

FORMAX[®]

2150 Series Production Pressure Sealer

6 Maintenance

This chapter explains how to clean the machine and replace the consumables.

⚠ WARNING



Turn off the Power switch before performing any maintenance operation. Otherwise, a part of the machine could move suddenly, causing severe personal injury or damage to the machine.

6-1

Cleaning the Vacuum Pistons

If paper dust sticks to the vacuum pistons, they will not move smoothly. Disassemble and clean them.

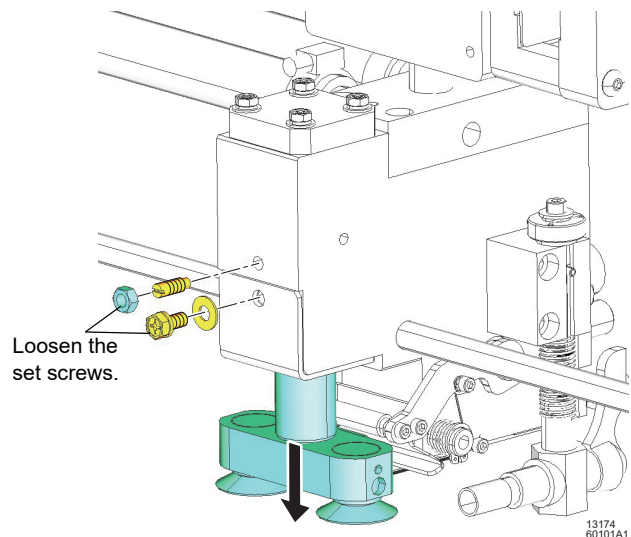
⚠ CAUTION



- Do not lubricate the vacuum pistons. Any lubricating oil will catch more paper dust.
- Do not hit or scratch the pistons.
- Keep the suction cups away from kerosene or oil to prevent them from deteriorating.

1 Remove the vacuum pistons.

- Loosen the piston set screw to remove the vacuum piston. Remove the two screws on the bottom of the piston to remove the suction block.



2 Clean the vacuum pistons.

Wipe the inside of piston well. Clean the holes in the suction head using compressed air.

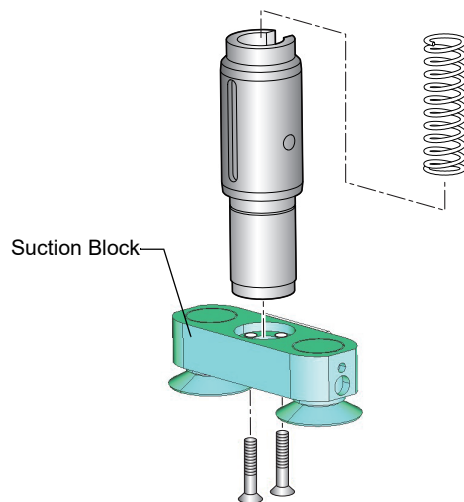


Note

If it is difficult to remove the dirt on the vacuum piston, wipe with ethanol alcohol or kerosene.

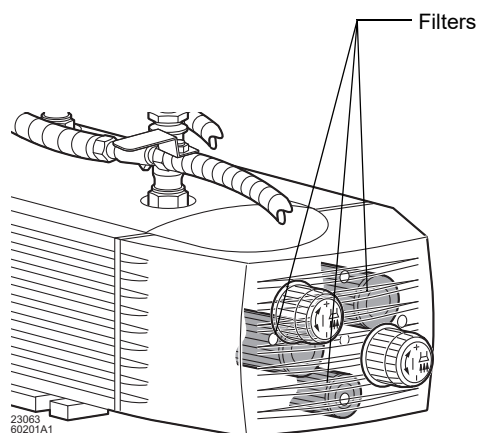
3 Assemble the vacuum pistons in the reverse order of removal.

- Insert the piston and lock lightly using the set screw. Then, loosen the set screw until the piston drops out by itself. Fasten the lock nut at the position.

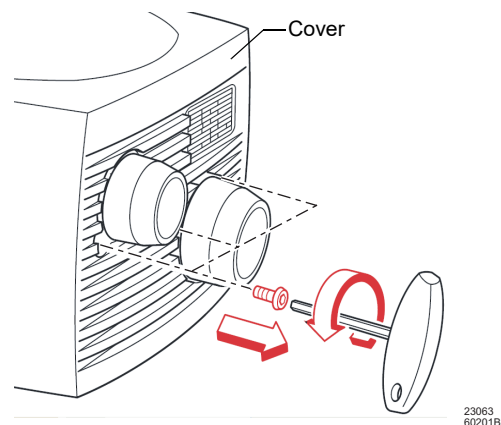


If the pump filters are clogged, the pump pressure will not increase when the regulator knob is turned. Clean the filters regularly. Remove any clogged dust using compressed air or a vacuum cleaner.

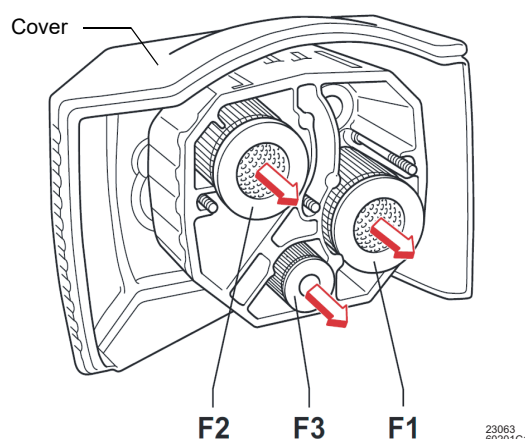
There are three filters installed as shown in the drawing to the right.



- 1** Turn off the power switch.
- 2** Remove the three screws and the cover shown in the drawing to the right.
- 3** Remove the filters.



- 4** Remove any dust in each filter using compressed air or a vacuum cleaner.
- If the dust cannot be removed, replace the filter.
- 5** Install the filters and parts in the reverse order of removal.



F1: Diameter 64 mm (2.5") Length 70 mm (2.8")
 F2: Diameter 64 mm (2.5") Length 60 mm (2.3")
 F3: Diameter 38 mm (1.5") Length 38 mm (1.5")

The fold rollers and drive rollers may become smeared with ink, and this may cause unreliable folding. Clean the rollers.

**WARNING**

Turn off the Power switch before cleaning the rollers.

- 1** Turn off the Power switch.
- 2** If necessary, remove the buckle chutes.

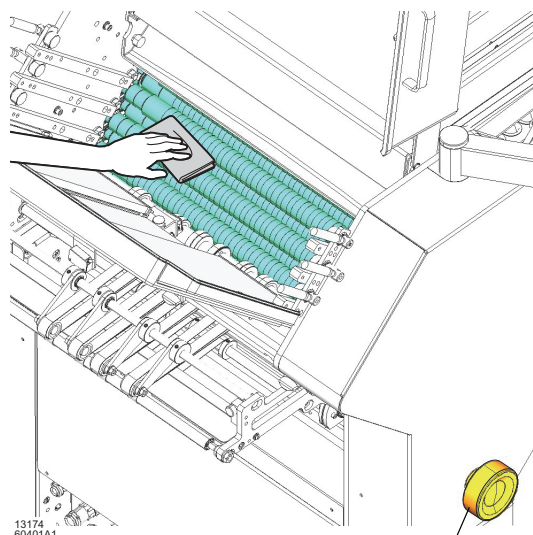
Refer to page 222.

- 3** Wipe the rollers using a cloth soaked with water or ethanol alcohol.

- Turn the rollers using the handwheel.

**CAUTION**

- Do not apply water or alcohol to the rollers directly. The rollers may not dry completely, and may contaminate the sheets.
- Do not use blanket cleaner or recovery agents for printers or isopropyl alcohol. They may cause damage or expansion of the rubber.



Handwheel

You may need to remove a buckle chute to clear a jam.

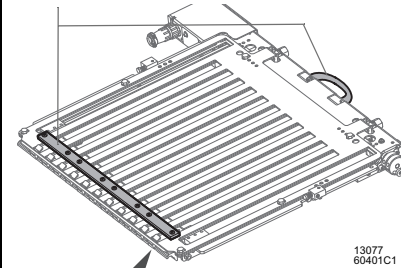
**WARNING**

Press the Emergency Stop button before removing the buckle chute. Otherwise, the machine may start suddenly and cause severe personal injury.

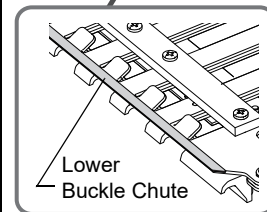
**CAUTION**

When you hold the buckle chute, do not hold the part shown in the drawing of the lower buckle chute. If the part of the lower buckle chute is applied, it may be deformed.

Hold here.



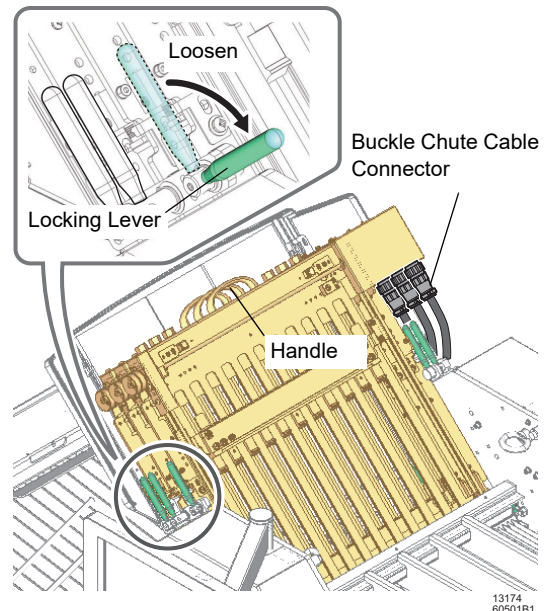
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Lower
Buckle Chute

First, Third and Fifth Buckle Chutes

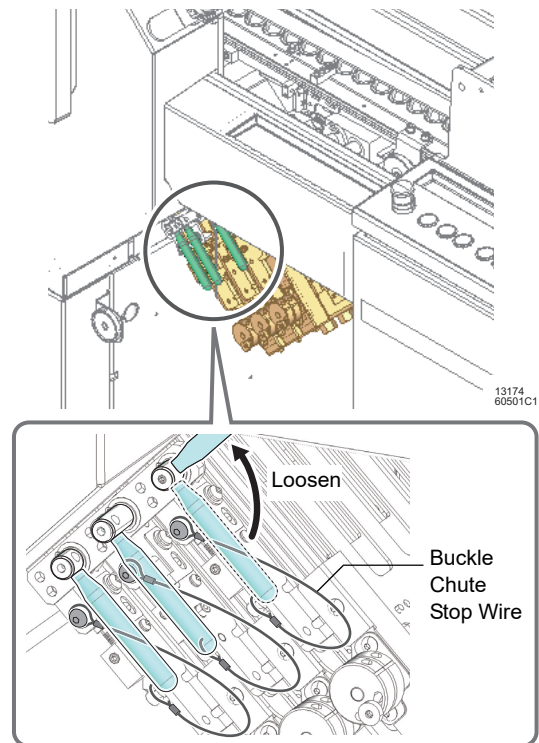
- 1 Press the Emergency Stop button.**
- 2 Disconnect the buckle chute cable connector.**
- 3 Loosen the locking levers.**
 - There are locking levers on the operator side and the rear of the assembly.
- 4 Remove the buckle chute.**
 - Pull out the buckle chute by lifting it up through the guides.



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Second, Fourth and Sixth Buckle Chutes

- 1 Press the Emergency Stop button.**
- 2 Disconnect the buckle chute cable connector.**
- 3 Check that the buckle chute stop wires are attached.**
 - There are wires on the front and rear of the assembly.
- 4 Release the locking levers.**
 - ➔ The buckle chute will slide down and be stopped by the wires.
- 5 Remove the wires.**
 - Lift the buckle chute a little and unhook the wires.
- 6 Remove the buckle chute.**



This sensor transmits and receives infrared light. The detecting sensitivity is decreased if dust is covering the sensor. The error icon  will be displayed on the Error screen. Clean the transmitter and receiver of the sensor using a soft cloth or brush. If the sensor is still covered with dust, wipe it off using a cloth soaked with a mild detergent.

**CAUTION**

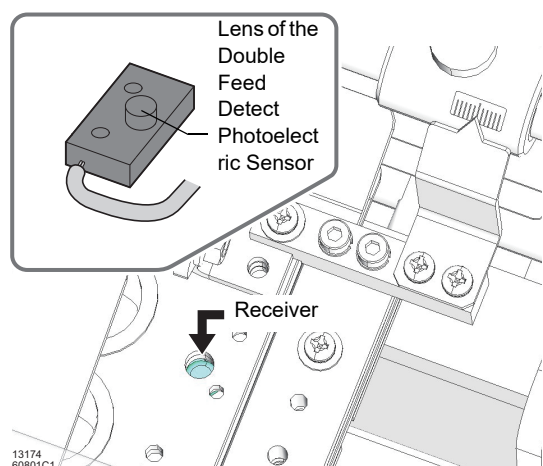
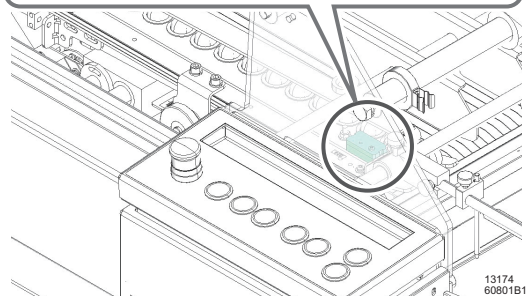
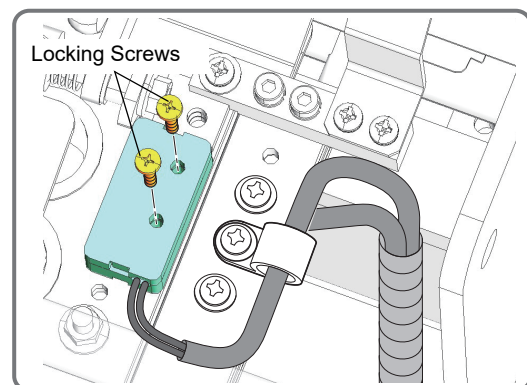
Use mild detergent to clean the sensor lens. Do not use blanket cleanser, recovery agents for printers, or any other cleaners. They may melt the lenses.

- 1** Turn off the Power switch.
- 2** Remove the transmitter section of the sensor.
 - Remove the two 4 mm locking screws.
- 3** Clean the lenses on the transmitter and the receiver of the sensor using a soft cloth or brush.
- 4** Reinstall the transmitter section of the sensor.
- 5** Turn on the main power.
 - If the error icon is displayed again, repeat steps 1 through 5.

**Additional Information**

Before operating the machine, turn the power off, wait 30 seconds, and turn it on again. If you do not do this, the machine will not run.

▼ Error Screen



**WARNING**

Turn off the Power switch before resetting any circuit breaker. Otherwise, the machine may start suddenly, causing severe personal injury.

**Important**

If a motor is overloaded, the circuit breaker will turn off the damage to the machine. Correct the cause of the overload before resetting the circuit breaker. If you do not do this, the breaker may trip again.

1 Identify which breaker is tripped using the list below.

Problem	Circuit Breaker
The display does not present any image when the main power is turned on.	Q00
The power lamp on the second station does not light.	Q02
The feed rotor does not rotate.	Q10
The pump does not run	Q11
The feed table does not move up and down	Q20
The gate fold buckle chute does not operate.	Q30
The delivery conveyor does not rotate.	Q40
The fold rollers in the second station do not operate.	Q60
The gate fold buckle chute in the second station does not operate.	Q61

2 Turn off the Power switch.

3 Remove the cover on the electrical box on the first station or second station.

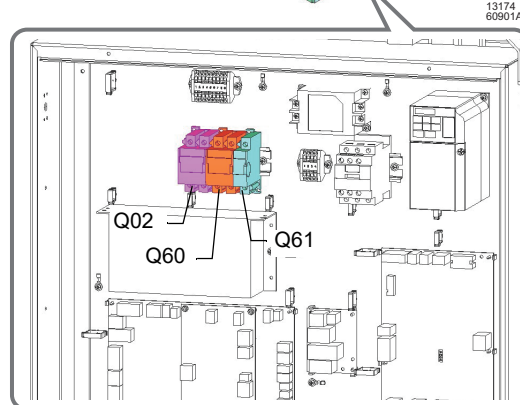
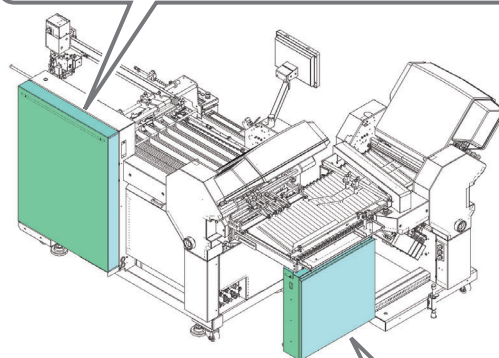
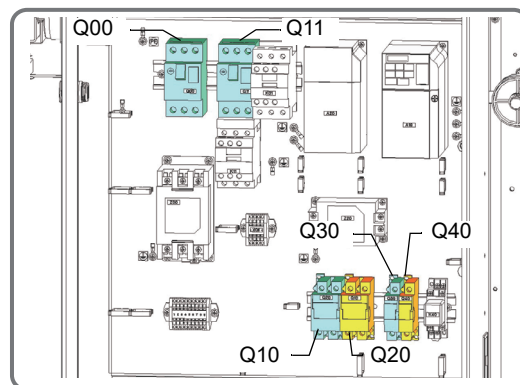
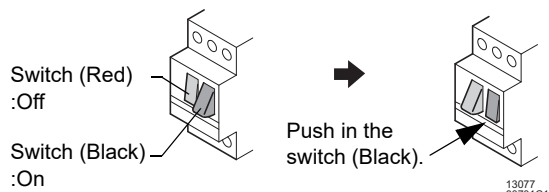
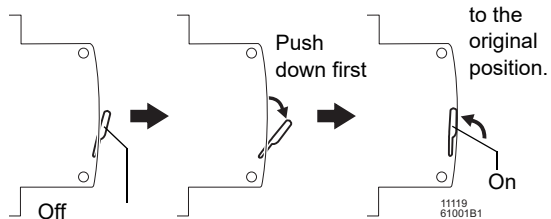
4 Turn on the breaker after waiting a few minutes.

- Push down the switch first, and return it to the original position to turn it on.

5 Attach the cover.

**Important**

If the circuit breaker trips again, please call your local dealer.

**Resetting the Circuit Breakers****Resetting the circuit protector**

6-7

Lubricating the Worm Gear

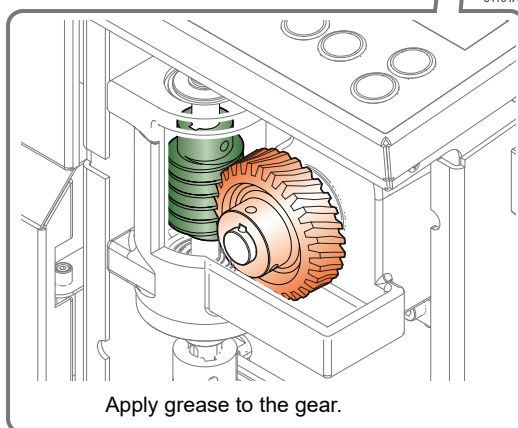
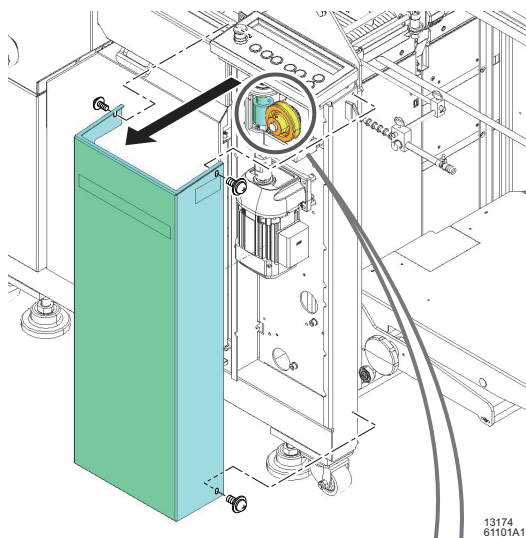
Frequency of lubrication: Once per 800 hours

The message screen about the cleaning will be displayed when the air filter should be checked.

Application Method...Brush

Grease: Lithium soap

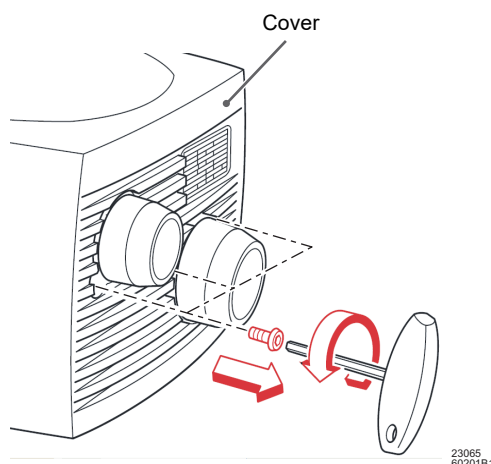
Viscosity: NLGI0



Apply grease to the gear.

The pump does not work correctly if the carbon blades in the pump are worn out. After 3,000 hours of use, follow the procedure below and check if the blades are worn. If necessary, replace the blades.

- 1 Turn off the main power.
- 2 Remove three screws and the cover shown in the drawing to the right.



- 3 Remove the rid.
- 4 Pull the carbon blades out and check them.



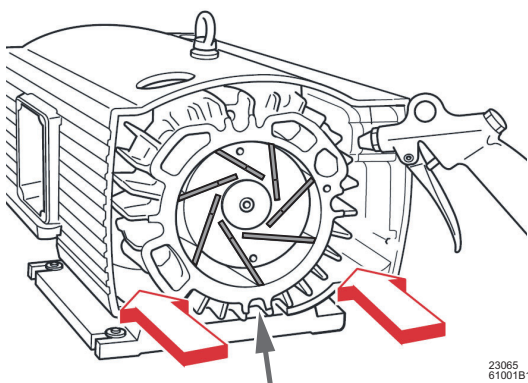
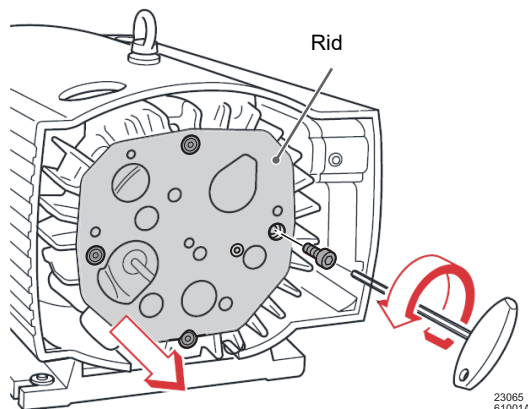
Note

If the length of the carbon blade is 27 mm / 1.06" or less, replace the blades.
- Replace all seven blades together.

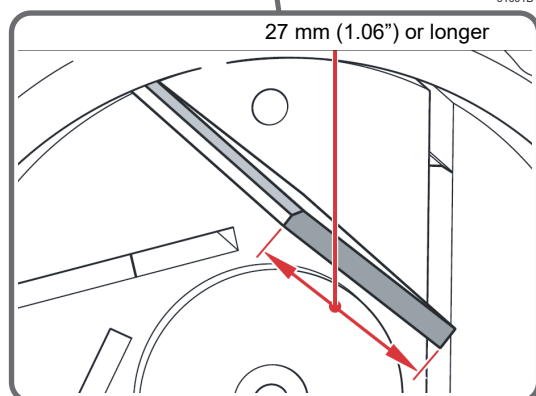


Important

When inserting the new blade, insert it to the direction shown in the drawing to fit the end of the blade on the inner wall of the cylinder.



- 5 Attach the covers in the reverse order of removal.



If you clean the touch panel improperly, it may be damaged. To prevent the damage to the touch panel, carefully read the and Cautions described below.

**CAUTION**

- Turn off the Power switch before cleaning.
- Use a cleaner for LCD screen. Do not use the alcohol, benzine, or thinner. Otherwise, it may damage the touch panel.
- Do not spray the cleaner directly to the touch panel. Otherwise, it may be dripping into the electrical parts, causing a touch panel to be damaged.
- Apply a cleaner to a cleaning cloth for eyeglass, then lightly wipe the LCD part only using that cloth. If you rub the LCD hard, it may be damaged.

7 Installation

7-1

Installing the First Station



WARNING



- The first station weighs 537kg (1,183.9 lb), and the pump weighs 29 kg (64.0 lb). Be very careful when moving these heavy sections of the machine.
- Place the machine on a solid and flat floor.
- Do not make the final connection to the power distribution board until all of the other wiring connections are completed. Otherwise an electric shock could cause severe personal injury.
- Attach the ground wire. Otherwise, leakage currents might cause severe personal injury.



CAUTION

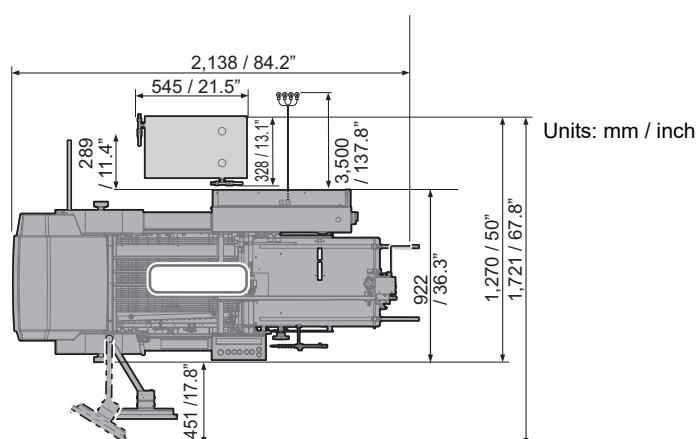


- Avoid direct sunlight.
- Avoid hot and humid locations.

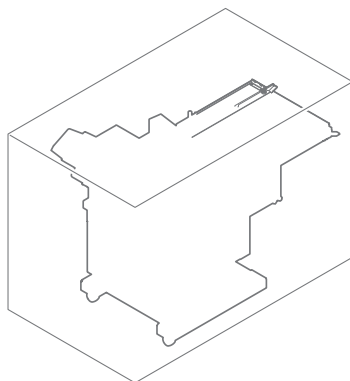
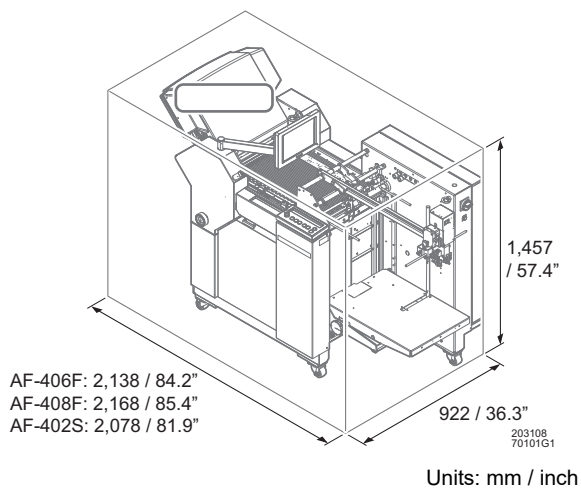
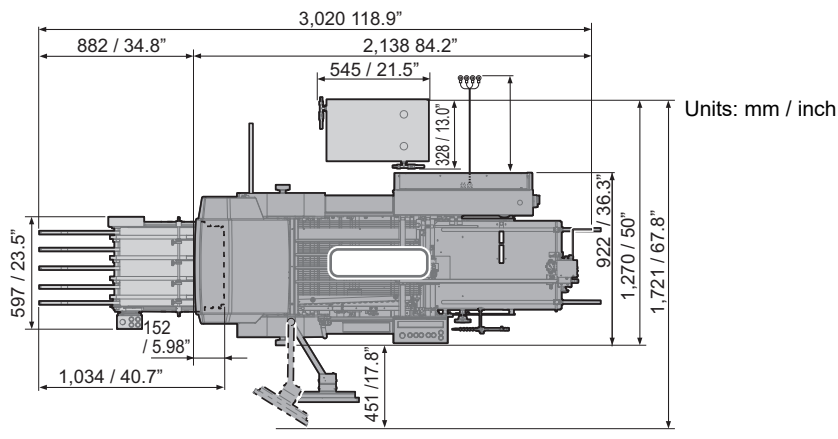
7-1-1 Placing the first station

1 Prepare enough installation space to allow for machine operation, daily checks, sheet replacement, and maintenance.

- Allow about 700 mm / 27.6" on all sides of the machine for maintenance and daily checks.



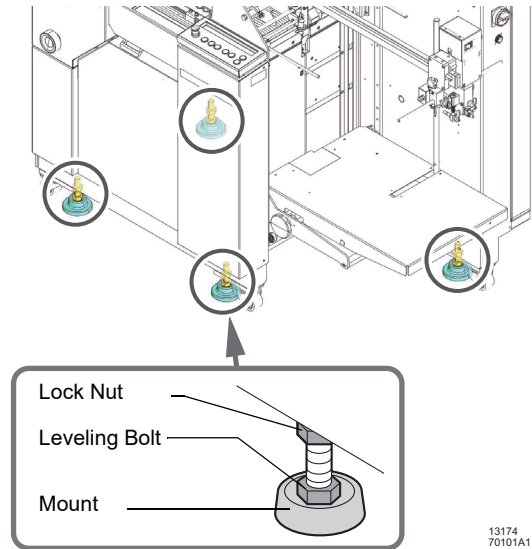
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2 Insert the leveling bolts.

- Insert the four bolts into the slots on the bottom of the machine.

3 Place the mounts under the leveling bolts.

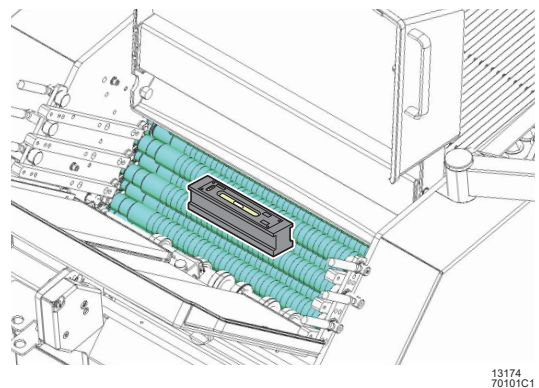
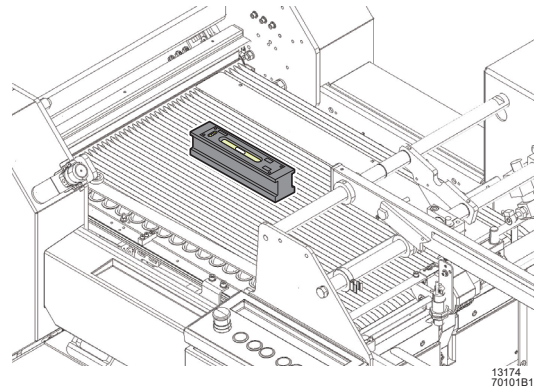


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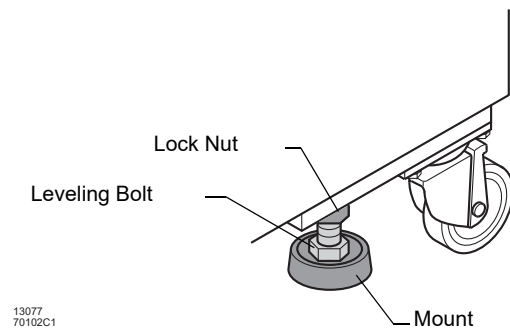
7-1-2 Level Adjustment of the First Station

1 Level the machine.

- Level the machine in both directions (parallel to the buckle fold rollers and 90 degrees to the buckle fold rollers) using the four leveling bolts and the 30 mm wrench.
- To check for level in the direction 90 degrees to the fold rollers, place a torpedo level on the side of the register guide section.
- To check for level in the direction parallel to the fold rollers, place a torpedo level on the bracket for the guide.

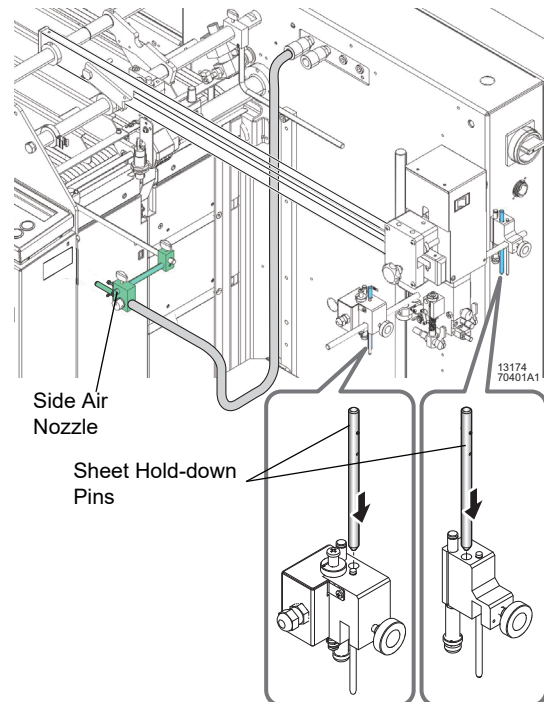


2 After making the leveling adjustment, tighten the lock nuts to lock the leveling bolts.



1 Install the accessories listed below:**First Station**

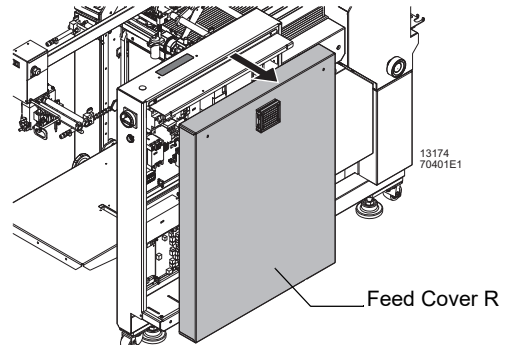
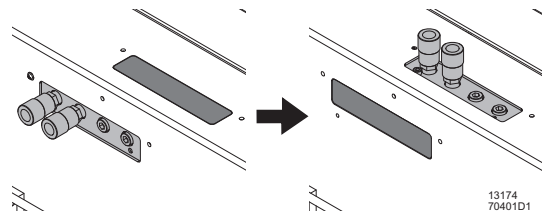
- Side Air Nozzle
- Sheet Hold-down Pin



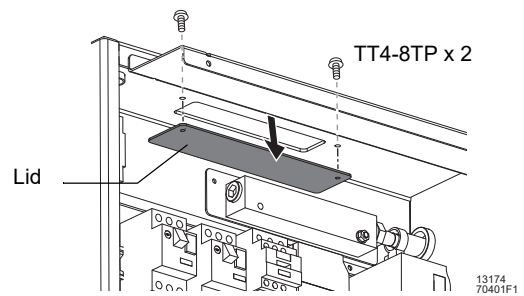
About Side Air in the First Station

When the machine is shipped, the air coupler for connecting the side air hose is facing inside the machine. If the hose hinders you from loading the sheets, you can remove the air coupler and attach it upward.

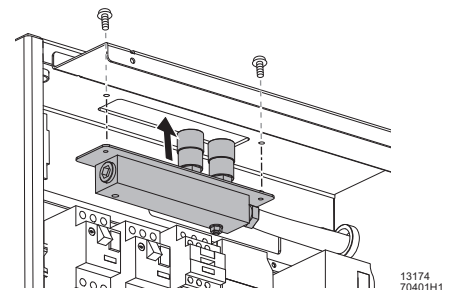
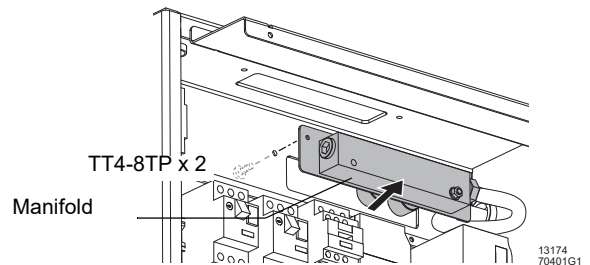
1. If an air hose is connected to the air coupler, remove it.
2. Remove the feed cover R.



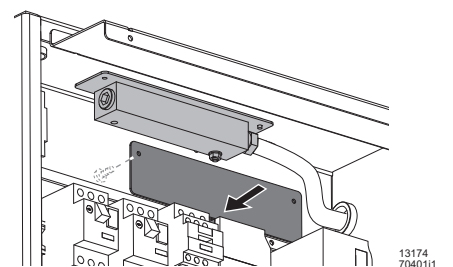
3. Remove the lid.



4. Remove the manifold. Remove the air coupler and attach it upward.



5. Install the lid.
6. Install the feed cover R.
7. Connect the hose.



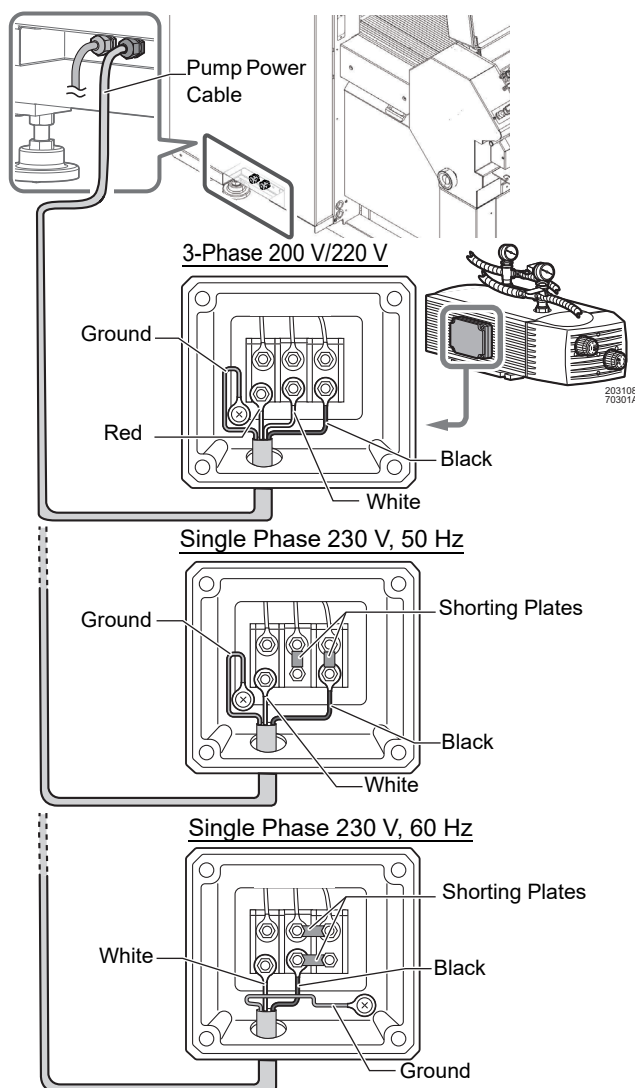
This section explains how to connect the power cable and hoses for the pump.

- 1 Place the pump behind the machine.**
- 2 Connect the power cable for the pump.**

- Connect the power cable for the pump from the back of the machine to the terminal board on the pump.

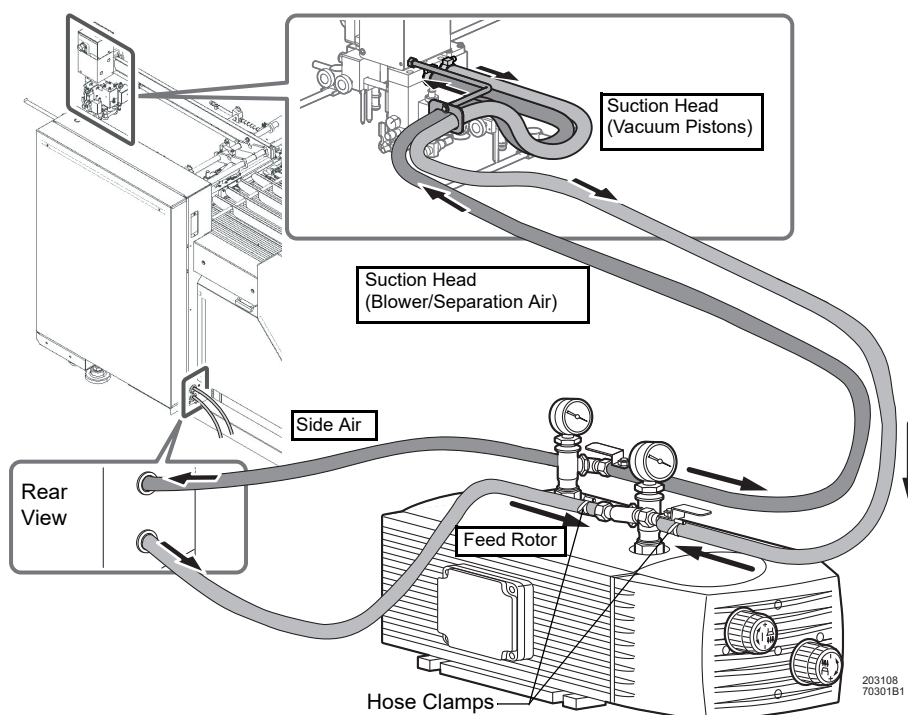


Important
Be sure to connect the ground wire.



- 3 Connect the air hoses to the pump.**

- There are four air hoses connected to the pump.
- Connect the hoses to the pump as shown in the drawing below.
- After connecting the hoses, fasten them using hose clamps.



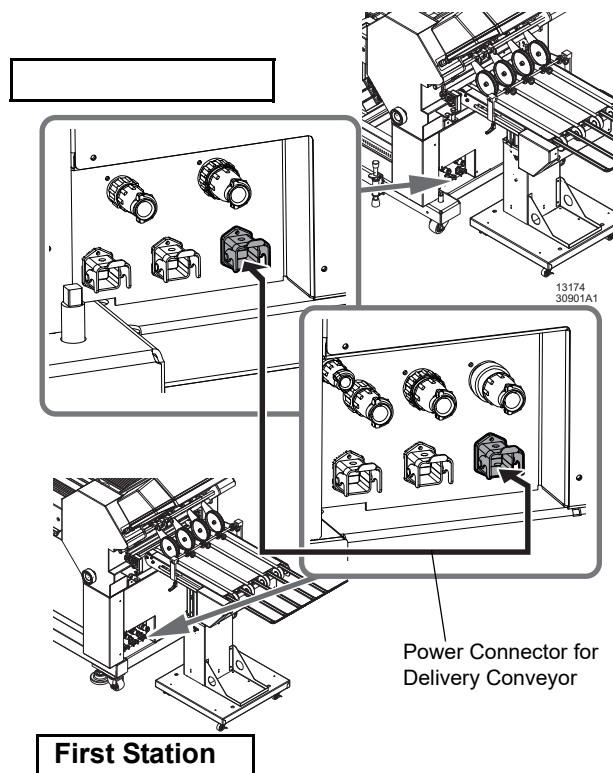
1 Install the delivery conveyor in the correct position to receive the sheets.

- Connect the power cable for the delivery conveyor to the power connector on the second station.



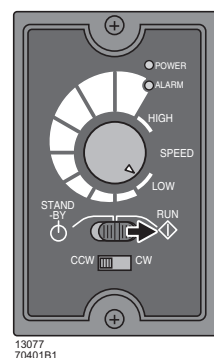
Note

If you connect the delivery conveyor to the first station, connect the power cable to the power connector for the delivery conveyor on the first station.



2 Set the conveyor control panel.

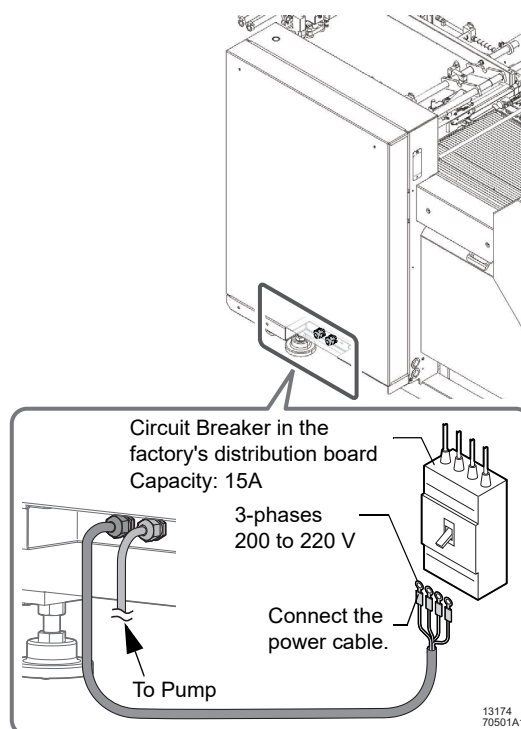
- Set the conveyor switch to Run.



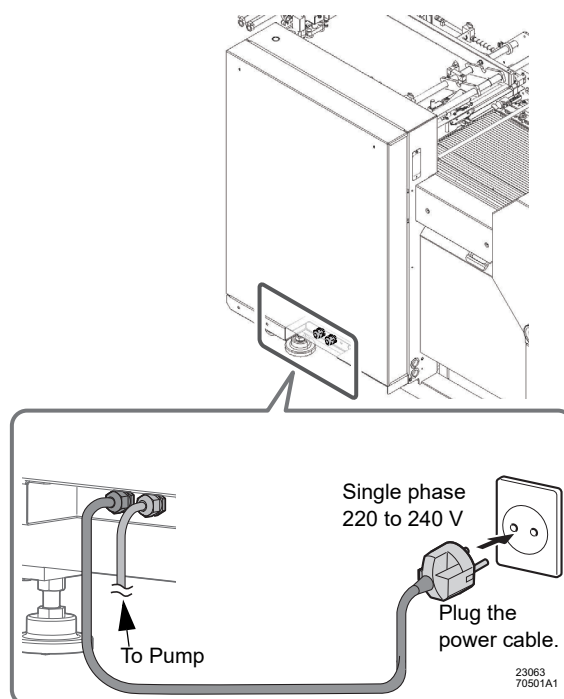
**WARNING**

If the machine's power cable will be connected directly to a circuit breaker on the power distribution board in the building, ask a qualified contractor to do the job.

- 1** Turn off the circuit breaker in the factory's distribution board.
- 2** Plug the power cable from the machine to the distribution board.
- Be sure to connect the ground wire.
- 3** Turn on the circuit breaker on the distribution board.
- 4** Turn on the Power switch.

**Single Phase 220 to 240 V**

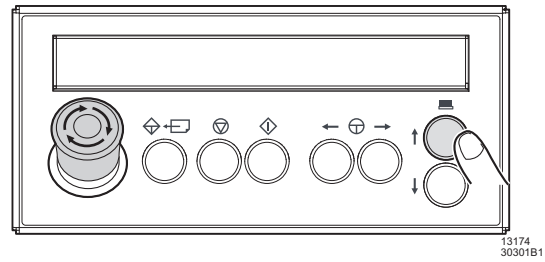
- 1** Plug the power cable from the machine to the distribution board.
- 2** Turn on the Power switch.



Check the direction of rotation of the fan on the pump to see whether the power cable is connected correctly.

1 Turn off the main Power switch.

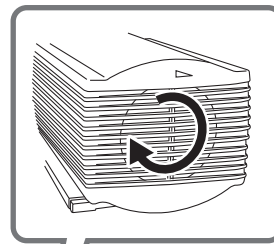
2 Raise the feed table.



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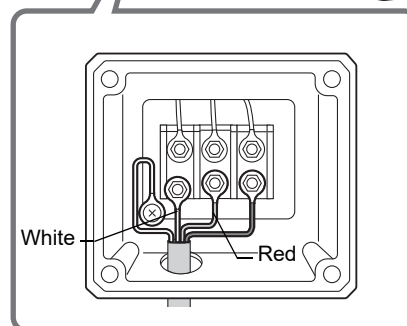
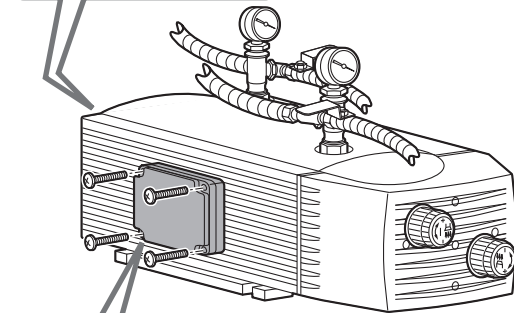
3 Start the pump and check the direction of rotation of the belt inside pump.

- Press the Motor/Feed Start button on the control panel to start the pump.
- Press the Motor/Feed Start button again to stop the pump immediately. If you let the fan rotate counterclockwise for a long time, the pump will be damaged.



4 If the belt rotates counterclockwise, do the following:

- 1) Turn off the Power switch.
2. Exchange the connections for the red and white wires connected to the terminal board.



- 1 Check that the correct date and time are displayed.
(If they are wrong, correct it.)

▼ Information Screen

The Information Screen interface features a top toolbar with icons for home, settings, file management, and help. The main content area is divided into two sections. On the left, a date and time selection box is highlighted with a red rectangle; it contains a clock icon, a date field (MM/DD/YYYY), and a time field (HH:MM). Below this are fields for '1 S/N' and '2 S/N'. On the right, there are five version fields: 'Panel Control Ver', 'First Station Control Ver', 'Second Station Control Ver', 'Knife unit Control Ver', and 'Camera unit Control Ver'. A bottom toolbar contains navigation and function icons. The screen number '13174' and version '70701A1' are displayed in the bottom right corner.

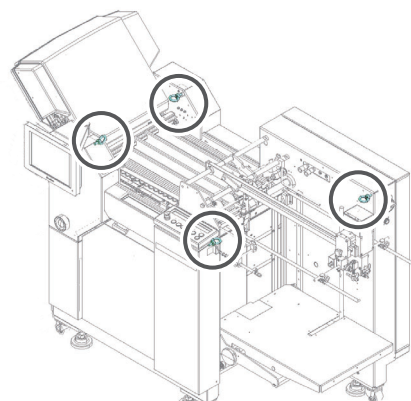
Panel Control Ver	
First Station Control Ver	
Second Station Control Ver	
Knife unit Control Ver	
Camera unit Control Ver	

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1 Check the following:

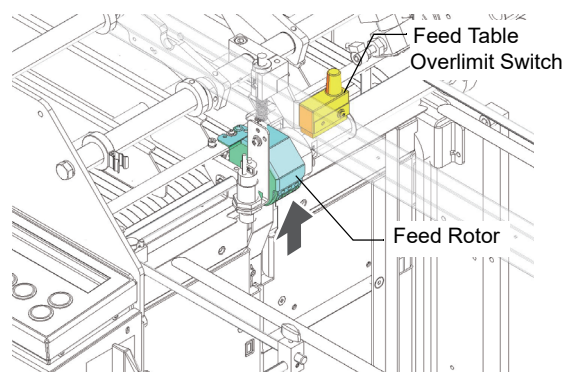
1. The Emergency Stop buttons operate correctly.
2. The short circuit connectors are attached to the signal connectors which are not used.
3. All the eyebolts are removed.

	CAUTION
	If the feed table is raised without removing the eyebolts, the table hits so that the chain may be cut.

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4. You must hear a click sound when you push up the feed rotor lightly.

	CAUTION
	If the Feed Table Overlimit switch does not work properly, the table hits against the feed rotor. This may damage the machine.

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5. Move the motor and check that there are no strange noises or bad smells.

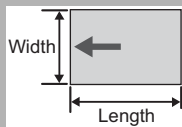
9 Appendix

This chapter lists the specifications, the accessories for this machine, consumables and options.

9-1

Specifications

Model	1st Station	FD 2150 (Semi Automatic) FD 2156 (Full Automatic)
Retail Name		Buckle Folder
Machine Structure		FD 2156: 6 Buckles FD 2150: 2 Buckles
Sheet Size	Max.	Width x Length 430 mm x 660 mm or 16.92" x 25.98" .
	Min.	Width x Length 50 mm x 100 mm or 1.97" x 3.94"
Sheet Weight Range		Uncoated Paper 33 to 157 gsm Coated Paper 73 to 157 gsm
Belt Speed		30 to 180 meters per minute or 98 to 590 feet per minute
Production Speed		Suction Head 30,000 cycles per hour
Buckle Chute Fold	Buckle Fold Length	1st Station 1st Buckle Chute: 20 to 350 mm or 0.79" to 13.77"
		2nd Buckle Chute: 20 to 280 mm or 0.79" to 11.02"
		3rd Buckle Chute: 20 to 350 mm or 0.79" to 13.77"
		4th Buckle Chute: 20 to 280 mm or 0.79" to 11.02"
		5th Buckle Chute: 20 to 350 mm or 0.79" to 13.77"
		6th Buckle Chute: 20 to 680 mm or 0.79" to 11.02"



Buckle Chute Gap		First Station 1st Buckle Chute: 1.0 mm or 0.039" 2nd buckle chute: 1.5 mm or 0.059" 3rd buckle chute: 2.0 mm or 0.079" 4th buckle chute: 2.0 mm or 0.079" 5th buckle chute: 2.3 mm or 0.091" 6th buckle chute: 2.3 mm or 0.091"		
Feeding	Sheet Feeding System	Air Suction Rotor & Suction Head (Feed interval and suction time are adjustable.)		
	Feeder Stack Height	Max. FD 2156: 500 mm or 19.68" FD 2150: 440 mm or 17.32"		
		Max Load. 150 kg or 330.6 lb		
Fold Rollers		Select one among the rollers below.		
		Material	Suggested Buckle Chute	Model
		Combination of soft polyurethane form rubber and steel roller	6	FD 2156
			2	FD 2150
Slit Perforation/ Perforation/ Scoring	Slit Perforation	No Accessories		
	Perforation	No Accessories		
	Scoring	Scoring blade width: 1 mm or 0.04"		
	Number of Holders	No Accessories		
Automatic Setup Accuracy		Minimum Setting Dimension: 0.1mm or 0.005"		
Infeed/Delivery Height		Delivery Height 1st Station: 871 mm or 34.3"		
Vacuum Pump		Standard		
Voltage/Frequency		1st Station: 3-phase 200 to 220 V, 50 or 60 Hz Single Phase 220 to 240 V, 50 or 60 Hz		

Rated Current	1st Station FD 2156: 3-phase 200 to 220 V, 50 or 60 Hz, 8.3 A Single Phase 220 to 240 V, 50 Hz, 8.2 A Single Phase 220 to 240 V, 60 Hz, 9.5 A FD 2150: 3-phase 200 to 220 V, 50 or 60 Hz, 8.0 A Single Phase 220 to 240 V, 50 Hz, 8.5 A Single Phase 220 to 240 V, 60 Hz, 10 A
Heat Output	1st Station: 2,750 kJ or 660 kcal
Motors	1st Station: 400 W x 1,200 W x 1, 1.3 kW x 1 (Pump)
Machine Dimensions	FD 2156 W2,138 x D922 x H1,457 mm or W84.2" x D36.3" x H57.4" FD 2150: W2,078 x D922 x H1,457 mm or W81.9" x D36.3" x H57.4"
Noise Level	L _{Aeq} 87.0 dB
Machine Weight	FD 2156: 537 kg or 1,183.9 lb AF-406FL/SL: 571 kg or 1,258.9 lb T-406F/S: 372 kg or 820.2 lb
Temperature and Humidity	Temperature 0 to +40 degrees Celsius or 32 to 104 degrees Fahrenheit Humidity 20 to 75%RH (There must not be any dew condensation.) (25 degrees Celsius or 77 degrees Fahrenheit and 52 +/- 6%RH are recommended.) Altitude 1,000 meters above sea level or below Pollution Level 2
Storage Conditions	Temperature -15 to +65 degrees Celsius or 5 to 149 degrees Fahrenheit Humidity 80%RH or below (There must not be any ice or dew condensation.)

The machine design and specifications are subject to change without notice.

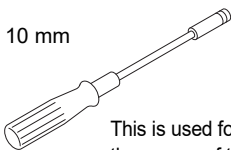
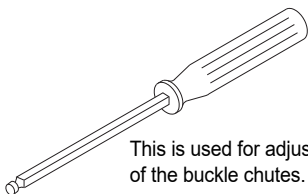
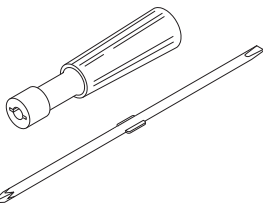
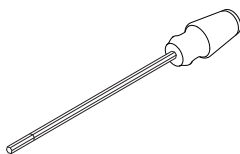
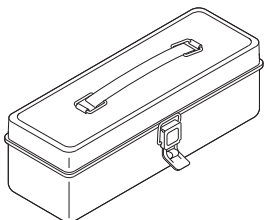
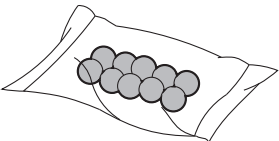
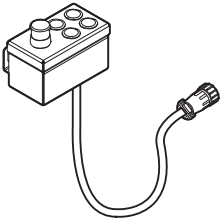
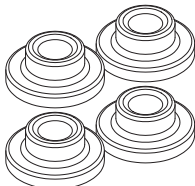
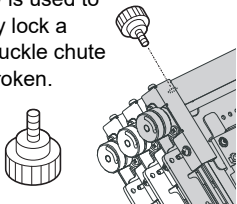
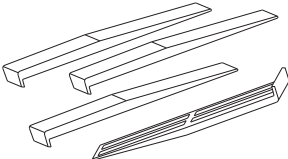
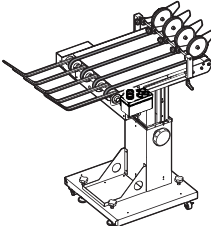
Specifications may vary depending on the job, paper quality, environmental influences, and various other factors.

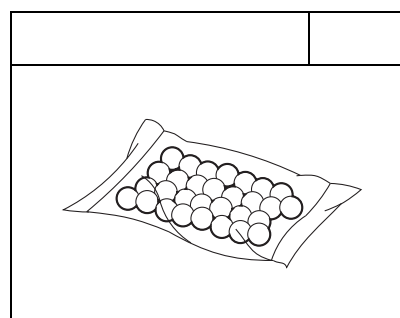
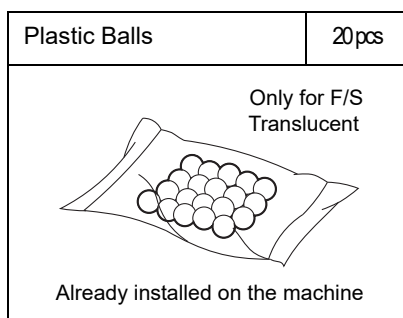
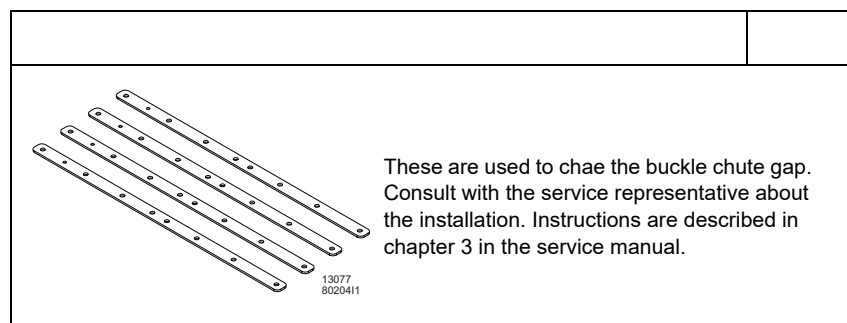
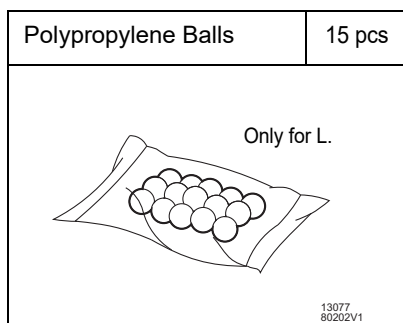
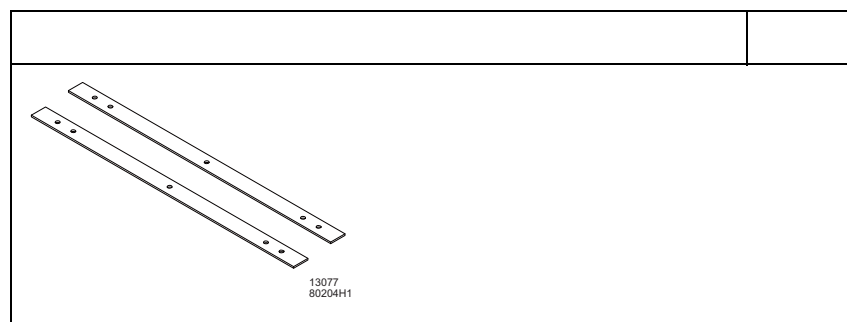
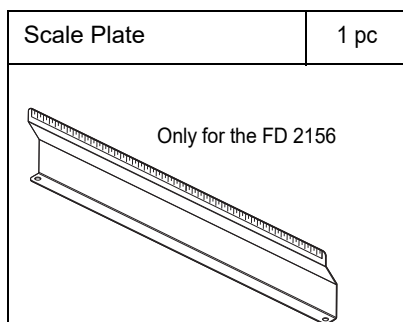
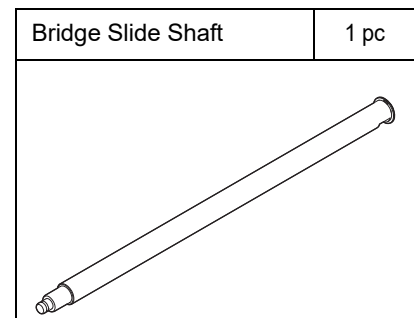
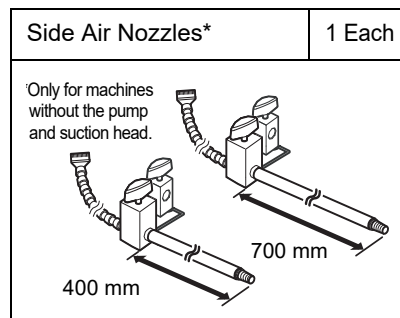
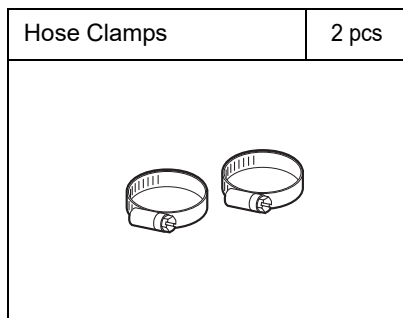
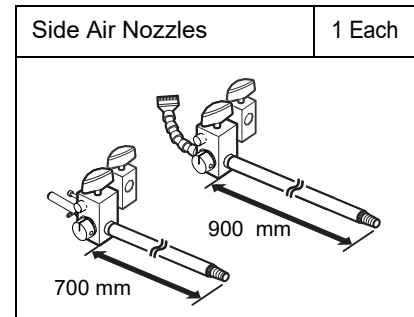
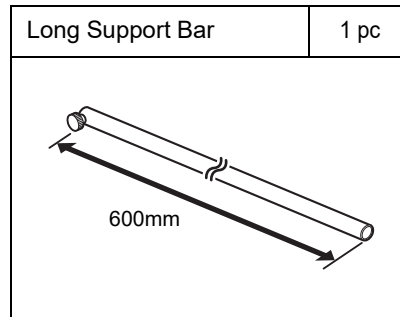
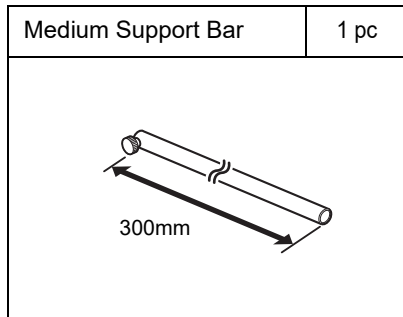
Please do a test run before starting production.

9-2

Accessories

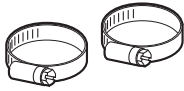
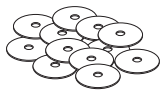
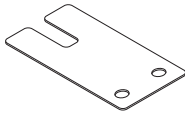
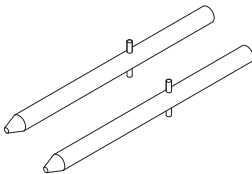
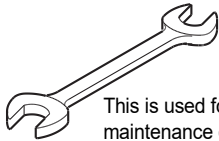
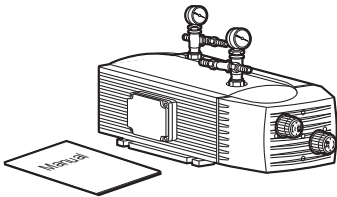
9-2-1 First Station

Socket Driver	1 pc	BallPointDriver(2.5mm)	1 pc	BallPointDriver(3mm)	1 pc
10 mm  This is used for replacing the spacer of the buckle chute.		 This is used for adjusting the positions of the scoring rollers		 This is used for adjusting of the buckle chutes.	
ReversibleScrewdriver	1 pc	Hex Driver (2.5mm)	1 pc	Tool Box	1 pc
		 This is used for adjusting the height of the delivery belt.			
Steel Balls	10 pcs	Remote Controller	1 pc	Mounts	4 pcs
					
User's Manual/Parts Book/ Blade Book	1 each	Leveling Bolts	4 pcs	Lock Nuts	4 pcs
					
Locking Screw	1 pc	Pins	4 pcs	Short Conveyor	1 pc
This screw is used to temporarily lock a shaft if a buckle chute motor is broken. 					

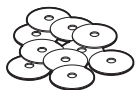
9-2-1 First Station(Continued)

Accessories

The following parts are necessary to retrofit the suction head.

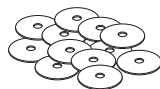
Hose Clamps 2 pcs 	Thin Suction Cups 10 pcs 	Thick Suction Cups 12 pcs 
Separator(PET) 1 pc 	Weights for Sheet Hold-down Bar 2 pcs 	Double Open-End Wrench(8/10mm) 1 pc  This is used for maintenance operation for suction head.
Pump and Operation Manual for Pump 1 Each 	Cutting Proof Gloves 1 set  WARNING Always wear cut-resistant gloves when installing/ removing parts or performing maintenance. Failure to do so may result in severe personal injury. Be careful especially when installing and removing the parts around the fold knives and buckle chutes.	

Thin Suction Cups



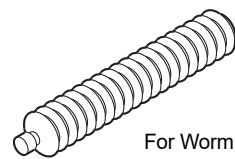
Parts Book for AF-406T6F: Fig.62 - Index1

Thick Suction Cups



Parts Book for AF-406T6F: Fig.62 - Index2

Grease Cartridge



For Worm Gear

Parts Book: Fig.62- Index9

Pump Filter 1



Parts Book: Fig.57 - Index9

Pump Filter 2



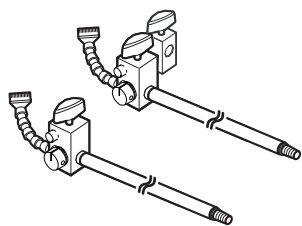
Parts Book: Fig.57 - Index10

Pump Filter 3



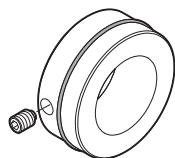
Parts Book: Fig.57 - Index11

Side Air Nozzles (Rear)



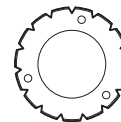
Parts Book: Fig.7
These are described in page 85.

Scoring Wheel



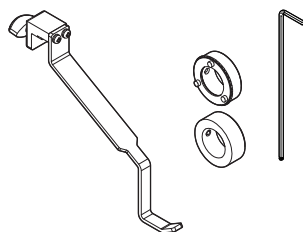
External Diameter: 41 mm / 1.614"
Parts Book: Fig.150 - Index10
External Diameter: 41.5 mm / 1.634"
Parts Book: Fig.150 - Index6
External Diameter: 42 mm / 1.654"
Parts Book: Fig.150 - Index11

Perforation Blade



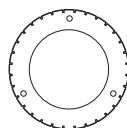
Cut 6 mm Blank 4mm
Parts Book: Fig.150 - Index3

Perforation Guides Set



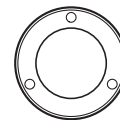
Parts Book: Fig.152
These are described in page 31.

Perforation Blade



Cut 3.2 mm Blank 0.8 mm
Parts Book: Fig.150 - Index1
Cut 1.4 mm Blank 0.8 mm
Parts Book: Fig.150 - Index2

Slitter Blade

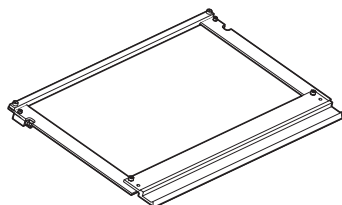


Blade for center cut
side out.

External Diameter: 41.4 mm / 1.630"
Parts Book: Fig.150 - Index8
External Diameter: 42.4 mm / 1.669"
Parts Book: Fig.150 - Index9
External Diameter: 44.4 mm / 1.748"
Parts Book: Fig.150 - Index13

Flat Deflector

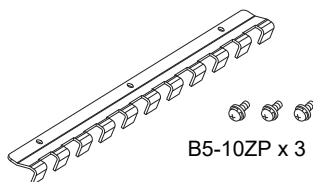
*1



Parts Book: Fig.156 - Index5

Straight Stopper

*1



B5-10ZP x 3

Parts Book: Fig.24 - Index45

Press Roller

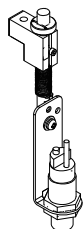
*1



Parts Book: Fig.155 - Index1

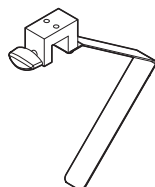
Sensor for Small Sheet

*1

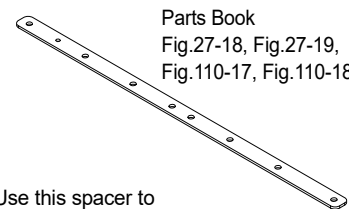


Parts Book: Fig.204

Delivery Guide



Parts Book Fig.35 - Index 14
This is described in pages 31 and 122.

Buckle Chute Spacer
(1.0 mm or 0.04")

Parts Book
Fig.27-18, Fig.27-19,
Fig.110-17, Fig.110-18

Use this spacer to
adjust the gap between
the buckle chutes.

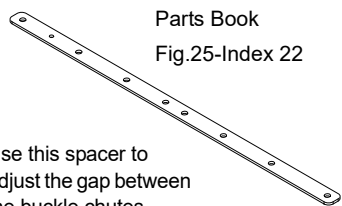
1st station: for 2nd, 4th, and 6th buckle chutes

*1 : See the attached user's manual for the instruction on installation.

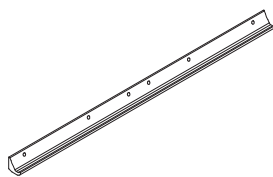
Buckle Chute Spacer L 15
 (1.5 mm or 0.059")

 Parts Book
 Fig.25-Index 22

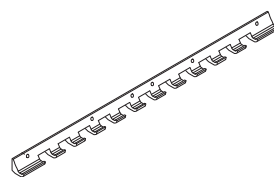
 Use this spacer to
 adjust the gap between
 the buckle chutes.

 1st station: for 1st, 3rd, and 5th buckle chutes
 See page 308 for the values of standard gaps.
 Consult with the service technician when
 you use this.

**Upper Straight Guide for
 First Buckle Chute**

Parts Book: Fig. 25- Index 19

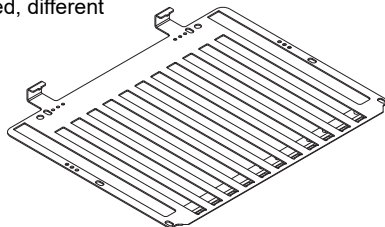

**Fluorine Resin Coated Upper
 Guide for Buckle Chute**

Parts Book: Fig. 25- Index 20


Lower Buckle Chute LF AS

 The edge of the lower buckle chute is slanted, different
 from the standard lower buckle chute.

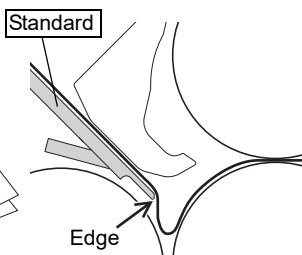
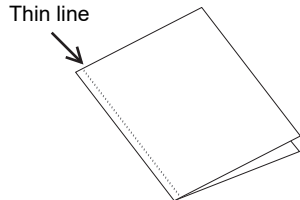
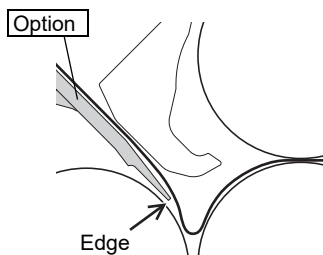
 Parts Book for AF-406F:
 Fig.25 - Index 23

 Parts Book for AF-406S:
 Fig.25 - Index 25

Shape of lower buckle chute edge

 Standard

 Option

Thin line


 If a thin line was made on the sheet at the position of 5 to
 10 mm or 0.20" to 0.39" from the folding line, the sheet
 could be scratched strongly by the edge of the lower
 buckle chute when passing through the buckle chute.

 The problem described on the left can be solved by replacing the
 lower buckle chute with this parts. Consult with the service
 technician when you use this.

Attention

 When this option is used, the minimum
 folding length will be about 35 mm or
 1.38".