on either the upper or lower slitter shaft. Once on the shaft, tighten the screws, aligning both the blade and the collar. This allows free horizontal movement on the shaft. Scoring blades should be placed so that the fold will be made with rather than against the scoring, or, in a continuing direction to the pressure of the crease that has been applied by the scoring blade.
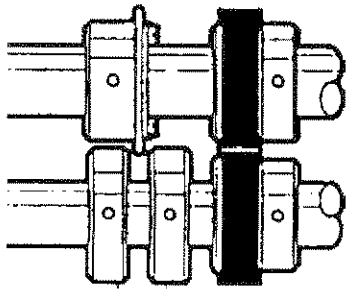
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Figure 12.2-1

For a wide, well-rounded score, use the two steel scoring collars. (See Figure 12.2-1) Sharpness and the depth of the score can be controlled by regulating the distance the collars are placed away from the scoring blade.

The scoring collars can also be placed on either side of the rubber scoring collar. The two collars can be compressed against the rubber collar, causing the rubber to bulge up for a deeper score. (See Figure 12.2-2)
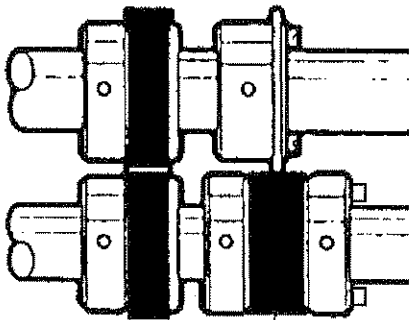

Figure 12.2-2

12.3 Slitting

NOTE: Slitting accessories are optional on your Quickfolder and can be ordered from your BAUMFOLDER Parts Department.

The AUTOFOLD can be used to cut folded or flat sheets apart. The general setup for blades and collars is shown in (Figure 12.3.1). Two or more cuts may be made if duplicate sets of cutters are used.
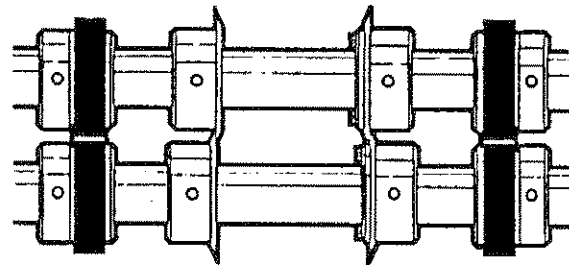

Figure 12.3.-1

Use care in mounting slitter blades to the collars in order to avoid ragged edges during slitting operations. Ragged edges can be caused by two conditions:

1) Nicks or burrs on the collars or blades. Remove carefully by filing or using a fine piece of emery cloth.

2) Incorrect mounting of blades caused by tightening with the wrong type of screw. Always use flat head screws on the side of the blade and blade holder collar, which are countersunk.

Before tightening the blade to the collar, slide the blade with the collar loosely attached on the end of the shaft. Then tighten securely, thus aligning both the blade and collar, allowing free horizontal movement along the shaft.

Place the blade, mounted on the collar, on the upper shaft in the proper position where the cut is to be made. Then move the blade and collar on the lower shaft so that the two flat edges of the blades are pressed snugly together. Too much space between the blades will produce a ragged cut.

Space the rubber pull-out tires to support the sheet.

13.0 MAINTENANCE

13.1 Maintenance and Care of your AUTOFOLD

The AUTOFOLD Air Feed has been designed to give you years of useful service, provided you maintain it according to these instructions.

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13.2 Lubrication

Apply one or two drops of light machine oil at all slitter shaft bearings and the feed table bearings and idler gear once a week. Be sure to keep oil off any surface which may contact the paper.

13.3 Cleaning of Fold Rolls

Periodically wipe off the rubber surface of the fold rolls using an approved solvent such as Surewash or its equivalent. Surewash is available from BAUMFOLDER in 1-quart (P/N 24108-001) and 1-gallon (P/N 24108-002) containers. A complementary bottle of Surewash is included with your machine.

13.4 Cleaning Filters

The filters on the pump should be checked periodically and cleaned as needed. The filters can be reached by unscrewing the filter jars.

13.5 Photo Eyes

Occasionally wipe off both photo eyes with a dry cloth.

13.6 Cleaning The Fold Stop Guides

The fold stop guides (See figure 4.7-1) should be cleaned once a week with a dry cloth to keep the plate moving properly.

13.7 Replacement Parts

To order replacement parts for your AUTOFOLD Air Feed, contact BAUMFOLDER Parts Department toll free, **800-543-6107**.
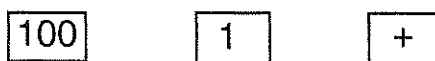
Always be sure to give the model number and serial number of your AUTOFOLD to ensure receiving the proper parts.

14.0 CALIBRATING THE 714MP AUTOFOLD

1) Place *calibration gage* on *feed table*.

Set this edge against caliper

- Position 2
- Position 3
- Position 1
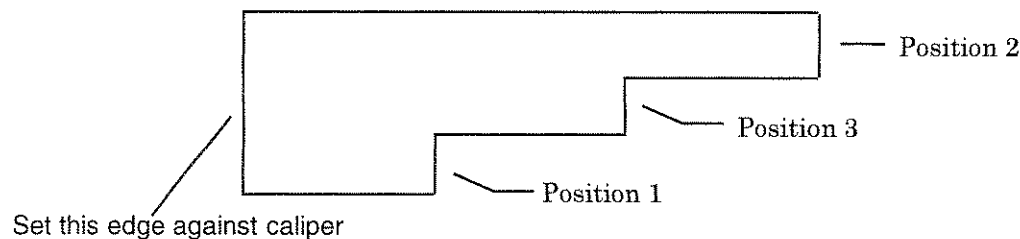
2) To enter calibration mode, push the following three buttons at the same time:

| 100 | | 1 | | + |

Display shows:

```
CALIBRATE PAPER
LENGTH   YES(+)  NO(-)
```

3) If the "–" button is depressed, return to count screen.

4) If the "+" button is depressed,

Display shows:

```
MOVE PAPER BACKSTOP
TO POSITION 1 (ENTER)
```

5) Move the *infeed table paper stop* to the front detent near the *feed wheel* (position 1 on the diagram above) and press the **ENTER** button. First data point entered.

Display shows:

```
MOVE PAPER BACKSTOP
TO POSITION 2 (ENTER)
```

6) Move the *infeed table paper stop* to the rear detent (position 2 on the diagram above) and press the **ENTER** Button. Second data point entered.

Display shows:

```
MOVE PAPER BACKSTOP
TO POSITION 3 (ENTER)
```

7) Move the *infeed table backstop* to the center detent (position 3 on the diagram above) and press the **ENTER** button. Folder determines if data points are within tolerance.

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8) If calibration is within tolerance,

Display shows:

> CALIBRATION OK

After 7 seconds display will return to the count screen.

9) If calibration is out of tolerance,

Display shows:

> CALIBRATION FAILED
> REPEAT Y(+) N(-)

10) If the "+" button is depressed system returns to step 4.

11) If the "−" button is depressed system returns to count screen.

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15.0 SHUTTING OFF THE JAM DETECTORS

1) To enter jam detector mode, push the following three buttons at the same time:

10		1		—

Display shows:

> FEEDER JAM ENABLED
> DISABLE ? (+) YES (-) NO

OR

Display shows:

> FEEDER JAM DISABLED
> ENABLE ? (+) YES (-) NO

2) When the "+" or "-" button is depressed,

Display shows:

> FOLDER JAM ENABLED
> DISABLE ? (+) YES (-) NO

OR

Display shows:

> FOLDER JAM DISABLED
> ENABLE ? (+) YES (-) NO

3) When the "+" or "-" button is depressed,

Display shows:

> EXIT JAM ENABLED
> DISABLE ? (+) YES (-) NO

OR

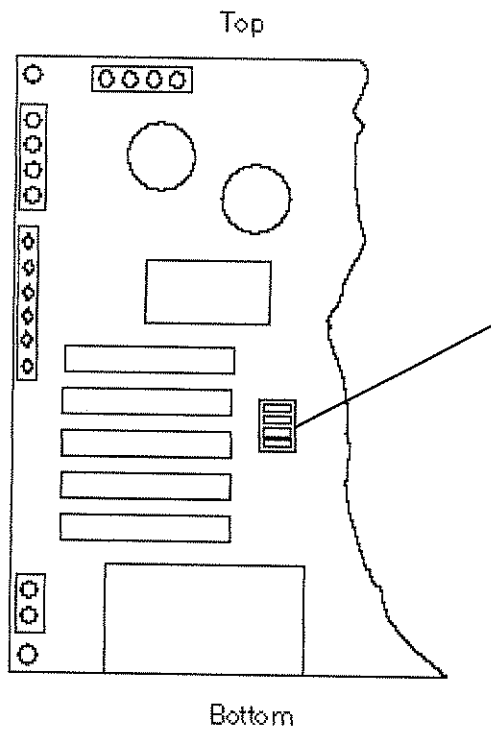Display shows:

> EXIT JAM DISABLED
> ENABLE ? (+) YES (-) NO

4) When the "+" or "-" button is depressed,

Display shows:

> TOTAL COUNT ######
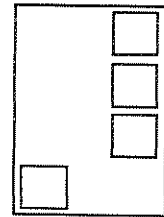> BATCH ### #####

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16.0 LANGUAGE SELECTION

Position of switchboard for language selection on electronic board.

Top

Bottom

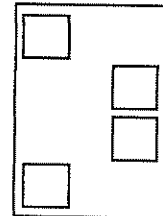Position of switches for different languages:
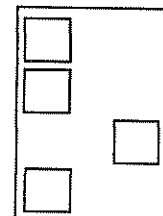
English

LANG 1
LANG 2
LINE VOLT
OVERRIDE

German

LANG 1
LANG 2
LINE VOLT
OVERRIDE
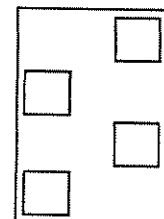
Spanish

LANG 1
LANG 2
LINE VOLT
OVERRIDE

French

LANG 1
LANG 2
LINE VOLT
OVERRIDE

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SUREWASH
17.0 MATERIAL SAFETY DATA SHEET

NOTICE: Surewash is a product of RBP Chemical Corporation, 150 S. 118th St., P.O. Box 14069, Milwaukee, Wisconsin 53214-0069. Tel. 414/258-0911, 800/558-0747.

```
H M I S RATING

Health: 1
Flammability: 2
Reactivity: 0
Personal Protection: 8
```

HAZARDOUS INGREDIENTS
Name: Medium Aliphatic Solvent Naptha (Syn: 140 HF Mineral Spirits)
CAS#: 64742-88-7
ACGIH TLV: 100ppm
OSHA PEL: 500ppm
%: <95

PHYSICAL/CHEMICAL CHARACTERISTICS
Boiling Point: ND
Solubility in Water: Insoluble
% Volatiles (by vol.): 95
Specific Gravity: 0.786
Appearance and Odor: Clear, light blue liquid with pleasant odor.

FIRE AND EXPLOSION HAZARD DATA
Flash Point: 140' F
Extinguishing Media: CO_2, Dry chemical, Foam
Special Fire Fighting Procedures: Wear self-contained breathing apparatus for any fire involving chemicals.
Unusual Fire and Explosion Hazards: None

REACTIVITY DATA
Stability: Stable
Incompatibility: Strong oxidizers
Hazardous Decomposition By-products: Carbon dioxide/monoxide
Hazardous Polymerization: Will not occur
Conditions to Avoid: Heat, Sparks, and Open Flames

HEALTH HAZARD DATA
Routes of Entry: Inhalation, Primary; Skin, Secondary; Ingestion, Unlikely
Health Hazards Acute and Chronic: Chronic inhalation of high concentrations may cause respiratory tract irritation and may affect central nervous system. May cause skin irritation. Chronic over-exposure to many petroleum hydrocarbons may cause liver or kidney injury. May cause eye irritation.

Emergency & First Aid Prodedures:
Skin Contact: Wash affected area with soap and water. Remove contaminated clothing.
Eye contact: Flush eyes with water for at least 15 minutes. Consult a physician.
Inhalation: Remove to fresh air. Restore breathing if required. Get medical attention.
Ingestion: DO NOT induce vomiting. Get medical attention.
Carcinogenicity: None of the ingredients in this product are listed by IARC, NTP, or OSHA as carcinogenic.
Signs and Symptoms of Over-exposure: Headache, dizziness, nausea, irritation of the mucous membranes, respiratory tract irritation or mild narcosis at high concentrations.
Medical Conditions Aggravated by Exposure: May aggravate an existing dermatitis.

PRECAUTIONS FOR USE AND DISPOSAL
Spills: Small spills can be soaked up with suitable absorbent. For large spills, dike the spill and pump to salvage tank.
Waste Disposal: Incineration or absorbent disposal according to local, state, or federal regulations.
Special Storage/Handling Precautions: None

CONTROL MEASURES
Respiratory Protection: Organic vapor respirator for concentrations above the TLV.
Ventilation: Mechanical
Eye Protection: Recommended
Gloves: Recommended, butyl, rubber or neoprene.
Other: Eye bath or safety shower should be located in the work place when working with chemicals.

*ND = No data found or not determined.

The information contained herein is furnished without warranty of any kind. Users should consider this data a supplement to other information gathered by them and are responsible for completeness of information to assure proper use of these materials and the safety and health of their employees.

This MSDS was prepared under the direction of: Wayne Koontz, Safety Director, 10-5-87; Revised 2-10-88 WJK, Rev. Code:01B.

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To order Surewash call toll free, 800/
543-6107
Part numbers: 24108-001 (quart) &
24108-002 (gallon)
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Call Toll Free

BAUMFOLDER PARTS

800-543-6107