FORMAX®

AC-10
In-Line Folder

10/2018

OPERATOR MANUAL

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INTRODUCTION AND SPECIFICATION

The **AC-10** is a self powered, stand alone folding machine with an innovative new vacuum controlled sheet alignment system which has been designed to take pre-creased stock from a wide range of both Formax and 3rd party creasing machines.

The A C - 1 0 features the unique Flying Knife Folding System used successfully in the much acclaimed Digifold which allows folding of most stocks from 0.1mm, reducing the possibility of scratching, marking or cracking of the substrate as is often associated with conventional folding systems.

A maximum paper thickness cannot be specified, as this is governed by the hardness of the substrate and the type of fold required; but in most cases stocks up to 0.35mm should present no problems providing they are properly pre-creased.

It is **IMPORTANT** to note that to prevent cracking, when using dry ink or toner based print engines, the material **must** be fully acclimatised for at least 48 hours before putting an image onto the paper.

IMPORTANT the operating environment should be controlled to a temperature between 16° C and 27° C Maximum.

Specification

Feeding System	Conveyor Vacuum Sheet Alignment
Input Bed Height	Adjustable from 850mm to 1000mm
Max. Sheet Size	600mm x 385mm (24” x 15”)
Min. Sheet Size	210mm x 140mm (8.3” x 5.5”) (dependant on stiffness of paper and type of fold).
Max. Paper Thickness	0.40mm (varies according to hardness, type of fold, and substrate).
Min. Paper Thickness	0.11mm (varies according to hardness, type of fold, and substrate).
Max. No. Folds per Sheet	2
Max. No. Stored Programmes	Unlimited
Min. Repeat Fold Distance	70mm (2.75”) (depending on paper weight)
Min. Fold Distance from Leading Edge	50mm (1.96”) (depending on paper weight)
Min. Fold Distance from Tail Edge	50mm (1.96”) (depending on paper weight)
Min. Fold Length	70mm (2.75”)
Speed per Hour (A4 in half)	6240 sheets (When used with a Formax Atlas Creaser; set on speed 3, Pulsed).

Note: The production speed varies according to the material size and the fold type.

Dimensions	L: 1700mm H: 1220mm W: 680mm L: (66.9”) H: (48”) W: (26.8”)
Weight	128Kgs (+50Kgs packing)
Power Requirement	1 phase 230v 50hz 1 phase 220v 60Hz, 1 phase 110v 60Hz
Sound Power Level (Connected to an Atlas C102)	77.0 decibels

*As part of our continued product improvement plan, specifications and information published in this manual are subject to change without notice.

All specifications are dependant on application, type of stock, temperature, relative humidity, RH and print engine used.

Specifications quoted were measured on uncoated and unprinted stock. E & OE.

Safety Do’s & Don’ts

REGLES DE SECURITE : « A FAIRE » ET « A NE PAS FAIRE »

Do - read this operator manual fully before operating the machine.
Lire ce mode d'emploi avant d'utiliser la machine.

Do - operate with the designated AC current only. Use an exclusive outlet, as overloading may cause fire or an electric shock.
Respecter l'alimentation électrique indiquée. Brancher sur une prise séparée car une surcharge peut entraîner un incendie ou un choc électrique.

Do - install the power cord out of the way to avoid a tripping hazard.
Installer le cordon d'alimentation de manière à ne pas pouvoir trébucher par dessus.

Do - make sure that the mains inlet connector is always easily accessible.
Ménager un accès libre à la prise de courant.

Do not - install the machine in an unstable place such that it tilts or shakes.
Ne pas installer la machine sur une surface non plane, afin d'éviter qu'elle ne penche ou ne vibre.

Do not - unplug the plug or unplug the power cord from the outlet with a wet hand, this can cause an electric shock.
Ne pas installer la machine sur une surface non plane, afin d'éviter qu'elle ne penche ou ne vibre.

Do not - unscrew and remove any covers from the machine, as it can cause an electric shock or injury.
Ne démonter et enlever aucun carter de la machine, par crainte de décharge électrique ou de blessure.

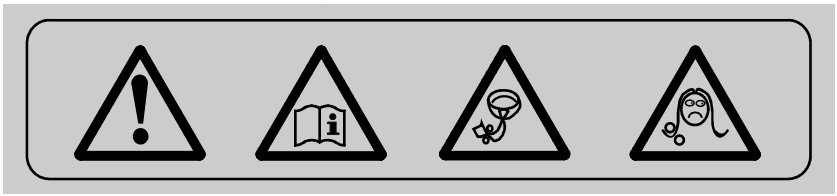
Do not - place receptacles containing liquids on any surface.
Ne pas placer de récipient contenant un liquide sur la machine.

Do not - adjust any part of the machine whilst rollers are running
N'effectuer aucun réglage pendant que les rouleaux fonctionnent.

Do not - operate the machine with loose or trailing clothing or loose hair.
Ne pas porter de vêtements flottants et rassembler les cheveux longs lors de l'utilisation de la machine.

Do not - under any circumstances adjust the paper gate when the machine is switched on.
En aucune circonstance, régler le séparateur de papier lorsque la machine est branchée.

Warning Labels

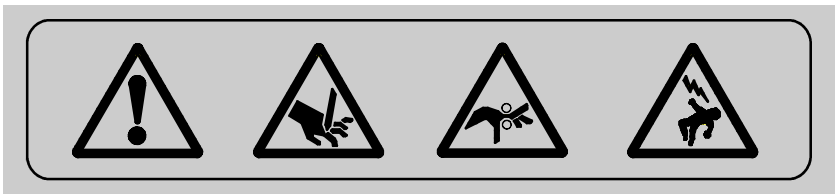


Do - be aware of any finger traps and rotating parts when operating the machine.
Attention au risque de se coincer les doigts, et aux pièces en mouvement lors du fonctionnement de la machine.

Do - read this operator manual fully before operating the machine.
Lire ce mode d'emploi avant d'utiliser la machine.

Do not - operate the machine with loose or trailing clothing.
Ne pas porter de vêtements flottants lors de l'utilisation de la machine

Do not - operate the machine with loose hair.
Rassembler les cheveux longs lors de l'utilisation de la machine.



Do - be aware of any finger traps and rotating parts when operating the machine.
Attention au risque de se coincer les doigts, et aux pièces en mouvement lors du fonctionnement de la machine.

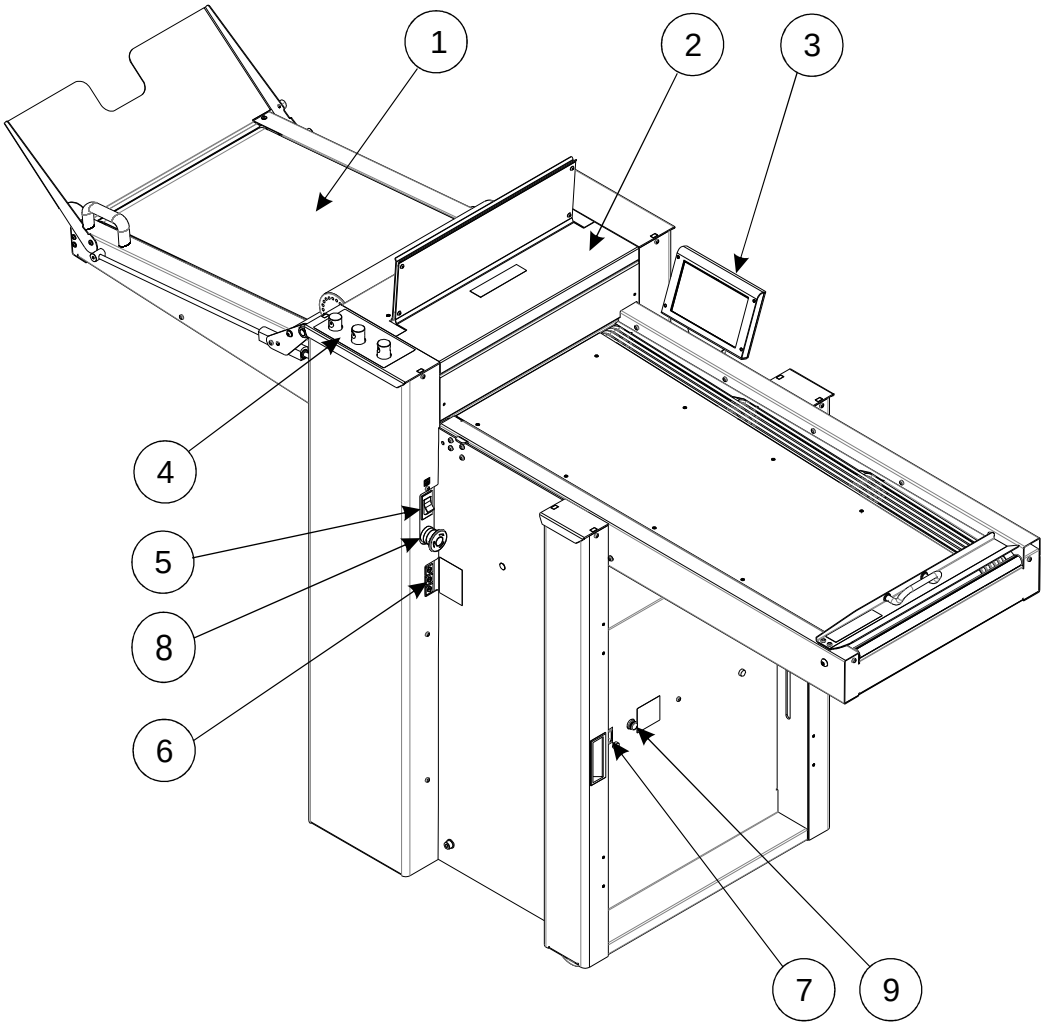
Do - be aware of sharp points and blades.
Attention aux éléments tranchants et aux couteaux.

Do - be aware of rotating rollers.
Attention aux rouleaux en fonctionnement

Do - be aware of low current anti-static shock.
Attention aux faibles chocs d'électricité statique

Key to photograph below

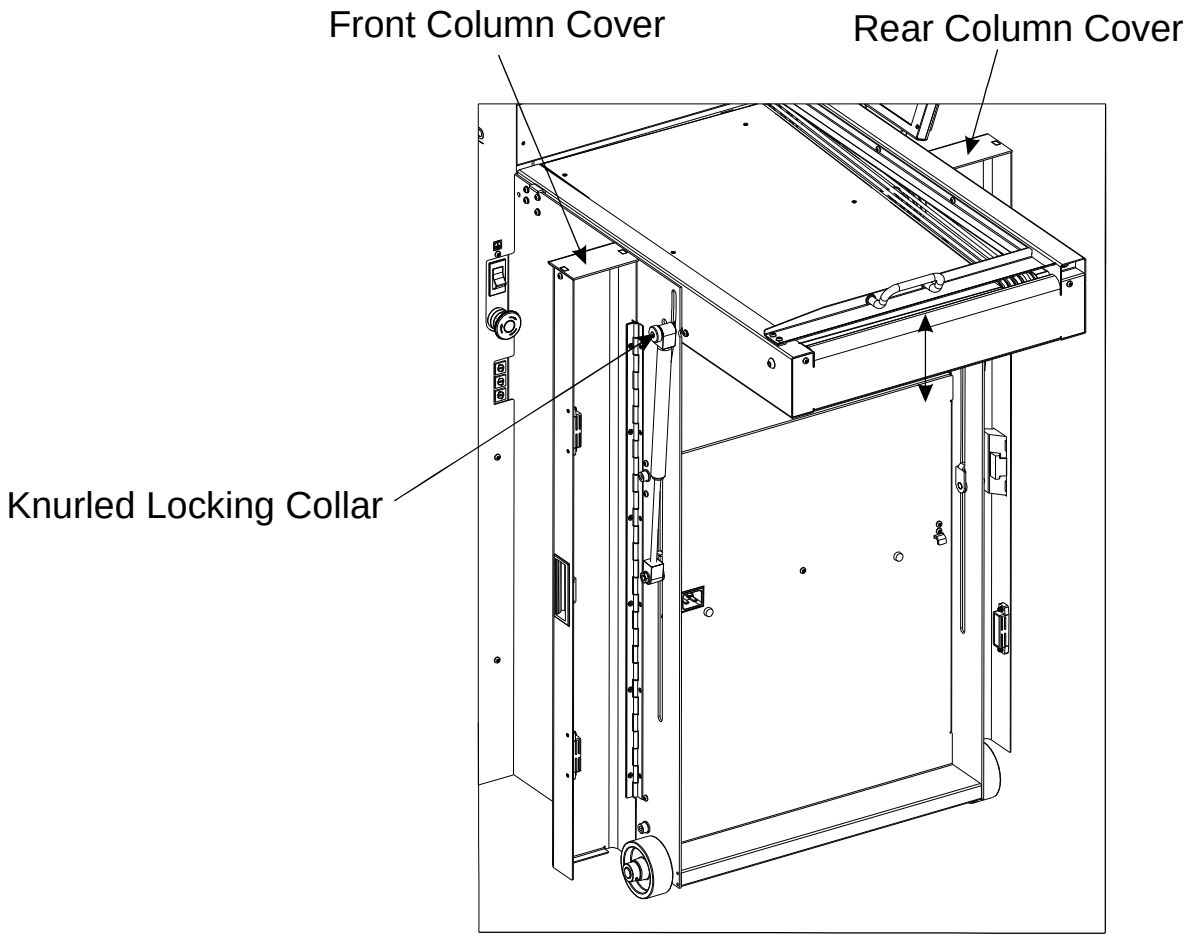
1	Delivery assembly	2	Top Cover	3	Touchscreen
4	Gap Set Knobs	5	System Switch	6	Fuses
7	Mains Input Socket	8	Emergency Stop Switch	9	Mains Fuse



ADJUSTING THE TILT OF THE FEED BED

1. The Feed Bed can be tilted, so that it matches the height of the creasing unit that is being used with it.

   (i) Open the front and rear column covers.
   (ii) Loosen the knurled locking collar at the top of the front gas spring.
   (iii) Adjust the tilt of the Feed Bed, (up or down) to match the height of the creasing unit, then re-tighten both of the knurled locking collars.



FITTING THE TRANSFER BED ASSEMBLY TO A ATLAS CREASER AND ALIGNING THE MACHINES.

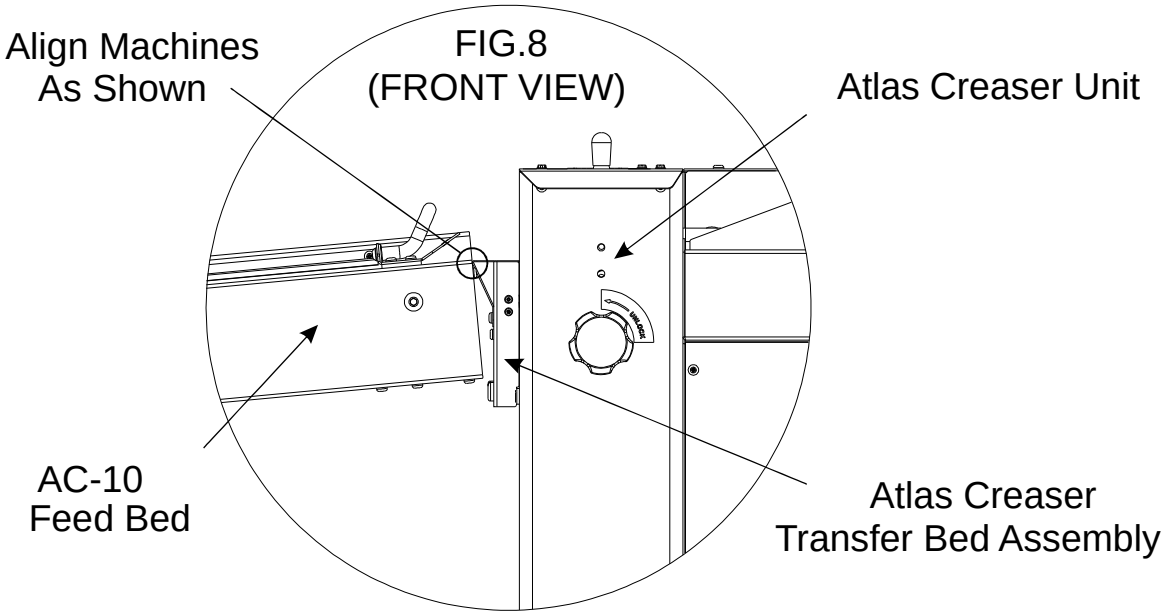
1. The AC-10is supplied, as standard, with a Transfer Bed Assembly that fits onto the Atlas C102 Creaser. A Transfer Bed Assembly that will fit the narrower Atlas C102 Creaser can be purchased as an optional extra (see accessories and options on page 39).

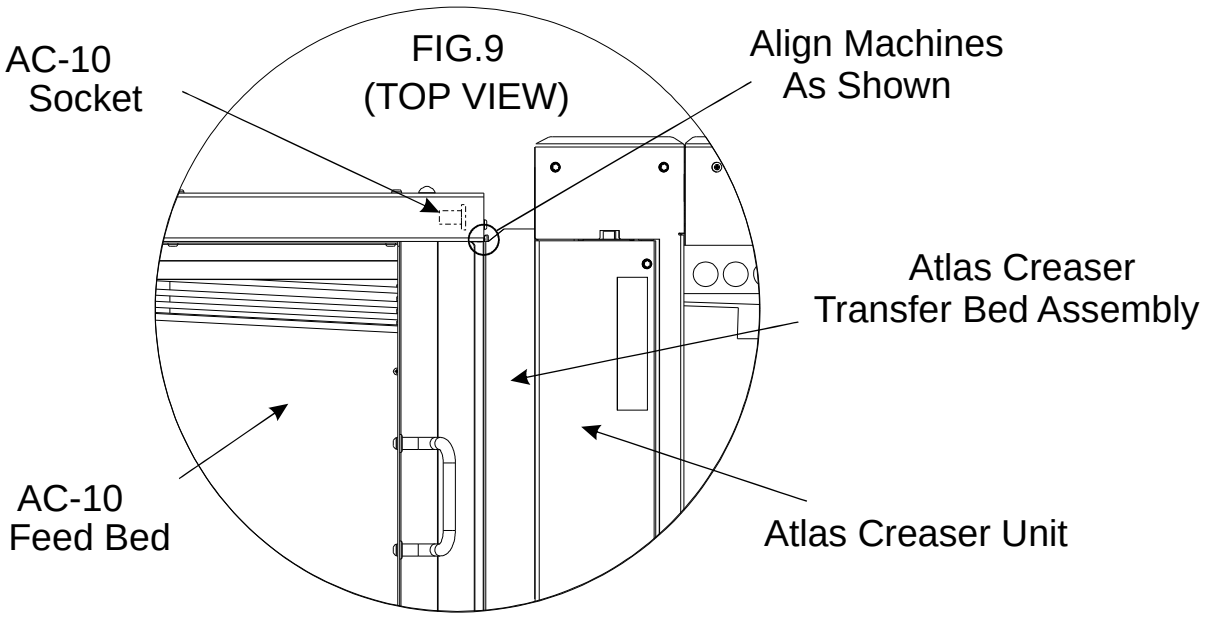
   (i) Remove the stacker unit from the Atlas Creaser and fit the Transfer Bed Assembly as shown in FIG.8
   (ii) Tilt the feed bed of the AC-10, as described above, to align with the Transfer Bed Assembly as shown in FIG.8

(iii) Adjust the relative positions of the machines so that the Transfer Bed Assembly aligns with the AC-10 Feed Bed as shown in FIG.9

(iv) Plug the connector, on the flying lead of the Transfer Bed Assembly, into the AC-10 Socket as shown in FIG.9. This electrical connection between the AC-10and the Atlas Creaser is a safety feature. If the system switch on the AC-10 is switched off or a jam occurs on the AC-10 the Atlas Creaser will stop feeding.

NOTE.
When using the AC-10 with an AtlasC102 or an Atlas C200, it is recommended that the Atlas Creaser is set to Pulse Feed and the speed is set to number 2. Depending on the type of crease and length of the paper, the speed setting may need to be changed to speed number 1 or number 3.





TOUCHSCREEN OPERATION

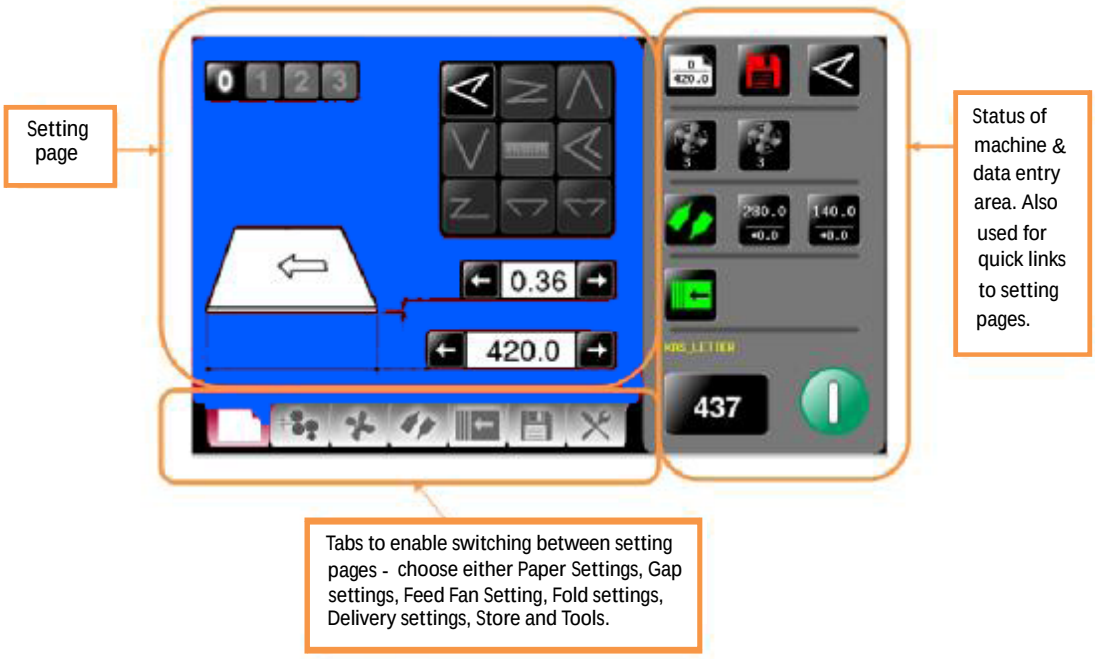
1. Turn the Emergency Stop button clockwise to switch the power on. After the system start up procedure the touch screen will be displayed as shown below.

IMPORTANT.

If you have not been trained to operate this machine, we strongly advise that you select the red cross icon.
We recommend that you either seek training or ask a trained operator to run the machine for you.
Select the green tick icon only if you have been trained to operate this machine.
If you have not been trained to operate this machine and you select the green tick icon, Formax accepts no responsibility for personal injury, damage to the machine or damage to materials being processed by the machine.

WARNING:-
Wait at least 10 seconds, after making any selection on the Touchscreen panel, before switching the machine OFF. Failure to do so could result in the data storage being corrupted, and the machine not operating.

The touch screen is laid out into 3 main areas as shown below:



Setting Pages.

Paper settings Page

Paper Type - As a guide choose as follows:

0 - approx 0.1 thk

1 - approx 0.2 thk

2 - approx 0.3 thk

3 - approx 0.3+ thk

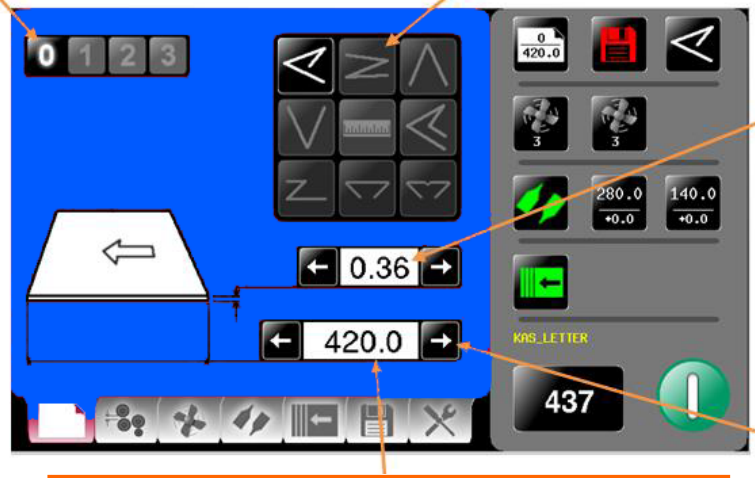
See Page 19

Fold Selection - For quick setting of fold positions on standard size sheets.

Highlighted fold is type currently selected, other folds may be selected. Currently selected fold is shown in the status area.

NOTE:-

Select the Ruler Icon to set Fold positions manually ('Set by Position' mode).



Page Thickness - On selection of status area is replaced with a calculator for inputting new values

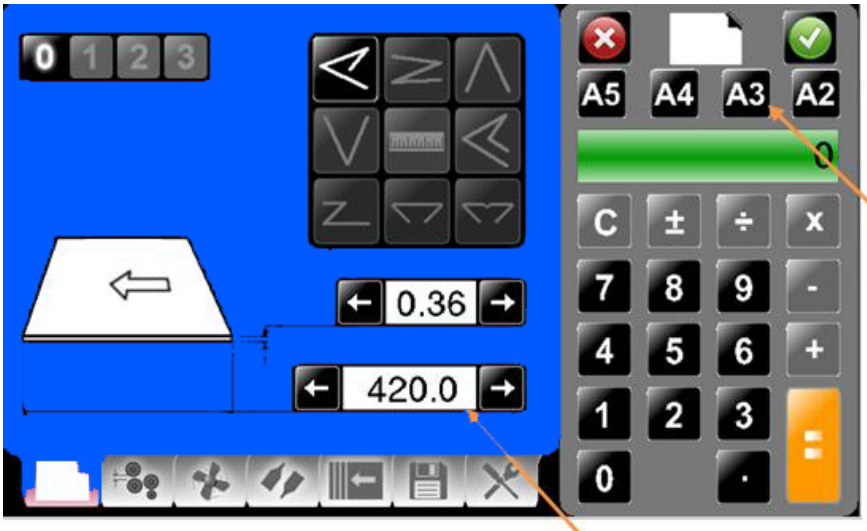
Range = 0.1 to 0.4mm

Increments of 0.01mm

Arrows may be selected to increase or decrease the page size in 0.1mm increments

Paper Length - On selection the status area is replaced with a calculator for inputting new values. Length range = 190mm - 900mm

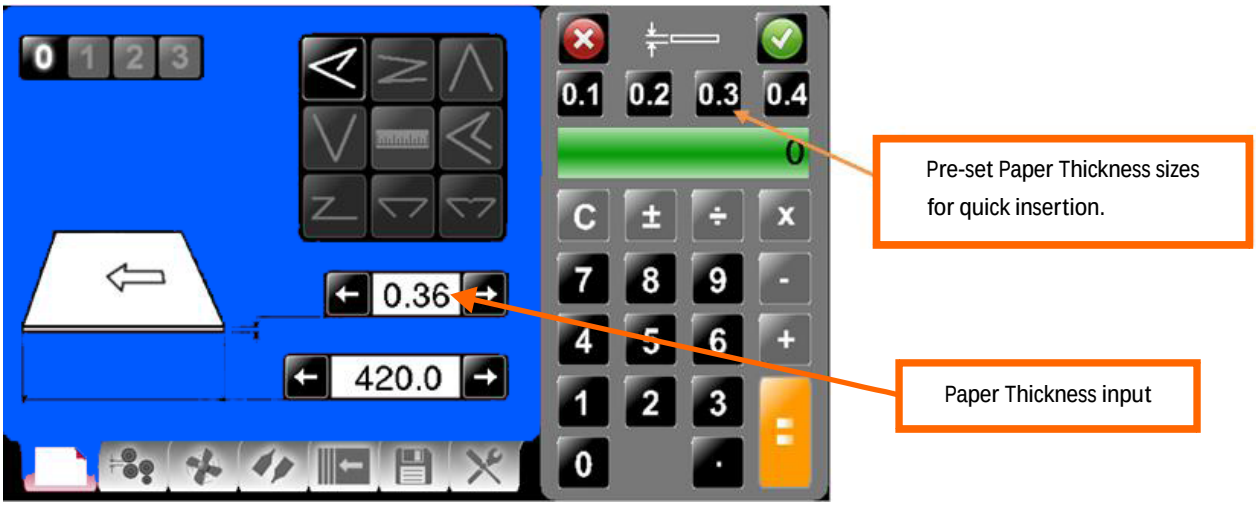
Paper size Selection.



Pre-set Paper sizes for quick insertion - Standard sizes for country origin would be shown.

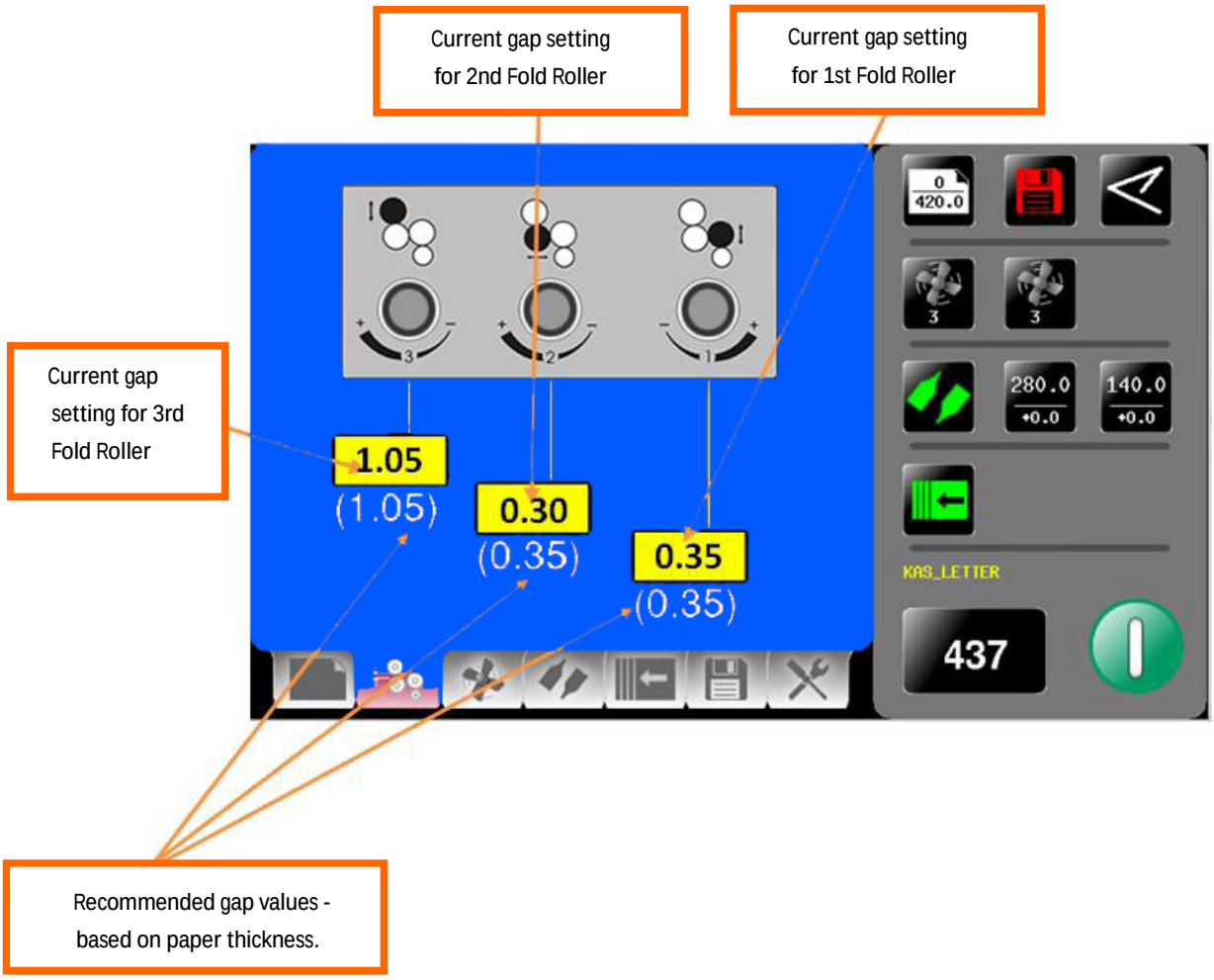
Paper input

Paper Thickness Selection.



Roller Gap Set Page.

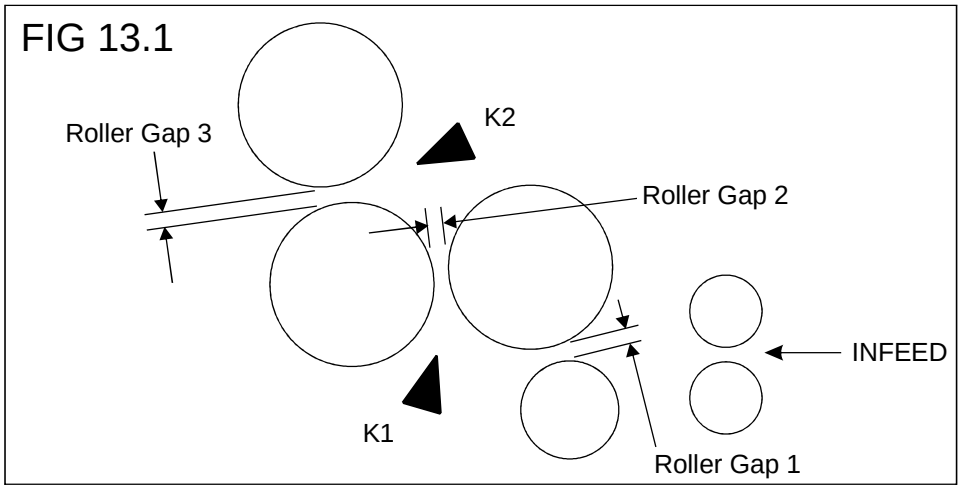
To get to the roller gap setting page click the lower tab 
Roller gaps may be in the range of 0.05mm to 1.5mm, with increments of 0.05mm



Setting the Roller Gaps (Gap 1, Gap 2 & Gap 3)

The roller gaps can be adjusted to suit the thickness of the material being folded; and the type of fold being produced. The roller gaps may also require adjustment if cracking of the print is noticeable. (see Fig 13.1 below).

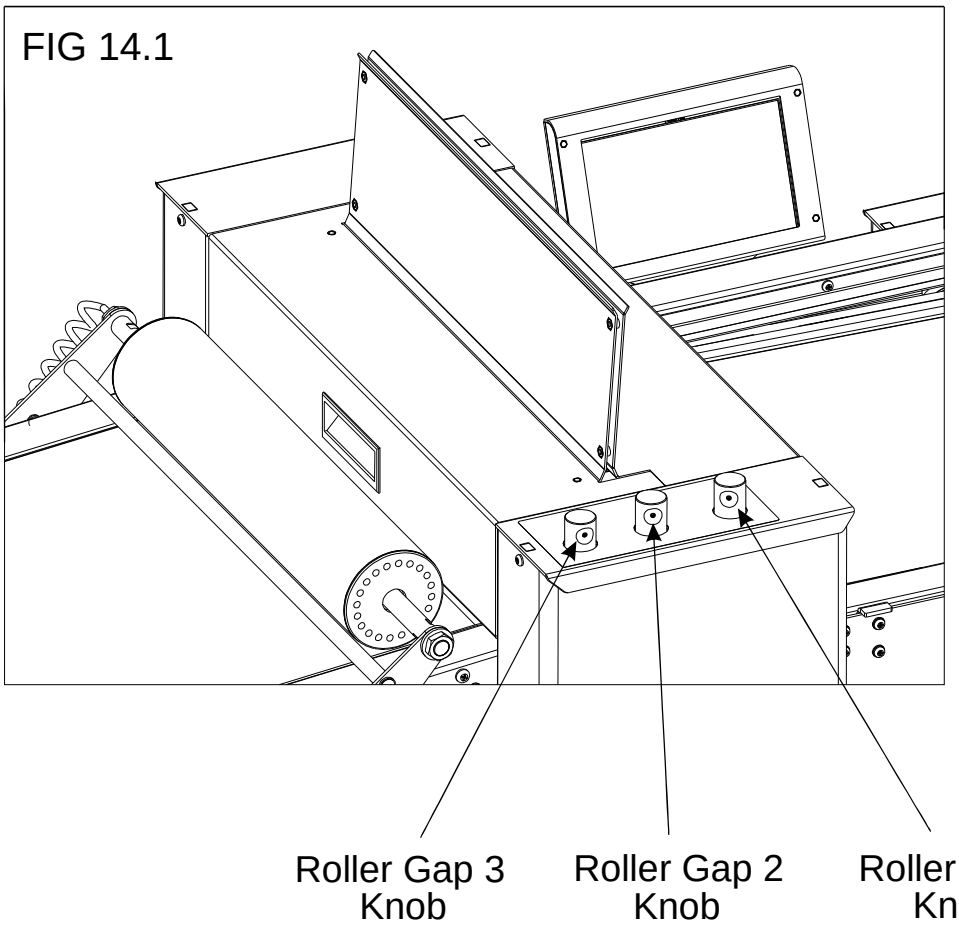
FIG 13.1



The gap settings (Gap 1, Gap 2 & Gap 3) can be adjusted by rotating the Roller Gap Set Knobs (see FIG 14.1 below).

IMPORTANT.
When setting roller gaps, you **must** first adjust the gap to a value greater than that required and then decrease the value to the required setting. (Do not set the gap, from a value lower than that required).

FIG 14.1



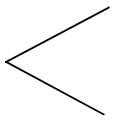
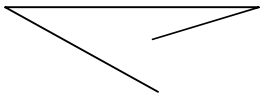
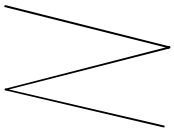
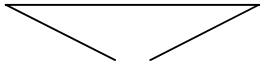
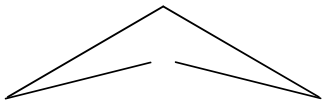
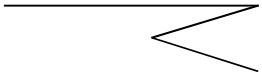
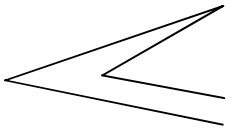
PROCEDURE. (FOR SET BY POSITION).
NOTE. Use the on screen guide for Set by Fold.

(i) Measure the thickness of the sheet using a Digital Vernier Calliper.
(ii) Set roller GAP 1 to the vernier reading.
(iii) Set roller GAP 2 and roller GAP 3, (for the type of fold being produced), using the GAP SET GUIDE table shown on next page.

Half Fold on Knife 1 →
Half Fold on Knife 2 →

GAP SET GUIDE			
FOLD TYPE	GAP 3	GAP 2	GAP 1
Half K1	2X	2X	X
Half K2	2X	X	X
Letter	3X	X	X
Concertina	3X	X	X
Gate	3X	X	X
Closed Gate	3X	X	X
Engineering	3X	X	X
Double	4X	2X	X

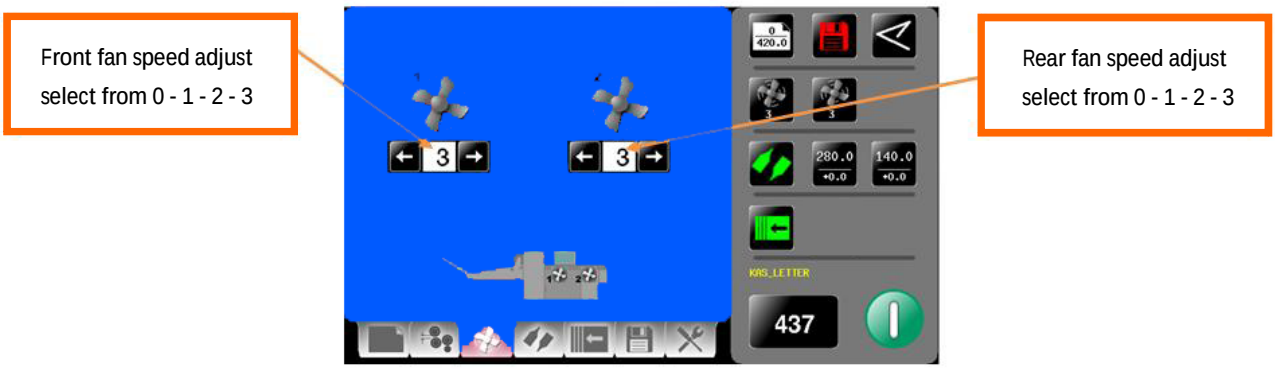
Example 1:- When producing a **Half K1** fold, if GAP 1 is 0.2 (X) then set GAP 2 to 0.4 (2 x X) and set GAP 3 to 0.4 (2 x X).
Example 2:- When producing a **Gate** fold, if GAP 1 is 0.3 (X) then set GAP 2 to 0.3 (X) and set GAP 3 to 0.9 (3 x X).

FOLD TYPES		
 HALF	 LETTER	 CONCERTINA
 GATE	 CLOSED GATE	 ENGINEERING
 DOUBLE		

Feed Bed Fan Settings Pages.

To get to the fed bed fan setting page click the lower tab  or  from the status area.

You can adjust the speed independently for the front and rear fans. On the optionally available long feed bed, a centre fan is also shown for adjustment.



NOTE.
The fans perform the function of sucking the stock down onto the drive belts. The drive belts then pull the stock against the rear side lay, so that the stock enters the folding mechanism squarely.

When feeding light stocks, if the stock buckles reduce the speed of the front fan (Fan 1). (0 = slowest speed, 3 = fastest speed)

When feeding heavy stocks, if the stock skews and is not pulled against the rear side lay increase the speed of the front fan (Fan 1).

Fold Settings Pages.

To get to the Fold setting page click the lower tab  or  from the status area.

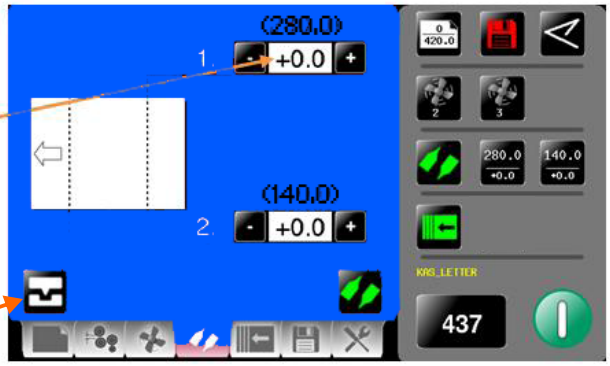
If you have selected a predefined standard Fold Type from the paper settings page the recommended crease positions can be viewed by selecting the crease position button. 

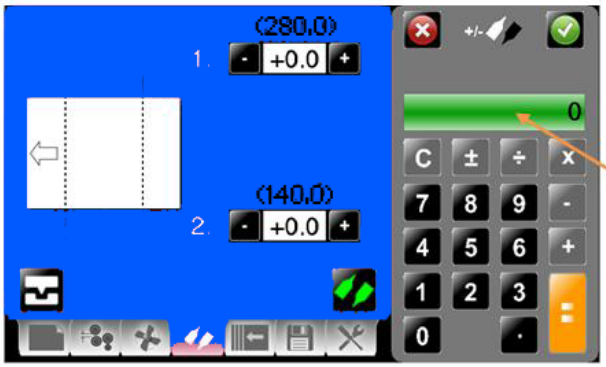
Folds in 'Set By Fold' mode.

K1 Fold micro adjust - On selection the status area is replaced with a calculator for inputting new values.

Micro adjust range is -5.0 to +5.0 with increments of 0.1mm

Crease Position Button



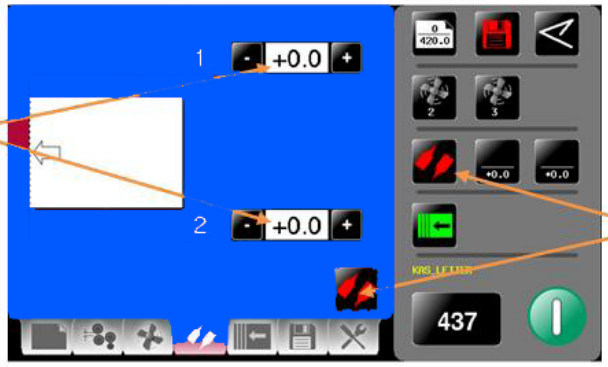


Folding can be Micro adjusted for fine adjustment.

Micro adjust range is -5.0 to +5.0 with increments of 0.1mm

With Folding turned off the deflect positions can be micro adjusted.

Micro adjust range is -5.0 to +5.0 with increments of 0.1mm

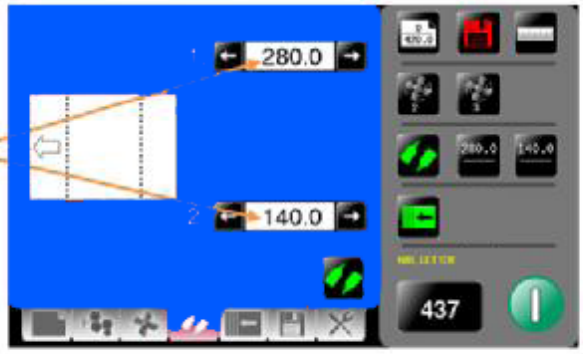


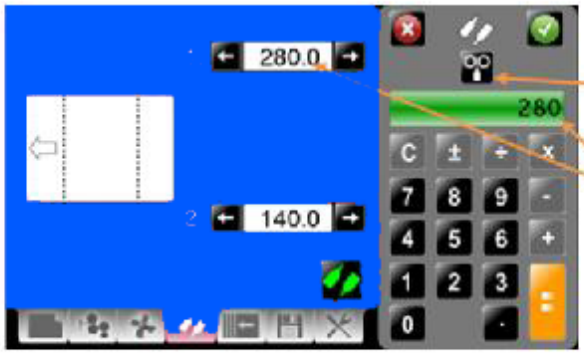
Folding on/off selector green is on & red is off. This is also indicated in the status area.

Folds in ‘Set By Position’ mode.

Fold distance from lead edge for knives (K1 & K2)

increments of 0.1mm





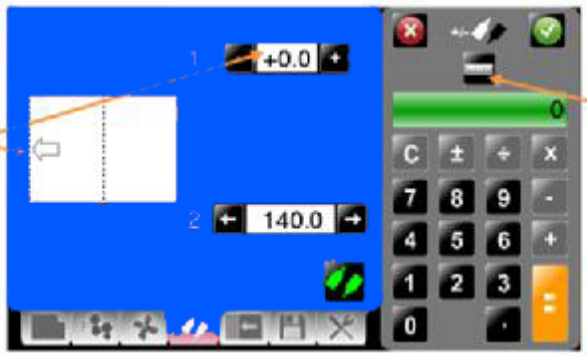
K1 deflect button

K1 micro adjust selected

K1 in deflect position.

This can be micro adjusted.

Micro adjust range is -5.0 to +5.0 with increments of 0.1mm

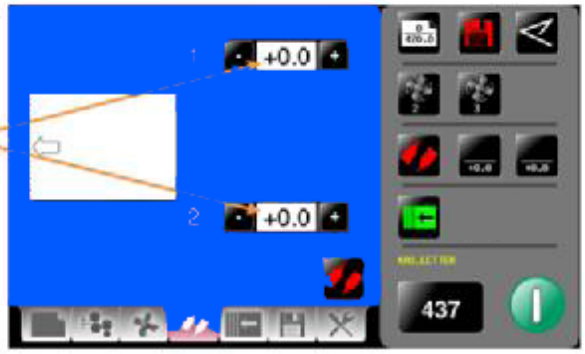


Clicking this icon switches deflect off &K1 returns to its original position.

K1 & K2 in deflect position.

This can be micro adjusted.

Micro adjust range is -5.0 to +5.0 with increments of 0.1mm



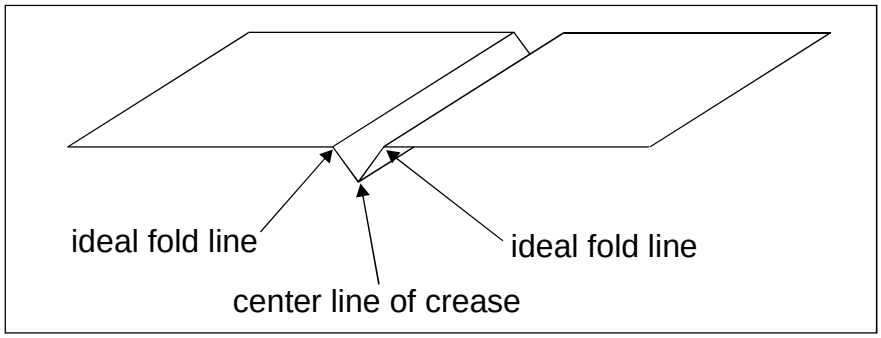
SET BY POSITION

IMPORTANT NOTES

1. The best fold squareness is achieved when the fold is not on the center line of the crease. It should be to one side of the crease center line as shown below. Unless the blade is on the bottom or knife 2.

   Example. Half fold on 420 mm sheet

   - Set crease at 210.0 mm
   - Set fold at 210.5 mm or 209.5 mm depending on the desired finish.



2. When using **Set By Position,** all dimensions are from the leading edge of the paper as shown in the example on page 20.

SET BY FOLD

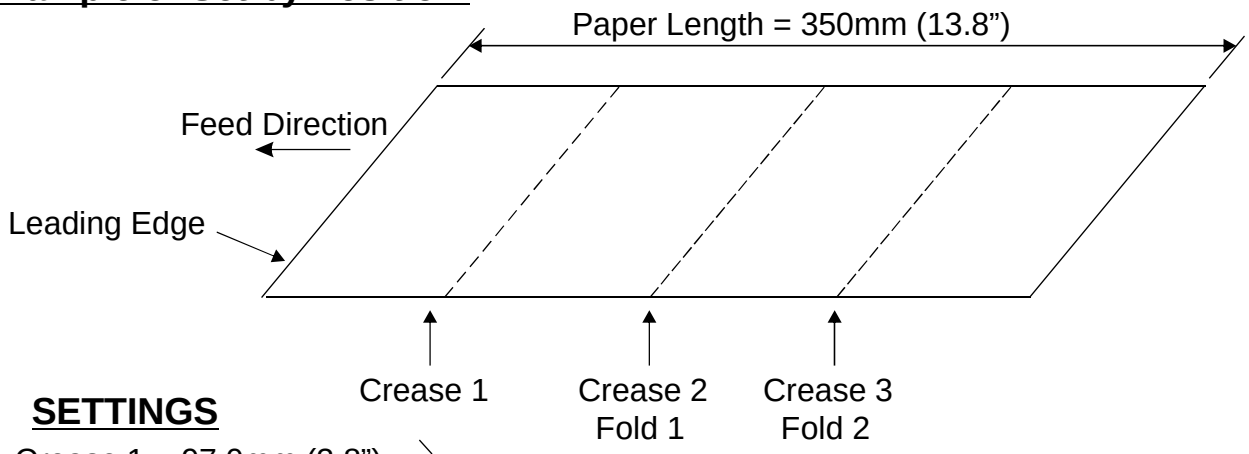
Paper Type - 0, 1, 2 and 3, is a fold compensation for variations in paper thickness, hardness and substrate. (see page 11)

- Paper type **'0'** - The crease and fold are set at exactly the same position. This may be used but beware some thin stocks will allow the fold to wander from one side of the crease to the other. (Use trims to overcome this).

- **Paper type '1' '2'** and **'3'** will move the fold relative to the crease and should be tried out with the stock in use.

Generally a higher number will be best for a thicker stock, but some settings will swap the fold from one side to the other side of the crease, this enables the user to choose the side that the crease will be seen. For example, on a front cover.

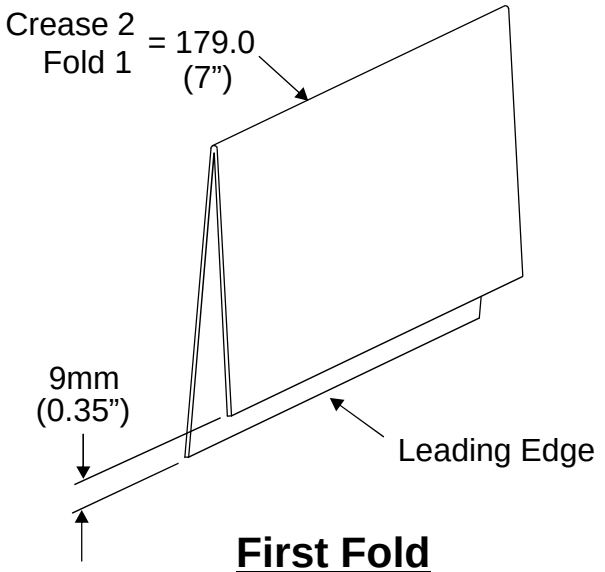
Example of Set by Position.



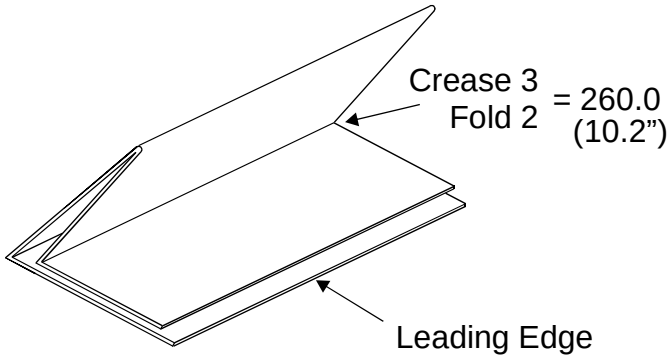
SETTINGS

Crease 1 = 97.0mm (3.8”)
Crease 2 = 179.0mm (7”)
Crease 3 = 260.0mm (10.2”)
Fold 1 = 179.0mm (7”)
Fold 2 = 260mm (10.2”)

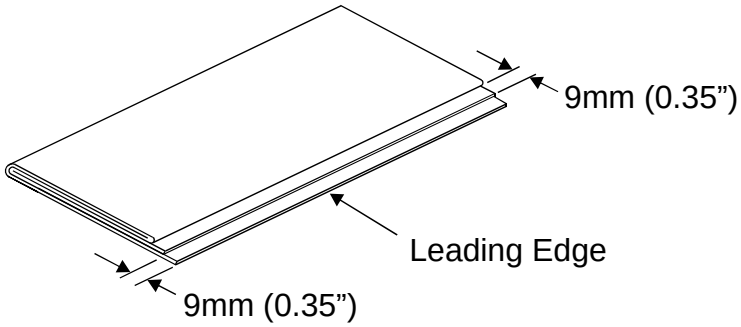
All dimensions are from the leading edge of the paper



First Fold



Second Fold



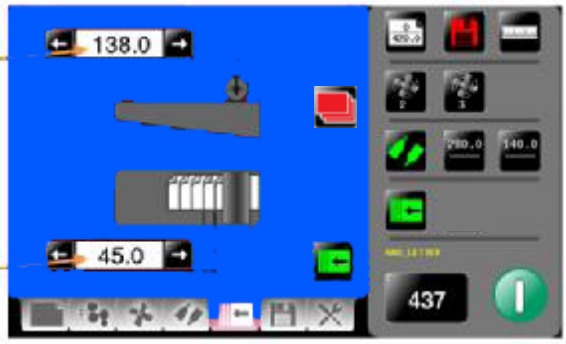
Finished Document

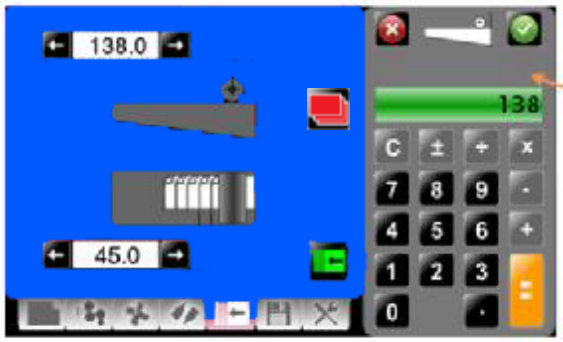
Delivery Settings Page.

To get to the Delivery setting page click the lower tab 

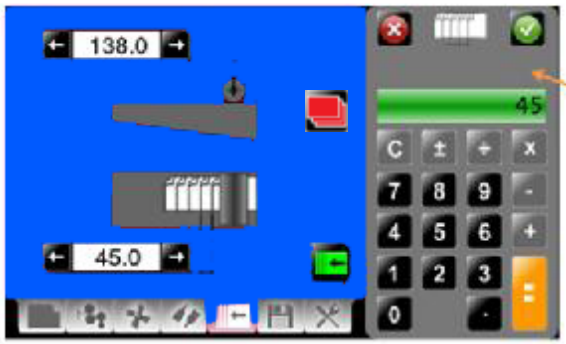
Roller position may be micro adjusted by clicking here.

Shingle may be micro adjusted by clicking here.

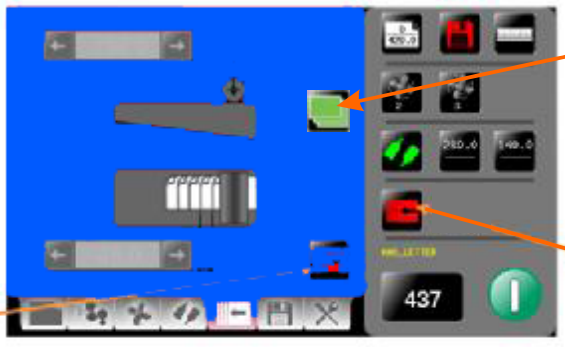




Roller adjustment calculator.



Shingle adjustment calculator.



Batch on/off Button
Set to OFF (red) for Normal feeding
Set to ON (green) for Batch feeding

See Page 22

Delivery on/off status red is off green is on.

The Delivery can be toggled On or Off by clicking here.

Setting the Delivery Conveyor System.

WARNINGS:-

1. The Machine will not start if the delivery unit is not in its up position.

2. If the delivery is turned off the roller will feed to the far end of the belt conveyor and park there until turned on again.

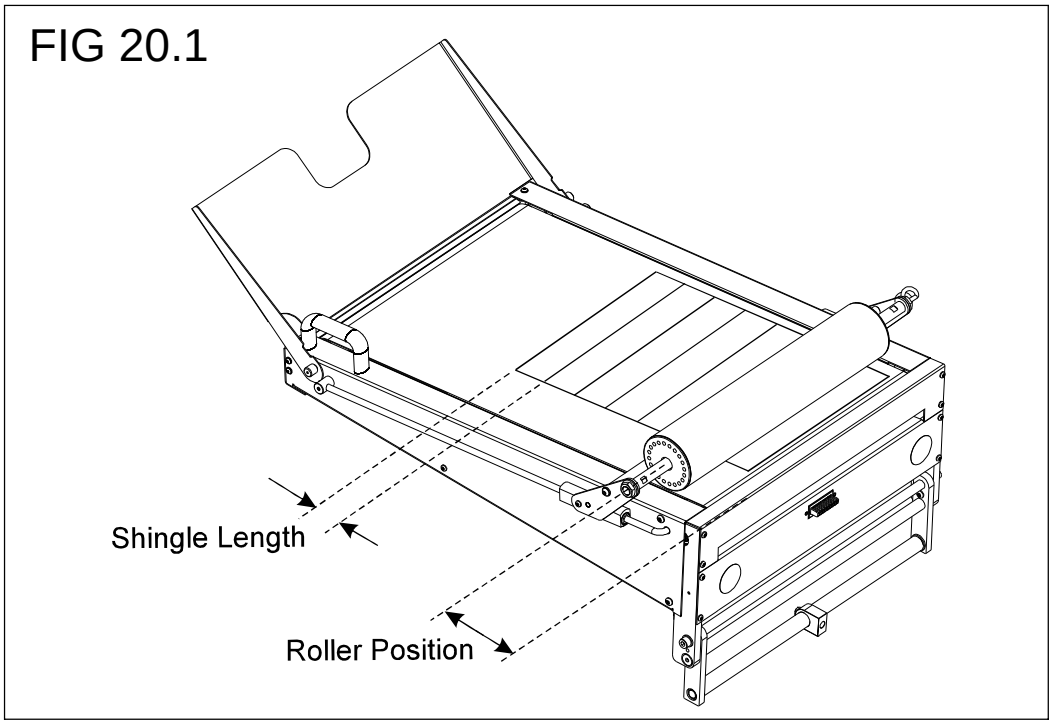
3. If the delivery is turned on when using the 'Set by Fold' mode of operation; the Roller Position and Shingle Length are automatically set, relative to the paper length and type of fold selected.

4. When using the 'Set by Position' mode of operation; the Roller Position and Shingle Length must be adjusted manually to suit the job. (See FIG 20.1 below).

5. When the optimum settings for the roller position and shingle length are achieved they can be stored with the job.

NOTE.
When setting the machine to do a Double Fold or Engineering Fold, with a paper length of 279mm (11") or less, the stacker roller will travel to the far end of the conveyor and stop. This is due to the shortness of the folded paper exiting from the machine.

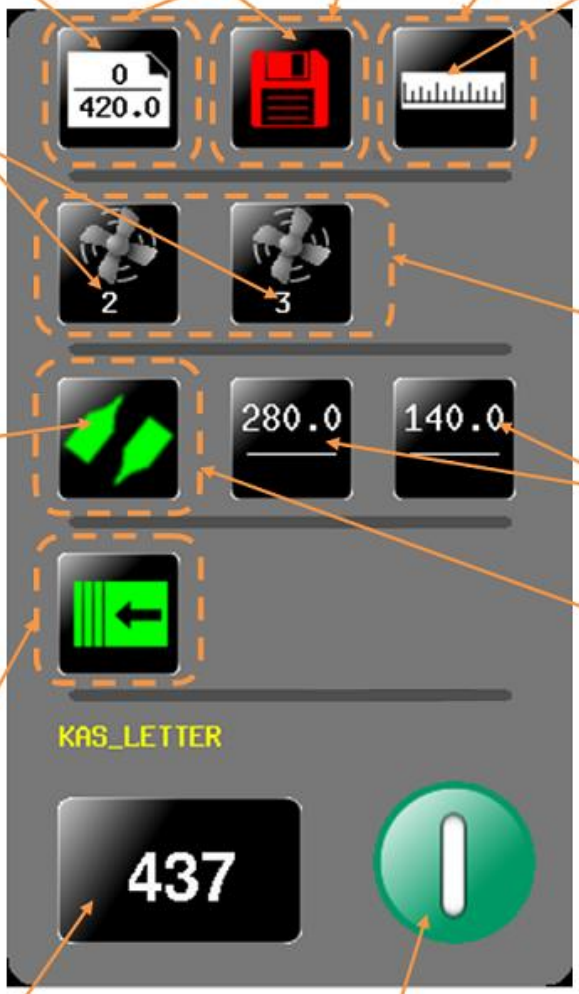
FIG 20.1



Batch On/Off Button.

If paper is being fed in Batch mode, the Batch On/Off Button should be set to **On** (green). The delivery roller will run continuously and the batches on the delivery conveyor will be separated.
If paper is being fed normally (i.e. not batched) the Batch On/Off Button should be set to **Off** (red). The delivery roller will then stop rotating if the paper feed is interrupted and rotate again when the paper feed continues, giving a uniform shingle length.

Status Screen.



Green icon indicates settings are saved - a red icon would show that settings have been changed but the job has not been saved.

Clicking in this area will take you to the store page

Clicking in this area will take you to the paper setting page.

Paper length & Paper Type - input from the paper setting screen.

Currently selected fold type - can be one of the following.

Fan speed 0 - 1 - 2 or 3 Front & Rear

Long bed option also has centre fan.

Clicking in this area will take you to the Feed bed setting page.

Indicator for status of knives.

 K1 & K2 On.

 K1 Off & K2 On

 K1 On & K2 Off

 K1 & K2 Off

Fold Positions & Micro adjust settings

Clicking in this area will take you to the Fold setting page.

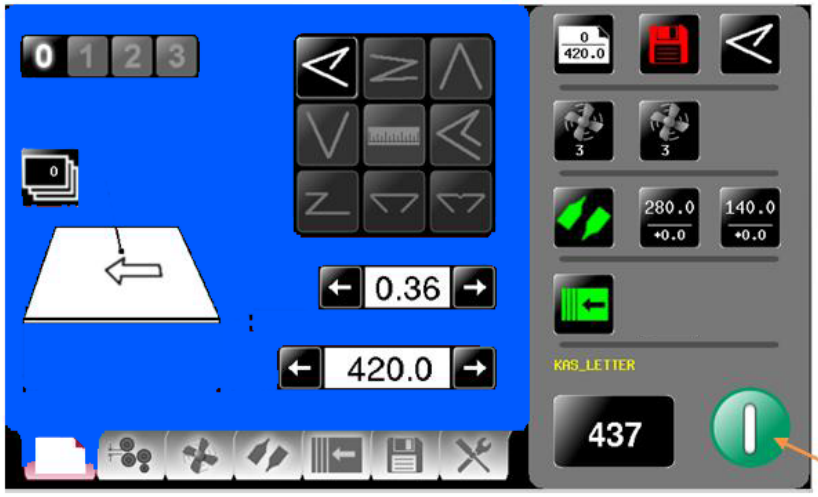
Clicking in this area will take you to the delivery setting page.

Current job count - click to zero

A screen will appear to confirm that you want to reset the count.

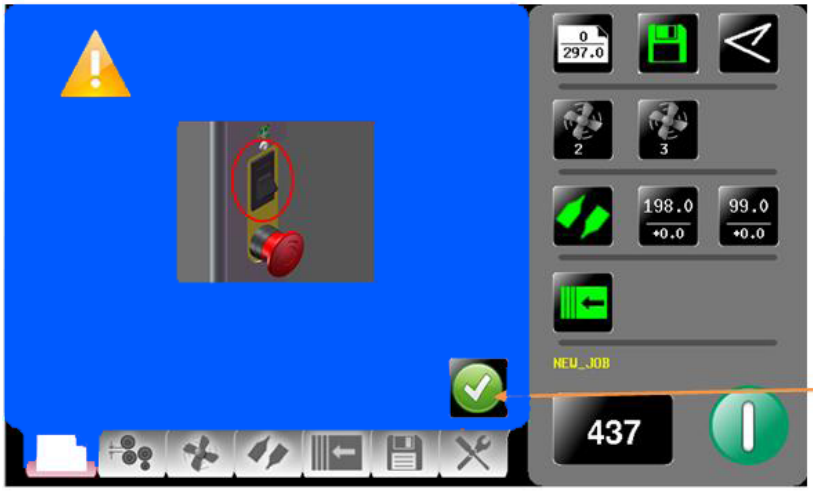
Click to start machine with settings currently shown - you will receive a notification if system switch is not on. Press again to stop Job

Run Job.



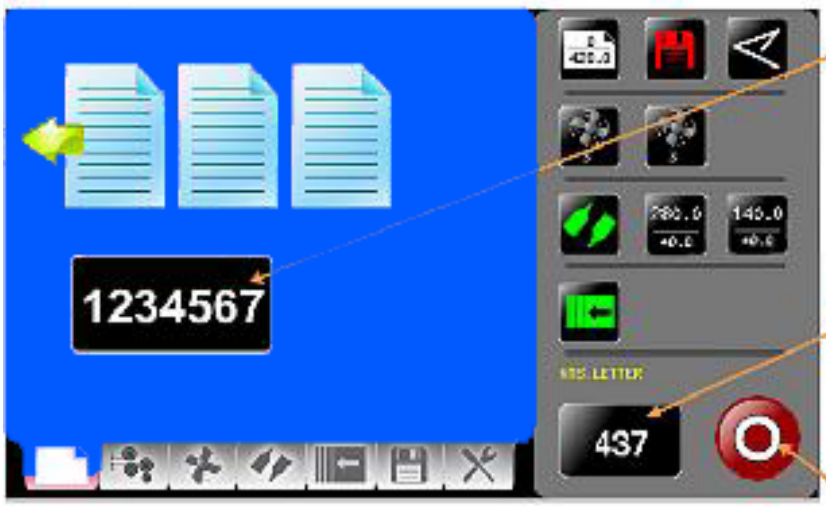
Click to run machine.

System Switch Not On.



Click to confirm System switch is on & then click run button again

The machine running screen will appear.



Run count

Job Count

Click to stop machine.

Setting the machine to operate in manual sheet feed mode

In order to feed heavy stock, very small or very large sheets, embossed or even irregular shaped sheets, it may be necessary to feed the sheets manually.

The machine can be programmed and set up in exactly the same way as explained when operating the machine automatically.

The machine can now be started by activating the System switch to ‘on’.

Select the  icon on the touch screen and begin to feed the sheets individually onto the feed bed.

To stop feeding the sheets, select the  icon on the touch screen and switch the System Switch off.

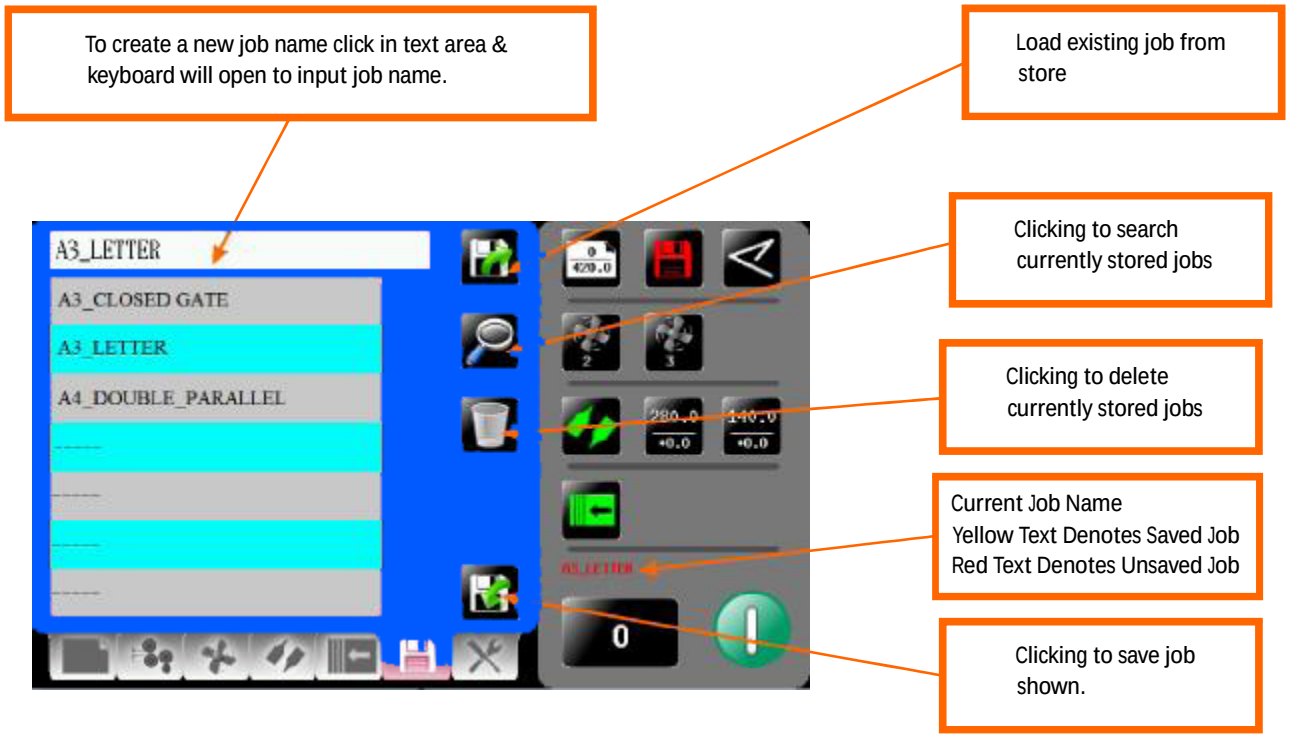
NOTE.
If the delay between feeding sheets is excessive, the system will time out.

Store Pages.

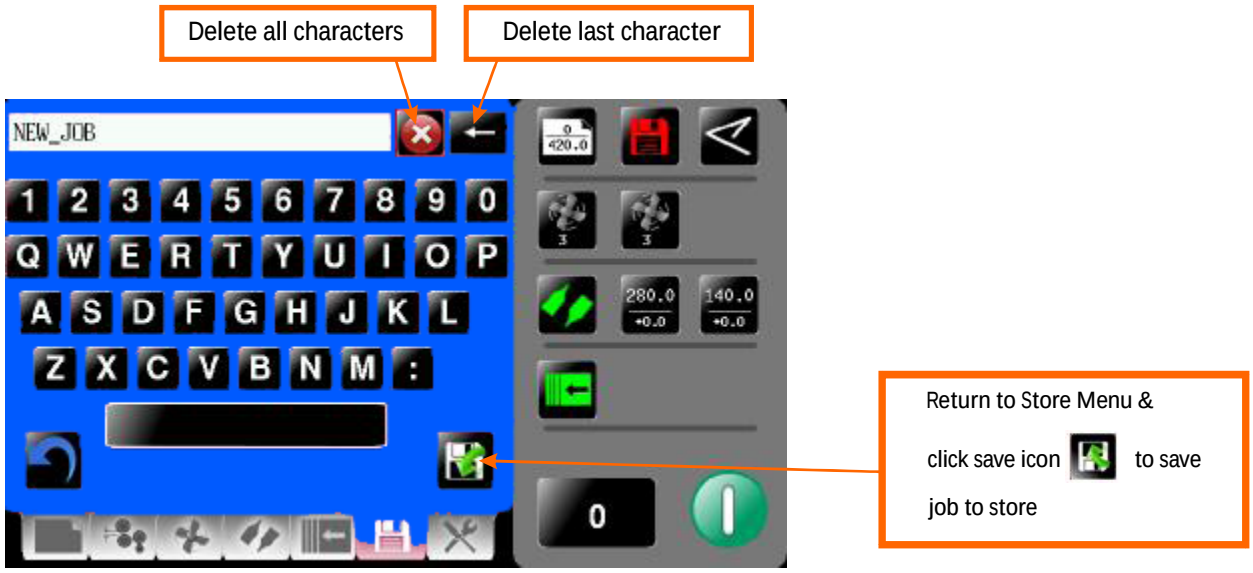
To get to the Store setting page click the lower tab  or  from the status area.

New Jobs.

Having set up your job you can give the job a name and save it to a store. You can also retrieve previously saved jobs, modify them or delete jobs you no longer require.



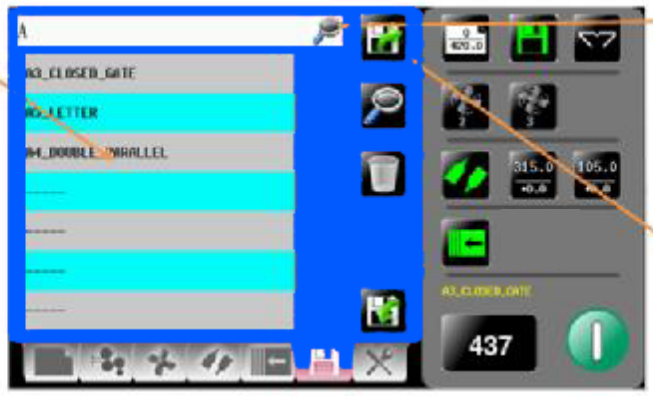
Keyboard for entering job name.



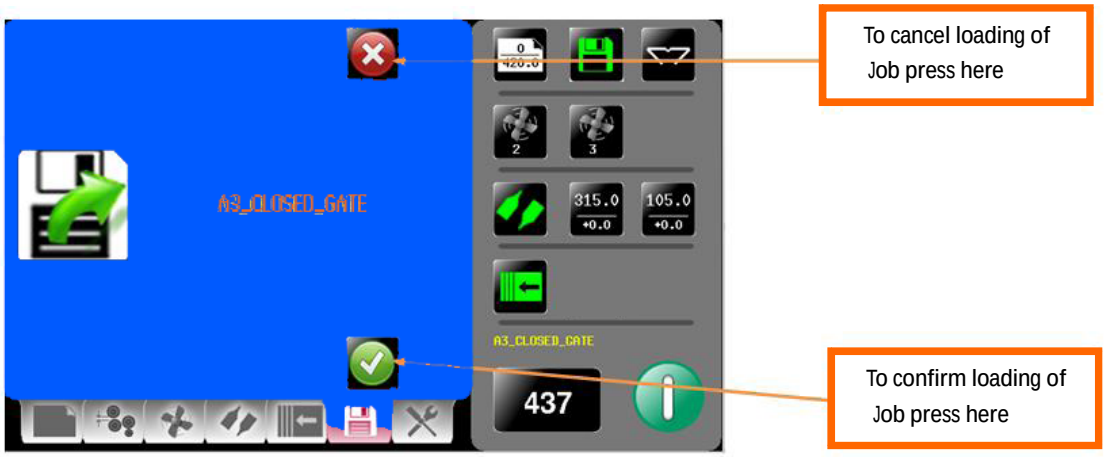
Save confirmation screen.

Search for current jobs to load or modify.

You can search for jobs by clicking the search icon , this will bring up the search keyboard for text input.

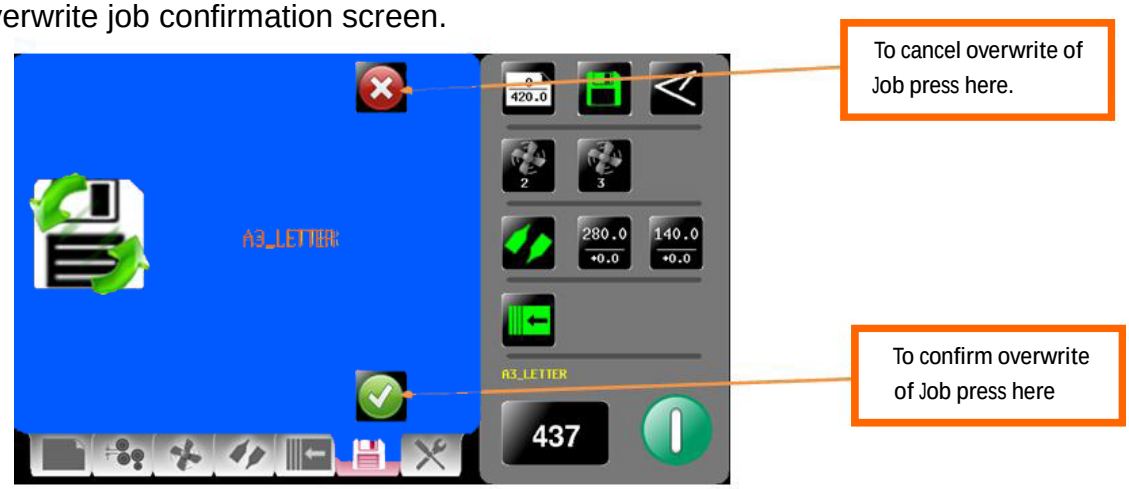


Loading job confirmation screen.

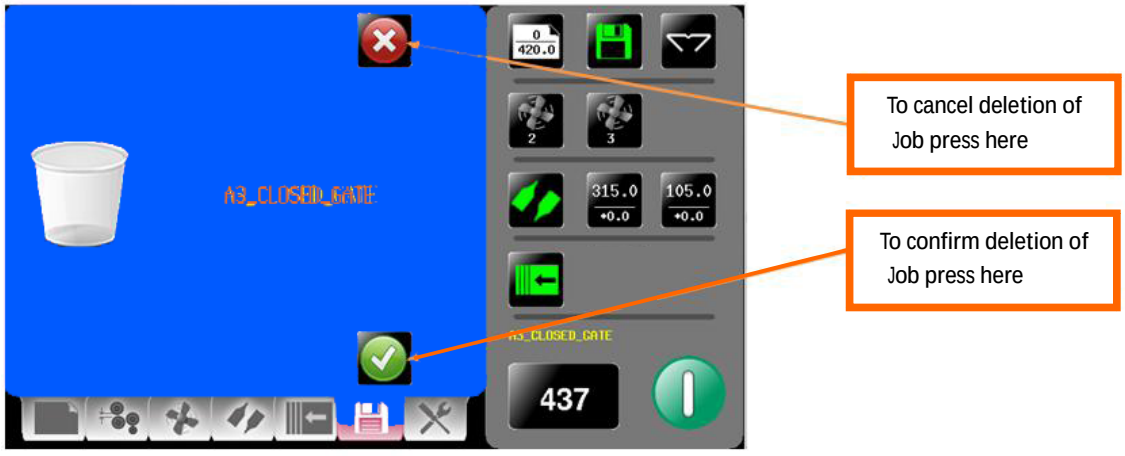


Loaded job may be modified and then re-saved as the same job name.

Overwrite job confirmation screen.

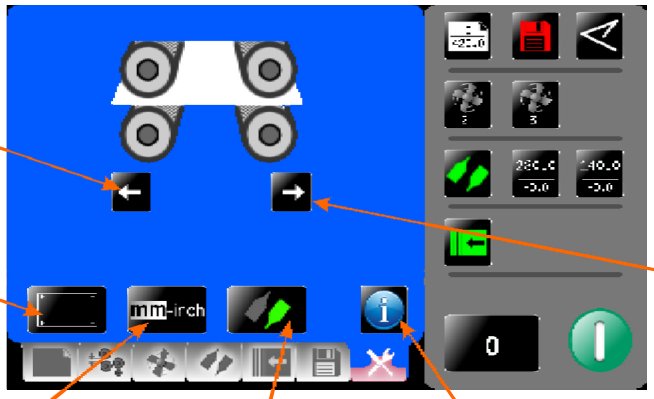


Delete job confirmation screen.



Tools Menu.

To get to the Tools page click the lower tab 



Inch paper in direction of arrow to clear jams

Touch Screen Calibration
See Page 30

Change Machine measurement settings, Imperial / Metric

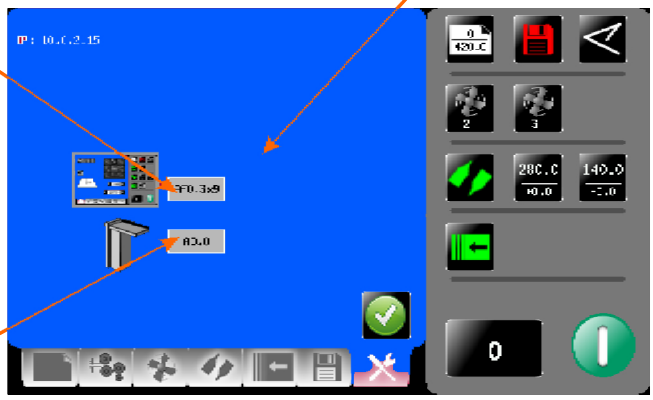
Toggle K2 ON and OFF
Used to Set Deflect Trims
See Page 31

Clicking this icon will show Machine programme revision & Touch Screen software revision.

Inch paper in direction of arrow to clear jams

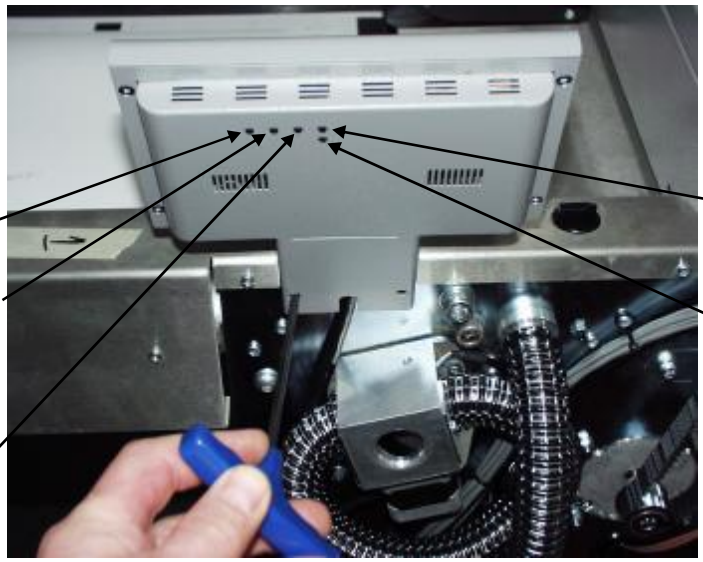
Touch screen software revision

Machine main board software revision



Touch Screen Calibration.

1. Switch the mains power on and wait for the main screen to appear before commencing to check the horizontal and vertical position of the display.
The position of the display within the surround is achieved by operating the button at the rear of the housing, press this a number of times to obtain the correct orientation required, move to the next button to move the position to centralize horizontal.



2. (i) Select the tools menu tab, and then Select the Touch Screen calibration icon.

(ii) Using a plastic pointer, soft leaded pencil, biro cap etc. and with gentle pressure. Touch the centre of the cross in each corner of the Touch Screen, as prompted, by the hand graphics. This procedure will calibrate the Touch Screen.

Deflect Trim Adjustments

The deflect trims may need to be calibrated to allow the sheet to pass through the machine without damaging the lead edge.

1. K1 Double Deflect Trim
   In the tools menu 

Conduct this test with K2 

turned off using the 'Tools' menu. 

If marking occurs on K1 then follow these general rules.

- Roller marks are caused by the Fold knife being too late, and so minus some K1 Deflect trim.
- General scuffing of the sheet underside are caused by the fold knife being too early, add some K1 deflect trim.

2. K2 Double Deflect Trim 

Ensure K2 is turned on using the 'Tools' menu. 

If marking occurs when K2 is turned on then follow these general rules.

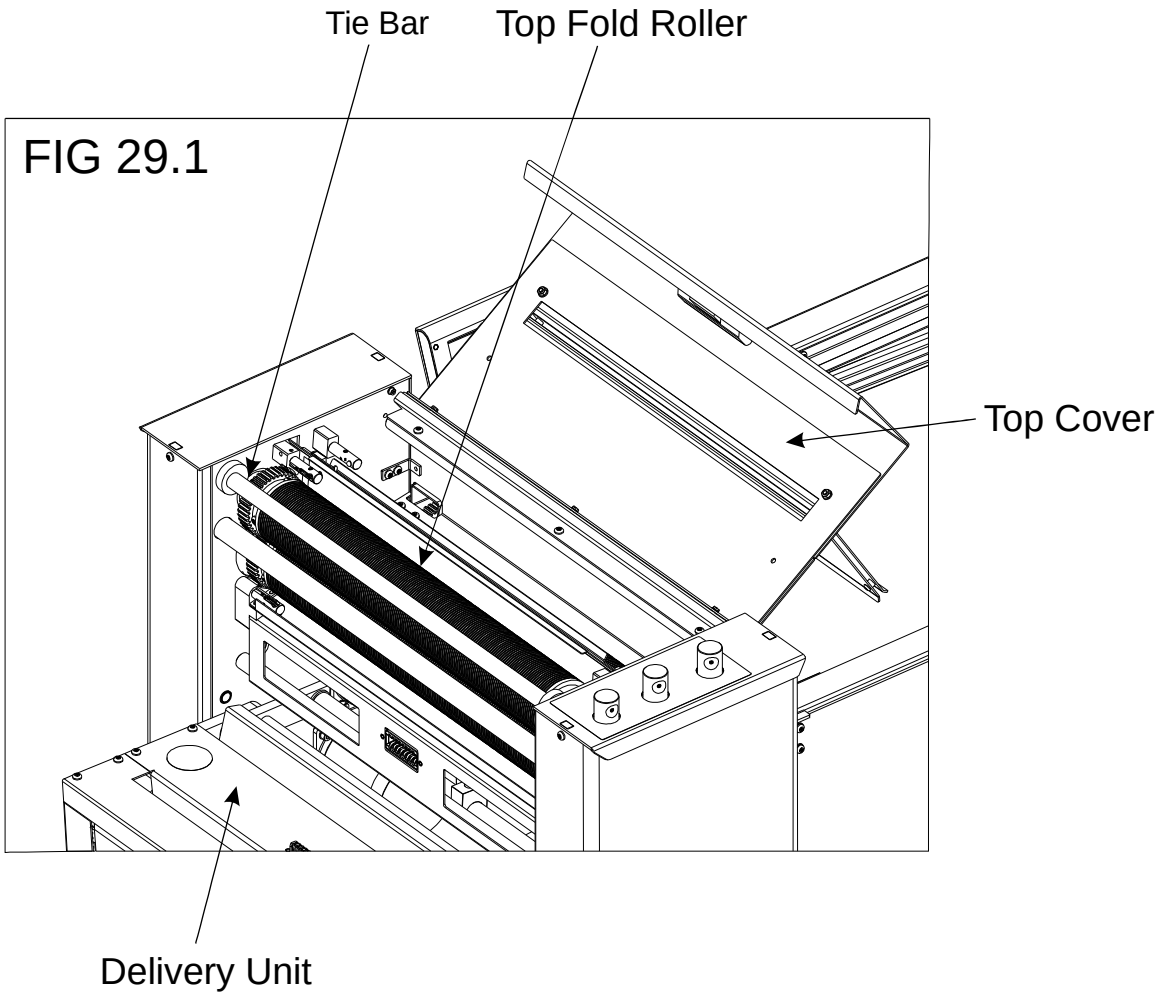
- Roller marks are caused by the Fold knife being too late, and so minus some K2 deflect trim.
- General scuffing of the sheet upper side are caused by the fold knife being too early, Add some K2 deflect trim.

Removing Paper Jams

In the event of a paper jam occurring, whilst running the machine, follow the steps described below to allow access to remove the jammed paper.

1. Unlock and lower the delivery unit, open the top cover; see FIG 29.1 below.

2. If the paper is jammed in the fold rollers; try to rotate the top fold roller, using both hands. Position the thumbs under the tie bar and spread the fingers out above the tie bar.



Paper fold out of square

Note:- the best fold squareness may be achieved when the fold is not on the center of the crease, but to one side or the other. Try this first.

- Check that the fold is to one side of the crease center line.
- Check that the roller gaps are not too tight and squashing the crease.
- Check that the roller gaps are not too large and allowing the paper to slide (especially so on glossy paper).

Paper jamming

- Check that the first crease / fold position is not too close to the leading edge of the paper. A minimum distance of 50mm (1.96”) is recommended.

Machine will not start

- Check the power supply to the machine.
- Check that the emergency stop button has been released.
- Check that the top cover is down.
- Check that the delivery unit is in the up position, and located correctly, (the machine will not start if the delivery unit is not in its up position).

Paper not feeding

- For heavy stocks, very small or very large sheets, embossed or even irregular stock, it may be necessary to feed the sheets manually - see page 25.

Cracking of the Printed Material along the Crease.

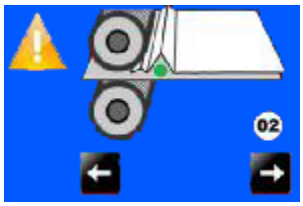
Cracking of the material along the crease may be caused by the following:-

- **When using dry ink or toner based print engines, the material <u>must</u> be fully acclimatised for at least 48 hours before putting an image onto the paper.**

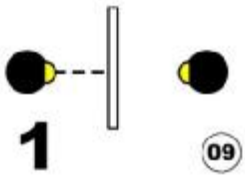
Error Screens

- **Sheet did not arrive.**
  If the machine stops and error message 01 is displayed on the touch screen, this indicates that the paper did not arrive at the end of the suck process; so the machine timed out. Press the green tick button and then press the start button.

- **Paper Crunch**
  If the machine stops and error message 02 is displayed on the touch screen, this indicates that a paper jam has been detected.
  Press the system switch down and then select the right or left arrows, to inch the paper forwards or backwards. See page 32 that describes how to remove paper jams.
  Press the green tick button and then press the start button.

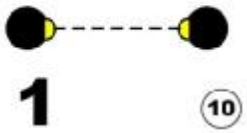


- **Clip 1 NOT clear** (Back Sensor)
  If the machine stops and error message 09 is displayed on the touch screen, this indicates that the sensor is or was blocked when it should have been clear.
  i.e. A jam in the paper path or the wrong length of paper has passed through the sensor.
  To correct - check if paper is present and check that the paper path is clear before restarting. See page 32 that describes how to remove paper jams.

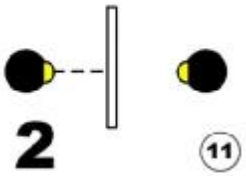


Error Screens (continued)

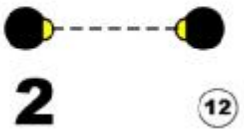
- **Clip 1 NOT Blocked** (Back Sensor)
  If the machine stops and error message 10 is displayed on the touch screen, this indicates that the sensor did not see the paper at the correct time.
  i.e. A jam in the paper path.
  To correct - Check if paper has jammed in the machine prior to the sensor.
  See page 32 that describes how to remove paper jams.

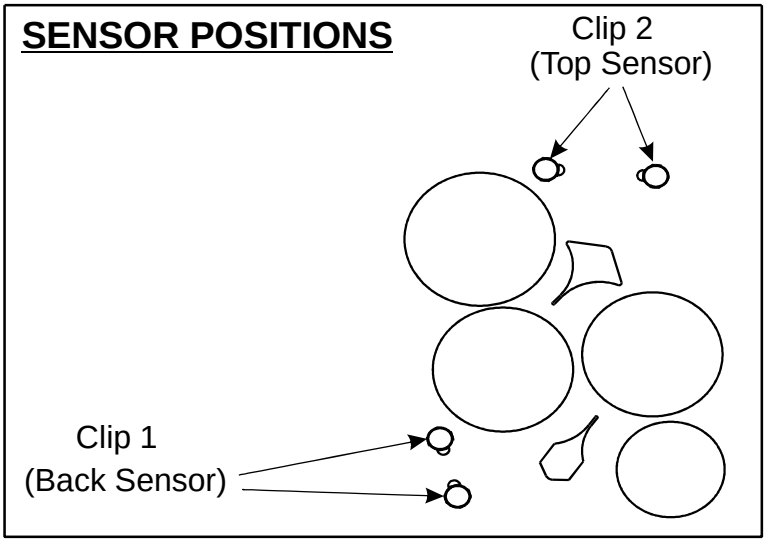


- **Clip 2 NOT clear** (Top Sensor)
  If the machine stops and error message 11 is displayed on the touch screen, this indicates that the sensor is or was blocked when it should have been clear.
  i.e. A jam in the paper path or the wrong length of paper has passed through the sensor.
  To correct - check if paper is present and check that the paper path is clear before restarting. See page 32 that describes how to remove paper jams.



- **Clip 2 NOT Blocked** (Top Sensor)
  If the machine stops and error message 12 is displayed on the touch screen, this indicates that the sensor did not see the paper at the correct time.
  i.e. A jam in the paper path.
  To correct - Check if paper has jammed in the machine prior to the sensor.
  See page 32 that describes how to remove paper jams.





- **Overlap**

  If the machine stops and error message 13 is displayed on the touch screen, this indicates that the 'Lead Edge Sensor' has seen a sheet subsequent to the first one as being longer. Again this could actually be a longer sheet, OR it could be a sensor problem (if it is a recurring problem). Check that the paper gate has been set correctly.

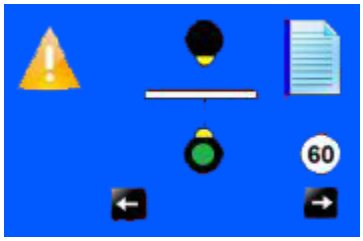
- **Sheets too close**

  If the machine stops and error message 45 is displayed on the touch screen, this indicates that the sheets are too close together. The rate of feed of the sheets needs to be slowed down. If the sheets are being fed from an Atlas C102 Creaser or an Atlas C200 Creaser adjust the speed on the Tools Menu screen to a slower speed.

Error Screens (Continued)

- **Lead Edge Sensor Fault**

  If the machine stops and error message 60 is displayed on the touch screen, this indicates that the lead edge sensor is blocked.
  Press the system switch down and then select the right or left arrows, to inch the paper forwards or backwards.
  Press the green tick button and then press the start button.
  This error message could also mean that the lead edge sensors are faulty or need cleaning.



Recommended weekly operator maintenance

Clean all sensors.

The lead edge sensor housing is located on the layedge side of the machine between the input roller shafts. With a slim brush the sensors can be cleaned when required. Pass the brush under the ball holder and push through until it passes the infeed rollers. Alternatively it can be blown with compressed air.

The Jam Sensor is situated just after the edge sensor and is inline across the paper path with the receiver in the operator side sideplate. This is not usualy sensitive to dust but if required can be blown with compressed air.

Clip 1 sensor is situated on the lower guides beneath the delivery conveyor and can be cleaned when required using a slim brush.

Clip 2 sensor is situated on the upper guides inside the top cover and can be cleaned when required using a slim brush.

Clean in feed rollers using the cleaning kit supplied (cleaning kit part number 90-018).

Technician Maintenance

It is recommended that your Machine is fully serviced at least once every six months by a factory trained Service Engineer.

ITEM	PART NUMBER	QTY	DESCRIPTION
1	184-018	1	OPERATORS MANUAL
2	90-018	1	ROLLER CLEANING KIT
3	650-040	1	POWER CORD C19 UK 16A 2.5m
4	601-167	1	DIGITAL THICKNESS GAUGE
5	613-229	1	WRITE-ON SERIAL NO. LABEL
6	65-104	1	SPECIFICATION LABEL MSL/CE
7	620-027	1	BONDUS L WRENCH 5mm
8	624-018	1	DISPATCH BOX
9	620-032	1	SPANNER 13MM COMBINATION
10			
11			
12			
13			
14			

ACCESSORIES AND OPTIONS

ITEM	PART NUMBER	DESCRIPTION
1	182-01-02	FEED BED FRAME - SHORT
2	184-11-01	TRANSFER BED ASSY - Atlas C102

ACCESSORIES....
....May be obtained from your dealer and fitted to your machine using the instructions supplied, or by reading your operators manual.

OPTIONS....
....May also be obtained and fitted by your dealer. You should not attempt to fit options as specialist tools and knowledge are required.

RECOMMENDED SPARES

PART NO.	DESCRIPTION
125-25-01	Small Stepper Driver - High Power
174-06-01	Small Stepper Driver - Low Power
174-01-03	Controller PCB Assembly + Chip
184-04-01	Fan Control PCB Assembly
174-19-01	RS232 Adaptor PCB Assy.
75-500-04	Mini ITX Motherboard - AC-10
126-059-02	Link - Paper Guide
145-093-02	Knife Driver Pin - M8
76-302	Lead - Delivery Input Connector
76-277	Lead - Sensor
76-281	Lead - Fan Assy.
76-282	Lead - Fan Assy.
76-283	Lead - Fan Assy.
76-300	Lead - Drive Motor
76-301	Lead - Fold Knives Motor
76-304	Lead - Fold Sensor
76-305	Lead - Gap Set 1 Pot
76-306	Lead - Gap Set 2 Pot
76-307	Lead - Gap Set 3 Pot
173-46-01	Lead - Gap Set 3 Pot
173-47-01	Lead - Gap Set 2 Pot
173-48-01	Lead - Gap Set 1 Pot
655-015	Power Supply - 24V
655-016	Power Supply - 48V
76-310	PSU Assembly - ATX12V - 300W
175-31-04	Input Roller Assembly - Upper
185-10-01	Input Roller Assembly - Lower
185-14-01	Fold Roller Assembly - Fixed
185-15-01	Fold Roller Assembly - 1st
185-16-01	Fold Roller Assembly - 2nd
185-17-01	Fold Roller Assembly - 3rd
175-10-04	Edge Sensor Assembly
75-06-02	Touch Screen Assembly - 7” (New Controller)
175-11-04	Sensor Bar Assembly
175-11-05	Sensor Bar Assembly

RECOMMENDED SPARES

PART NO.	DESCRIPTION
175-125-01	Connecting Link Assembly - Drive
175-125-02	Connecting Link Assembly - Knife Hubs
182-014-02	Belt - Paper Transport - Medium
182-014-03	Belt Paper Transport - Short
184-03-01	Jam Detector - Emitter
184-03-02	Jam Detector - Receiver
186-02-01	Clip Sensor Assy. - Lower
604-103	Gas Spring - Delivery
604-108	Gas Spring
607-005	Belt - Vacuum Roller
607-045	Multi Beam Coupler
607-182	Timing Belt 180XL 062
607-185	Timing Belt 160XL 062
681-020	Fuse - 500mA - 20 x 5mm - Anti-surge
681-011	Fuse - 315mA - 20 x 5mm Anti-surge - Ceramic
681-019	Fuse - 6.3A - 20 x 5mm - Anti-surge Ceramic
652-047	Fuse - 15A (6.3 X 32) - Anti-surge
613-351	Micro Switch - Guard
613-365	Emergency Stop Switch - Double Pole
626-008	Anti-Static Bar
626-009	Anti-Static Bar - Female
652-011	Switch - Low Current Coil - Black
75-512	Anti - Static Transformer - UL
76-262	Stepper Motor - Roller Drive
76-258	Stepper Motor - Belt Drive
76-259	Stepper Motor - Roller Position
124-01-27	Lead - Delivery Roller Pot

NOTE.....
The items listed above represent parts which are subject to wear, loss, or accidental damage, and is included for your guidance only.
Replacement of parts fitted to your machine require specialist knowledge and should therefore be entrusted to your dealer.

MACHINE CALIBRATION HISTORY

Serial Number:-

Date:-					
Total Count:-					
Stretch					
Lead Edge Trim					
Del. Roller Trim					
Knife 1 Trim					
Knife 2 Trim					
K1 Deflect Trim					
K2 Deflect Trim					

Date:-					
Total Count:-					
Stretch					
Lead Edge Trim					
Del. Roller Trim					
Knife 1 Trim					
Knife 2 Trim					
K1 Deflect Trim					
K2 Deflect Trim					

Date:-					
Total Count:-					
Stretch					
Lead Edge Trim					
Del. Roller Trim					
Knife 1 Trim					
Knife 2 Trim					
K1 Deflect Trim					
K2 Deflect Trim					

Date:-					
Total Count:-					
Stretch					
Lead Edge Trim					
Del. Roller Trim					
Knife 1 Trim					
Knife 2 Trim					
K1 Deflect Trim					
K2 Deflect Trim					

FUSE POSITIONS & RATINGS

(POSITION ET CLASSIFICATION DES FUSIBLES)