

# FORMAX<sup>®</sup>

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FD 1500 Plus  
AutoSeal<sup>®</sup>

OPERATOR MANUAL  
FIRST EDITION



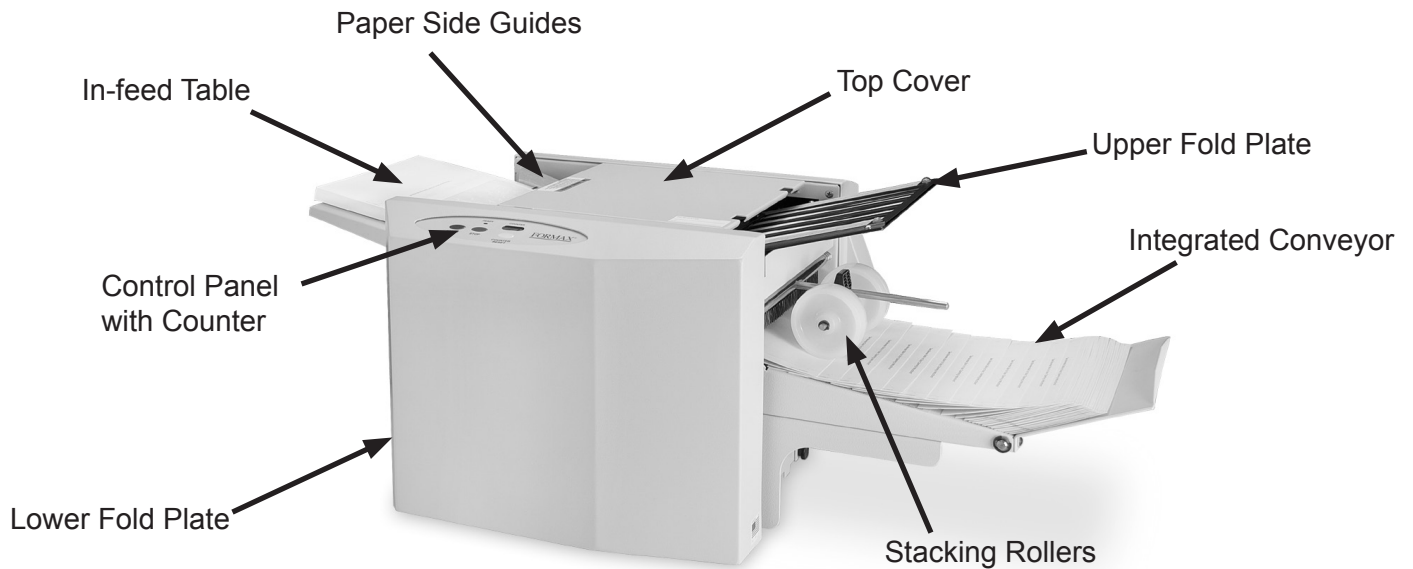
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# DESCRIPTION



## **FUNCTION:**

The FD 1500 Plus Pressure Sealer folds and seals many different configurations, including “C”, “Z”, “V” and custom folds. It also accommodates several different sizes of forms. For configurations and/or paper sizes specifications below.

## **SPECIFICATIONS:**

<b>Maximum foldable paper size</b>	Up to 8.5” W x 14” L
<b>Fold styles</b>	C, Z, V and custom folds
<b>Paper loading capacity</b>	Up to 150 sheets
<b>Speed</b>	Up to 5,200 forms per hour
<b>Machine weight</b>	90 lb.
<b>Power supply</b>	120 volts, 50/60Hz, 3.5 Amps

# UNPACKING AND SET UP

1. Check package for shipping damage. If there is shipping damage, do not discard the box.
2. **CAUTION:** Two people must lift machine out of the box.
3. To attach the conveyor to the out-feed, align the tab on the right side of the conveyor with the slot on the machine (Figure 1a). Rest it upon the two alignment studs (see arrows), and tighten the four thumbscrews provided (Figure 1b).
4. Plug cord into machine and into wall outlet.

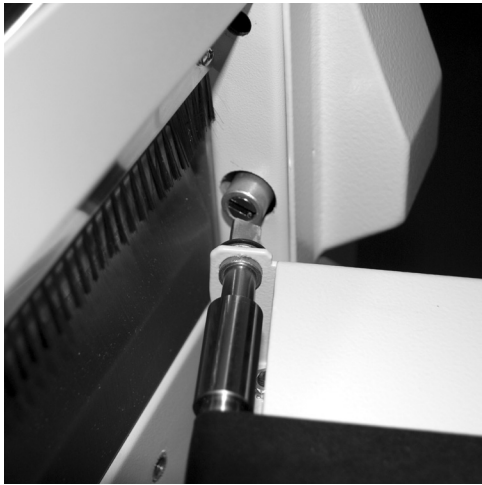


Figure 1a

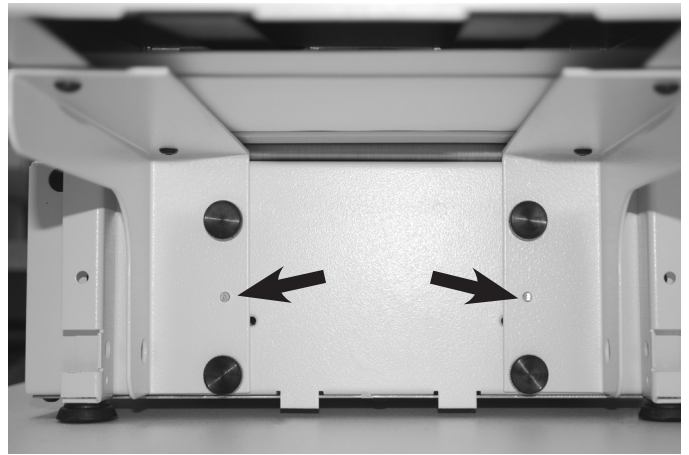


Figure 1b

# CONTROL PANEL



<b>Start</b>	Starts machine.
<b>Stop</b>	Stops machine.
<b>Ready light</b>	Steady green when power is on.
	Blinks red when cover is open or fault is detected.
<b>Counter Reset</b>	Resets counter
<b>Counter</b>	Shows forms count

# OPERATION

1. Adjust fold plates to desired fold for length of paper (see fold plate adjustment on page 4). To do this, loosen the two thumbscrews (figure 4a & b) on each fold plate. Align center bar (figure 4a & b) so the marks on each side match up. For “V” folds, remove the lower fold plate, turn around 180° and reinstall.
2. Make sure fold plates and cover are reinstalled properly.
3. Plug in cord and turn power on (figure 2).
4. To make sure folds are in the correct location, push the paper feed lever (figure 3) down and place one form onto the in-feed table and press the start button. Adjust fold plates if necessary (see fold plate adjustment on page 4).
5. Push the paper feed lever down and load paper neatly stacked and squared onto the in-feed table. Paper can be stacked up to 150 sheets. **Note:** Standard “Z” fold forms can be loaded face up or down with the glue edge leading. All “C” fold forms must be loaded face up with glue edge leading.
6. Be sure the ready light is green and press the start button to begin operation.

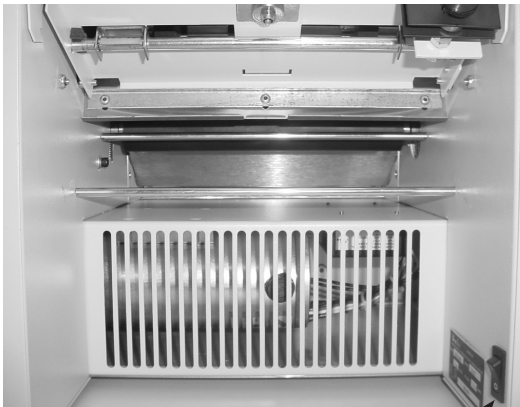


Figure 2

Power Switch



Figure 3

Paper Feed Lever

# FOLD PLATE ADJUSTMENT

Upper Fold Plate

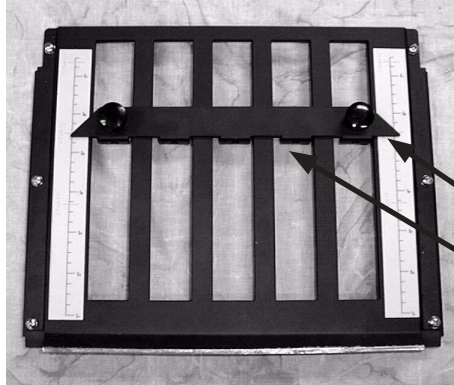


Figure 4a

Lower Fold Plate

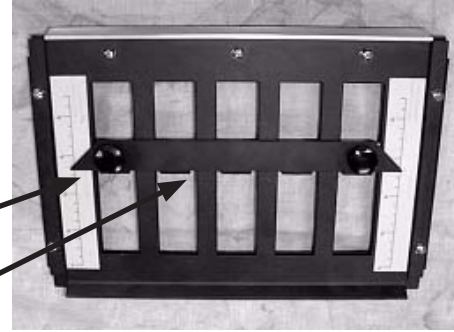


Figure 4b

Thumbscrews

Bar

1. To adjust the first fold remove the top cover. If the first fold is too long loosen the two thumbscrews on the upper fold plate and slide the bar down. If the fold is too short loosen the thumbscrews and slide the bar up.

**NOTE:** The bar should be on the same marks on each side.

2. To adjust the second fold remove the lower fold plate. If the second fold is too long loosen the two thumbscrews and slide the bar up. If the fold is too short loosen the thumbscrews and slide the bar down.

**NOTE:** The bar should be on the same marks on each side.

3. For quick setup of “C”, “Z” and “V” folds refer to the blue lines on the fold plate.

4. To reinstall the upper fold plate, slide the plate (with thumbscrews facing up and the throat toward the inside of the machine) until the grooves on the underside line up with the four pins on the machine (figure 5a & 5b).

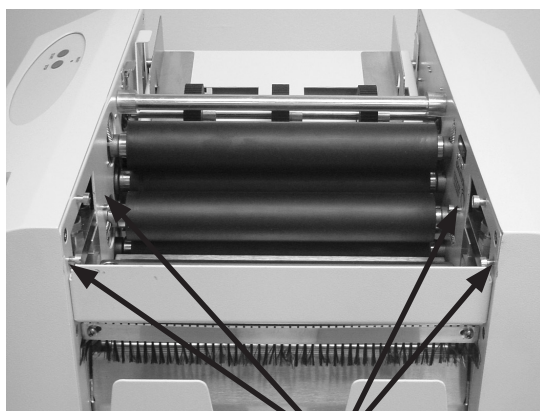


Figure 5a

Fold Plate Pins

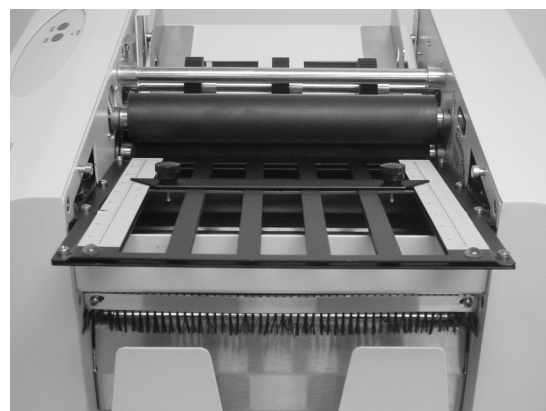


Figure 5b, correctly installed



5. To reinstall the lower fold plate, slide the plate (with the thumbscrews facing up and throat toward inside of machine, figure 6b) until it rests on the two silver bars (figure 6a) and locks into place (figure 6c).

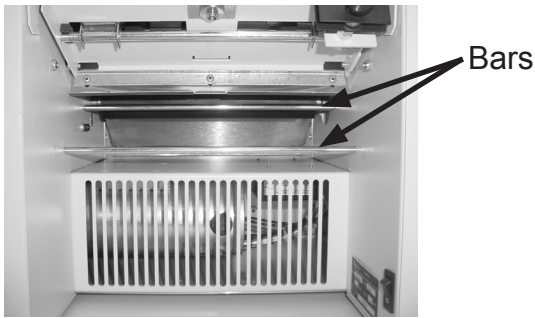


Figure 6a

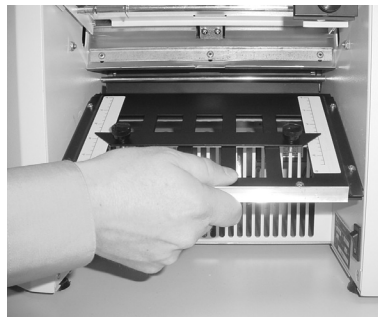


Figure 6b

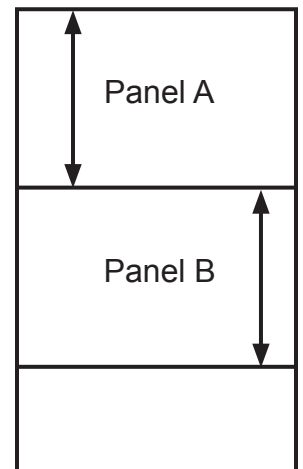


Figure 6b

## **SETTING CUSTOM FOLDS**

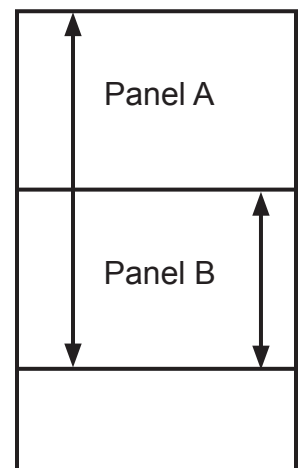
### **Eccentric “Z”**

1. Measure the length of panel “A”.
2. Adjust the upper fold plate so that the bar lines up with the measurements of panel “A”, for example: if panel “A” is 5 1/4” long move the bar up or down so that it lines up with the 5 1/4” mark on the fold plate.
3. Measure the length of panel “B”.
4. Adjust the lower fold plate so that the bar lines up with the measurements of panel “B”.
5. Load forms and press start (refer to OPERATION on page 2).



### **Uneven “C” / Return Mailer**

1. Measure the length of panel “A” & “B”.
2. Adjust the upper fold plate so that the bar lines up with the measurements of panel “A” & “B”, for example: if panel “A” + “B” is 10 1/2” long move the bar up or down so that it lines up with the 10 1/2” mark on the fold plate.
3. Measure the length of panel “B”.
4. Adjust the lower fold plate so that the bar lines up with the measurements of panel “B”.
5. Load forms and press start (refer to OPERATION on page 2).



## DAILY MAINTENANCE

1. It is recommended to let forms cool for one-half hour, from the laser printer, before folding and sealing. This allows toner to set on the forms, and static electricity to discharge. The 400 Series Jogger is recommended for best results. The Jogger squares the forms and dissipates heat and static created by laser printers.
2. If toner builds up on the metal sealer rollers, clean the rollers with a lint-free cloth dampened sparingly with a mild household cleaner.
3. Clean in-feed wheels and fold rollers with Formax-recommended roller cleaner & rejuvenator to remove paper dust and toner. A damp cloth with water is the best alternative. **CAUTION:** Do not use any chemicals other than the roller cleaner & rejuvenator or water.

## TROUBLESHOOTING

### Clearing paper jams:

**WARNING:** Turn machine off and unplug cord from its receptacle.

1. If a jam occurs in between the metal sealing rollers, remove any remaining forms from the hopper. Remove the top cover and the upper fold plate. Remove the jam-clearing tool (located under top fold plate), apply the tool to the upper metal roller (figure 7) and turn clockwise (**Caution:** Do not apply excessive force or rollers may be damaged) until the paper jam is clear. Remove the jammed form and return tool in holder and reinstall the upper fold plate. Reinstall cover and press the start button.

**Note:** Press the black button (figure 8) near the power cord inlet to reset the breaker if necessary.



Figure 7

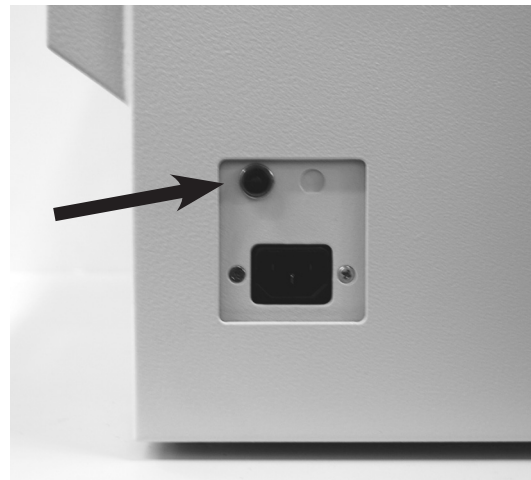


Figure 8

2. If a jam occurs in the fold plates, remove fold plate and remove paper. Reinstall fold plate.

# **TROUBLESHOOTING**

## **Fold quality needs improving:**

1. Make sure paper is squared and installed correctly. Side guides should be evenly balanced and snug against the paper.
2. If folds are still incorrect, adjust fold plates (see fold plate adjustment on page 4).

## **Paper is not folding square (Skewing):**

1. If paper pulls left or right, adjust the skew adjuster. To adjust the skew, turn the skew adjuster (figure 9) left or right until the paper is feeding correctly.

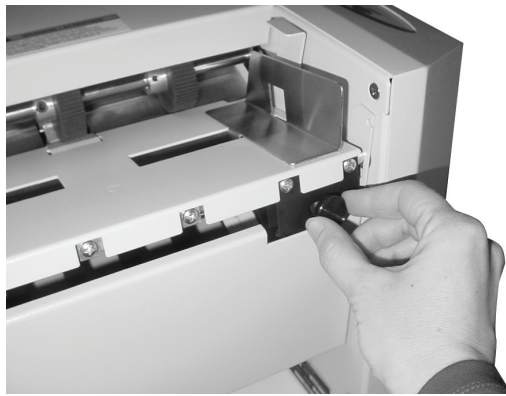


Figure 9

## **Ready light is not illuminated and power is on:**

1. Press the black button (figure 6) near the power cord inlet to reset the breaker.

## **Ready light is blinking red:**

1. Check that the top cover is installed properly.
2. Check to be sure the photo-eye, before the metal sealer rollers, is clear of forms and/or paper dust.

# INSTALLING OPTIONAL FLOW STRAPS

1. Optional Flow Straps can be used when processing thicker paper stock. To install, fold over 1/2 inch of strap. (figure 8a)

2. Place strap over static brush in appropriate location. (figure 8b)

**NOTE:** Straps should not be placed where they will interfere with the conveyor belts or the weighted outfeed tires, (see figure 11).

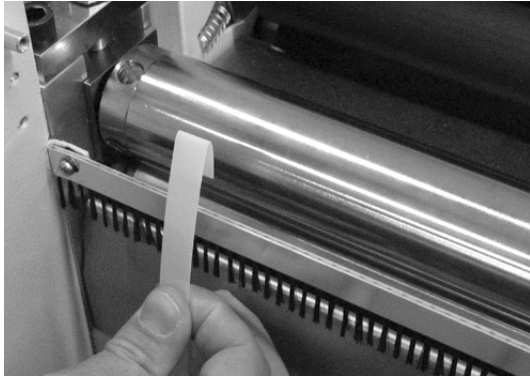


Figure 8a

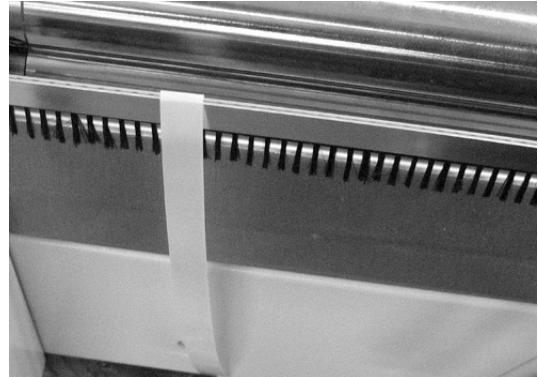


Figure 8b

3. With strap in place, press clip down over strap. (figure 9)

4. Figure 10 shows strap and clip in place.

**NOTE:** Clip must be removed before moving strap to a different location.

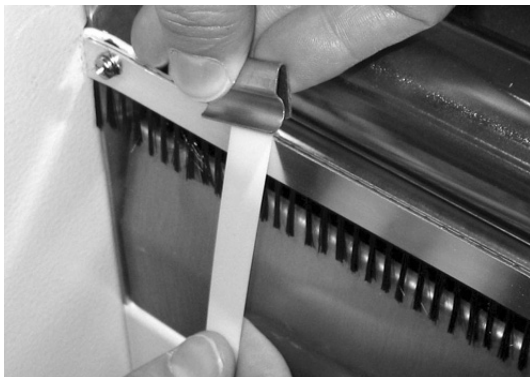


Figure 9

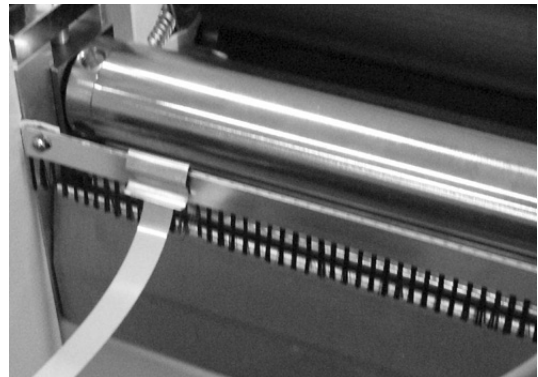


Figure 10

5. Repeat process on other side. Figure 11 shows two straps in place.

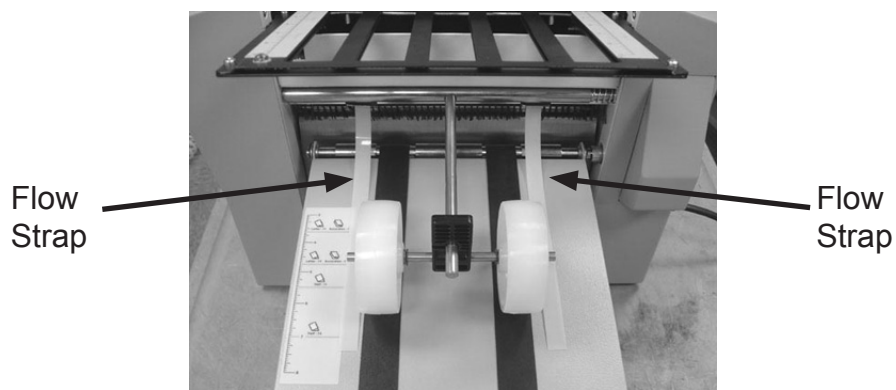
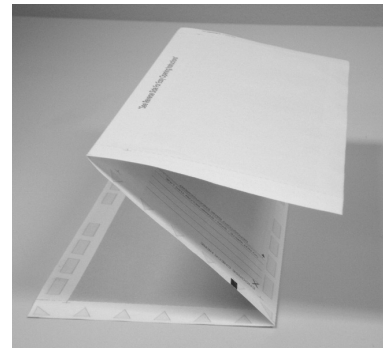
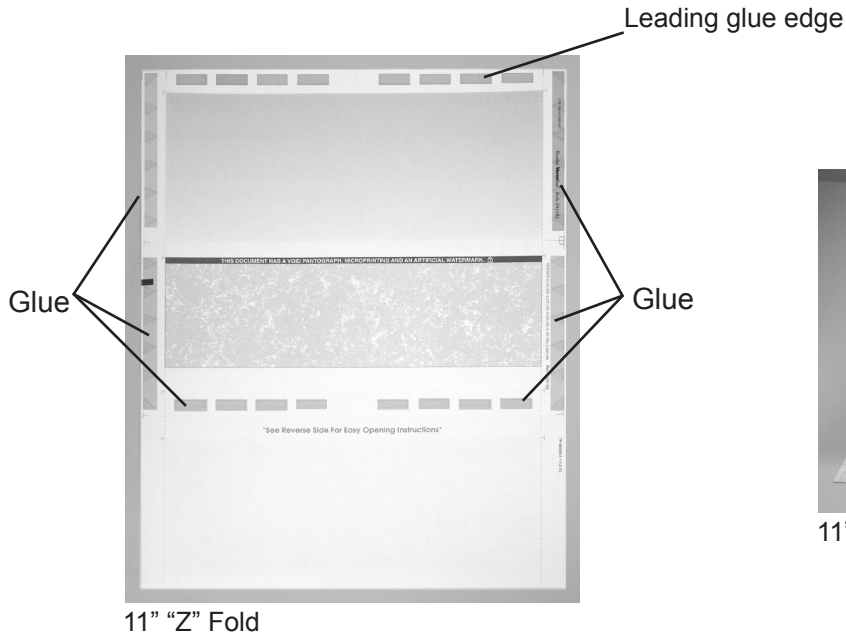


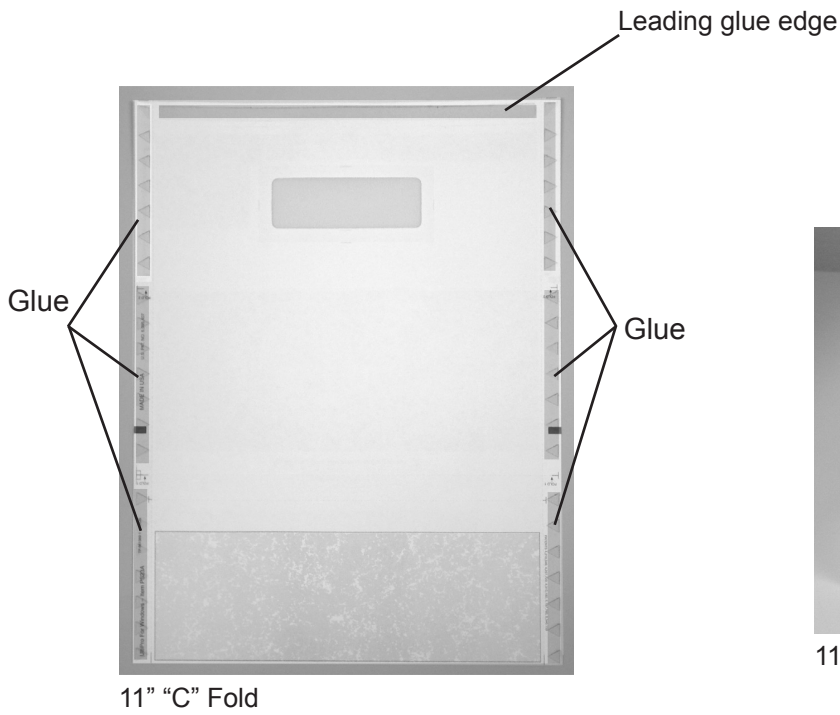
Figure 11

# DETERMINING FOLD TYPE

Two Standard Folds 11" "Z" & 11" "C"  
Refer to Operator Manual for custom fold setup.



11" "Z" Fold



11" "C" Fold

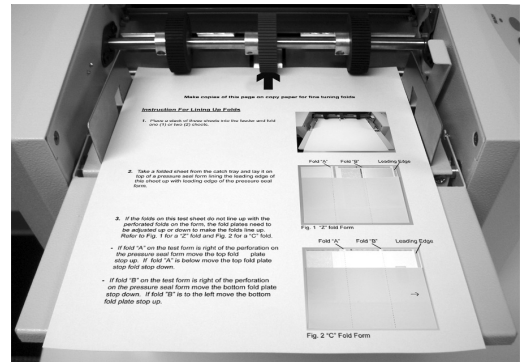
# Leading Edge



Make copies of this page on copy paper for fine tuning folds

## Instruction For Lining Up Folds

1. Place a stack of these sheets into the feeder and fold one (1) or two (2) sheets.



2. Take a folded sheet from the catch tray and lay it on top of a pressure seal form lining the leading edge of this sheet up with leading edge of the pressure seal form.

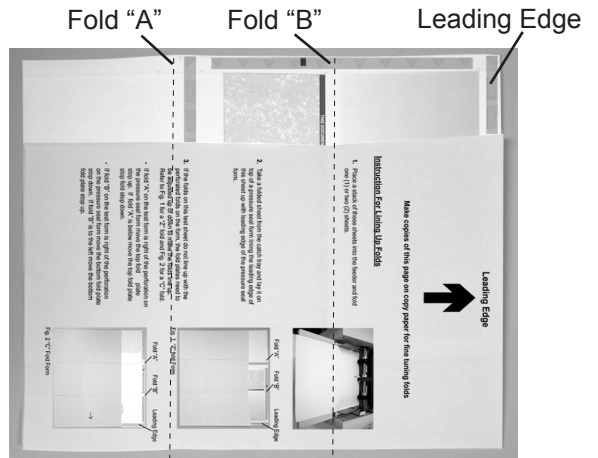


Fig. 1 "Z" fold Form

3. If the folds on this test sheet do not line up with the perforated folds on the form, the fold plates need to be adjusted up or down to make the folds line up. Refer to Fig. 1 for a "Z" fold and Fig. 2 for a "C" fold.

- If fold "A" on the test form is right of the perforation on the pressure seal form move the top fold plate stop up. If fold "A" is below move the top fold plate stop fold stop down.
- If fold "B" on the test form is right of the perforation on the pressure seal form move the bottom fold plate stop down. If fold "B" is to the left move the bottom fold plate stop up.

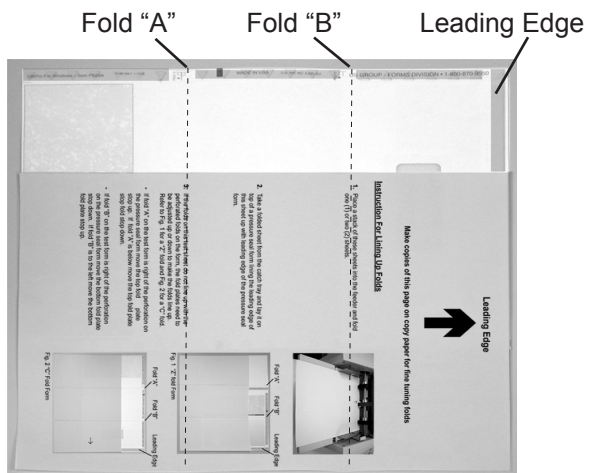


Fig. 2 "C" Fold Form