BOOKLET MAKER E-SERIES

OPERATOR MANUAL

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1. IMPORTANT

F: Important

Cette machine ne peut fonctionner qu'avec toutes les sécurités au repos (capots plexi) et tous les accessoires (plateau de réception ou de transfert, convoyeur de sortie, conteneur déchets de coupe) en place.

Attention: Garder les mains à l'écart des pièces en mouvement.

GB/US: Important

This machine will operate only with all the safety devices of the collating / finishing line deactived (guards) and delivery/transfer tray or conveyor waste container connected in working position.

Caution: Keep hands clear of moving parts.

D: Wichtig

Diese Maschine kann nur in Betrieb genommen werden, wenn alle Sicherheitsvorrichtungen der Verarbeitungsstrasse (Plexihauben, Notschalter, Empfangs oder Transfertplatte Auslage) sich in Arbeitsposition befinden.

Achtung: Hände nicht in die Nähe laufender Maschinenteile bringen.

ESP: Importante

Esta máquina sólo se pondrá en funcionamiento cuando todos los dispositivos de seguridad de la línea de clasificación / acabado estén desactivados (dispositivos protectores) y la bandeja de salida / transferencia o el contenedor de desechos de la transportadora estén conectados en la posición de funcionamiento.

Precaución: Mantenga las manos alejadas de las partes móviles.

2.1 Foreword

Thank you for choosing a BOURG product.

This manual is a guide to operate the Booklet Maker E series.

Please follow carefully the instructions and you will enjoy years of excellent work with your system.

If you have any difficulty using your equipment, please call us and ask for technical assistance (all the phone numbers are available at the end of this manual).
We will be delighted to help you.

All the information in this publication is based on the latest information available at the time of approval for printing.

We reserve the right to revise this publication and to make changes in the content without obligation to notify such revision or changes.

THIS MANUAL IS INTENDED TO BE USED EXCLUSIVELY BY QUALIFIED TECHNICAL PERSONNEL.

3.1 Warning Pictograms

The BME is a booklet maker which produces booklets or side stitched documents.
All format settings will be done automatically from the U.I.
The booklet maker jogs the set and in this position it is stitched.
The booklet is then folded and is front trimmed.

Please pay attention to the description of the following pictograms:
Caution:

on a yellow background,
indicates a hazardous situation that can cause small or severe injury.

Warning:

on a orange background,
is used to indicate a hazardous situation which has some probability of death or severe injury. Warning should not be considered for property damage accidents unless personal injury risk is present.

Danger:

on a red background,
indicates a hazardous situation with a high risk of death or severe injury. The 'danger' sign does not apply to accidents causing material damage, unless they can cause personal injury.

Orange background, warning.
This label is located near the main power unit. It warns of a high risk of electrocution when opening the power supply box with a risk of severe injury or death.

Orange background, warning.
This label is located near the knife of the folding machine. It warns of a high risk of severe hand injuries when placing your hands under the knife.

Yellow background, caution.
This label is located near the knife of the press-cutter. It indicates a high risk of severe injury if you put you hands under the knife.

Yellow background, caution.
This label is located near the wheel-work of the chain. It indicates a high risk of injury to your fingers if they get stuck between the wheel-work and the chain.

Yellow background, caution.
This label is located near the stapling head. It indicates a high risk of severe injury to your fingers if you place them under this head.

BOOKLET MAKER E-SERIES

CAUTION

DO NOT OPERATE

WITHOUT SAFETY

COVERS IN PLACE

Yellow background, caution.
This label is located at the rear of the machine under the safety cover. It indicates that the machine may not be operated, under no circumstances, without the safety covers being in place.

Yellow background, caution.
This label is located near the main power supply.
It indicates that this power supply cabinet may only be opened by qualified personnel.

CAUTION

ELECTRICAL HAZARD

AUTHORIZED SERVICE

PERSONNEL ONLY

CAUTION

PINCH POINTS

KEEP HANDS CLEAR

Yellow background, caution.
This label is located near the primary shaft. It indicates a high risk of severe injury to your fingers if they get stuck in the belt

Initial version : 11/08
Lastest revision : -

BOOKLET MAKER E-SERIES

3.2 Warning pictograms location

Initial version : 11/08
Lastest revision : -

BOOKLET MAKER E-SERIES

CAUTION
ELECTRICAL HAZARD
AUTHORIZED SERVICE
PERSONNEL ONLY

CAUTION
DO NOT OPERATE
WITHOUT SAFETY
COVERS IN PLACE

CAUTION
PINCH POINTS
KEEP HANDS CLEAR

CAUTION
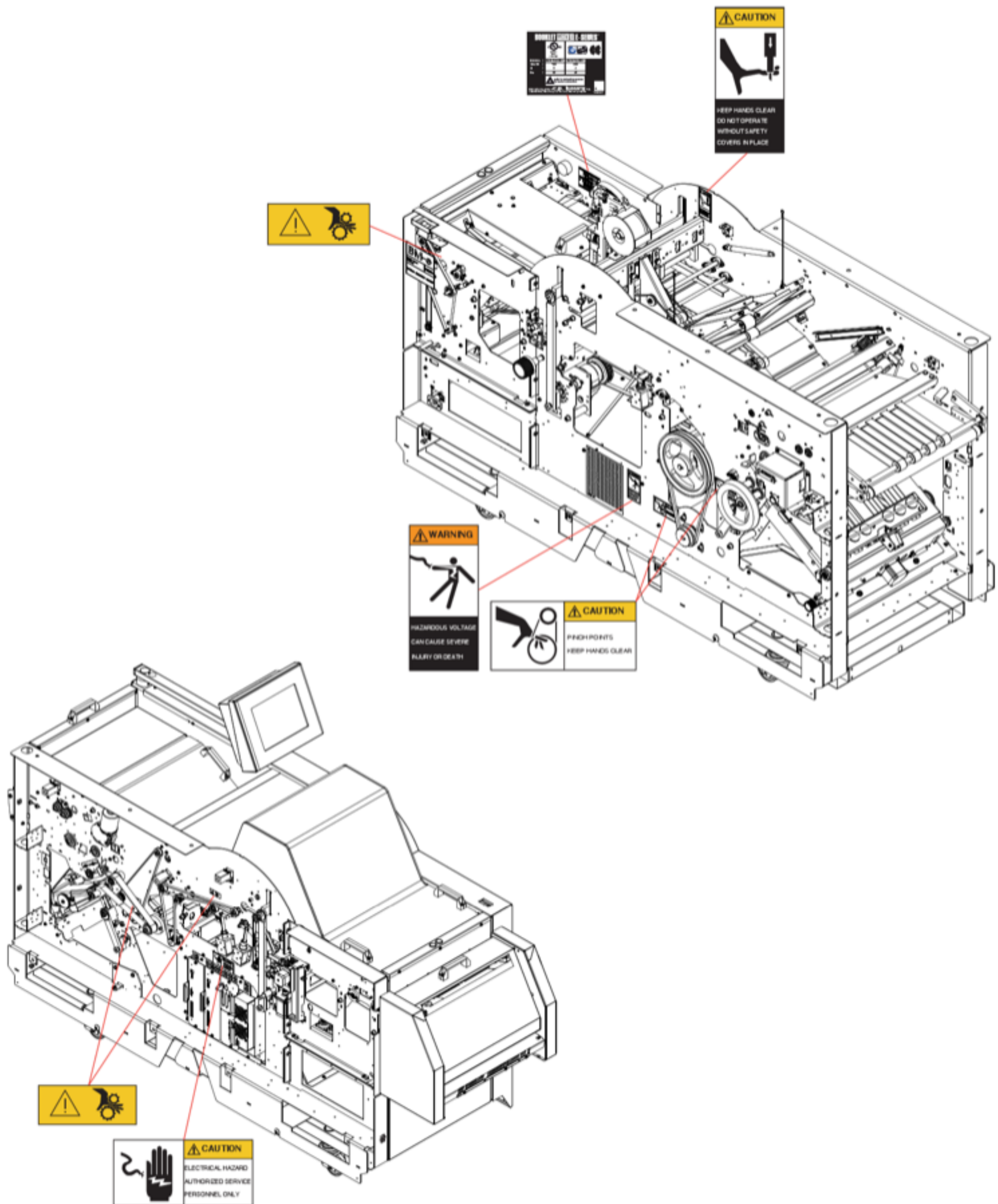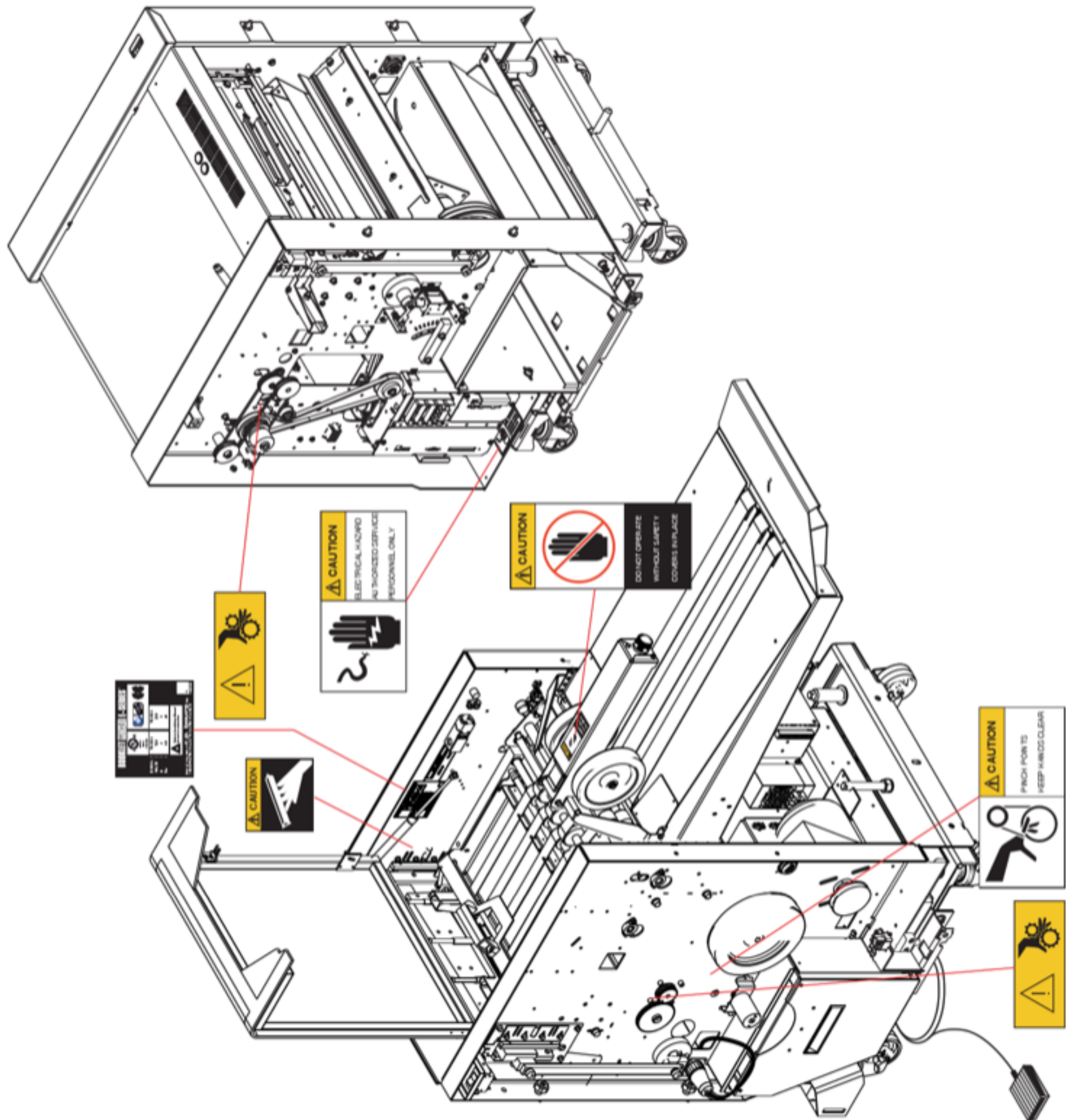
3.3 BME description

3.3.1 Technical characteristics
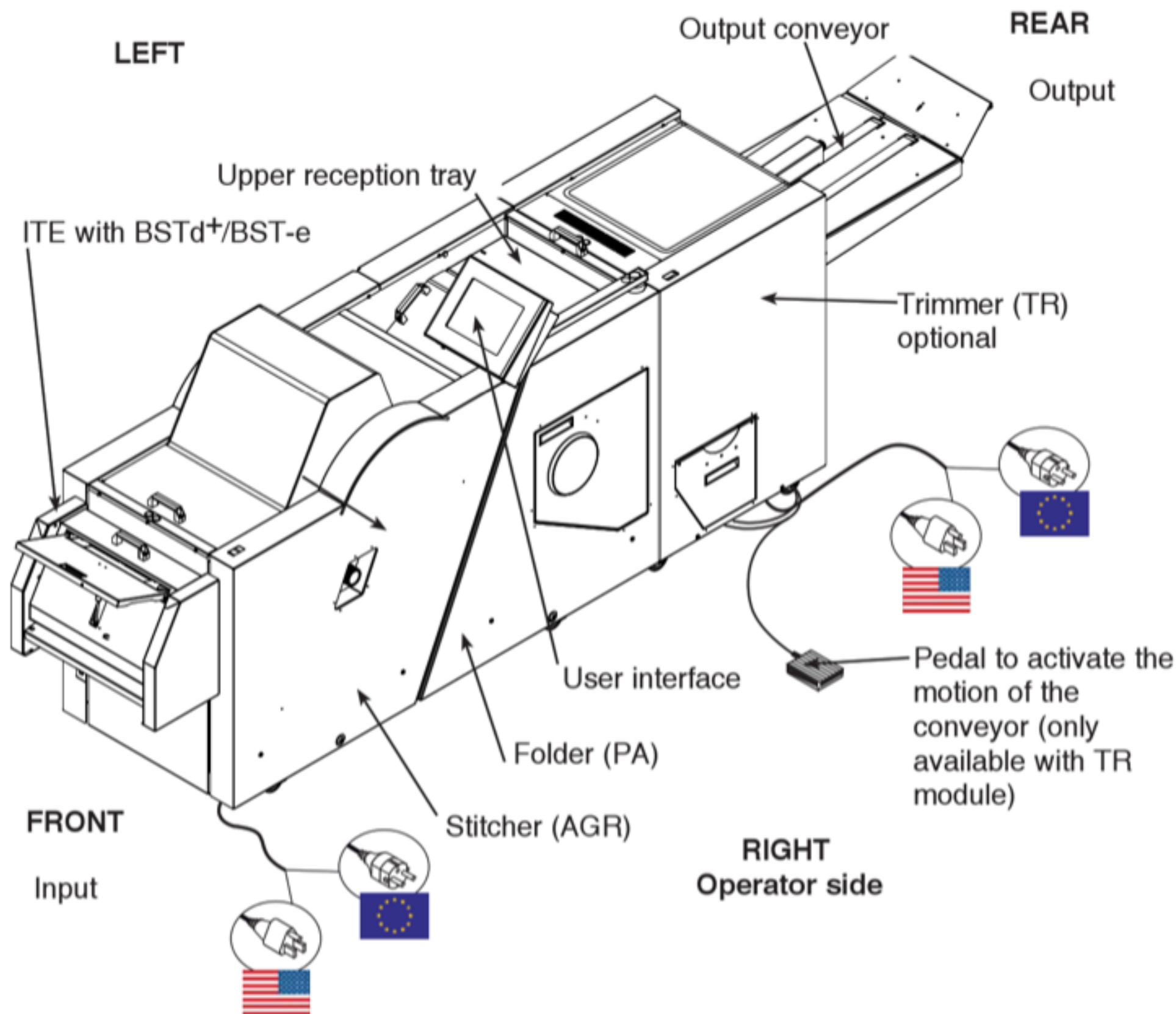
Verify that you electrical service corresponds with one of the following:

USA	120V AC +/- 10%	-	60Hz
EUROPE	230V AC +/- 10%	-	50Hz
JAPAN	230V AC +/- 10%	-	60Hz

Check your environmental conditions.
This machine is designed for the following environment:

- Storage and transport:
  Temperature: -34°C through 60°C / -30°F through 140°F
  Relative humidity: 5 through 90% RH
  Altitude: -31m through 12 192m / -100 ft.through 40 000 ft.
  Atmospheric pressure: ≥ 56kPa (420mm Mercury)

- Work environment:
  Temperature: 10°C (50°F) through 32°C (89.6°F)
  Relative humidity: 40 through 85% RH

- Power consumption:

Consumption / Machines	Maximum		In operation	
	230 V 50Hz	120 V 60Hz	230 V 50Hz	120 V 60Hz
AGR-PA	994 W	924 W	740 W	760 W
AGR-PA-TR	1675 W	1480 W	1110 W	1160 W

- BTU output: from 2525 to 5700 BTU/H (complete system).

- Noise level: 70 db.

Warning: Never remove the power cord while the machine is turned ON.

General
- Input/Output paper path: 860 mm without ITE and 610 mm with ITE.
- Variable speed of input motor.
- Centered registration: the BME positions itself to the center of the processed paper format from the upstream registered equipment thanks to a transversal motorization.
- Full automatic adjustment depending on the format.
- Upper reception tray for top/edge/corner stitched booklet or poor booklet.
- Paper path jam, open baffles and open covers detectors.
- Detection of output conveyor full and trim waste container full.
- Machine is managed via the U.I.
- Different component position (heads/stops/joggers/PA press/TR press/holding wheels/ conveyor motion) is automatic depending on the defined job in the U.I.
- Fine adjustments possible while machine is working.

Stitcher
- The BME is equipped with 2 or 4 stitching heads.
- Equipped with ISP stitching heads featuring toolless change over self threading cassette for stitch wire supply.
- On demand before delivery, the machine can be equipped with 2 or 4 Hohner heads compatible with various diameter wire.
- Hohner heads convertible to loop stitch model via optional upgrade kit.
- Heads supplied with wire n°25 (EU) or 25 Gauge (US).
- Capacity of 50.000 stitches (75 gsm, 2 to 30 sheets).

Folder
- Booklets folded between the belts with a fold crush device.
- Booklet pressure adjustment.

Trimmer
- Upper and lower knives, without heel, can be easily replaced.
- Equipped with a system to ease the ejection of the chips.
- Waste bin that can be emptied while machine is working.

Output Conveyor

- Operator adjustment on U.I. conveyor advance step per book.
- Conveyor full detector (can be disabled).
- Device to offset the sets - offset every N sets, with N adjustable by operator on U.I.
- Automatic positioning of set holding wheels, based on finished set dimensions.
- Pedal to activate the motion of the conveyor (only available with TR module).

3.3.2 Stitching possibilities depending on paper width

Paper width		119 (4.7") to 218 mm (8.6 ")	218 (8.6") to 268 (10.5")	268 (10.5") to 370 (14.6")
Machine Type	Stitch position			
2 heads on 2 bracket heads	2 saddle or top	Space between stitches = 80 (3.1") to paper width - 28 mm		
	1 corner	YES (left or right)		
2 heads on 4 bracket heads*	2 saddle or top	"Space between stitches = 80 (3.1") to paper width - 28mm (middle brackets**)"	"Space between stitches = 80 (3.1") to 190 (7.5") (middle brackets**)"	"Space between stitches = 80 (3.1") to 190 (7.5") (middle brackets**) and 240 (9.4") to paper width - 28 mm (outside brackets**)"
	1 corner	YES (left or right middle brackets**)	Not possible	YES (left or right outside brackets**)
4 heads	2 saddle or top	"Space between stitches = 80 (3.1") to paper width - 28mm (middle heads)"	"Space between stitches = 80 (3.1") to 190 (7.5") (middle heads)"	"Space between stitches = 80 (3.1") to 190 (7.5") (middle heads) and 240 (9.4") to paper width - 28 mm (outside heads)"
	4 saddle or top	Not possible		"Space between middle stitches = 80 (3.1") to paper width -188 mm"
	1 corner	YES (left or right middle head)	Not possible	YES (left or right outside heads **)
* Requires installation of heads on proper brackets (middle or outside ones)				
** Stitching head position at installation				

On demand before delivery, the machine can be equipped with 4 heads brackets but only 2 heads. In this case it could be upgraded with 2 additional heads.

Corner stitching

The middle of the stitch is placed at 14mm from the side (left or right) of the sheet and at 7mm from the lead edge of the sheet. You must clutch and activate the used head (s).
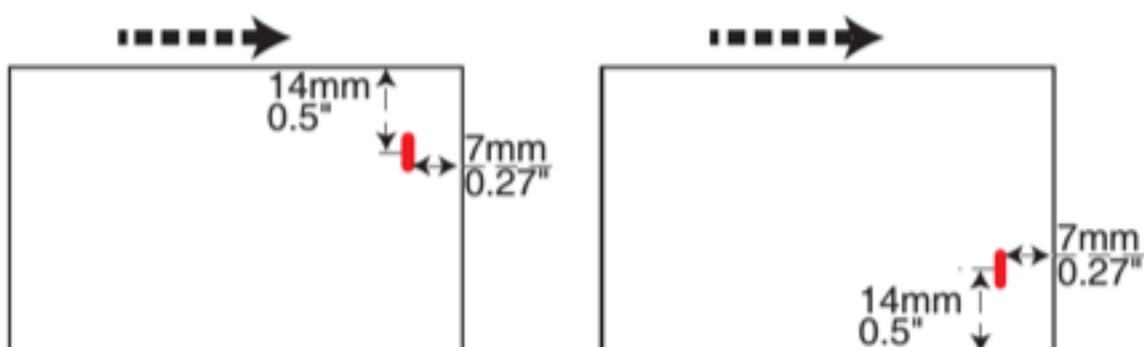
To avoid severe mechanical interferences which could lead to serious damages, unclutch the unused heads when it is asked on User Interface.

3.3.3 Technical specifications

> **Note:** The figures below represent what the BME is capable of producing. The device feeding paper to the BME may alter those specifications.

Type of paper
Any type of paper except paper with a window or transparent paper.
Coated / uncoated from 60 to 160 gsm.
Covers from 80 to 250 gsm (up to 350 gsm if the covers are creased).

Paper format

Saddle stitching

Top/side stitching

Min = 119mm (4.7")
Max = 370mm (14.6")

Min = 119mm (4.7")
Max = 370mm (14.6")

Min = 180mm (7.1")
Max = 600mm (23.6")

Min = 170mm (6.7")
Max = 300mm (11.8")

Folding/Trimming

Max. trim = 25mm (1")

For a format higher than or equal to 190mm (95mm folded)

Min = 119mm (4.7")
Max = 370mm (14.6")

Min = 70mm (2.8")
Max = 300mm (11.8")
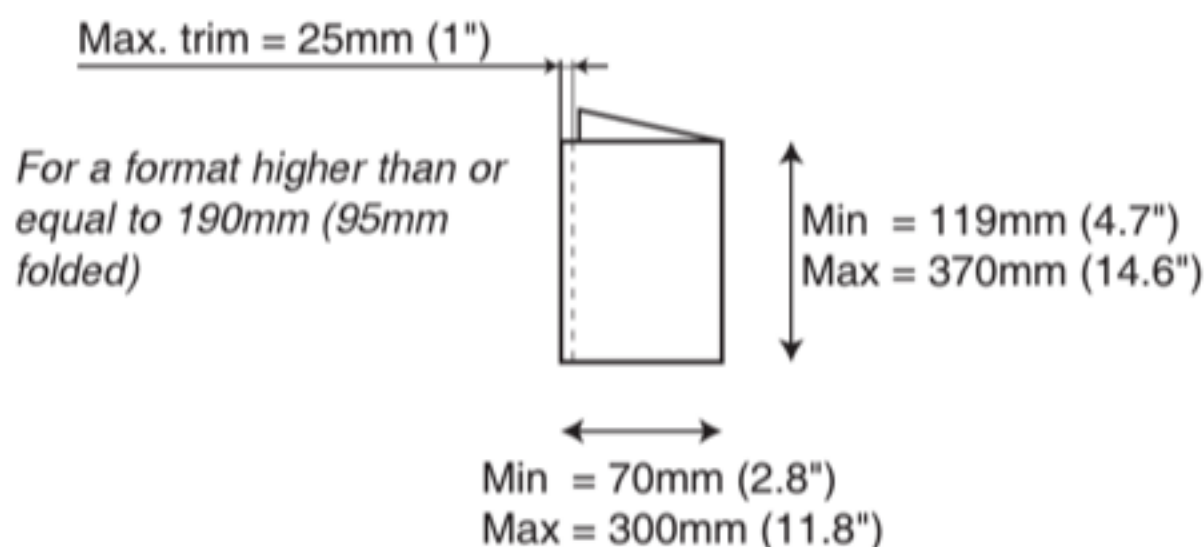
Productivity
- Up to 5000 sets/hour, in each case (stitching only, stitching & folding or stitching, folding and trimming).
- Based on A4 format 80 gsm.

> Note: The specified paper thickness figures are given for guidance only. The actual performances of the machine will depend on the nature of the paper and covers used.

PRODUCTIVITY (books / h) (over lap 15 mm)	EURO		USA	
	A4	A3	8,5 / 11	11 / 17
5 sheets	5050	4350	5150	4300
10 sheets	4700	4100	4850	4050
15 sheets	4450	3900	4600	3900

Booklet thickness

Saddle stitching (middle of the sheet stitching) fold and cut :
- from 2 to 30 sheets of 75 gsm or equivalent thickness (cover included) Maximum 3 mm.
- Top or corner stitching (without either fold or cut) :
  from 2 to 55 sheets of 80 gsm or equivalent thickness (cover included).

Stitcher

See "*Stitching possibilities depending on paper width*".

Folder

Maximum pressure by default, pressure can be decrease through U.I. to avoid cover marking/ crackles.

Trimmer

Waste bin capacity: 8000 paper strips of 80 gsm with a cut of 5mm.
The waste bin can be emptied without stopping the machine during 50 cycles, after which the machine will stop.
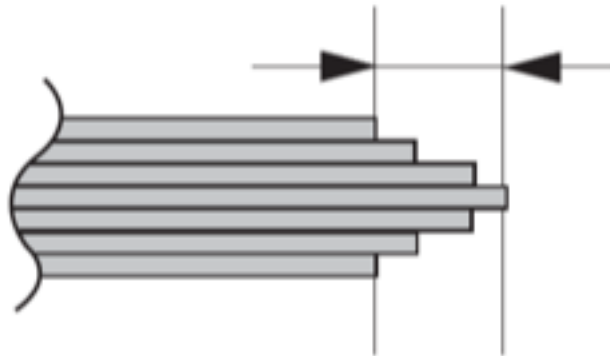
	Length of the cut
Min.	0 mm (0 in.)
Max.	25 mm (1 in.)
Standard	5 mm (0.2 in.)

Conveyor

Capacity: 42 sets (A4 format) of 10 sheets (80gsm) - theoretical values.

Motion step:

Step	Value	Value U.I.
Minimum	20 ± 10 mm	1
Maximum	330 ± 40 mm	29
By default		8
Conveyor does not stop		30

Offset set device:

	Offset	Value on U.I.
	No offset	1
Minimum	Offset of 2nd set	2
	Offset of 3rd set	3
	Offset of nth set	11
Maximum	Offset of 250th set	250

3.3.4 Stitch and Fold offset possibilities

STITCH OFFSET	FOLD OFFSET
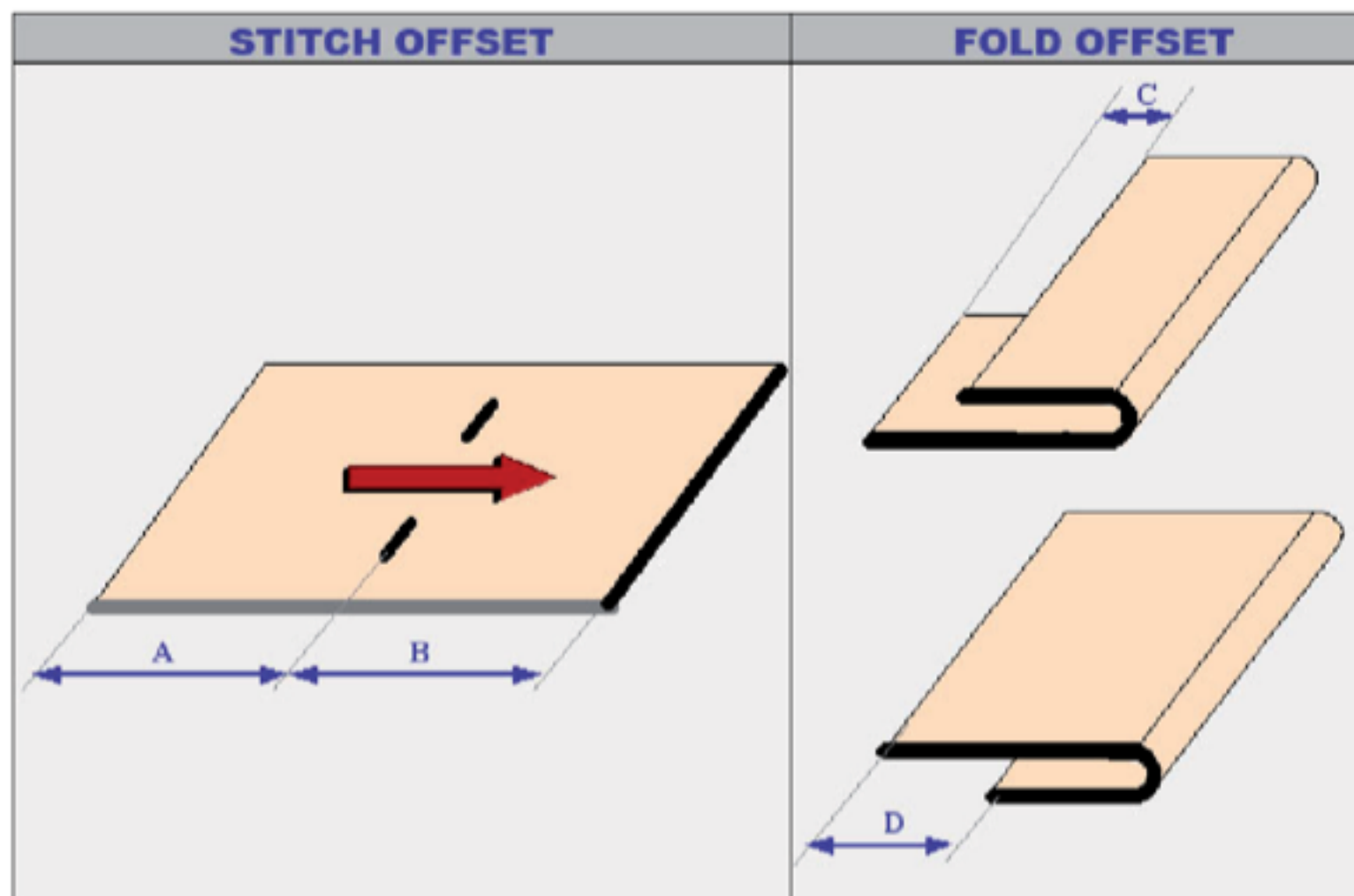
MINIMUM AND MAXIMUM OFFSET FOR EU FORMATS (mm)							
A3 (portrait) :	A= -90	SRA3 (portrait) :	A= -75				
	B= 90		B= 75				
	C= -90		C= -75				
	D= 120		D= 135				
A4 (portrait) :	A= -58,5	A4 (landscape) :	A= -15	SRA4 (portrait) :	A= -70	SRA4 (landscape) :	A= -22,5
	B= 58,5		B= 15		B= 70		B= 22,5
	C= -151,5		C= -195		C= -140		C=-187,5
	D= 58,5		D= 15		D= 70		D= 22,5
A5 (portrait) :	A= - 15						
	B= 15						
	C= -195						
	D= 15						
CD (portrait) :	A= -35						
	B= 35						
	C= -175						
	D= 35						

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MINIMUM AND MAXIMUM OFFSET FOR USA FORMATS (inch)

17x11 (portrait) :	A= -3,31		
	B= 3,31		
	C= -3,31		
	D= 4,96		
11x8,5 (portrait) :	A= -1,96	8.5x11 (landscape) :	A= -0,71
	B= 1,96		B= 0,71
	C= -6,31		C= -7,56
	D= 1,96		D= 0,71
10x8 (portrait) :	A= -1,46	8x10 (landscape) :	A= -0,46
	B= 1,46		B= 0,46
	C= -6,81		C= -7,81
	D= 1,46		D= 0,46
CD (portrait) :	A= -1,38		
	B= 1,38		
	C= -6,89		
	D= 1,38		

MINIMUM AND MAXIMUM OFFSET FOR JAPANESE FORMATS (mm)

B4 (portrait) :	A= -92	B4 (landscape) :	A= -38,5
	B= 92		B= 38,5
	C= -118		C= -171,5
	D= 92		D= 38,5
B5 (portrait) :	A= -38,5	B5 (landscape) :	A= -1
	B= 38,5		B= 1
	C= -171,5		C= -209
	D= 38,5		D= 1

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Lastest revision : 02/09

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3.4 BM-e Process Description

a. Paper path
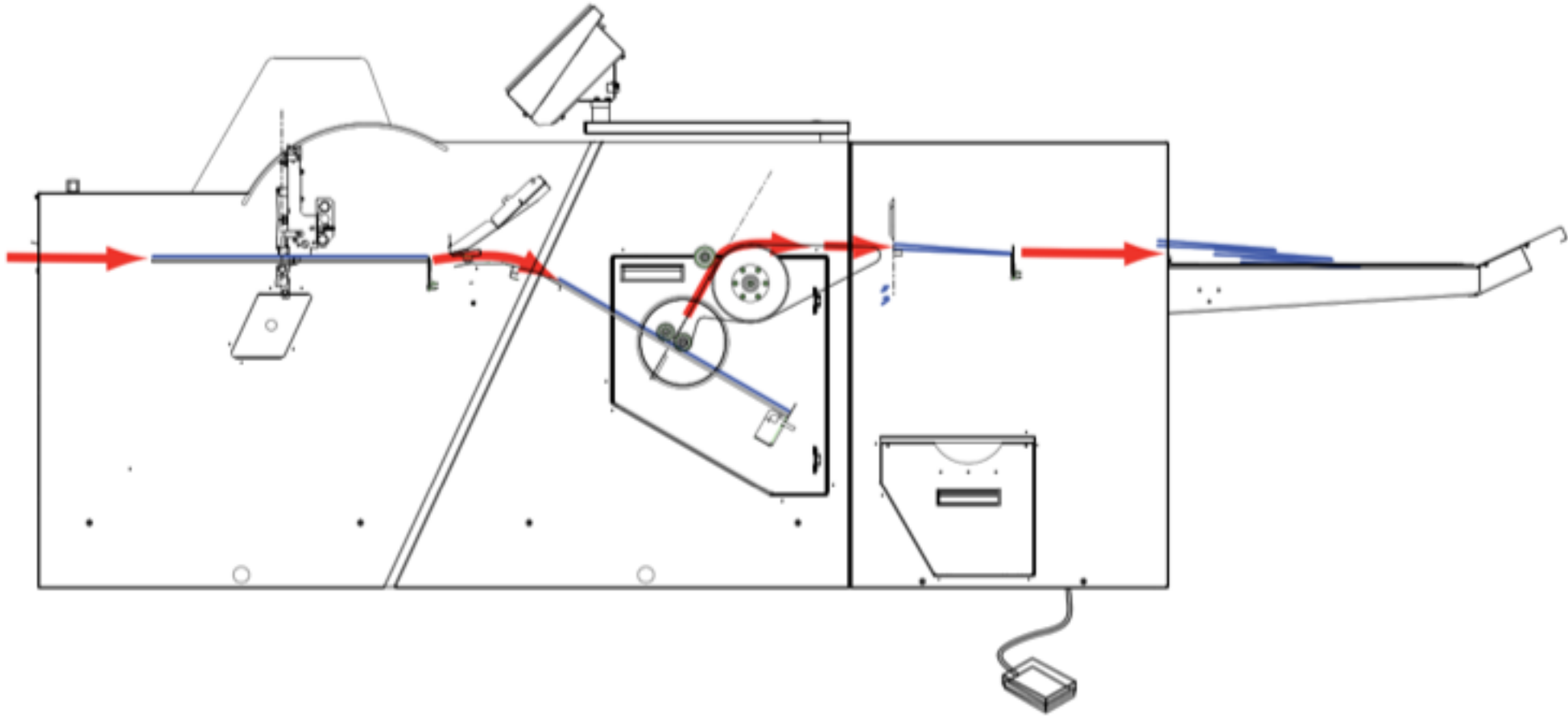
b. Jam clearance
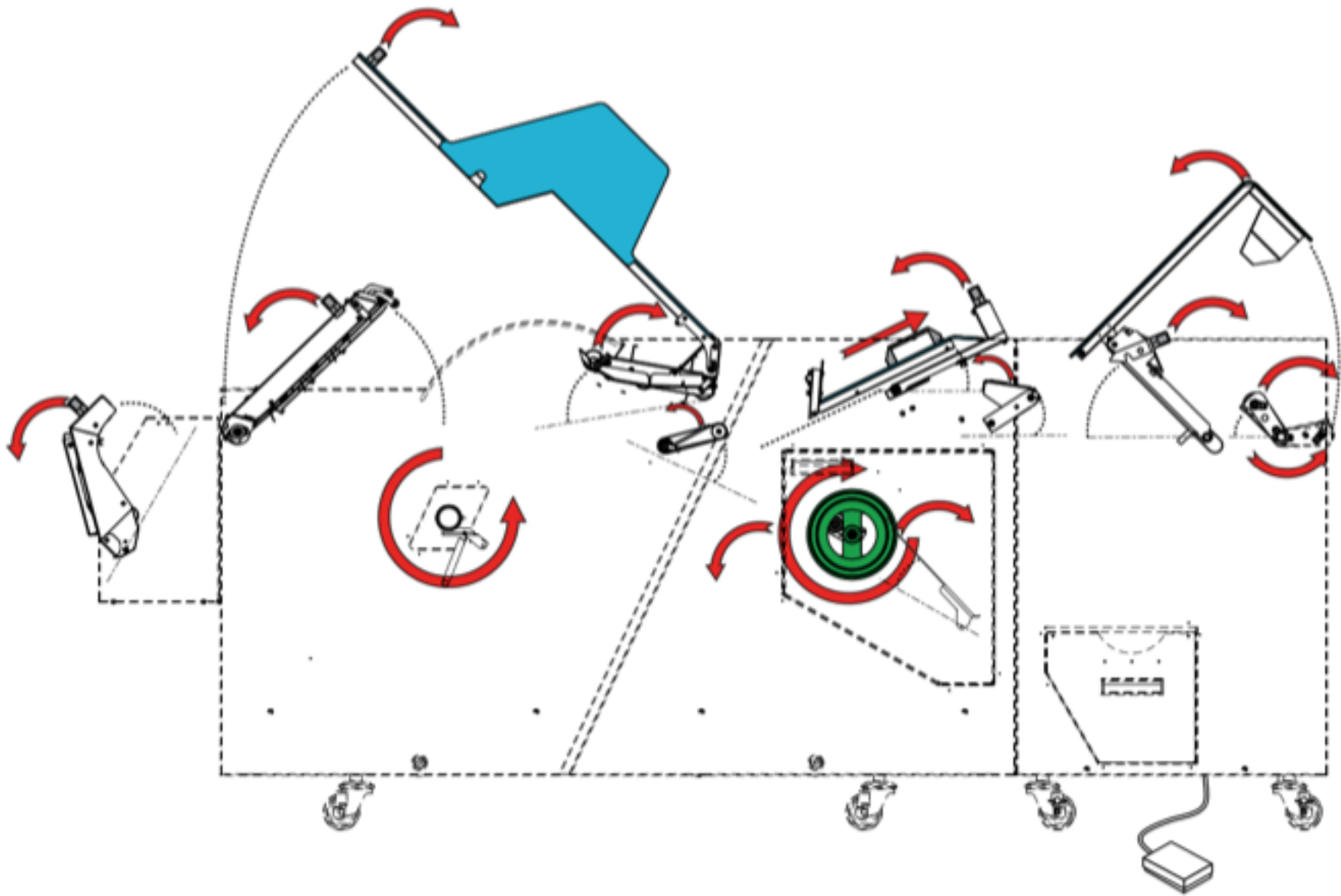
3.5 BME power ON

Safety precautions for the connection to mains : *In order to avoid any danger during the installation, utilization or maintenance of the equipment, the power cord should be located near the equipment and be easily accessible at all times.*
Unit must be connected to the mains on a 15 A
maximum branch circuit protection.

Push on main switch to set it on position "I".
The green led lights. After a few seconds, the machine initialize itself.
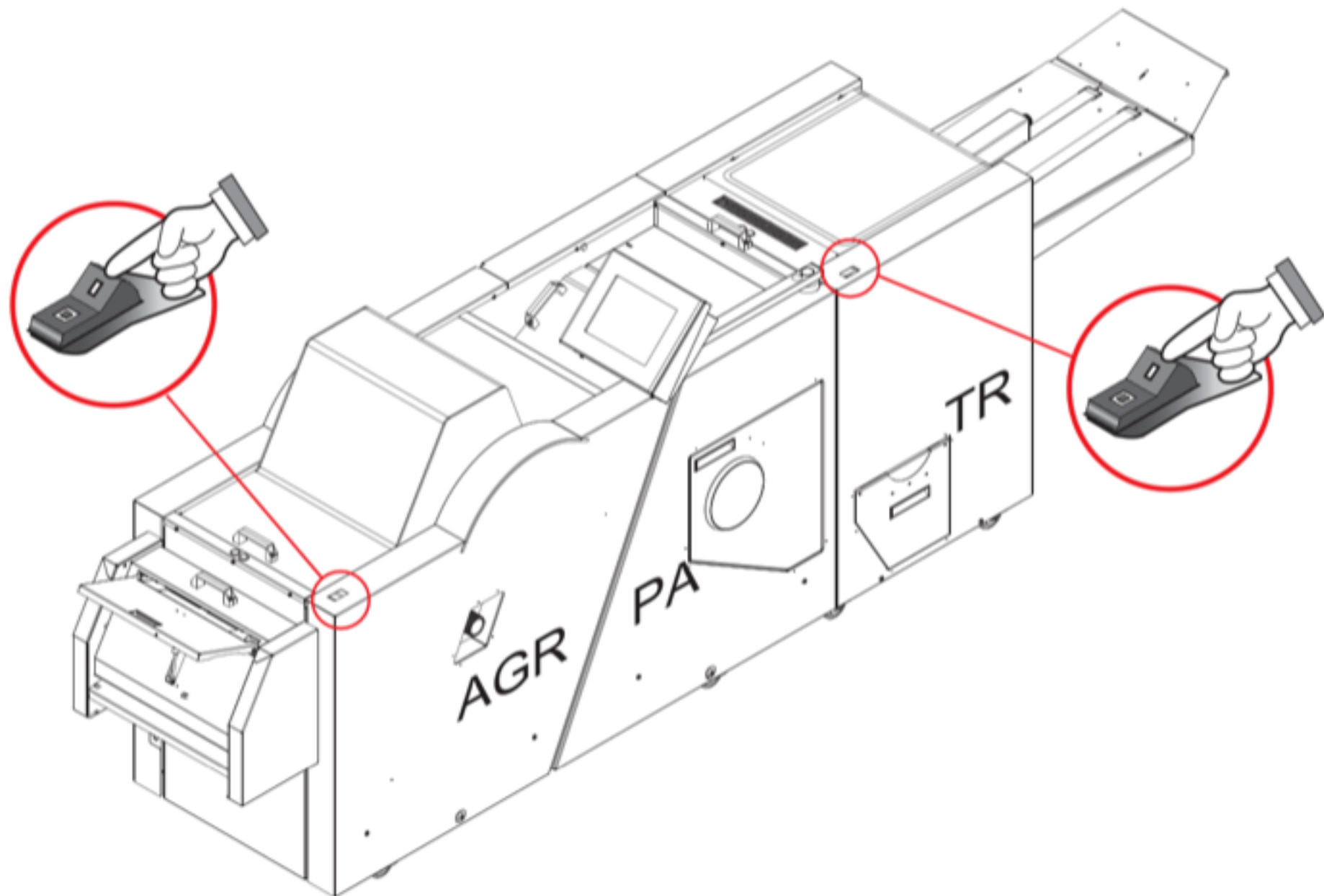
Starting order: TR (1) - AGR / PA (2).
There is no switch on U.I., it is supplied with electricity by the AGR-PA module.

3.6 Stitching head adjustment

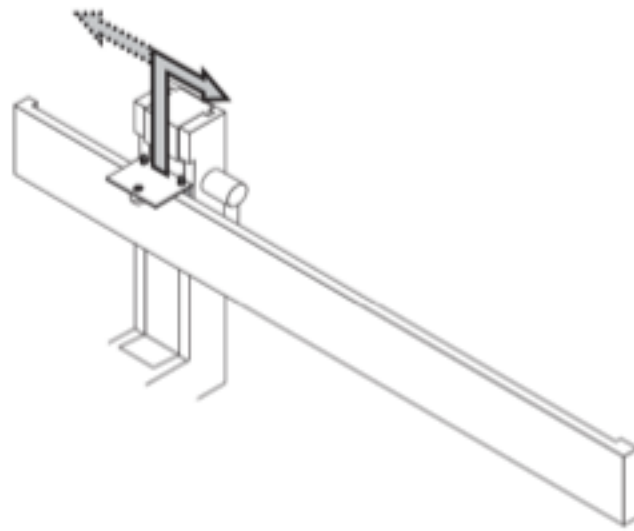### 3.6.1 Stitching heads mechanical unclutching

See Head manuals.

1) To unclutch the locking catch:
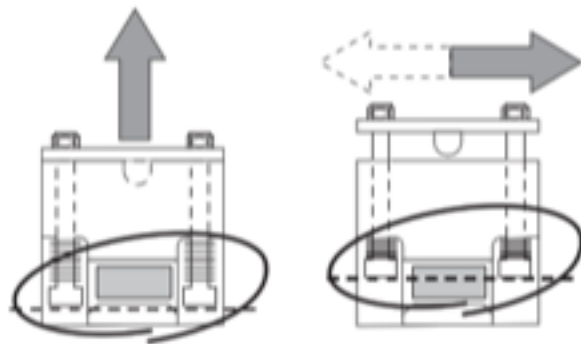
2) To remove stitcher bar from the AGR:

Same procedure
for both kind of heads
(ISP & HOHNER)

Stitcher bar

Locking catch (keeper)
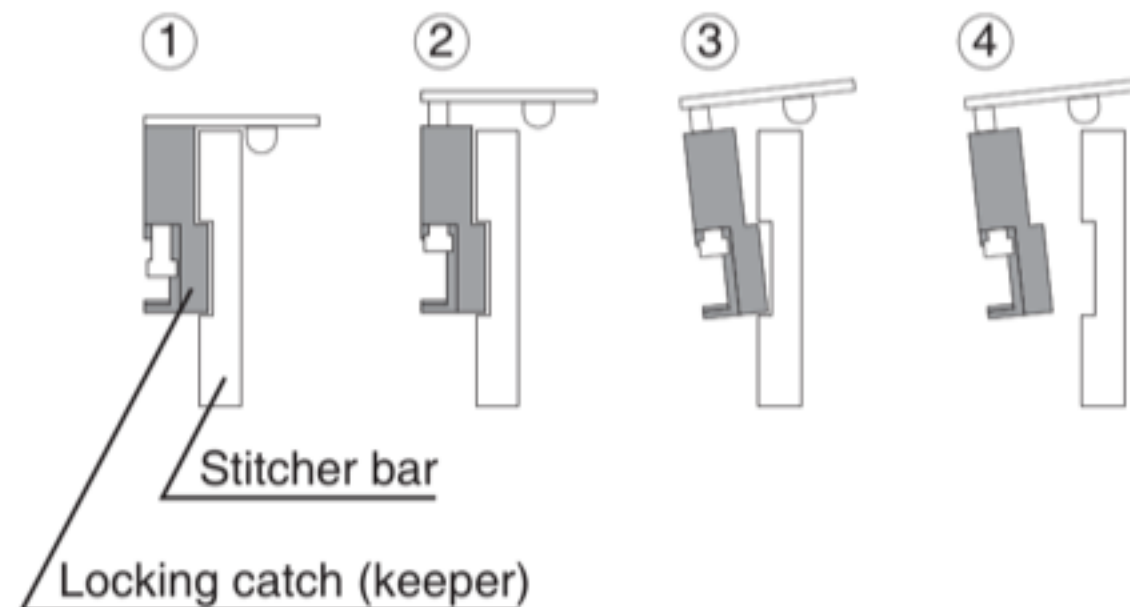
3.6.2 Stitching wire length adjustment

See Head Manuals.

Note : There is a risk of injury while handling a booklet if a stitch leg is shorter than the other.

3.6.3 Cassettes replacement with ISP heads

Localization of the heads according the error message.

With 2 stitching heads:

Head 1
Head 2
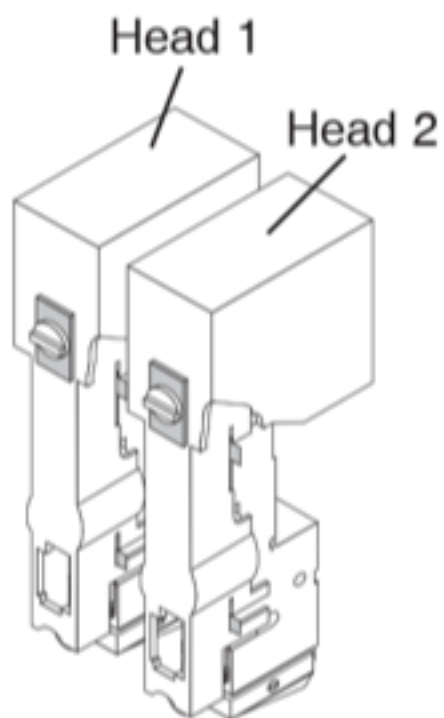
With 4 stitching heads:

Head 1
Head 2
Head 3
Head 4
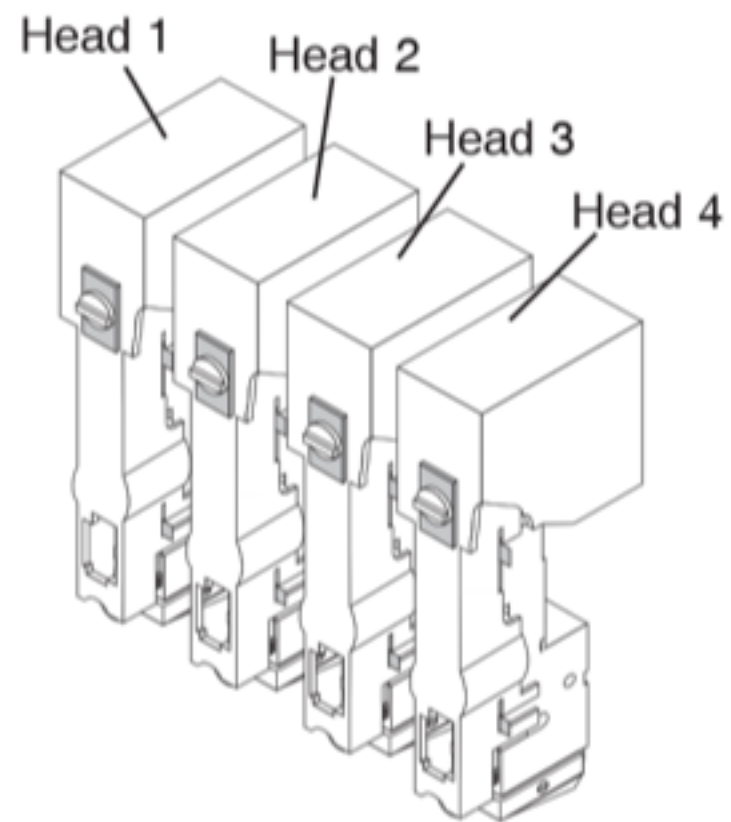
Step 1: Remove the empty cassette:
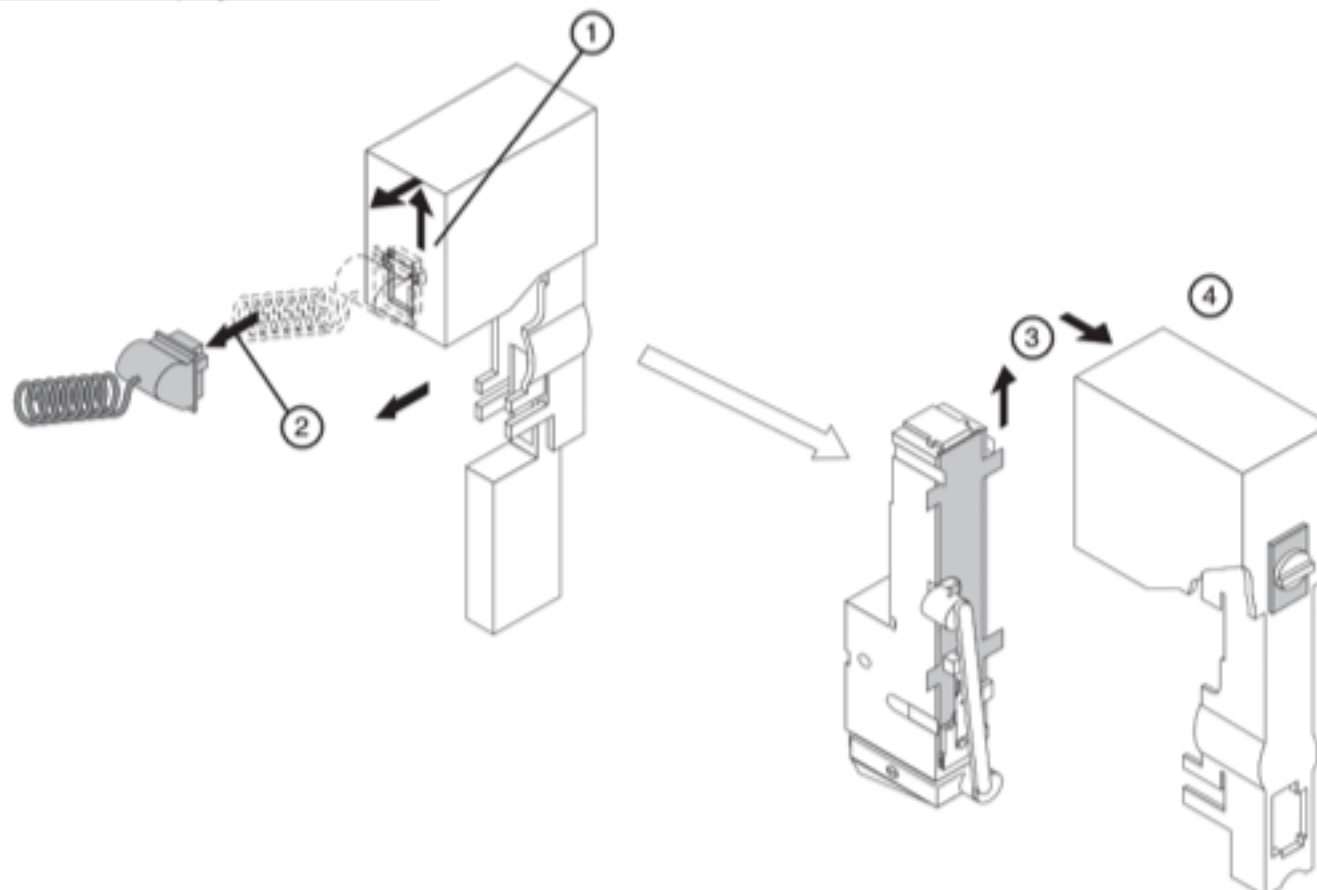
Step 2 stitching head prevention cleaning:

The stitching head must be lubricated each time the cassette is replaced. Please use the tube of grease delivered together with the cassettes.

> **Note:** *According to MSDS and 2000/532/EC lubricant is not a hazardous substance. The lubricant should be used until the tube is empty. The empty tube should be thrown away to domestic or industrial waste.*

See Head manuals.

Step 3: New cassette installation:
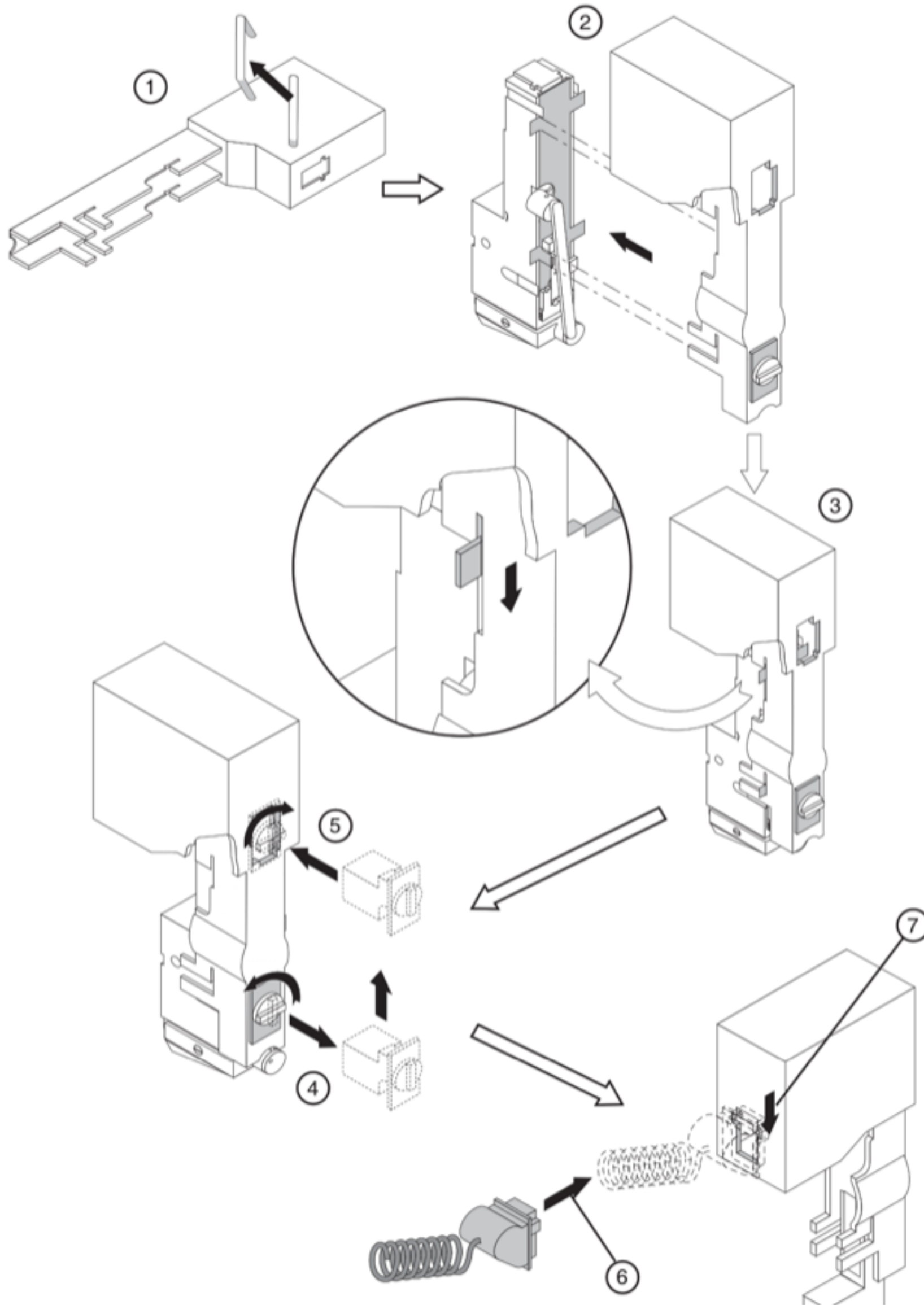
Step 4 : Re-initialization of the stitching head:

When removing the rotator operating spring from the stitching head (for lubrification) you will loose the wire for next stitch. Therefore the stitching head must be actuated to make the machine again available for next booklet.

Execute a manual stitching.

3.6.4 Wire spool replacement (for Hohner heads)

Note: Oil the felt discs on the wire bow of the Hohner heads. See chapter : Preventive maintenance.

For Hohner stitching heads.
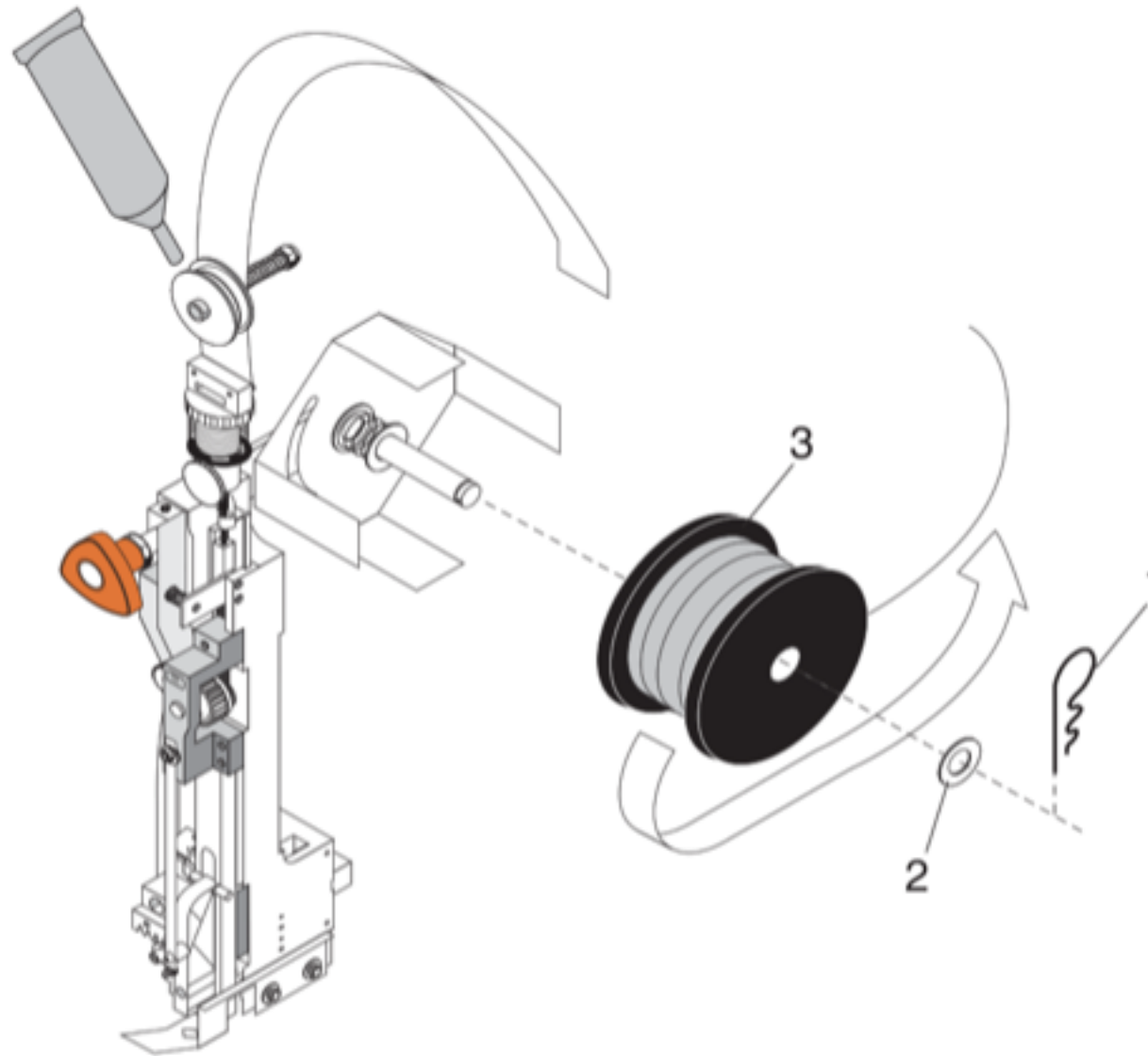
- Remove pin ref.1 and washer ref.2.
- Remove the emty spool.
- Install a new spool ref.3 (pay attention to wire direction).
- Reinstall the washer ref.2 and the pin ref.1 in the shaft groove.

3.6.5 Wire jam in the stitching head

If a missing stitch is noticed at the exit of the BME, there might be a wire jam in the head.
Apply the following instructions to clear jam and reinstall the wire.

For ISP stitching heads
1- Remove cassette with jam as follows.

9mm
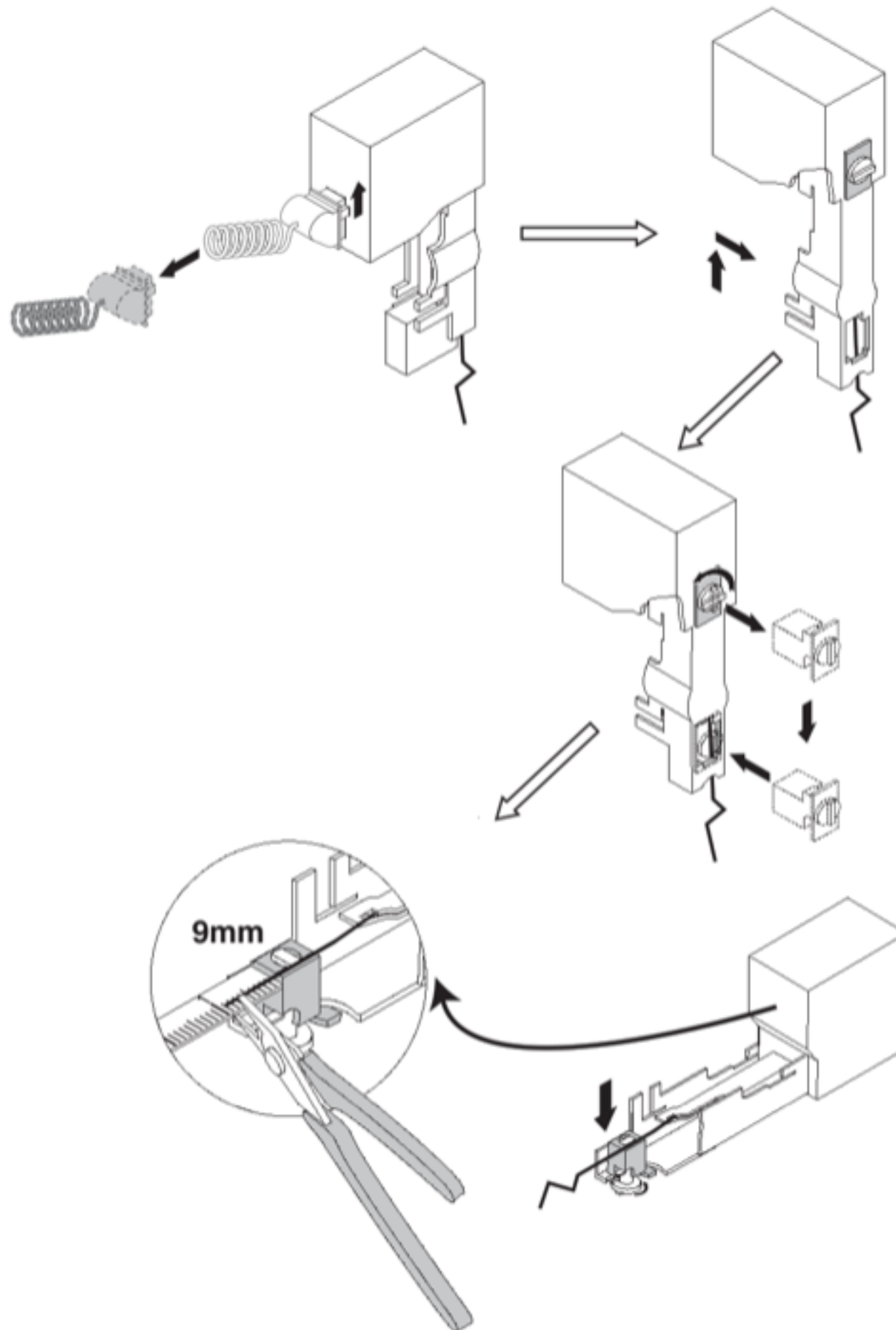
2- Reinstall cassette (steps 3 and 4 of a new cassette install).

For Hohner stitching heads
See Head manuals.

4. THE USER INTERFACE (UI) SCREENS

The User Interface is a touch screen.
Select your choice by pressing on the screen with your finger.
The User Interface is divided into several tabs that vary according to the configuration.
Each tab has its own preference and/or adjustment buttons.
The control buttons are common to all tabs.
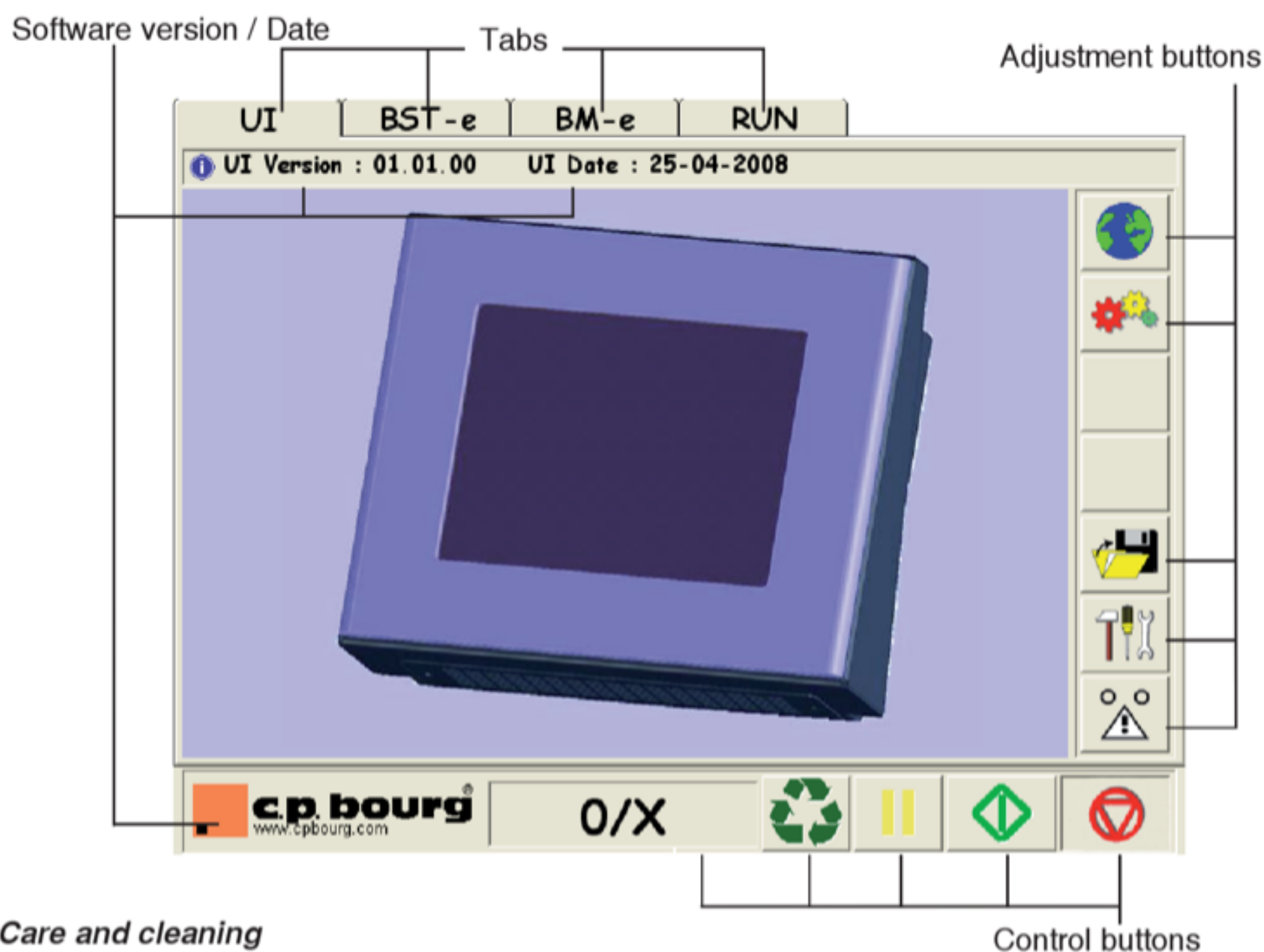
Care and cleaning
Do not place anything on the screen.
Do not let liquid get on or into the screen.
Use a regular glass cleaner to clean the screen (proceed as explained below).

To clean the screen:

1. Switch off the UI.
   Do not use a spray cleaner on the screen, because the cleaner may drip inside.
2. Wet a soft cotton cloth with the cleaning solution and gently wipe the screen.
3. Do not use cleaning solutions containing solvents. Dry with a clean, soft cotton cloth.

> CAUTION : Danger of explosion if battery is wrongly replaced. Replace only with the same or equivalent type recommended by the manufacturer. Dispose of used batteries according to the manufacturer's instructions. See Section Adjustment/Replacement of Service Manual for battery replacement.

5.1 U.I. screen options

At power ON of the machine, the U.I. screen appears by default.
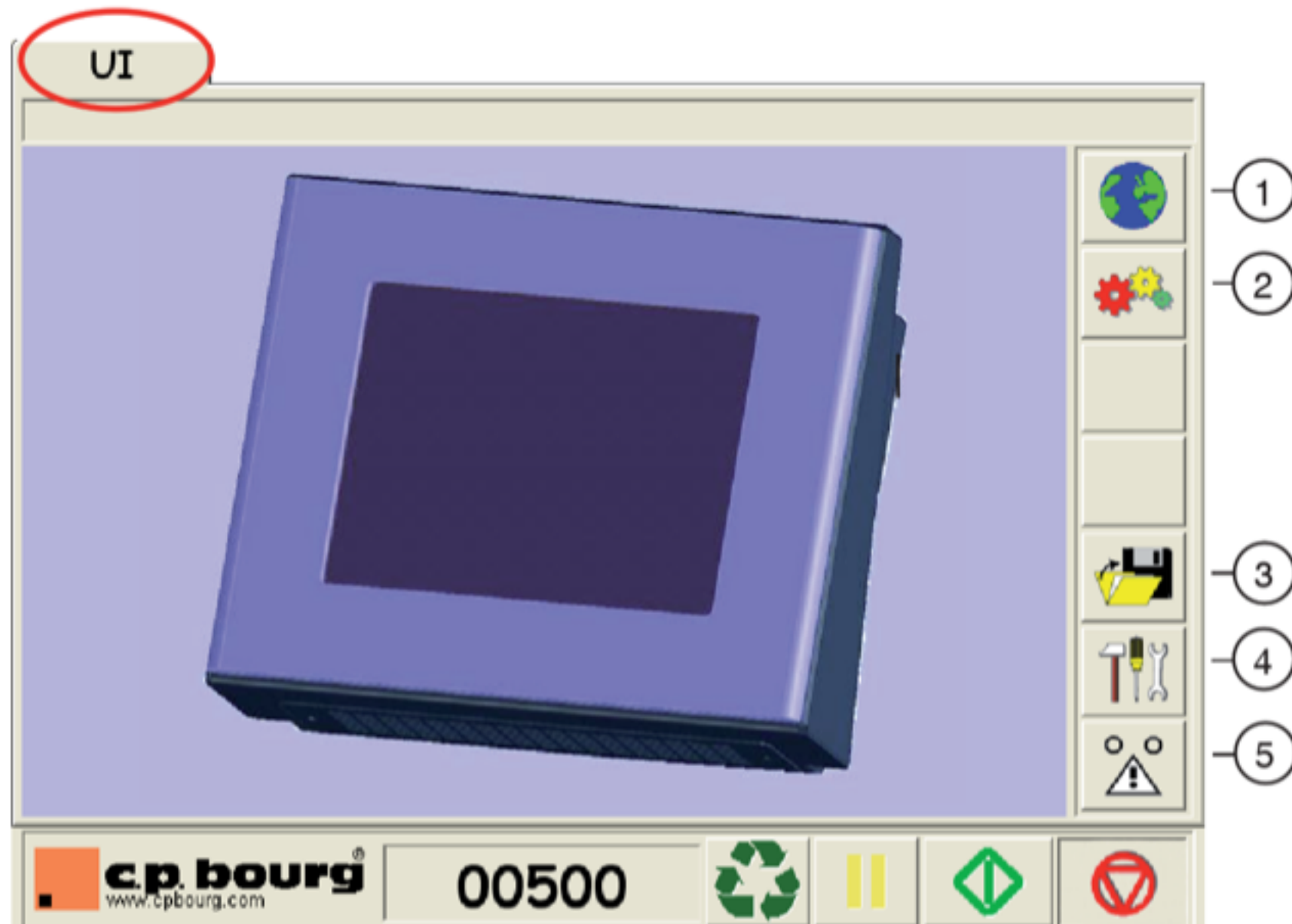
1 - OPERATOR'S PARAMETERS:
  Press button to the right of the screen to enter your own parameters.

2 - MACHINE LINE CONFIGURATION:

3 - FILE MENU:
  Allows to open/delete an existing job or create/save a new job. Available if the step two has been validated.

4 - TECHNICIAN MENU:
  Autorised to be used by a qualified technician.

5 - INFORMATION AND ERROR MESSAGES

5.1.1 U.I. screen Operator's preferences

The UI screen option allows the user to configure his preferences.
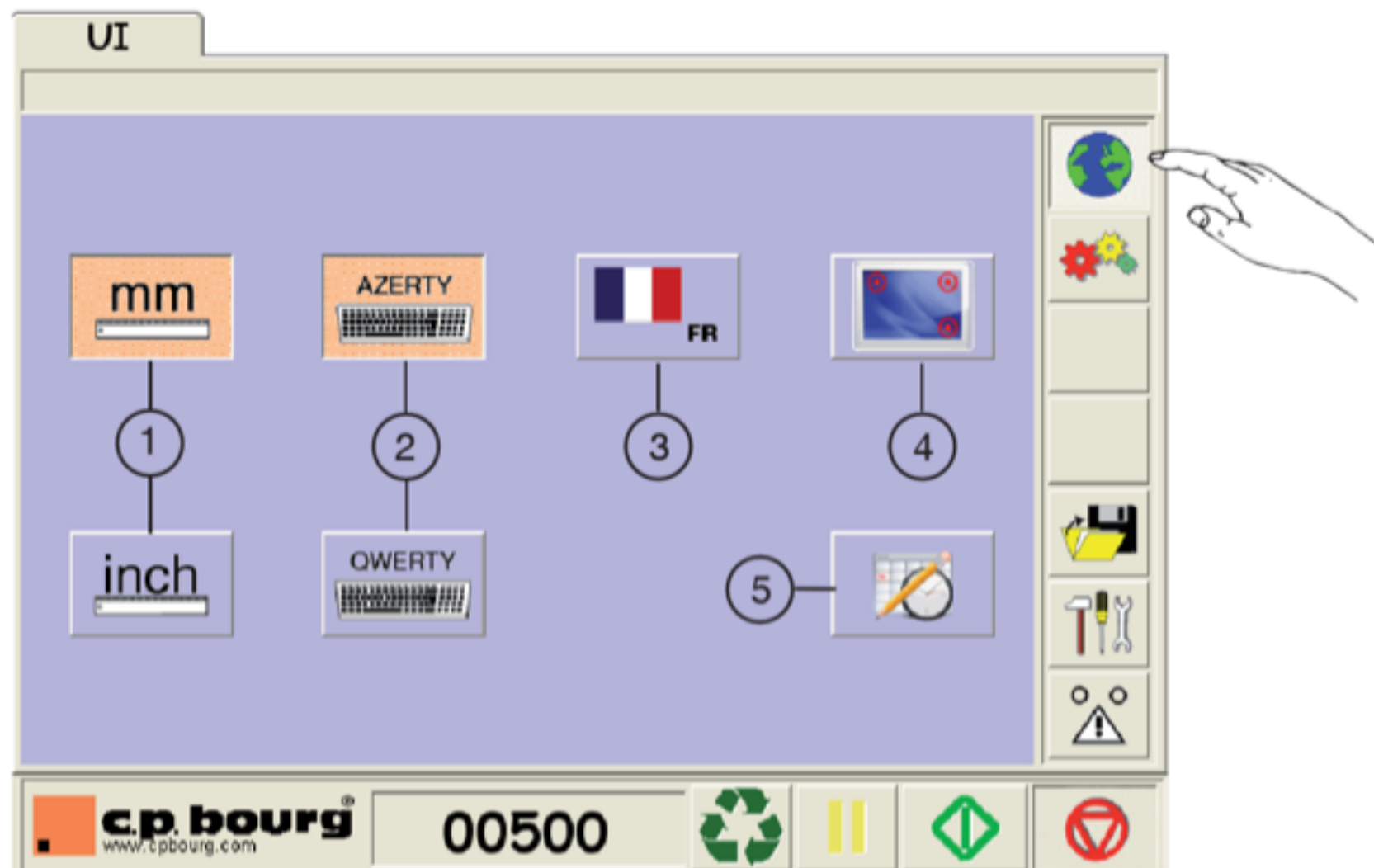
1 - UNITS:
   Allow you to select your choice for measures in mm or inches.

2 - KEYBOARD CHOICE:
   Select the kind of keyboard AZERTY or QWERTY.

3 - LANGUAGE:
   Choose your language (FR - IT - DE - ES - PO - NL - PL - NO - US - GB).

4 - SCREEN PARAMETERS:
   Graphical User Interface calibration.

5 - DATE and HOUR SETTINGS.

5.1.2 Machines line configuration

After installation of all machines, enter the line of machines in the U.I.
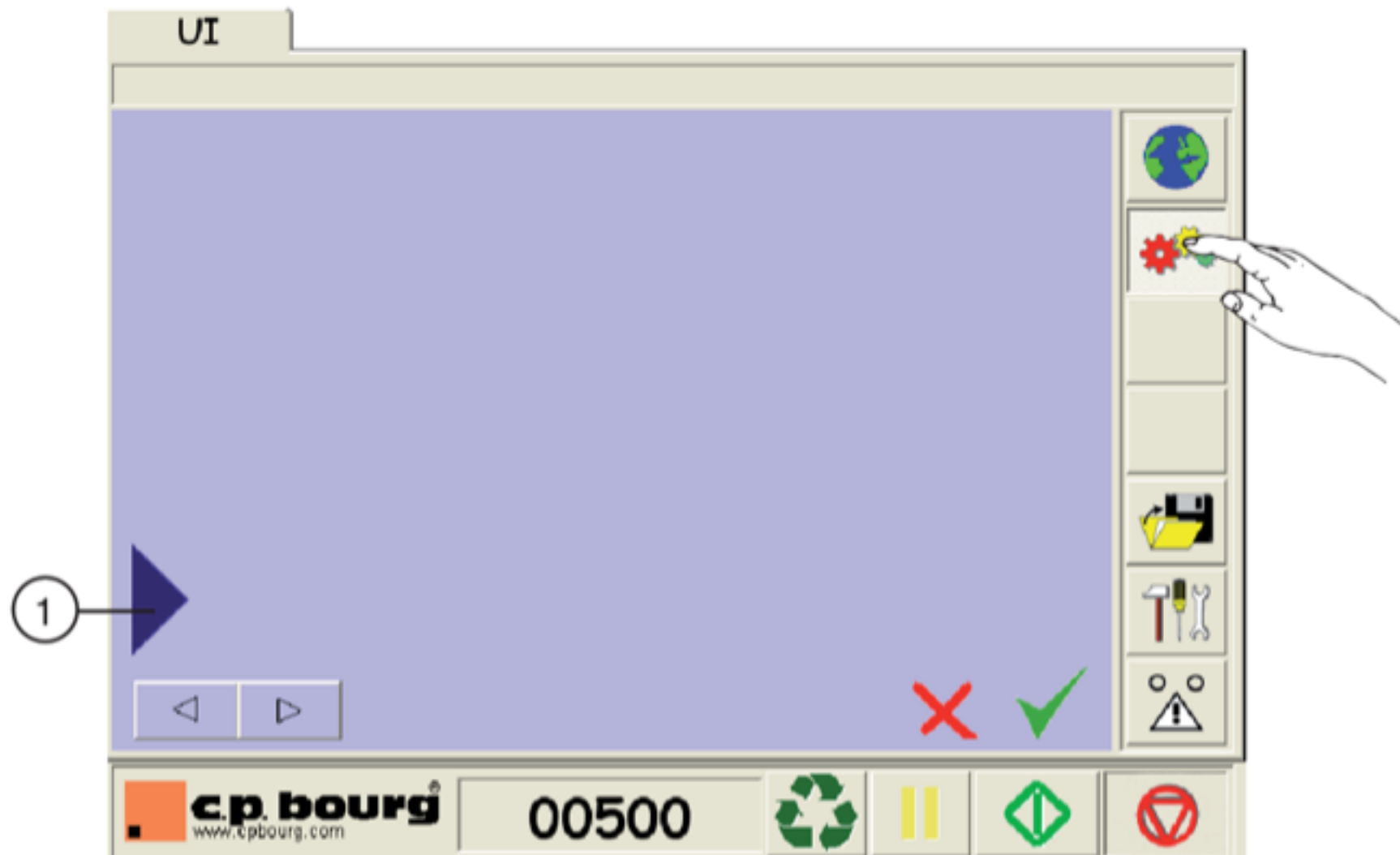
The following configurations are availables:

- Tower BST-d$^+$ ➔ BM-e AGR/PA ➔ BM-e TR

- Tower BST-d$^+$ ➔ BM-e AGR/PA

- Tower BST-e left ➔ Tour BST-e right ➔ BM-e AGR/PA ➔ BM-e TR

- Tower BST-e left ➔ Tour BST-e right ➔ BM-e AGR/PA

- Tower BST-e right ➔ BM-e AGR/PA ➔ BM-e TR

- Tower BST-e right ➔ BM-e AGR/PA

- Tower BST-e right ➔ BM-e AGR/PA ➔ BM-e TR ➔Spine Master

- …

a) Train configuration BST-e Right (or BSTd+) + BM-e AGR-PA + BM-e TR configuration.

Press Machine Line Configuration button.
Press the blue arrow (1) to access to the dialogue box.

Select the first machine of your line (BST-e Right in example).
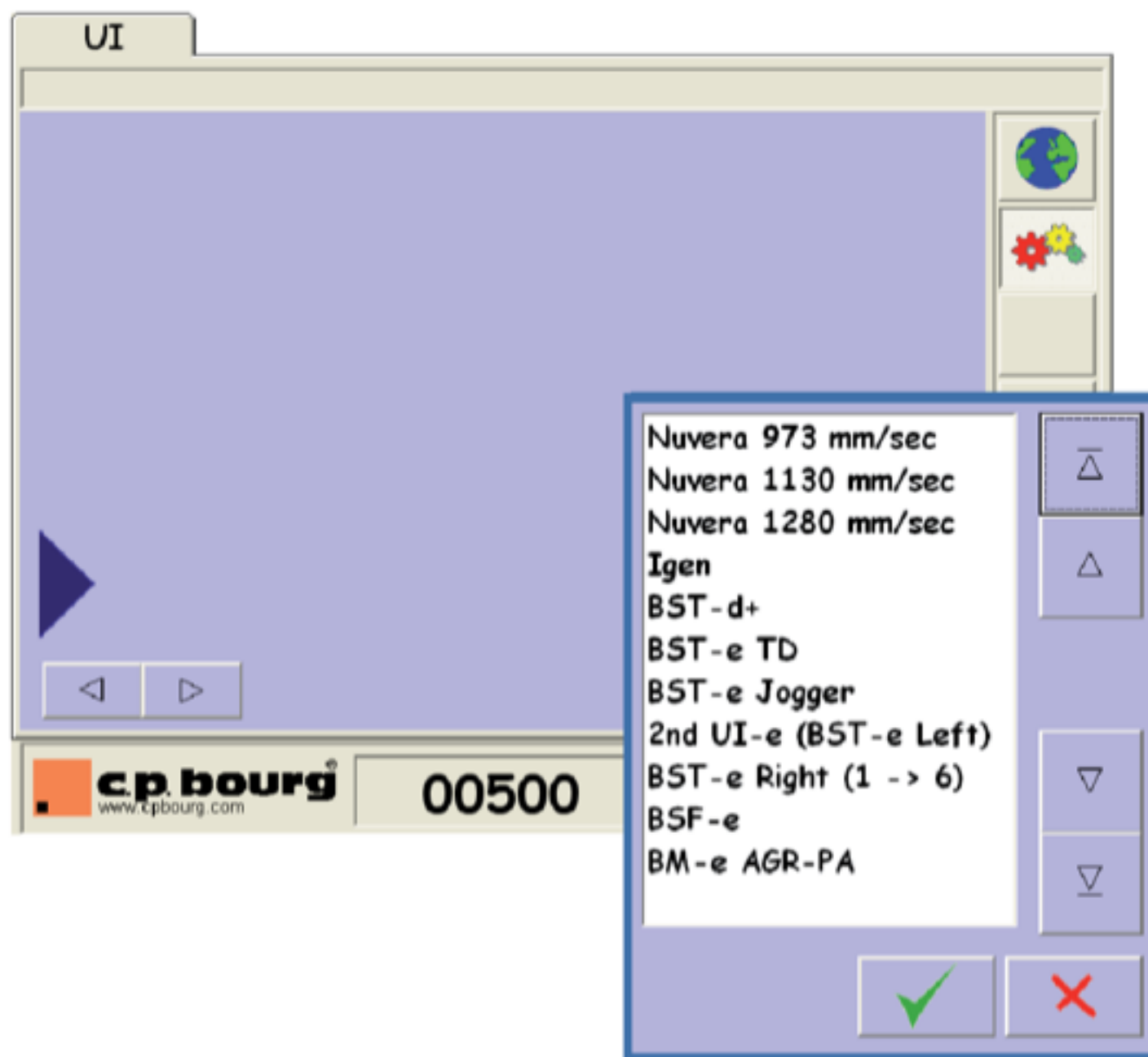
Nuvera 973 mm/sec
Nuvera 1130 mm/sec
Nuvera 1280 mm/sec
Igen
BST-d+
BST-e TD
BST-e Jogger
2nd UI-e (BST-e Left)
BST-e Right (1 -> 6)
BSF-e
BM-e AGR-PA

00500

Press "V" to validate.
The machine appears on the screen.
Press the blue arrow again.

Master Right

18:03:45

0/X

BOOKLET MAKER E-SERIES
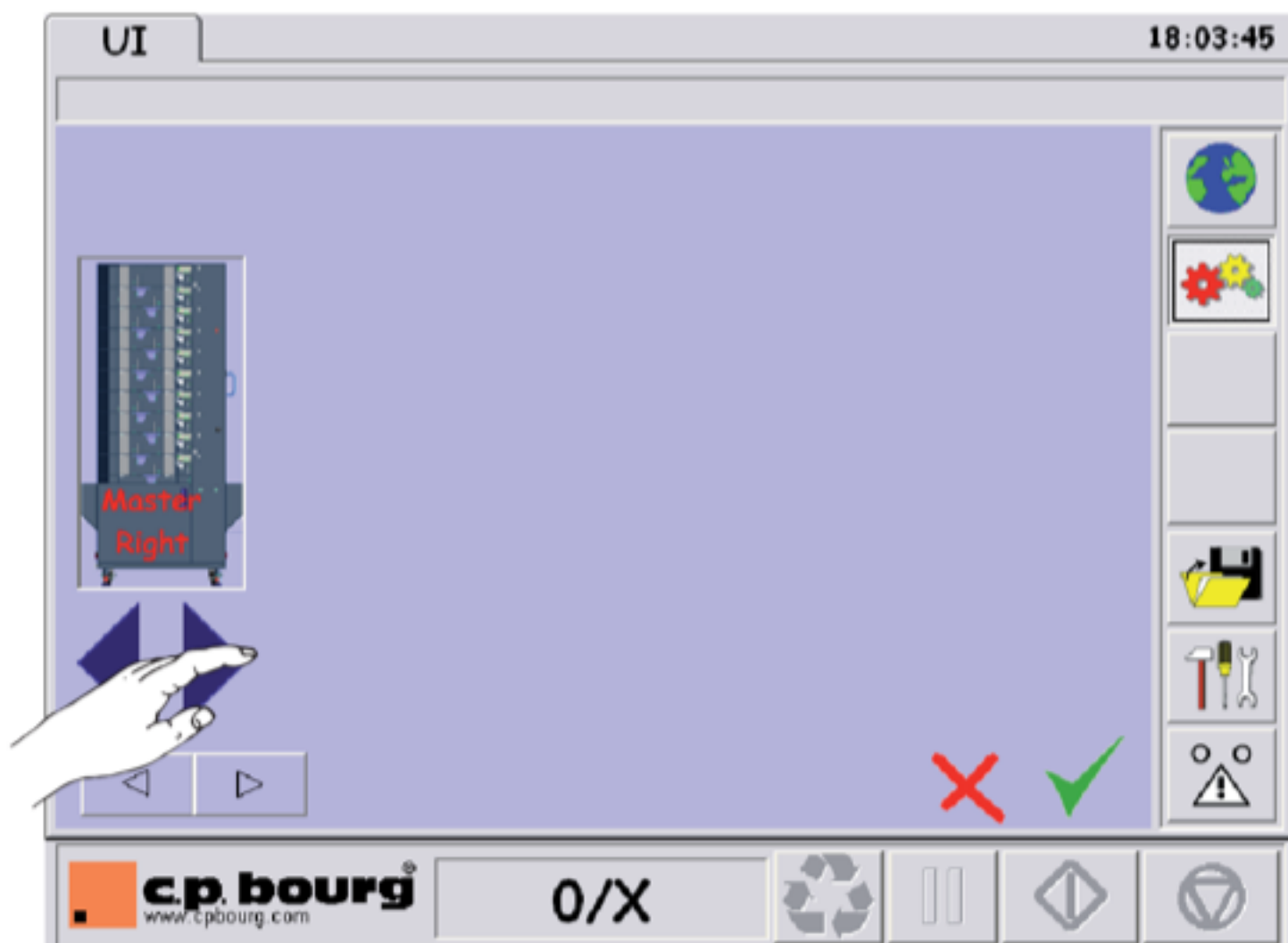
The only possibility is BM-e AGR-PA because is the only machine that can be installed after a right tower.
Select the machine. Press "V" to validate.
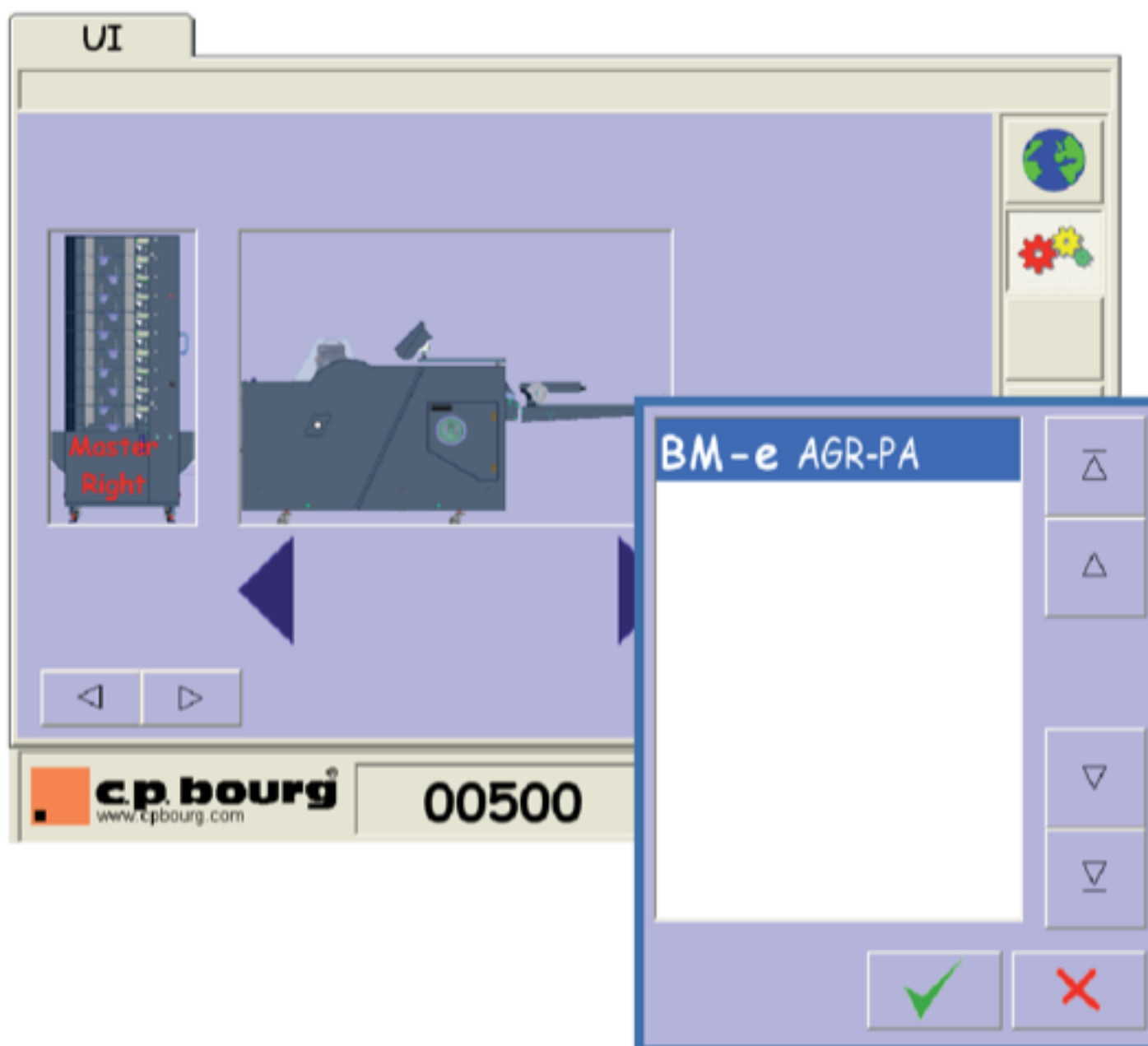
The machine appears on the screen.
Press the blue arrow again.
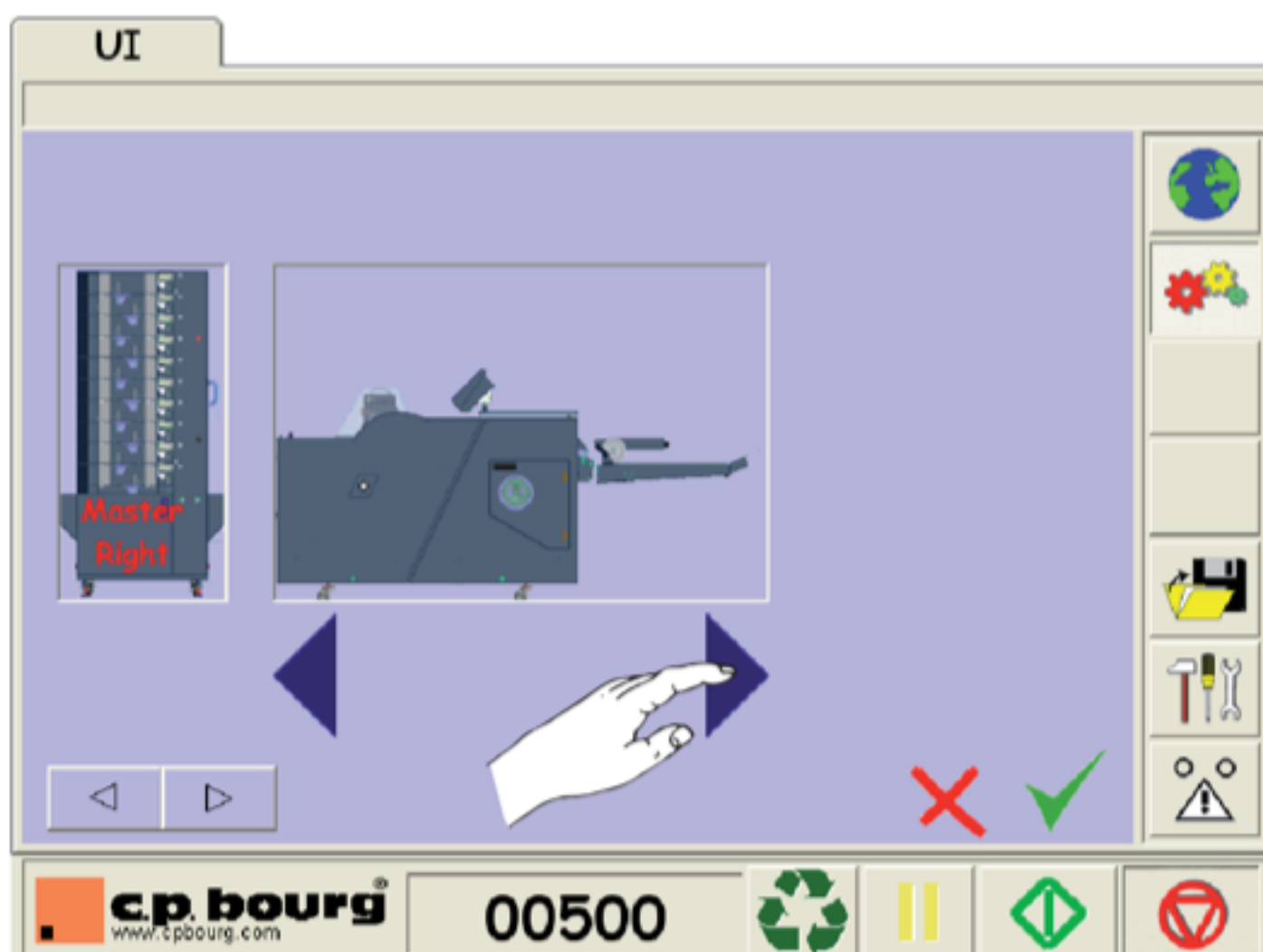
Select the BM-e TR.
Press "V" to validate.
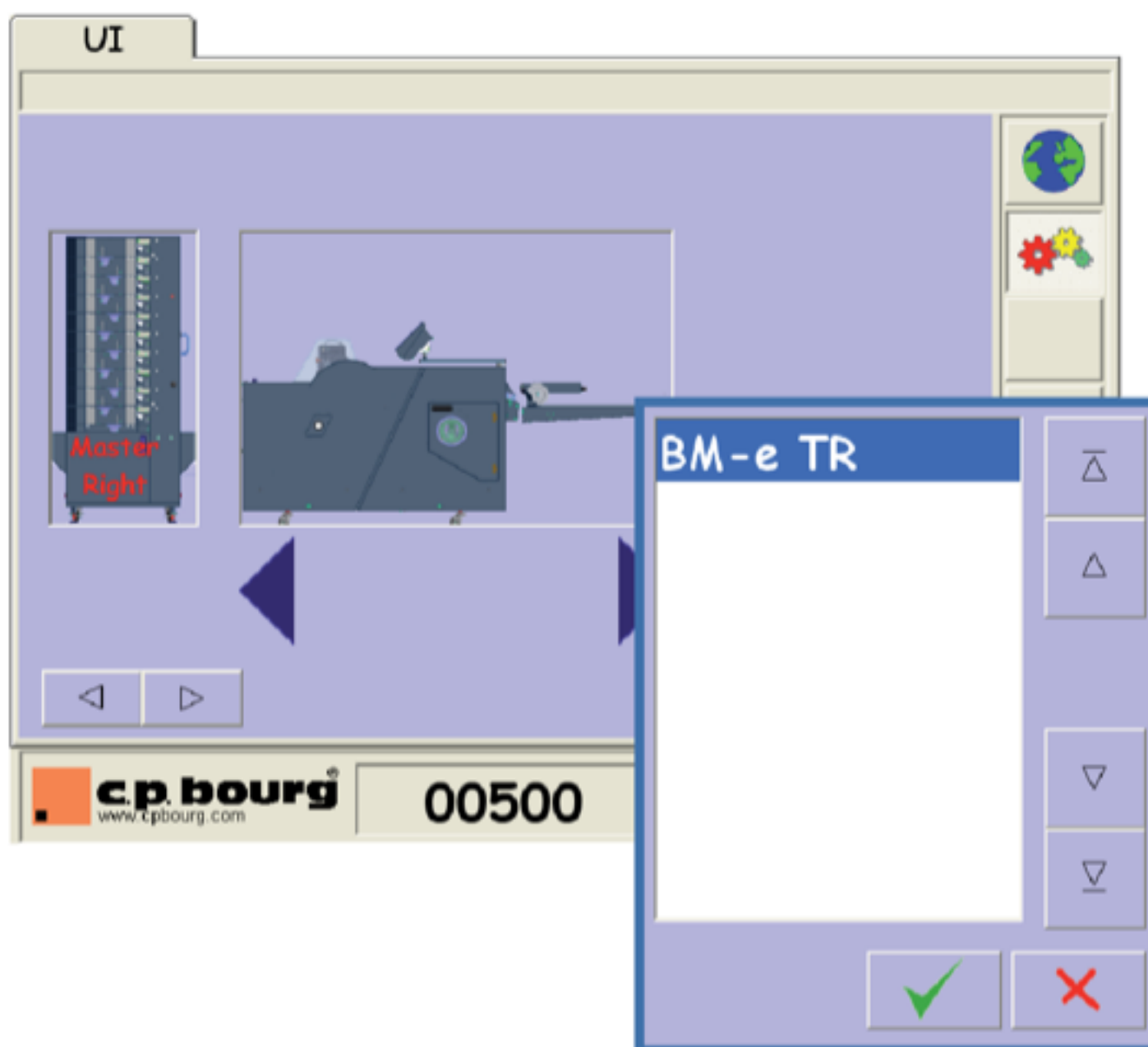
The machine appears on the screen.
The configuration is finished, valid by pressing "V".
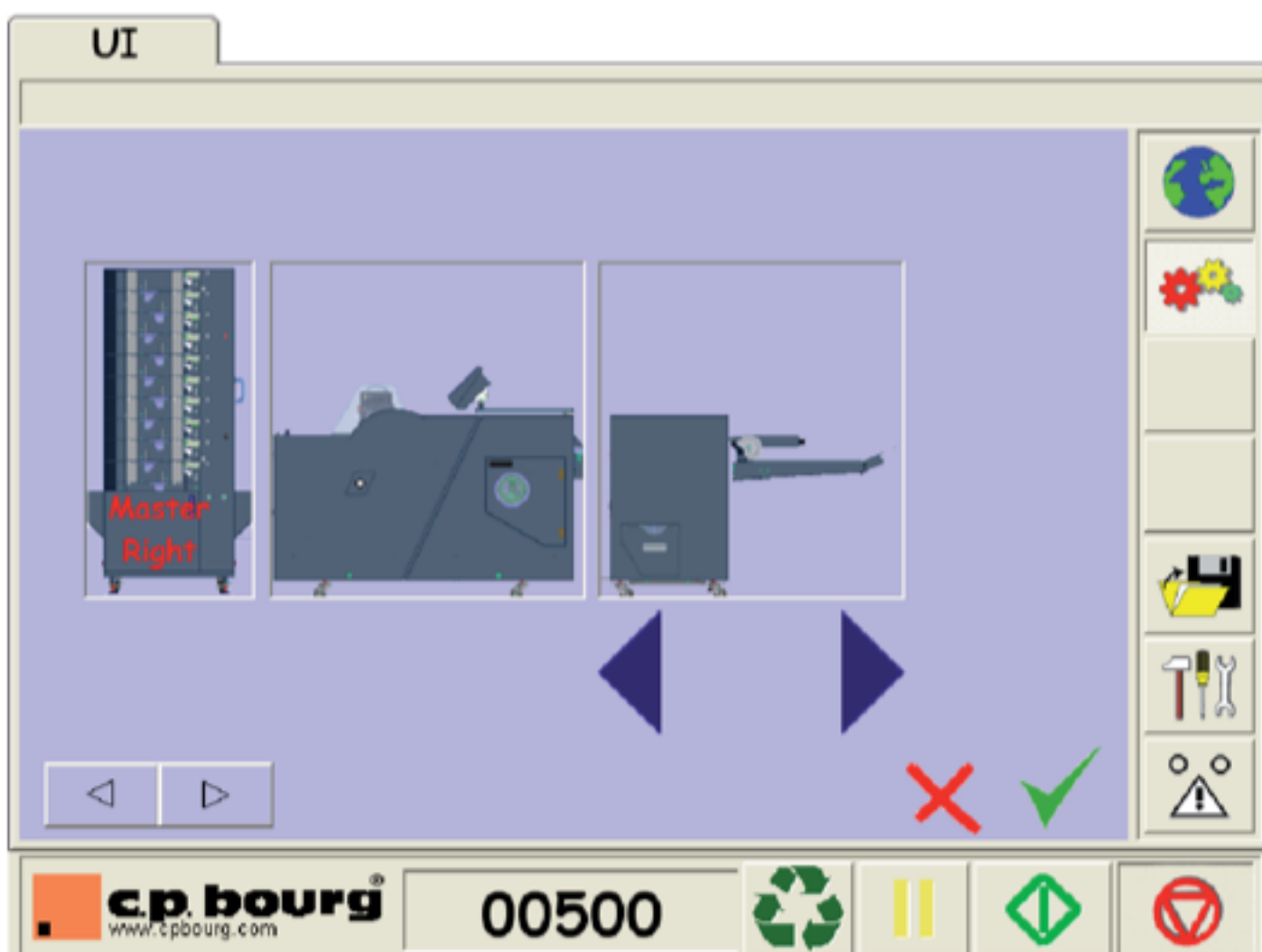
A message appears. To confirm your configuration press YES.
The screen shuts down and then restarts by itself.
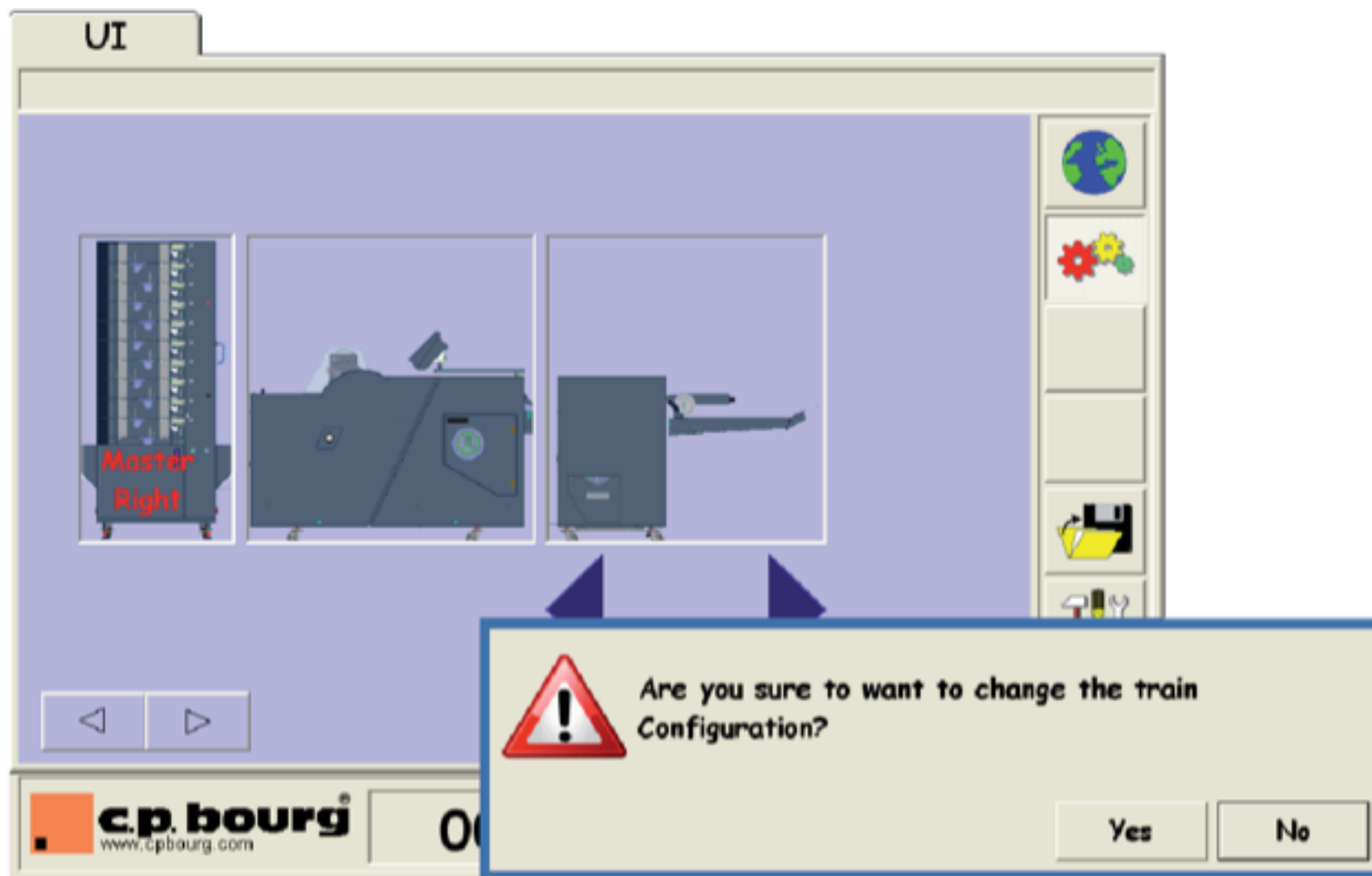
Some new tabs appear according to the configuration.
A new tab "RUN" also appears to make some fine adjustments while machines are running
(see chapter 5.4 RUN screen).
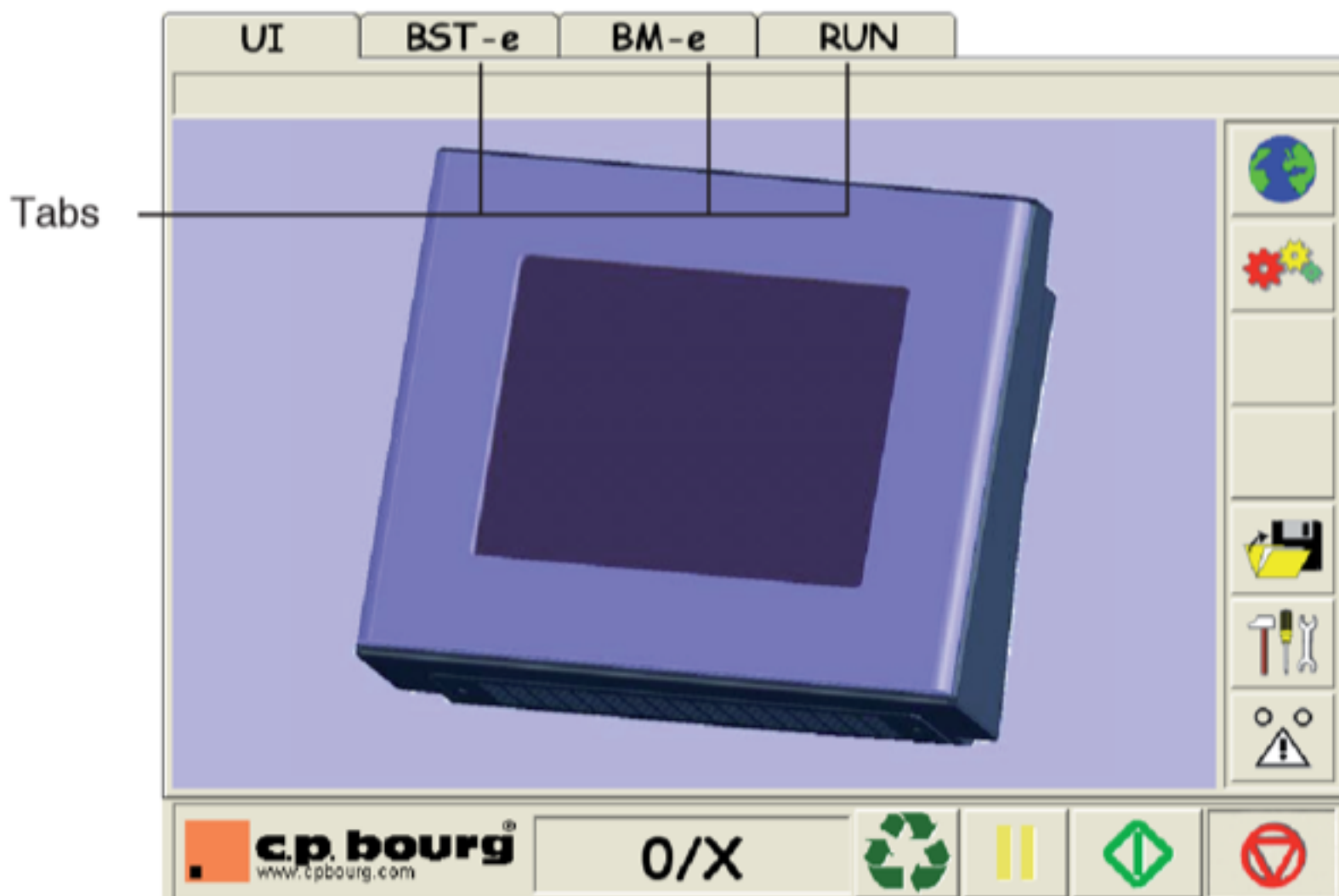
ATTENTION: For BSTd+ / BM-e configuration, BSTd+ tab will not appear.
The BSTd+ has its own U.I.

Note: To complete the BSTd+ and BM-e configuration. Go to BSTd+ screen and press SBM4 (4) button.

Initial version : 11/08
Lastest revision : -

BOOKLET MAKER E-SERIES
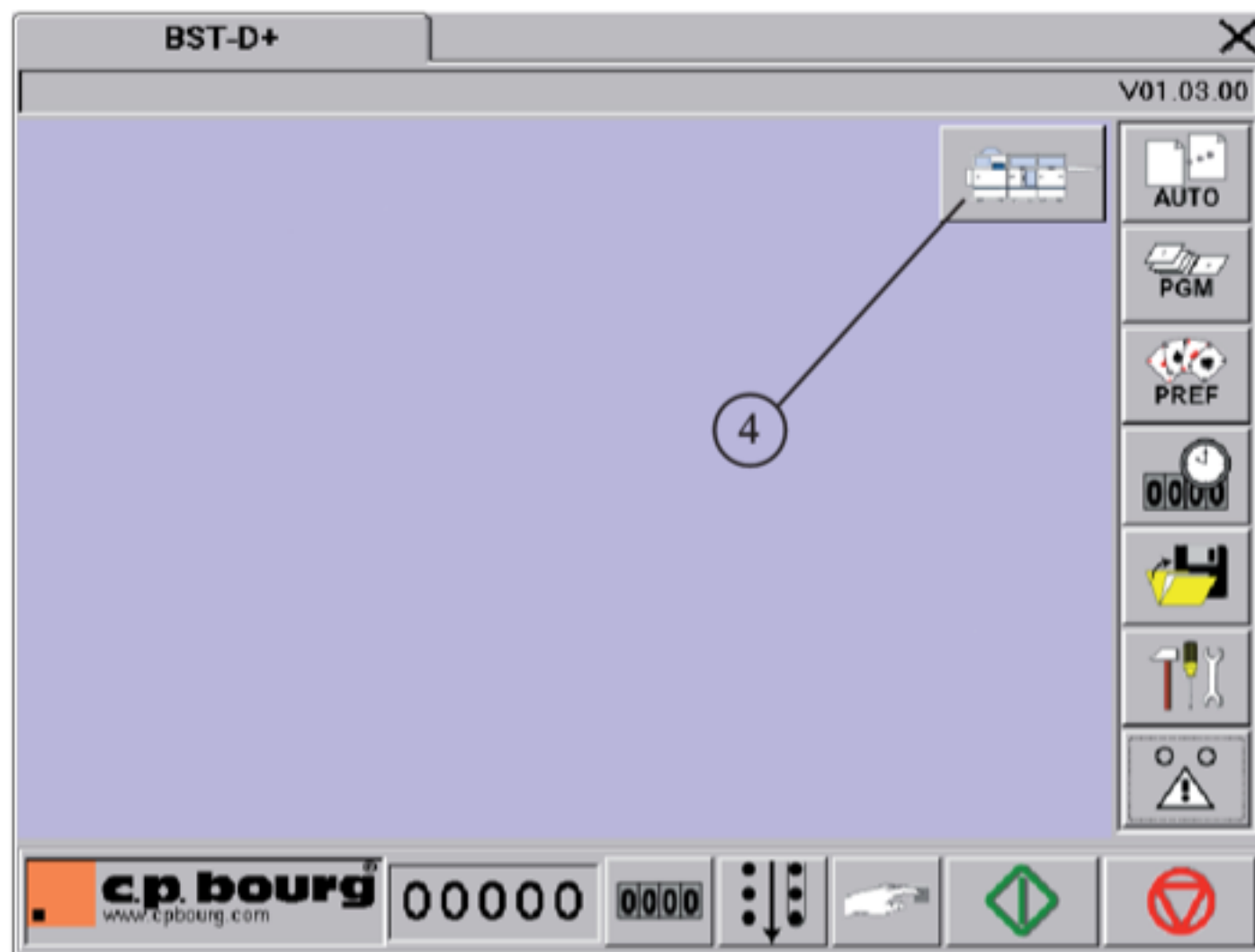
5.1.3 File menu

This menu allows to save, delete, open and recall a job (program).

BOOKLET MAKER E-SERIES
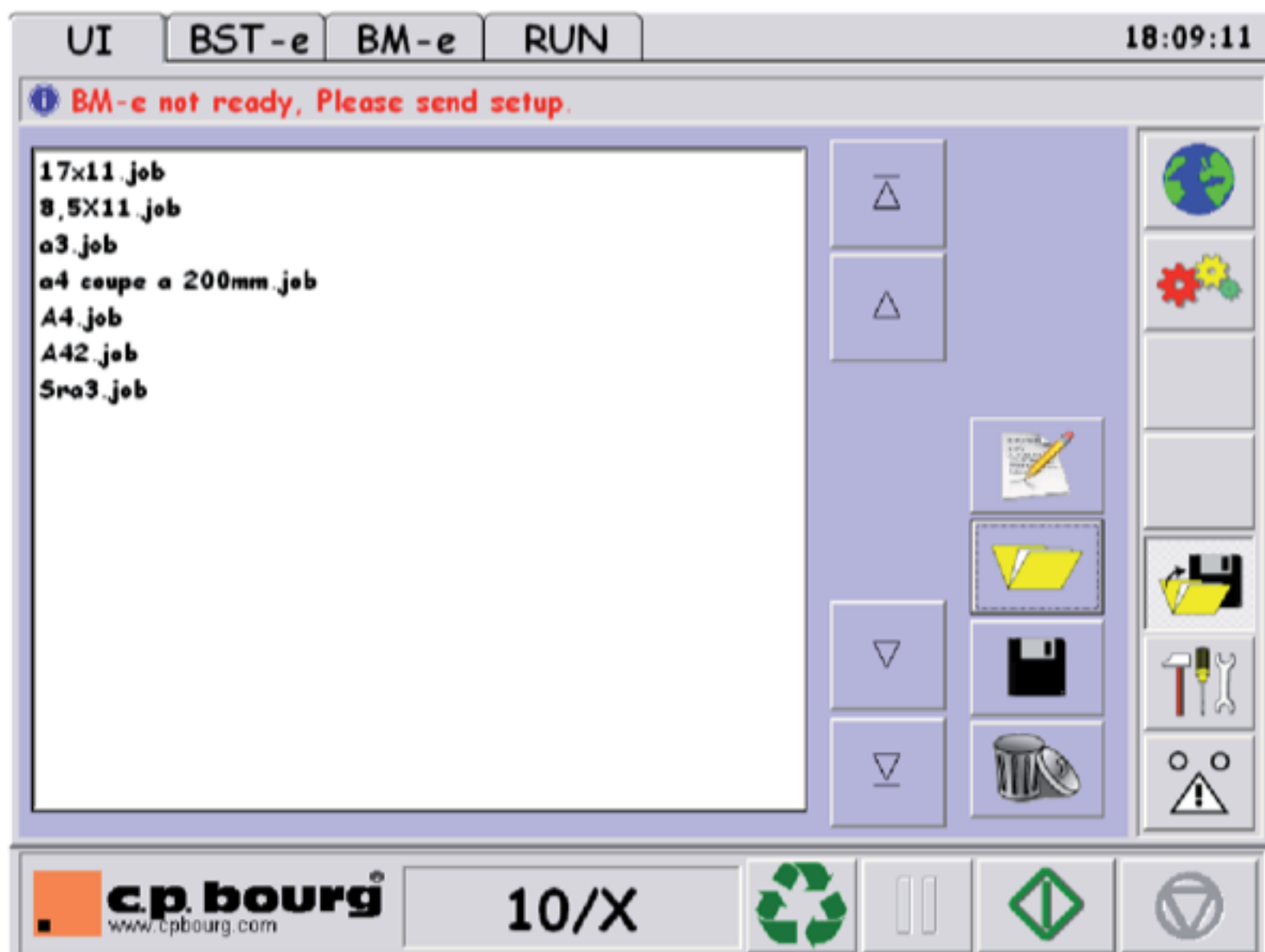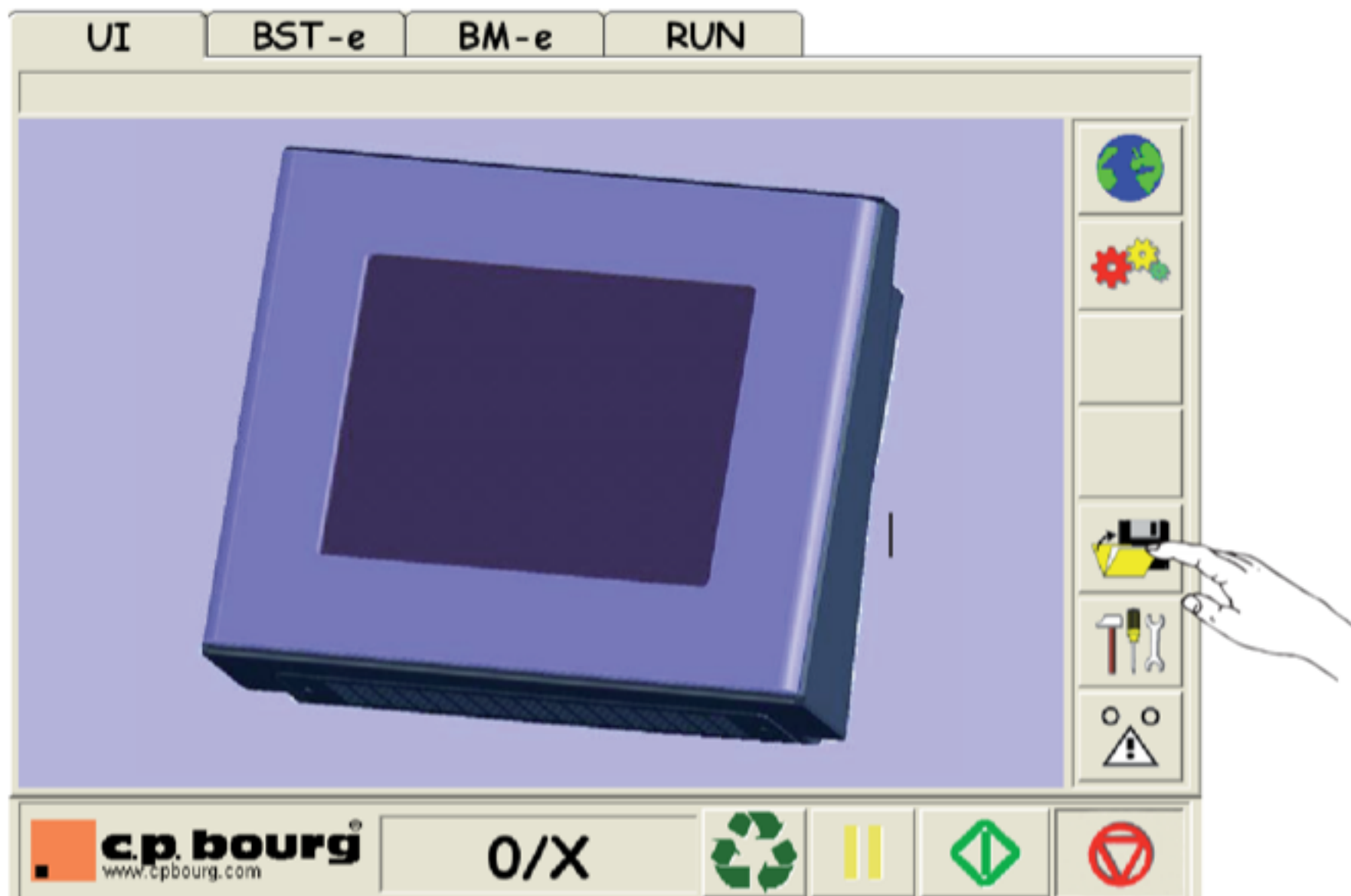
5.2 BST-e screen options

This is the main screen for the BST-e. It allows the operator's adjustments for the BST-e.
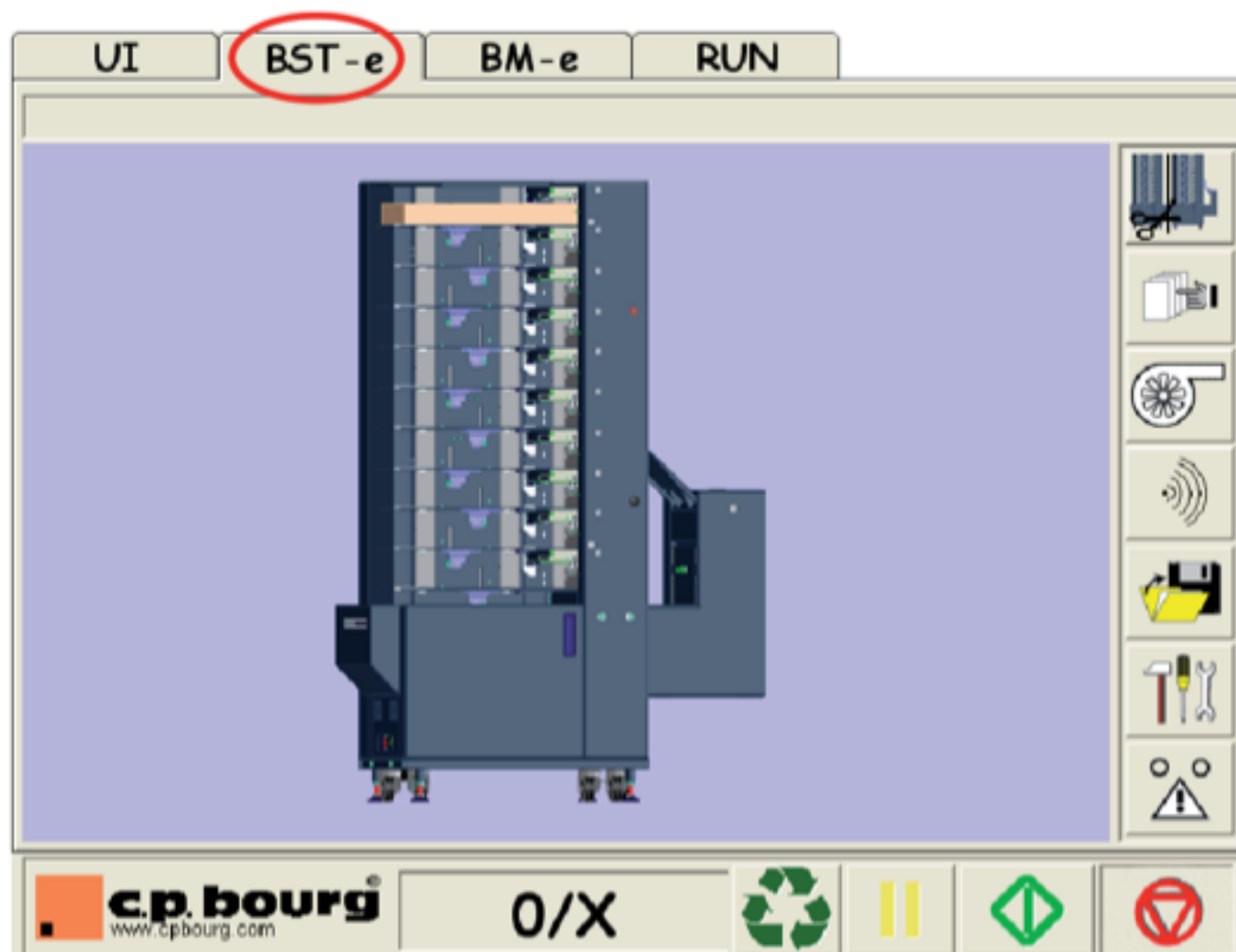
Note: These functions are detailed in the BST-e Operator Manual.

5.3 BME screen options

The "BM-e" screen option allows the user to define the realization of the booklet.
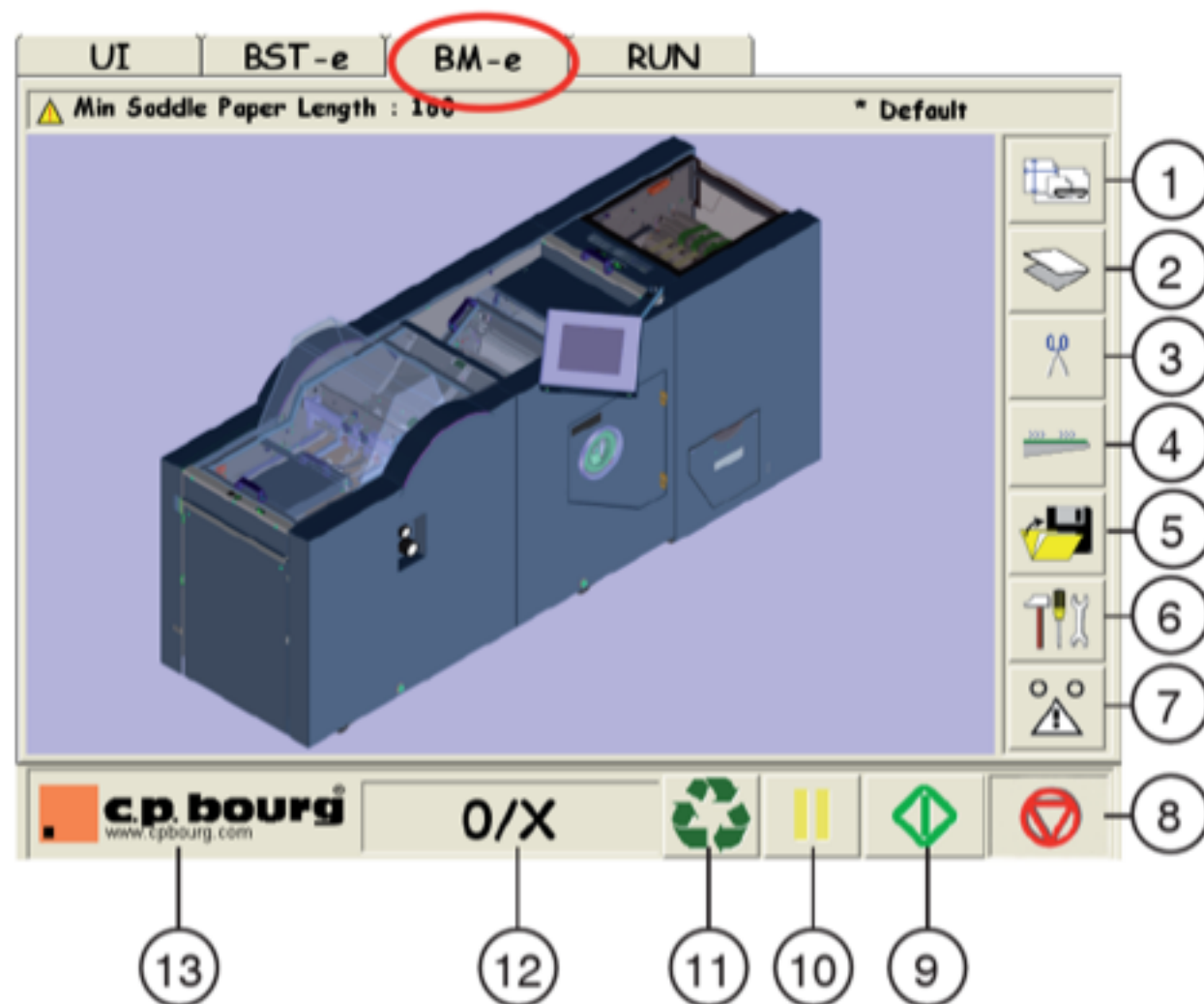
1 - Stitching/format paper screen: allows programming the stitching parameters.

2 - Folding screen: allows programming the folding parameters.

3 - Trimmer screen: allows programming the trimming parameters.

4 - Conveyor screen: allows programming the conveyor parameters.

5 - File menu: allows the recording, the creation of a new job and to open or erase an existing job.

6 - Only for technicians use.

7 - Error warning.

8 - STOP: End of cycle.

9 - START OF JOB.

10 - PAUSE: Stops collating for a brief moment to enable the operator to empty the accessory.

11- PURGE: Clears the machine after a jam.

12 - COUNTER.

13 - Software version: Software update history.

5.3.1 Paper format and Stitcher parameters screen

Press the button "PAPER FORMAT AND STITCHER SCREEN" to have access to the stitching parameters.

- Press on value to edit
- Enter the value using the keypad.
- Validate "**V**".
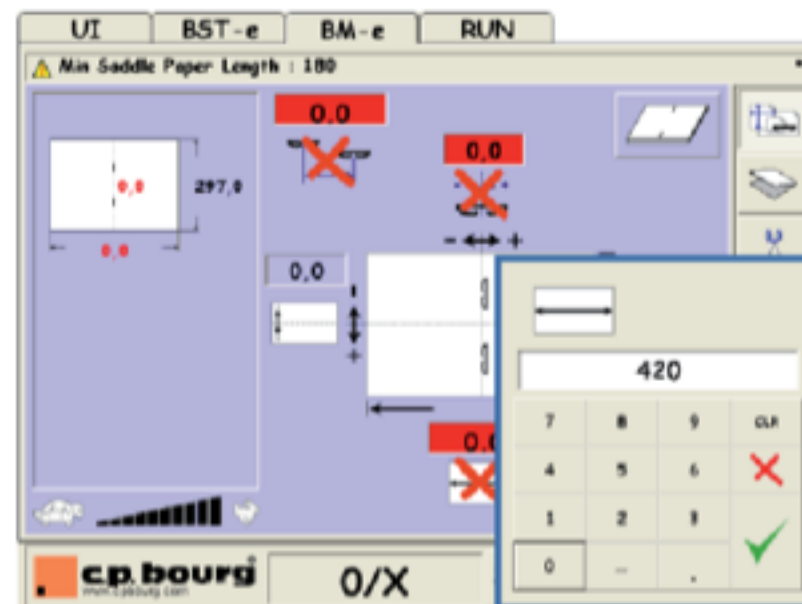
"**V**" Valid the adjustment parameters entered in the different screen.

"**X**" Cancel the last modifications entered in the defined job.

Six adjustments are available:

Summary area
See Productivity
and Summary
chapter 5.3.5
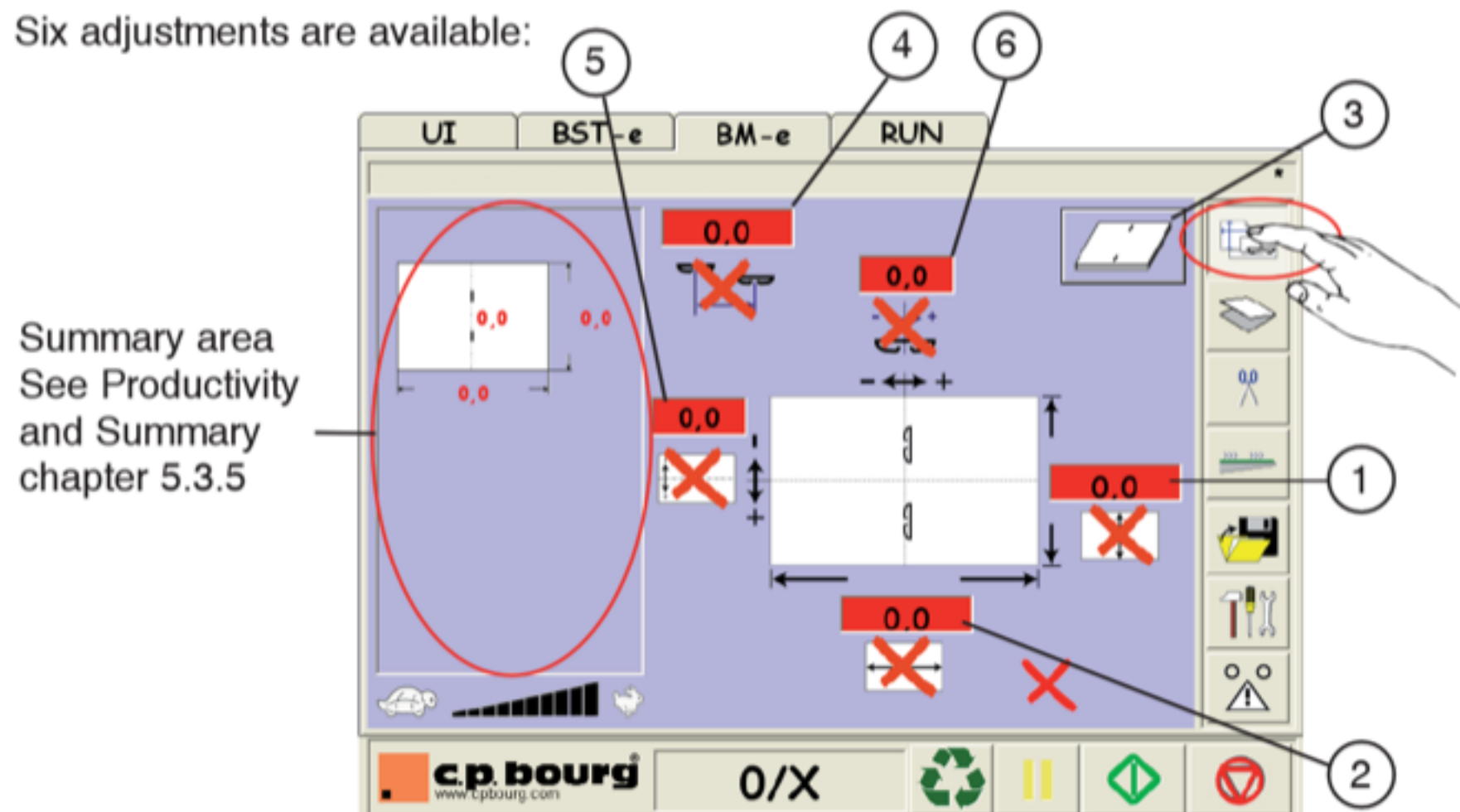
1 - Paper width choice.

2 - Paper length choice.

3 - Stitching mode choice.

Saddle stitching.

Top stitch.

Left corner stitching.

Right corner stitching.

Cancel stitching function.

4 - Space between stitches.

Only for saddle and top stitch.
Determine the value through the numerical keypad.
Validate "V".

5 - Stitch position choice (left or right).
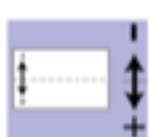
This function allows to offset the stitches to the right (+) or to the left (-) compared with the middle of the paper width.
Position 0,0 = centred stitch.
Determine the value through the numerical keypad.
Validate "V".

6 - Stitch position choice (front or rear).
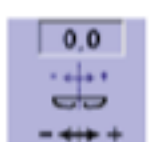
This function allows to offset the stitches to the front (+) or to the rear (-) compared with the middle of the paper length.
Position 0,0 = centred stitch.
Determine the value through the numerical keypad.
Validate "V".

Attention: When the values are not compatibles, the affected area is in red colour. You have to change the value to validate the configuration.

5.3.2 Folding parameter

Press the button "FOLDING" to have access to the folding parameters.
Three adjustments are available:
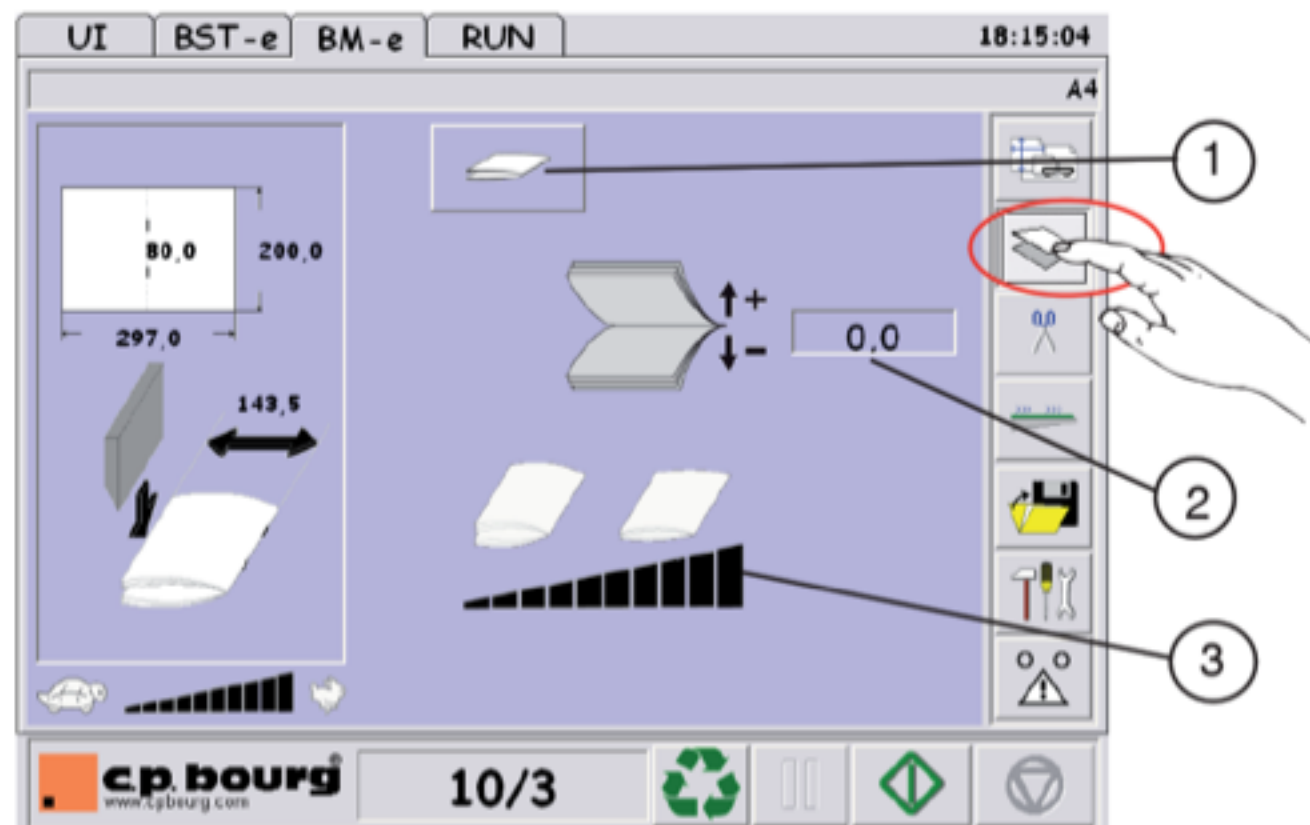
1- Folding function selection:

Folding option activated.

Folding function not activated. Sets are sent to the upper reception tray.

2 - Fold position:
   By default, the fold will always be in the middle (0,0) of the paper length. It is possible to offset the paper fold frontward (+) or backward (-).
   Press area 2 and determine the value through the numerical keypad.
   Validate "V".

3 - Folding pressure selection:
   By default, the pressure will always be maximum.
   Decrease the pressure if there are too many cracks or marks on the cover.

→ + the pressure   - the pressure ←

"V" Validation of the adjustment parameters entered in the different screens.

"X" Cancel the last values entered in the defined job.

5.3.3 Trimming parameter

Press the button "TRIMMING" to have access to the trimming parameters.
Four adjustments are available:
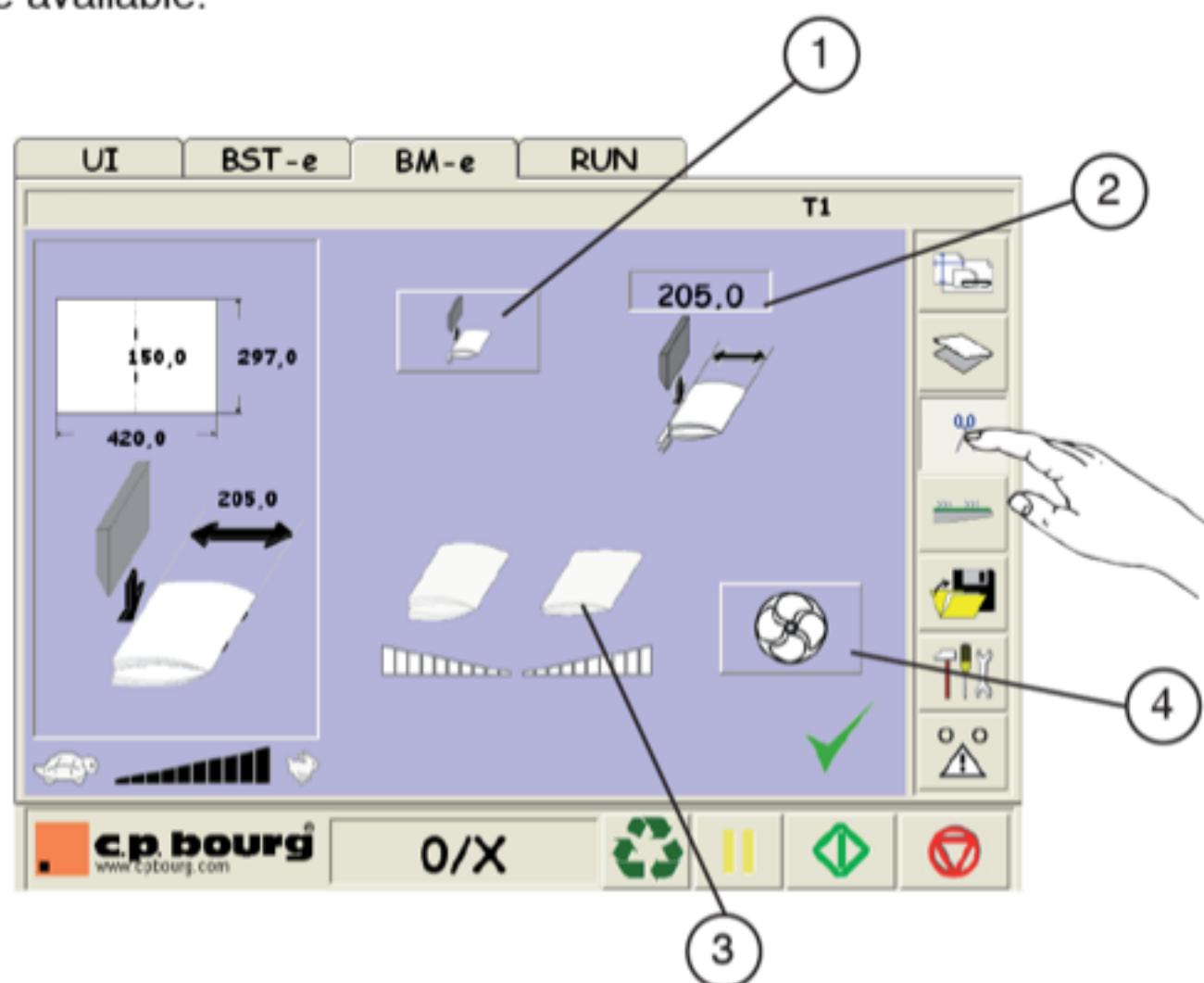
1 - Trimming function selection.

   Trimming option activated (go to the three additional options described below).

   Trimming option not activated (go directly to output conveyor parameter).

2 - Booklet final length selection.
   Determine the value through the numerical keypad, validate "V" .

3 - Trimmer conveyor height choice.
   The trimmer conveyor height set itself is automatically in relation to the booklet thickness.
   The operator may adjust this height.

Maximum height	Maximum height

4 - Active or deactive the blower to evacuate the chips.

"V" Validation of the adjustment parameters entered in the different screens.

"X" Cancel the last values entered in the defined job.

5.3.4 Output conveyor parameter

Press the button "CONVEYOR" to have access to the conveyor parameters.
Three adjustments are available :
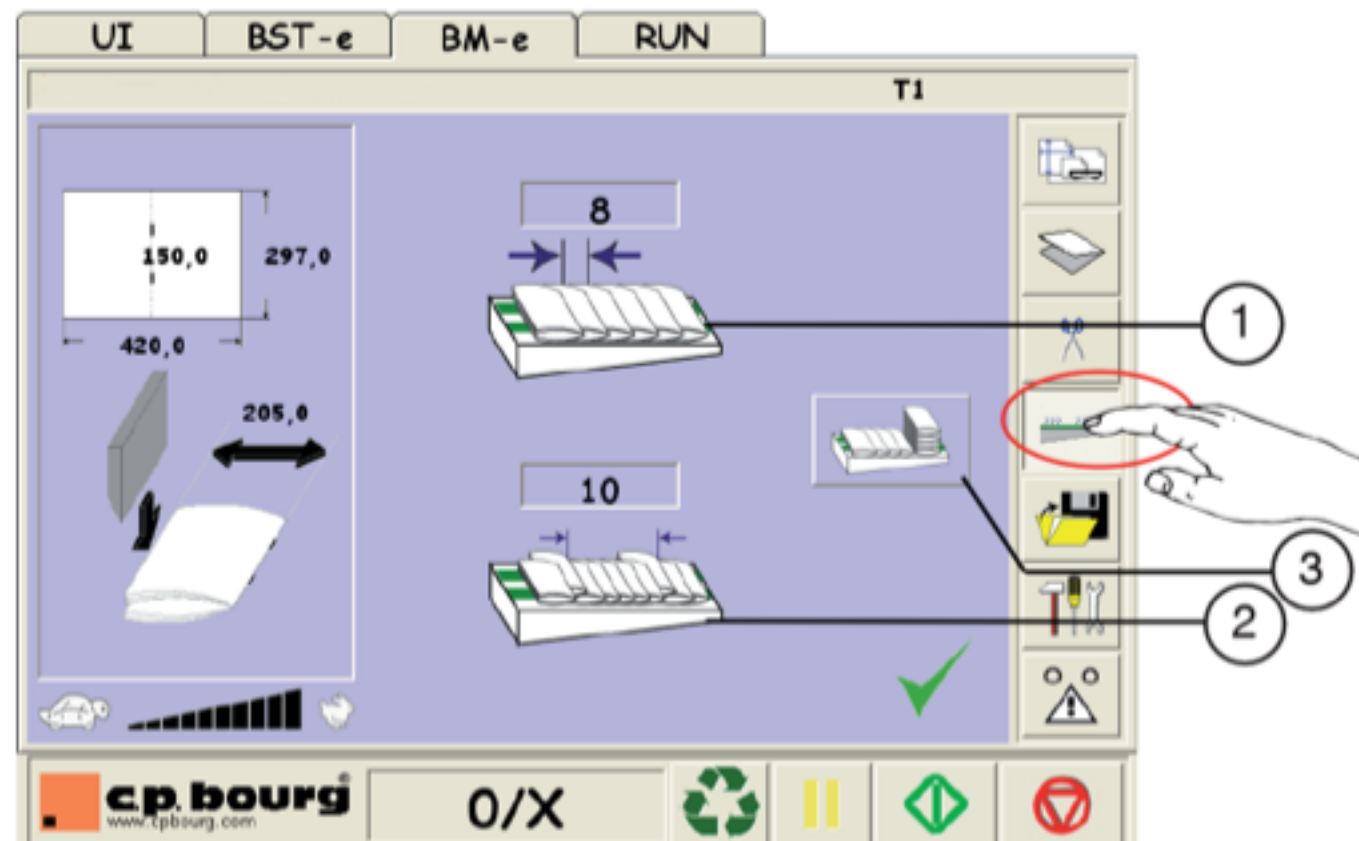
1 - Conveyor advances selection.
   Adjust the conveyor advance (1 to 30) to obtain the space desired between the booklets.
   1 = small space
   29 = long space
   30 = continuous advance
   Determine the value through the numerical keypad, validate "V".

2 - Booklet offsetting on conveyor selection.
   This function allows to offset a booklet every x booklets in order to count the booklets more easily.
   x being the entered value.
   1 = aligned (no offset)
   2 = every second set offset
   3 = 1 − 2, 3rd is offset
   7 = 1 − 2 − 3 − 4 − 5 − 6, the 7th is offset
   Maximum is 250
   Determine the value through the numerical keypad. Validate "V".

3 - Conveyor full option selection.

   Cancel the conveyor full detection. The machine does not stop even if the conveyor is full.

   Conveyor full detection. The machine stops when the conveyor is full.

"V" Validation of the adjustment parameters entered in the different screens.

"X" Cancel the last values entered in the defined job.

5.3.5 Productivity and Summary parameter
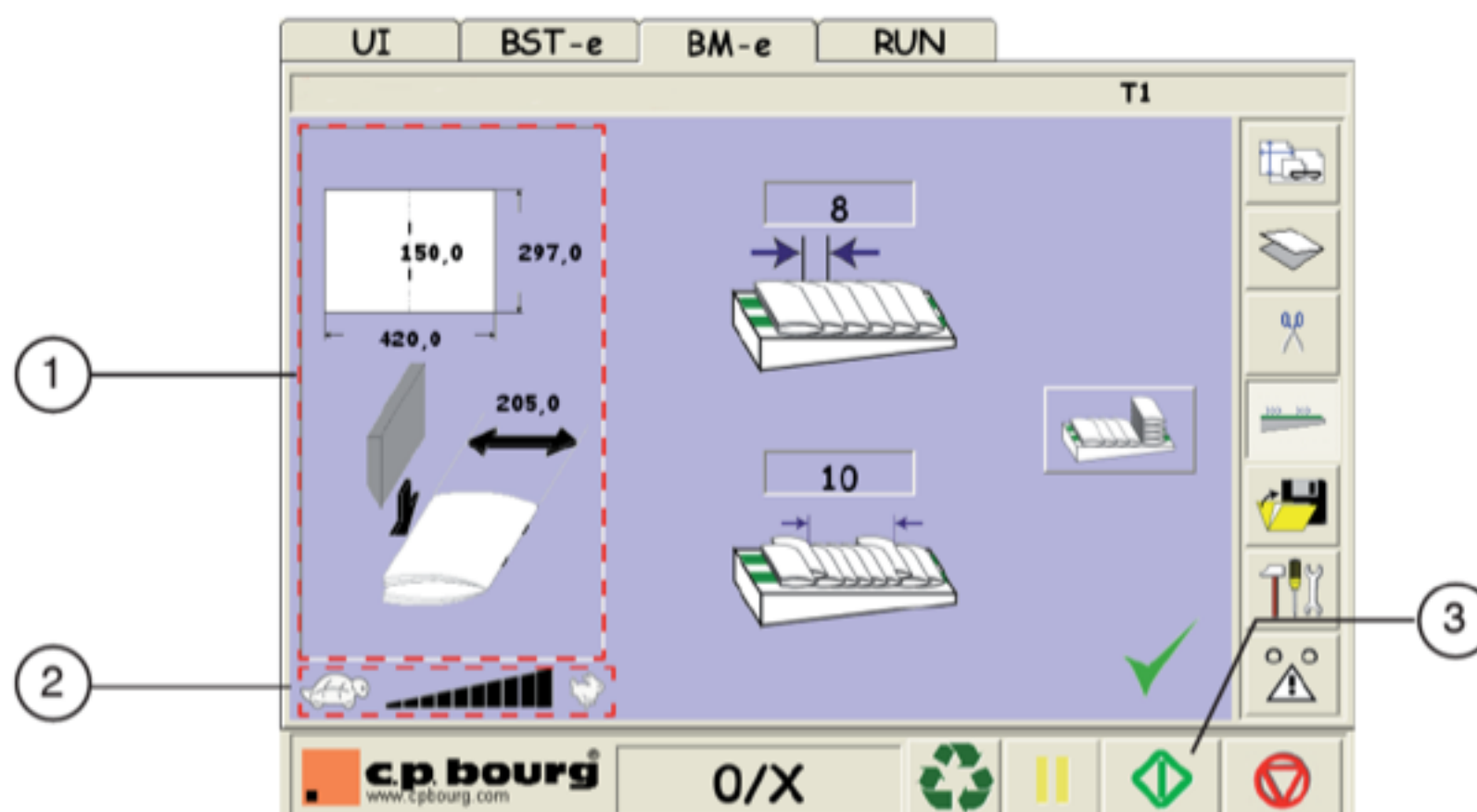
1 - Summary screen.
   On each screen, the summary screen shows the main parameters entered for stitching, folding and trimming.

2 - Productivity and running speed of the BMe.
   It is possible to decrease the Bookletmaker speed. In order to obtain a better quality for finished booklets made with delicate papers.

There are 3 speed available :

 One jogging only in the AGR.
The time of booklet positioning in the PA is the shortest possible.

 Two joggings in the AGR.
The time of booklet positioning in the PA is medium.

 Three joggings in the AGR.
The time allows the booklet to be perfectly positioned in the PA.

IMPORTANT: The four main adjustments are complete: paper format, stitching, folding, trimming and conveyor.
Press Start button (3) to send some sheets and verify the parameters.
If it is correct, *enter the number of desired jobs (see chapter 5.3.13/14 Counter of set and send the job.*
If it is not correct, *it is possible to correct the parameters in the above menus or make fine adjustments in the RUN mode (see chapter 5.4 RUN).*

5.3.6 File menu parameter

The BME graphical interface allows an easy and performing jobs management.
Press the button "FILE MENU" to have access to the file parameters.
Five adjustments are available:
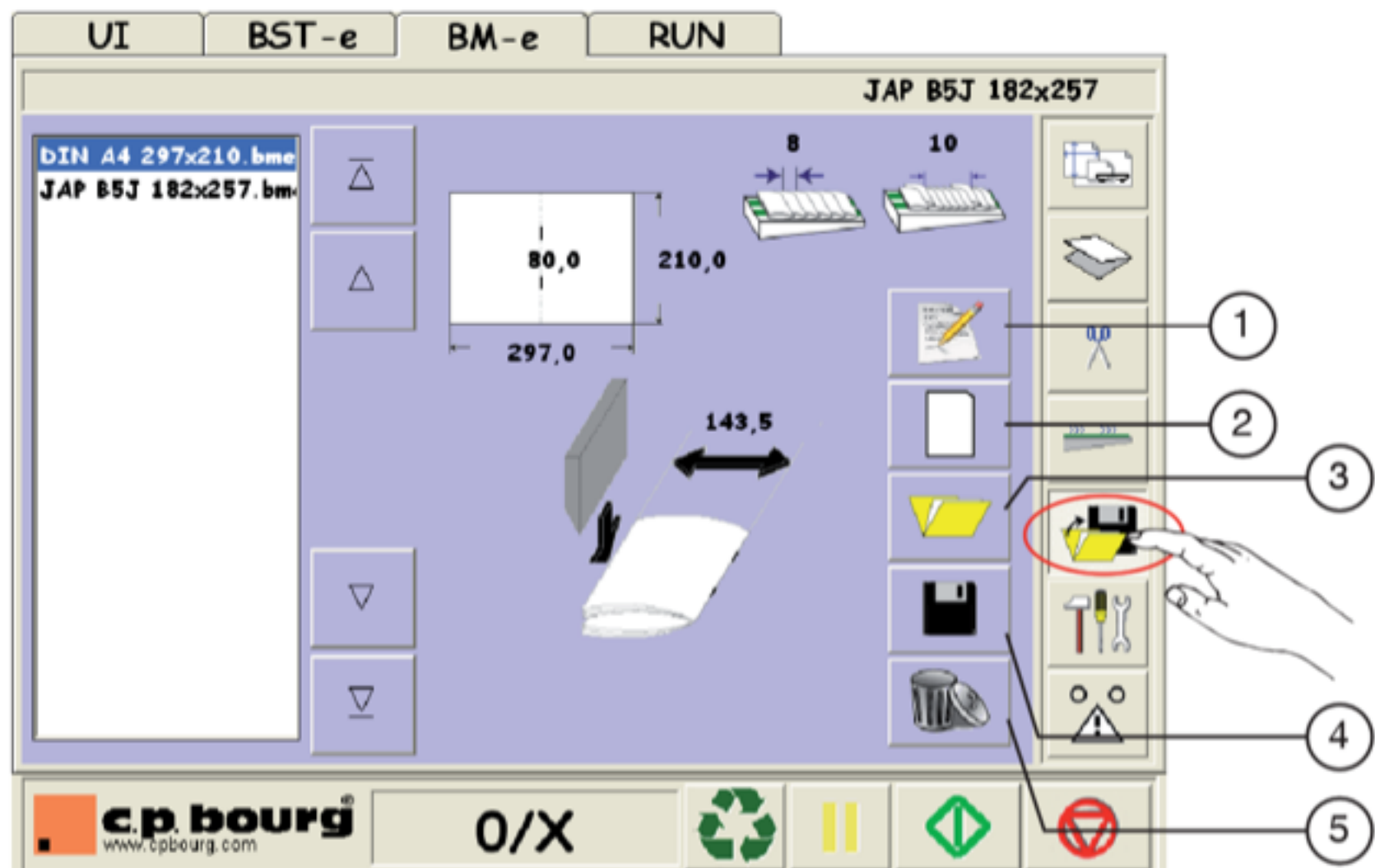
1 - **Make a comment** on the saved jobs.

2 - **Open** an existing model in the EU, US, JA formats which could be used as beginning for a new job.

3 - **Open** a job saved by the operator.

4 - **Save** a new program with his name and characteristics.

5 - **Erase** an existing program no longer used.

Make a comment

This menu allows to make a personal comment on a saved job.
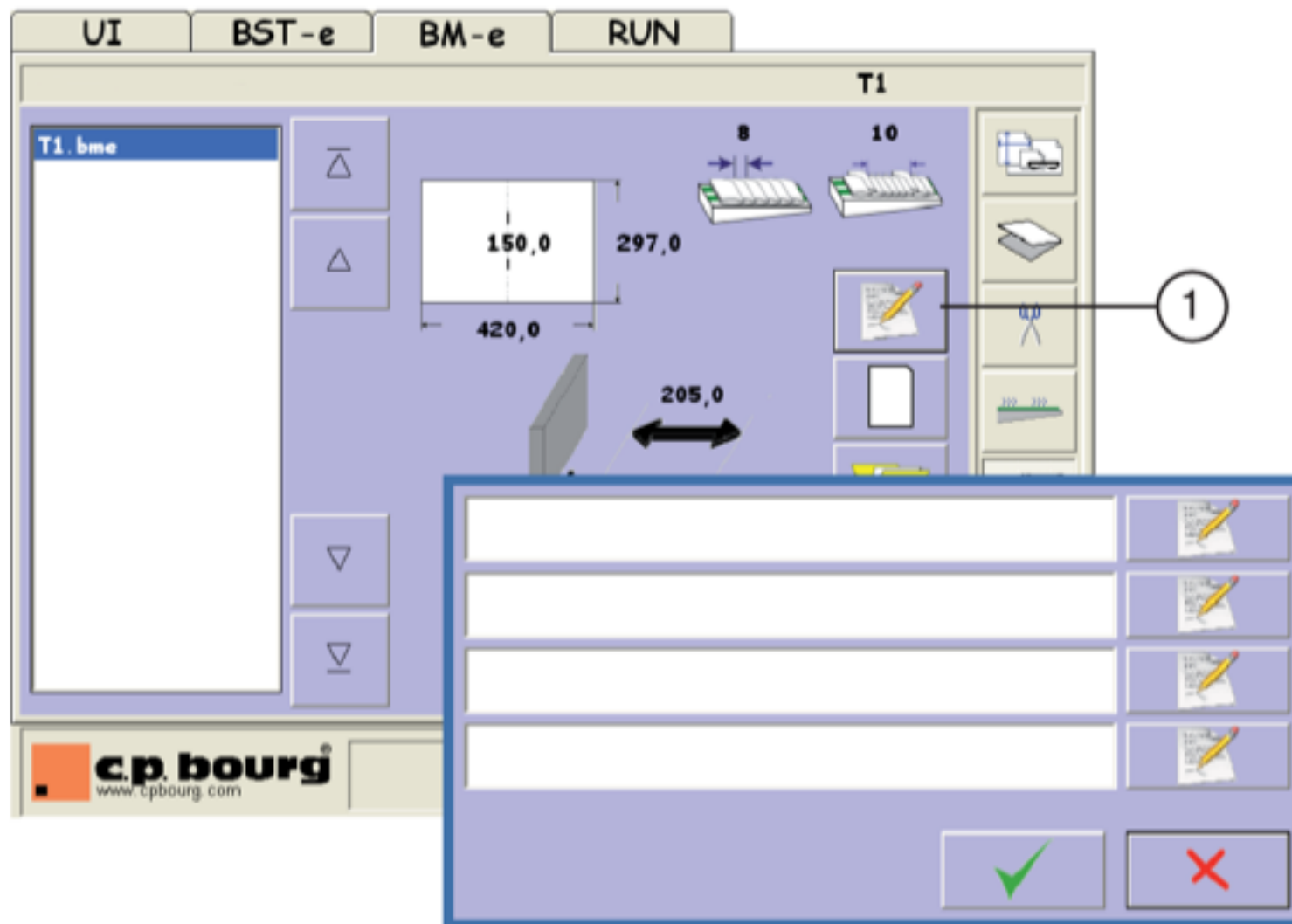
Select a job and press button (1) to access to the dialogue box.
4 lines are available to write the comments through the alphanumeric keyboard.
Press enter to display the comment on the line.
Validate "V".

New job loading

This menu allows to load models based on standardised formats.
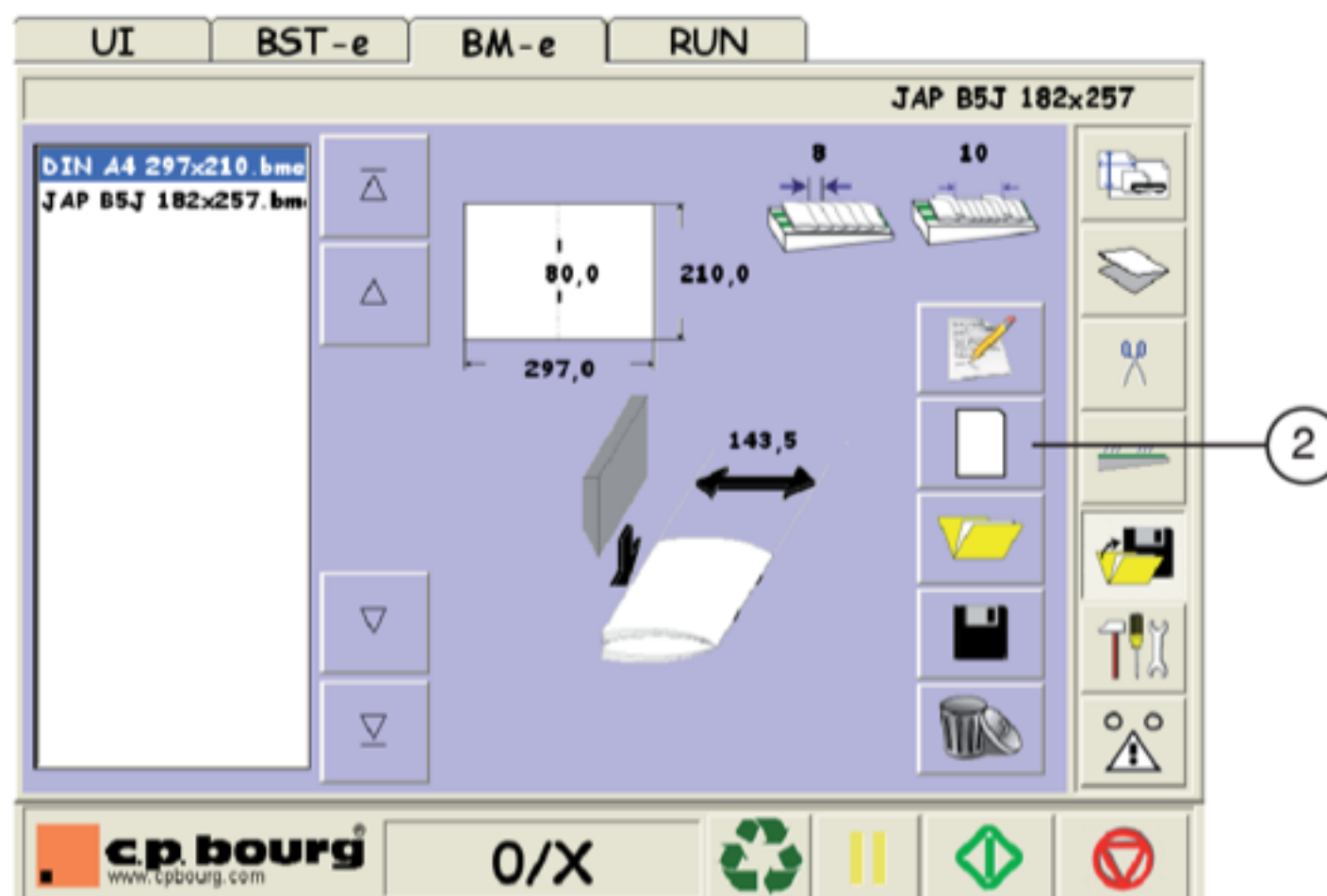
Press the button (2).

Select a or some standard(s) among the 3 suggested (EU, US or JA) using button (3).

Select a model using the arrows and validate "V".

Press OUI/YES to open the selected job or NON/NO to return to the previous screen and select another job.

This model can be the starting point to define a new job.
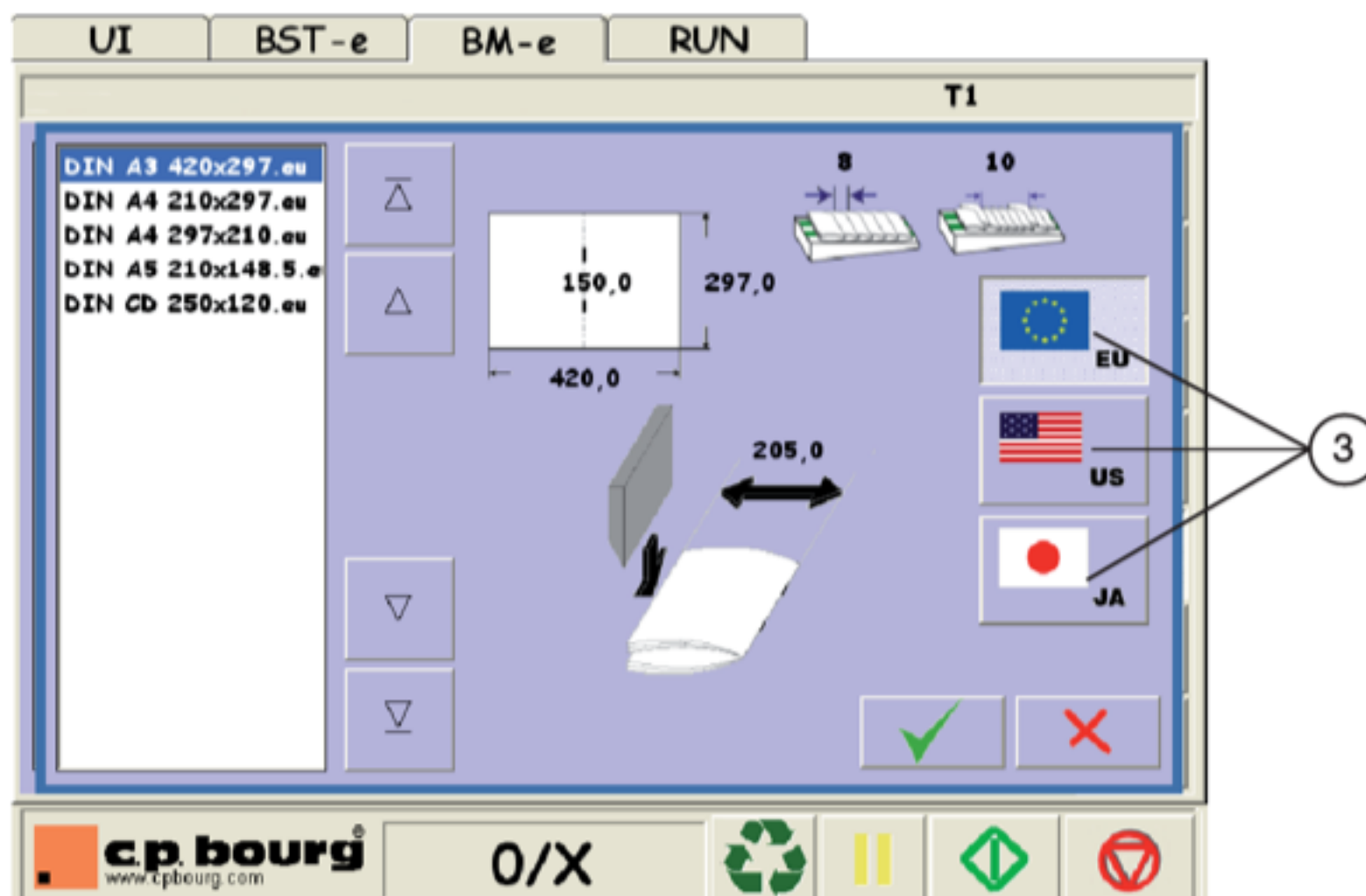
Opening an existing job

This menu allows to open a job saved by the operator.
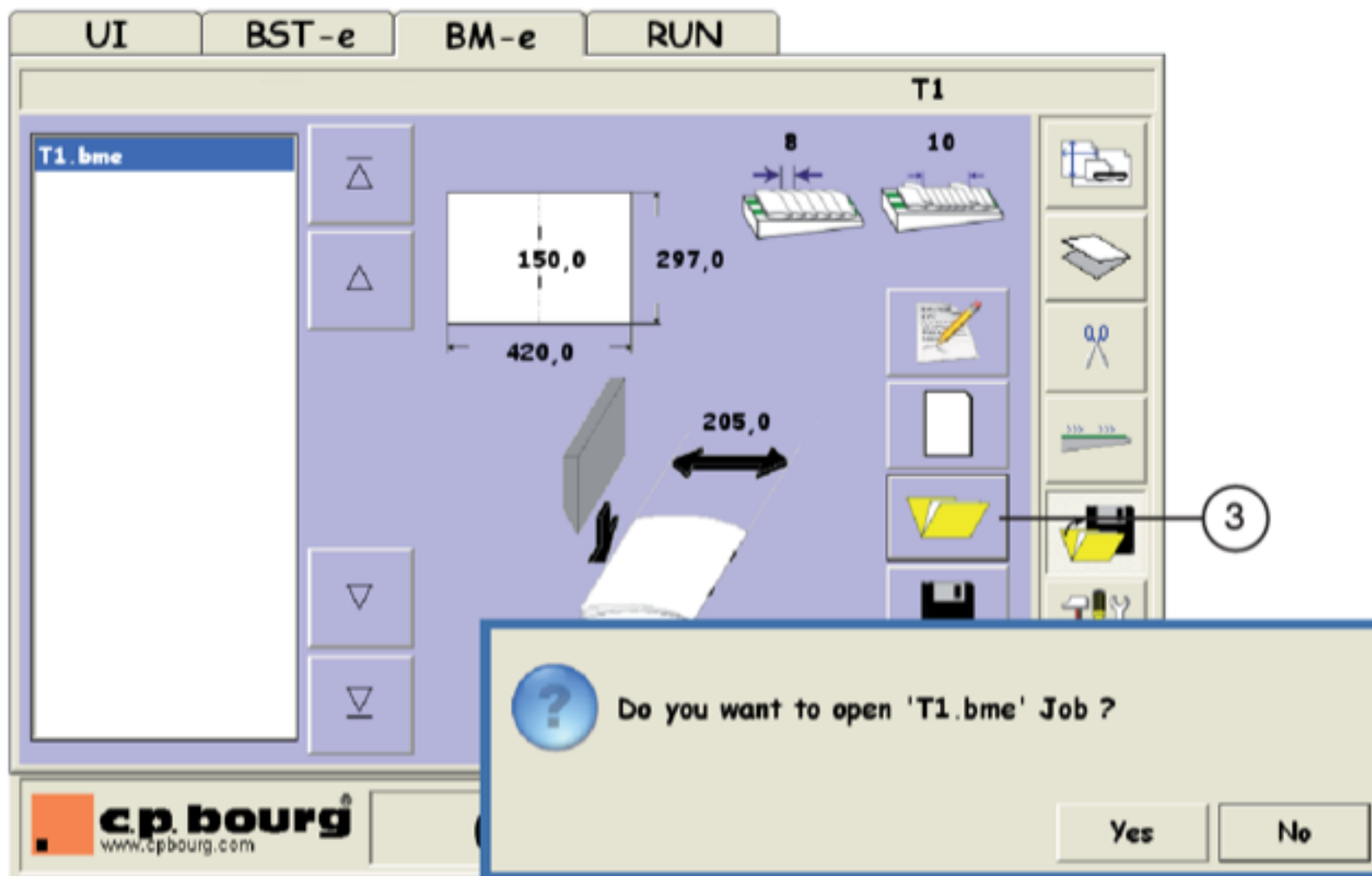
Select a job in the left column and press button (3).

Press OUI/YES to open the selected job or NON/NO to return to the previous screen and select another job.

This job can be the starting point to define a new job.

Save a job

When a job has been defined by the operator, it can be saved as follow.
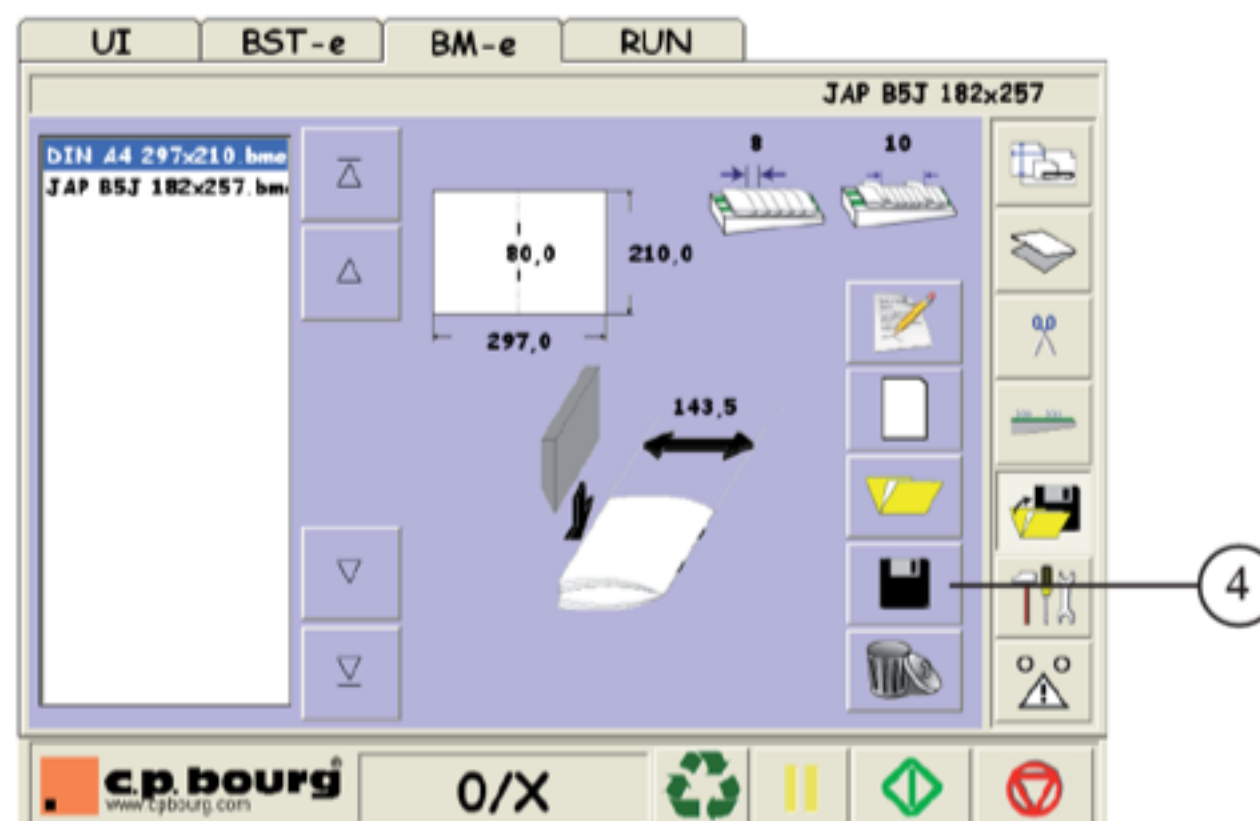
Press button (4).

Enter a name for the job on the alphanumeric keyboard and confirm it by "ENTER".

The new job appears in the left column.

If the name given already exists and that you press "enter", a message will appear to ask you to confirm the replacement of an existing file by the new one.

Press OUI/YES to replace the existing job by the new one or NON/NO to return to the previous screen and rename the new job.

Note: Approximately 500 jobs can be saved.
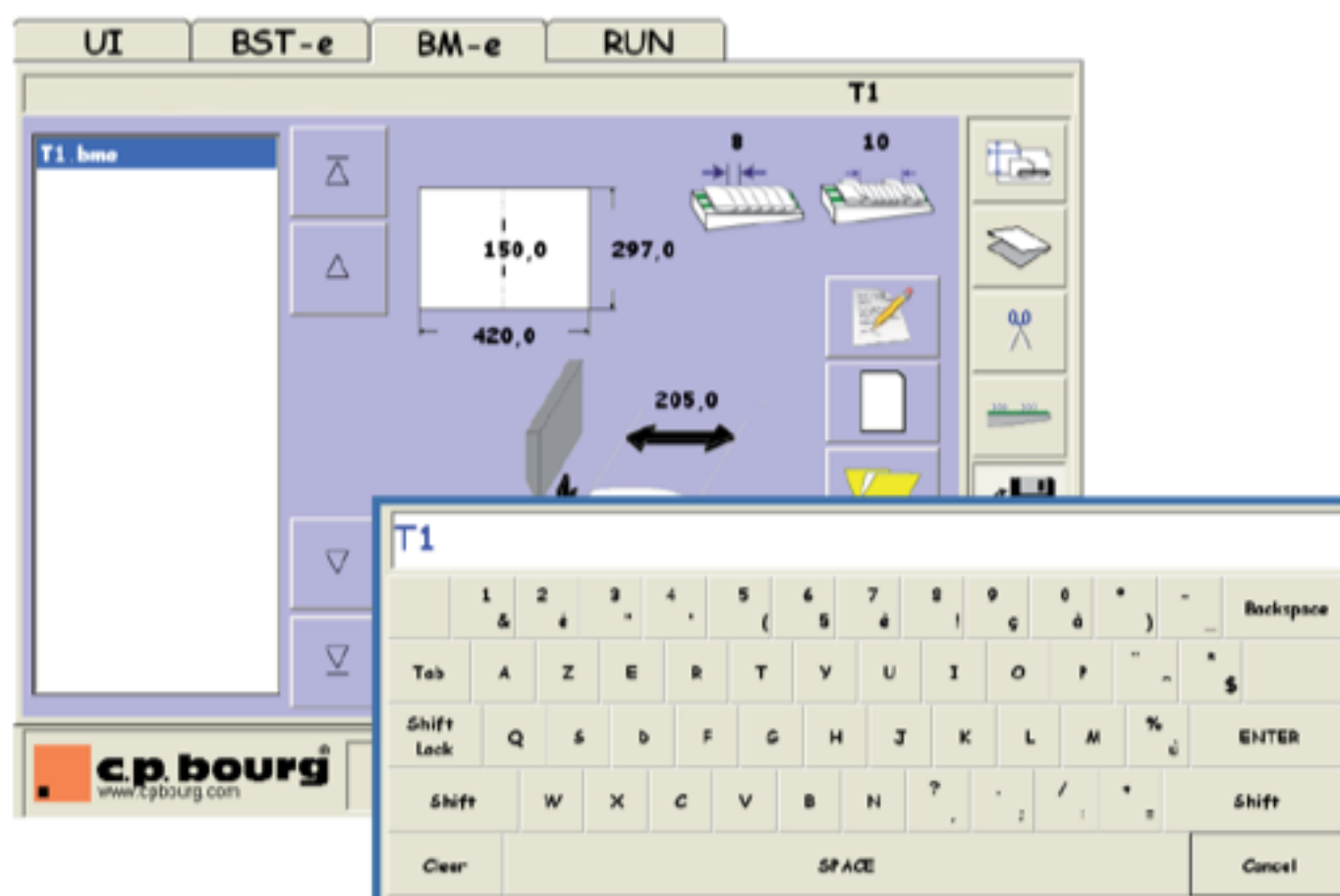
Erasing a job

This menu allows to erase an existing job.
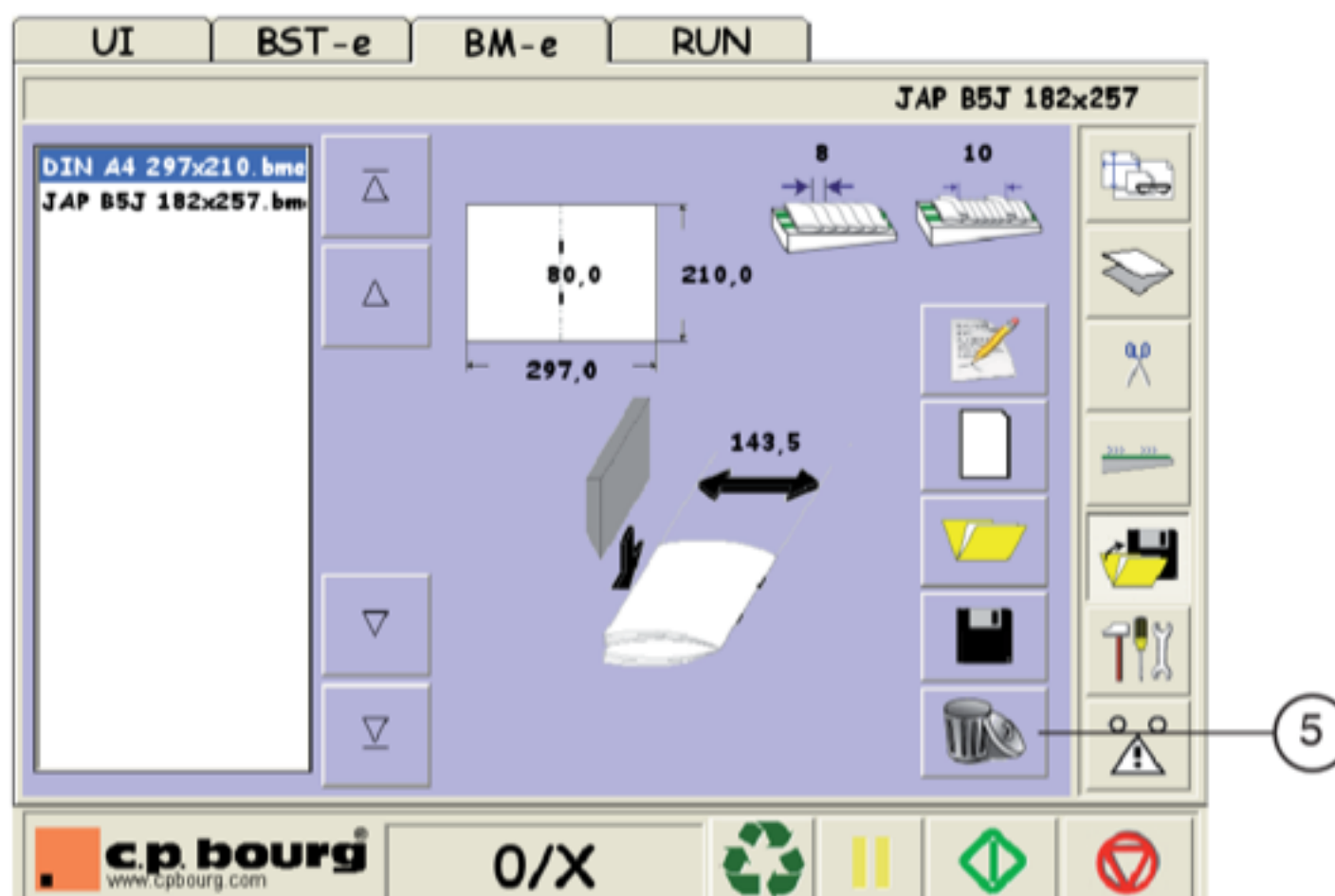
Attention: Once deleted, there is no way to recover the deleted program.

Select the job to be erased in the left column.
Press button (5).

The following screen appears.

Press OUI/YES to erase the selected job or NON/NO to cancel and return to the previous screen.

5.3.7 Preferences Menu

Calibration Set Option | Stitch Head Form | Purge Option

UI · BST-e · BM-e · RUN — 18:26:41 — A4

- Calibration Set Option
  - Always Process
  - Always Reject
- Save Adjustements
  - Disabled
  - Enabled
- Stitch Head Form
  - Normal Stitch
  - Loop Stitch
- Purge Option
  - Ask Operator
  - Always Process
  - Always Purge

Go Home · Stitch Pulse

c.p. bourg — www.cpbourg.com — 0/X
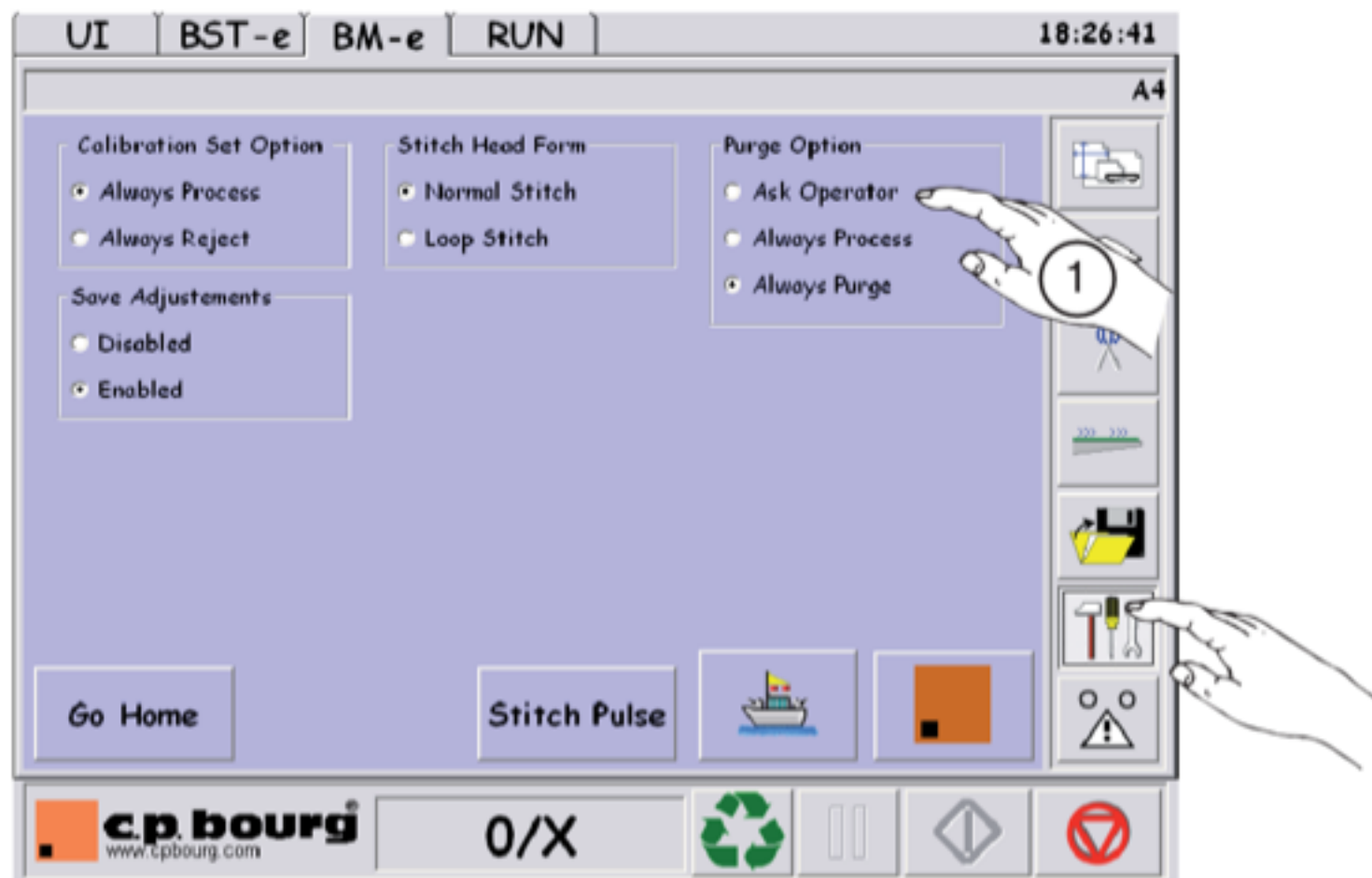
Calibration Set Option

Always Process: Always process the tower calibration set.
Always Reject: Always reject the tower calibration set. The set will be sent to the upper reception tray.

Save Adjustments
Disabled: Ask to operator to save adjustments.
Enabled: Always save adjustments.

Stitch Head Form
Select the desired stitch head form: Normal Stitch OR Loop Stitch.

Initial version : 11/08
Lastest revision : 02/10

BOOKLET MAKER E-SERIES

Purge Option

This function allows operator to purge the machine after a jam.

Sequence is the following:

1) TR purge then PA purge, booklets are processed (if possible) then sent to the output conveyor.
2) Feeder purge: The sheets will be stacked under AGR.
3) AGR purge: Depends on "Purge Option" chosen.

Always Process: Always process the booklets under AGR; The booklet (stitched, folded, trimmed) will be sent to the conveyor.
Always Purge: Always send sheets to the upper reception tray without stitching them.
Ask Operator: A screen offers the operator to make a choice between the two previous options.

Go Home

The machine goes to home position.

Stitch Pulse

1 stitch head cycle without stitch.

 Press this button to put the machine in shipping position before moving the machine.

 Allow technician to enter in the technical menu.

This menu is intended to be used exclusively by qualified technical personnel.

5.3.8 Warning screen and error messages

The warning and errors screen displays the error messages and the warning of the complete machine line.

 This button erases the indications of the screen.

 This button allows to reach the WARNING & ERRORS screen from any other screen.

Note: Some messages disappear when the error is corrected (for example: "cover open" is reset as soon as the cover is closed). But some others will continue to be displayed (e.g.: "double detected" or "cannot run program").

5.3.9 STOP button

Stops the machine in a synchronised way.

5.3.10 Start button

Starts the job.
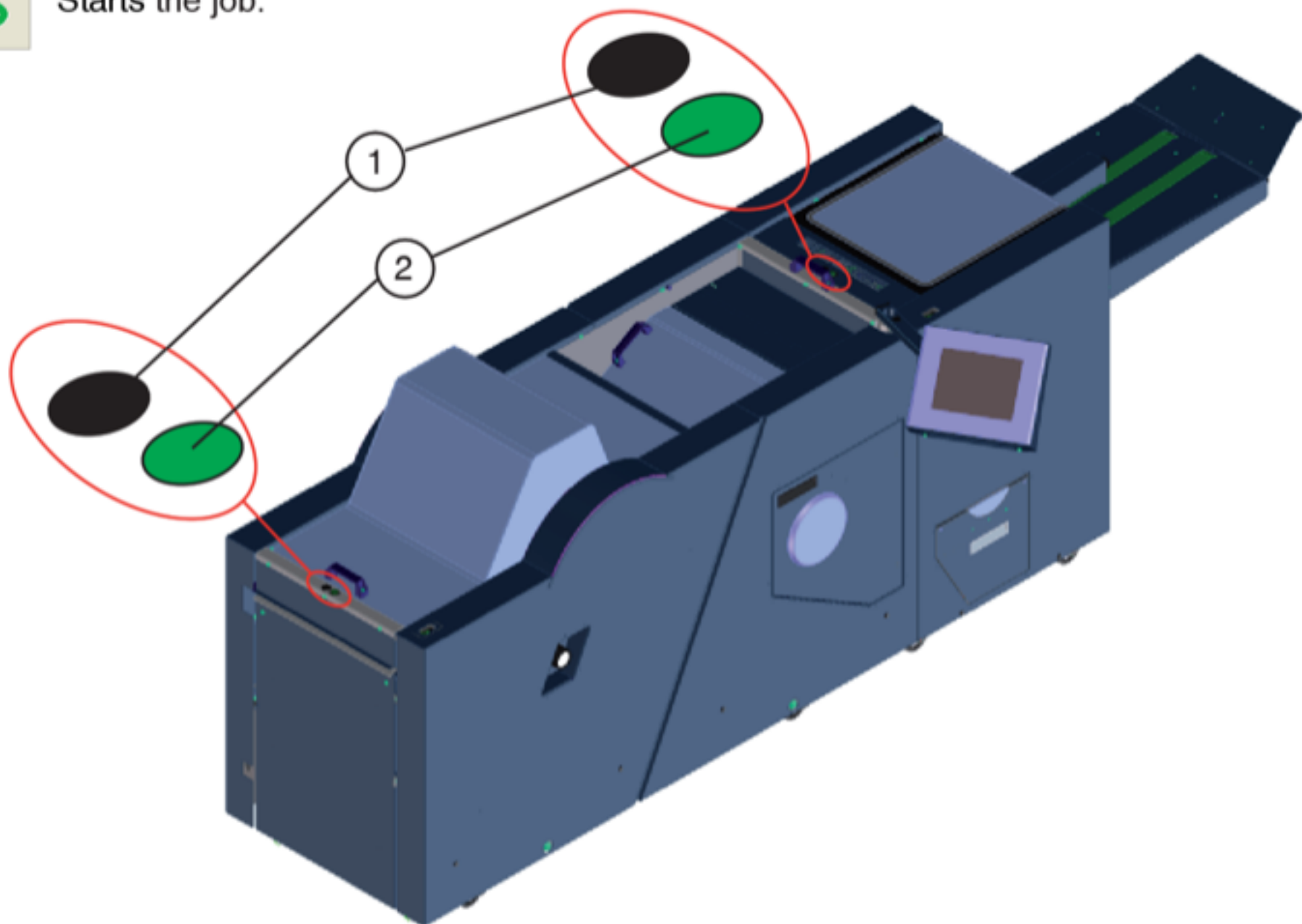
Note: Both fonctions STOP and START are accessibles from UI and on the machine. Both buttons (1) are used to stop the machine and the (2) buttons to START the machine.

5.3.11 Pause button

The pause button stops the sheets feeding without stopping the turbines and belts. Allows restarting the job faster (only with BST-E).

5.3.12 Purge button

This function allows to clear the machine after a stop (jam). See chapter 5.3.7 Preferences Menu for details.

5.3.13 Counter of set (configuration BST-e / BM-e)

- Press (1) button to open the "counter" screen.

BOOKLET MAKER E-SERIES
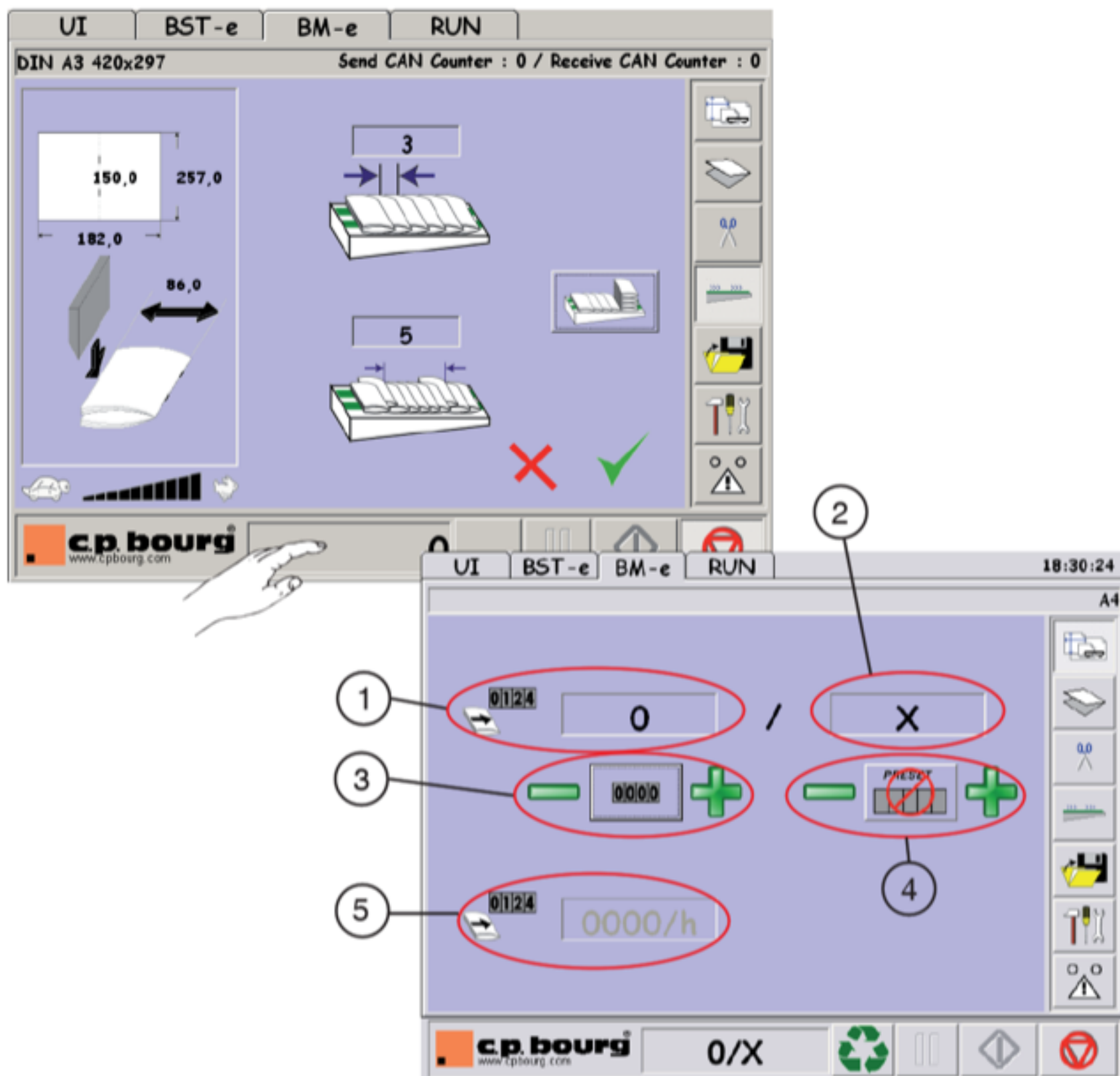
1 - This counter displays the total number of sets already done for the running job. Press the button to enter a number of sets already made.

```
0124

            0

 7    8    9    CLR

 4    5    6    ✗

 1    2    3    ✓

 0    —    ,
```

2 - Number of sets pre-defined. 0= X= infinity preset.

```
PRESET

            0

 7    8    9    CLR

 4    5    6    ✗

 1    2    3    ✓

 0    —    ,
```

3 - Press this button to reset the counter to zero. Press button + or - to increase or decrease the counter by 1.

4 - Activate or desactivate the preset. Press button + or - to increase or decrease the counter by 1.

5 - Productivity display.Numbers of sets on conveyor by hour

BOOKLET MAKER E-SERIES

5.3.14 U.I. version and update history

Simple clic on the CP Bourg area gives you the U.I. version and update history.

5.4 RUN screen options

The RUN screen allows you to perform some fine adjustments while machines are running.
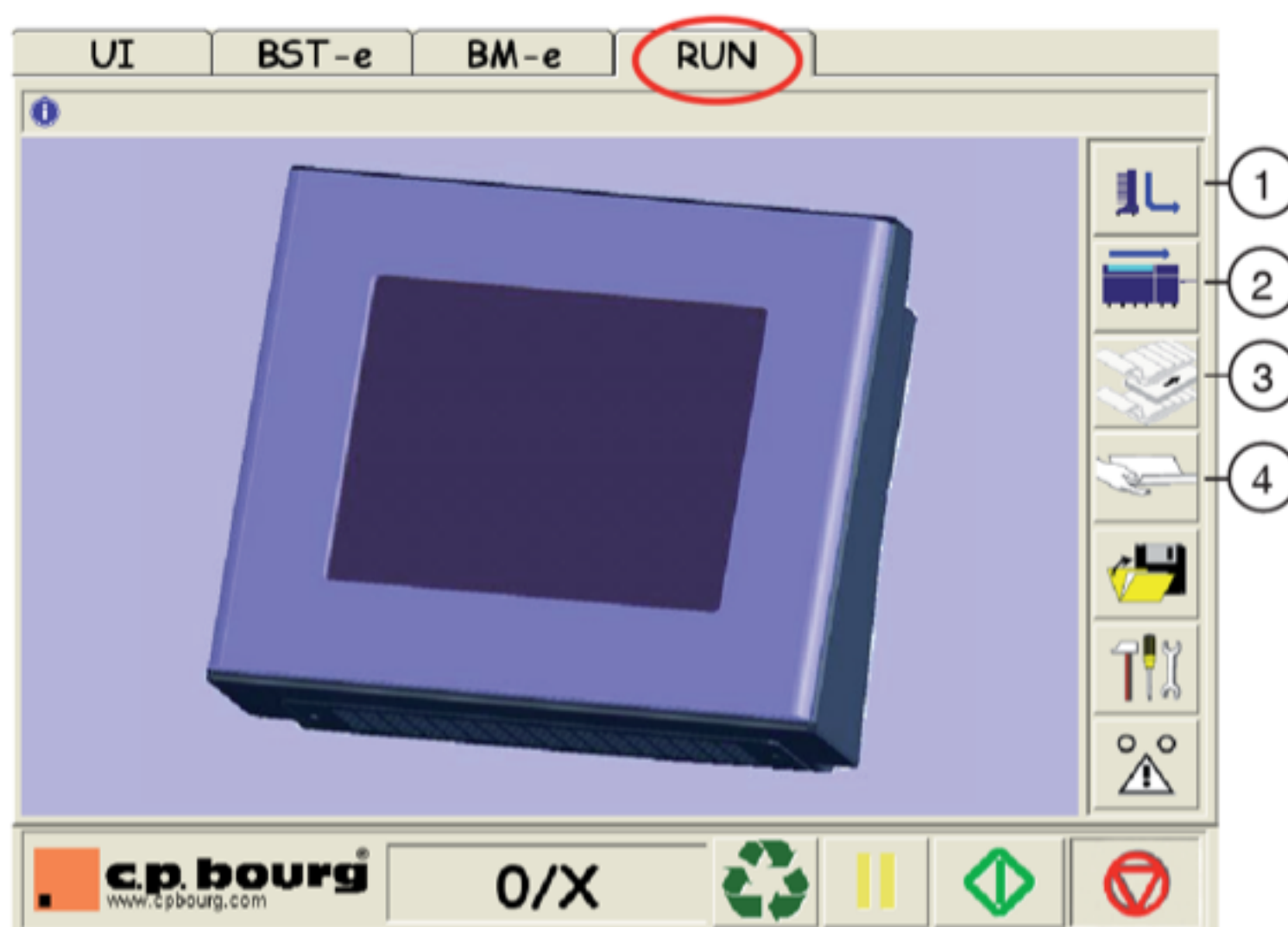
1 - BSTE-e ADJUSTMENTS IN MODE RUN.
   (see operator manual BST-e)

2 - BM-e ADJUSTMENTS IN MODE RUN:

3 - MARRYING TABLE:
   This function allows to add a sheet or a block of sheets in a set.

4 - MANUAL INSERTION:
   Allows to insert sheet manually to execute a job in the BM-e.

5.4.1 BST-e adjustments in RUN mode

Press the button to access to the setting parameters.
This menu gives an overview and allows parameters adjustemnt while machines are running.
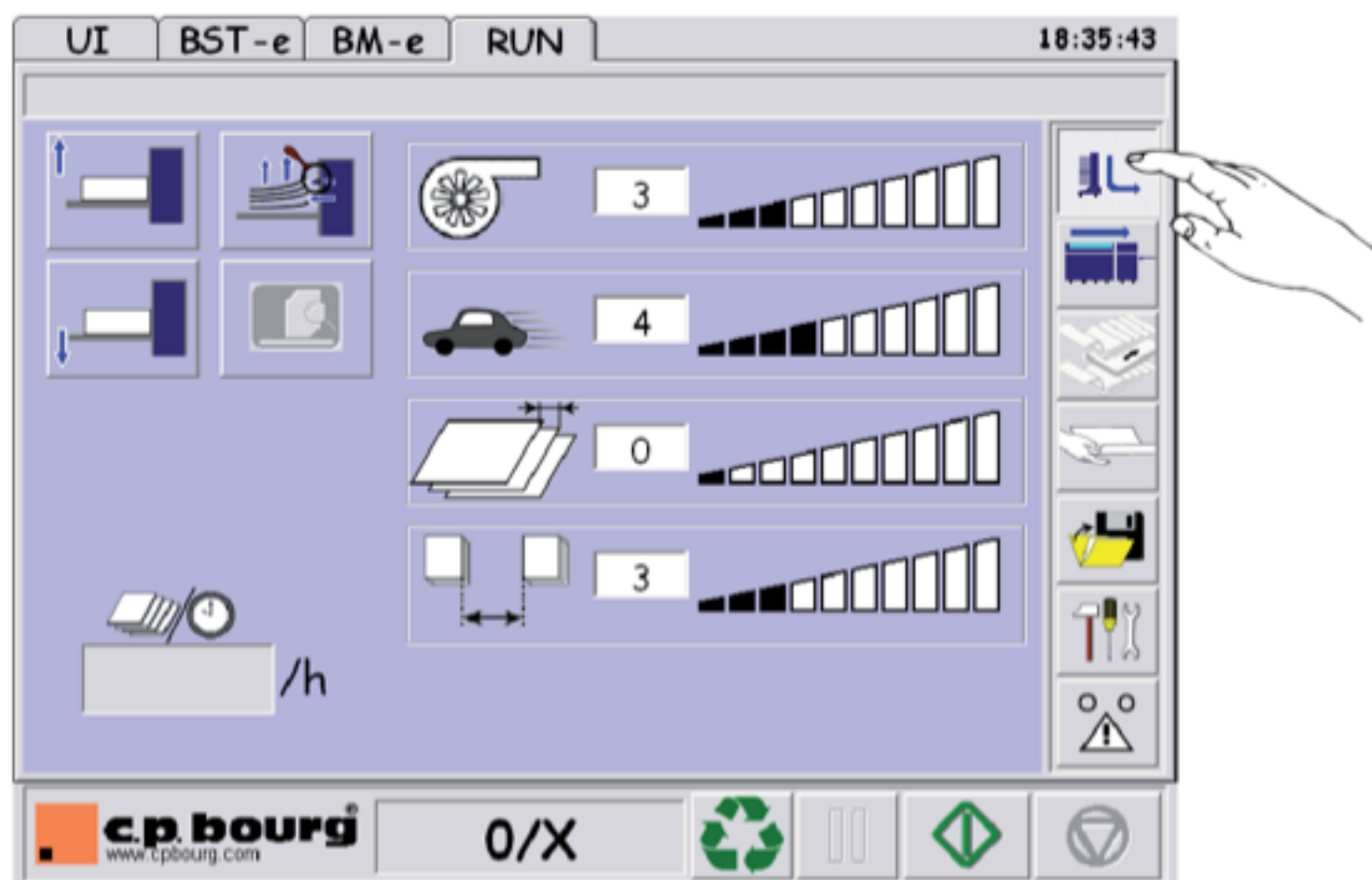
These adjustments are described in the BST-e Operator Manual.

BOOKLET MAKER E-SERIES

5.4.2 BM-e adjustment in RUN mode

This menu gives an overview and allows parameters adjustment while machine is running.
Press the BM-e button to access to the setting parameters.
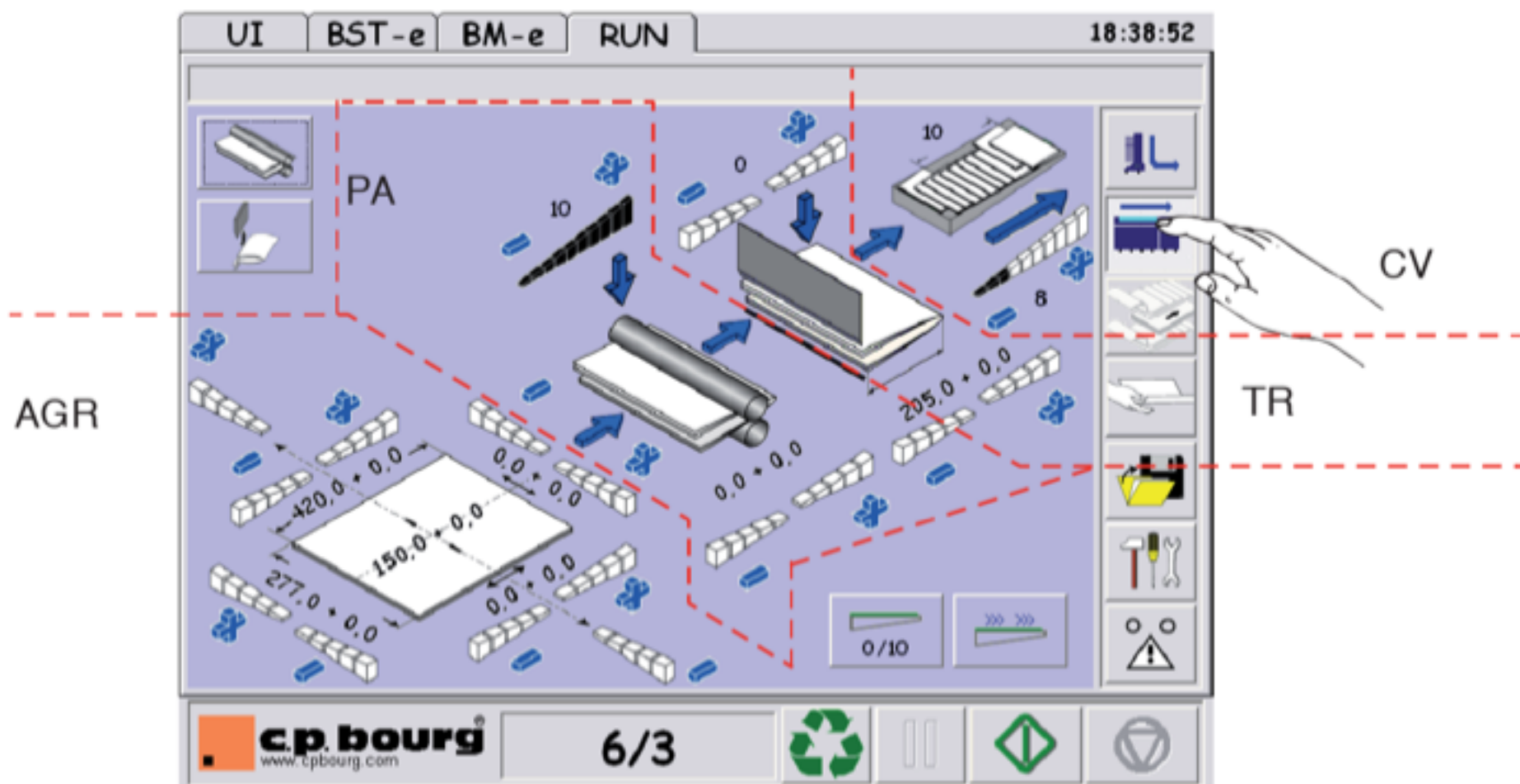
Four areas for adjustments are available:

- AGR area for paper format and stitching.

- PA area for folding.

- TR format for trimming.

- CV area for conveyor.

This buttons are used as described below:

0/10	Press this button to reset the counter conveyor value and force the offset of a booklet.
	Conveyor forced advance: This command can also be activated by the pedal (if present).
	Activation and deactivation of the folding (and so of the trimmer). When this function is deactivated, the next set will come out in the upper receiving tray.
	Activation and deactivation of the trimmer. When this function is deactivated, the next set will come out on the conveyor but not trimmed.
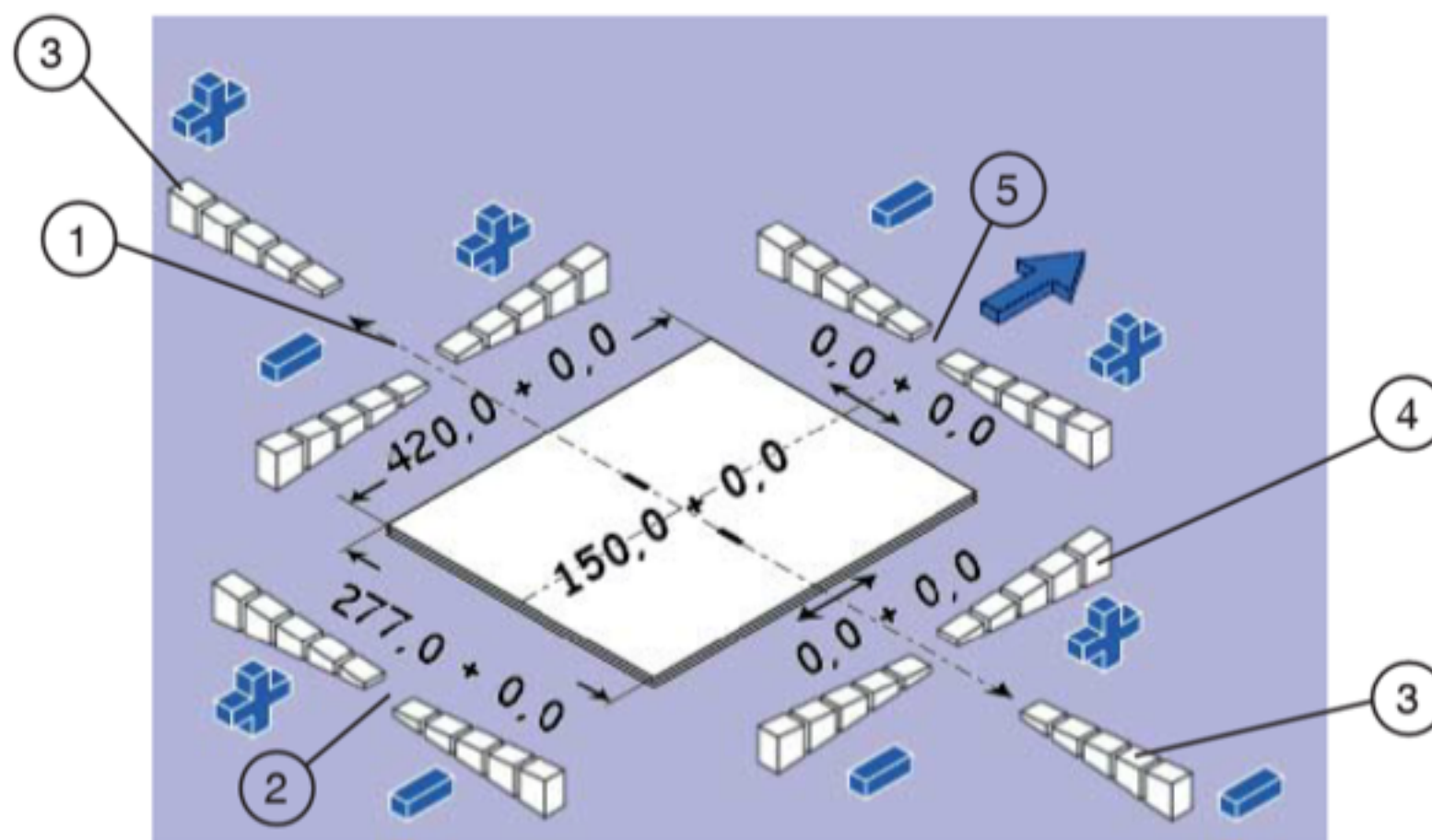
Adjustment of the stitcher while running (AGR).

1. Adjustment on paper length, maximum modification ± 3mm.

2. Adjustment on paper width, maximum modification ± 3 mm.

3. Adjustment on stitch spacing, maximum modification ± 3mm.

4. Adjustment on stitch position on paper length.

    + Stitches offset to the paper front, maximum modification ± 3mm.
    – Stitches offset to the paper rear, maximum modification ± 3mm.

5. Adjustment on stitch position on paper width.

    + Stitches offset to the paper right, maximum modification ± 3mm.
    – Stitches offset to the paper left, maximum modification ± 3mm.

PA area: Folder adjustment while running
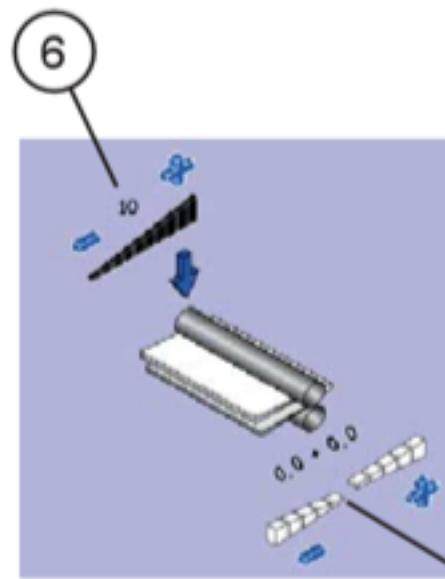
6 - Folding pressure adjustment (maximum by default).

7 - Fold position adjustment in relation to stitches.
+ Final booklet upper face will be longer.
- Final booklet lower face will be longer.

Maximum modification ± 1,5mm

TR area: Trimmer adjustment while running
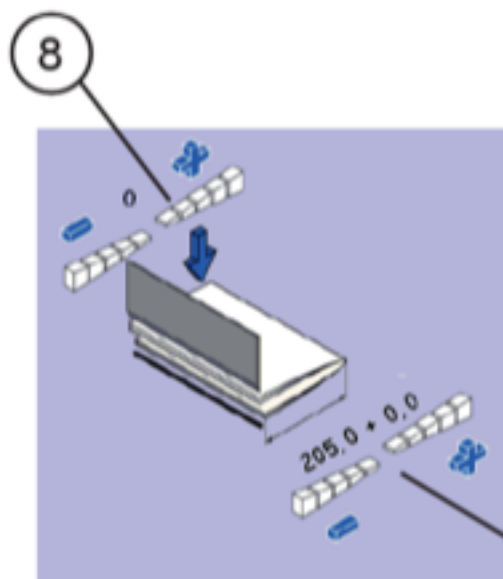
8 - Trimmer conveyor height adjustment.
+ Minimum height.
- Maximum height.
9 - Booklet final length adjustment.
 Maximum modification ± 3mm.

CV area: Conveyor adjustment while running
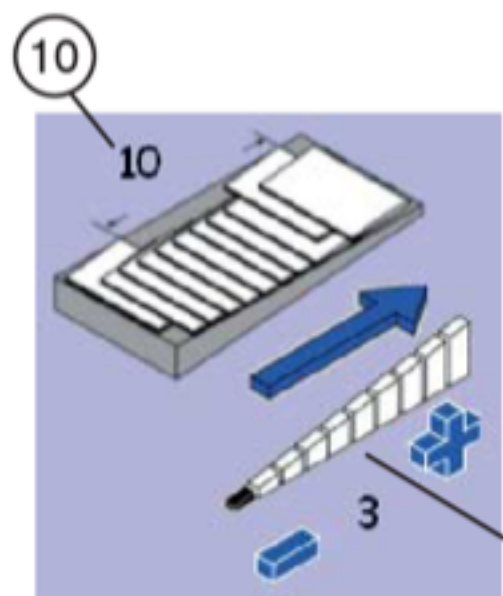
10 - Offset value correction.

11 - Conveyor advance correction.

5.4.3 Manual feeding

This function allows to feed sets manually in the BM-e.
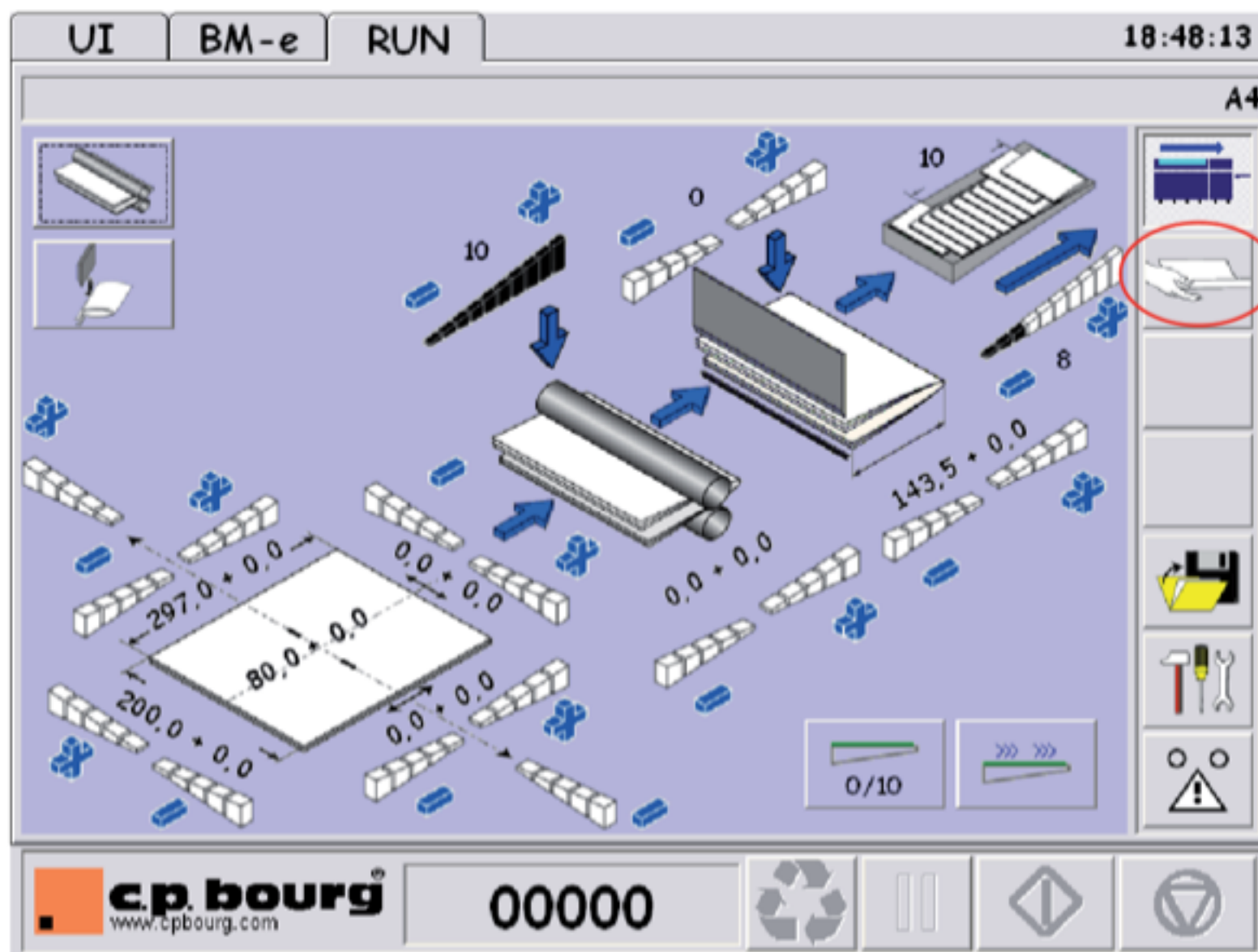
Select RUN menu, then the manual feeding screen. You will see hereunder screen :

BOOKLET MAKER E-SERIES
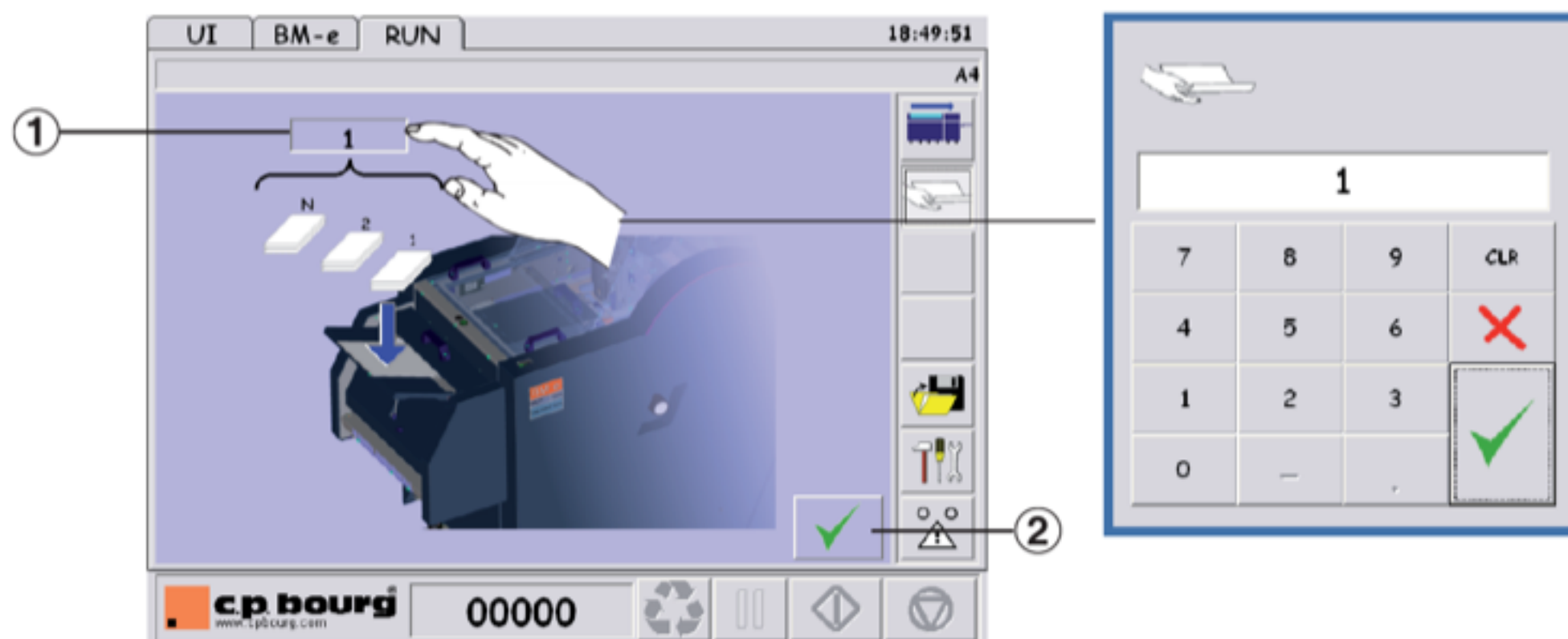
- Press (1) to have access to the numerical keypad.

- Enter the number of sheets or blocks of sheets to compose the set (pay attention to the limitations). Validate with ✓ .

- Validate the function by pressing button (2). The manual feeding button becomes orange.

- Press START button from RUN menu. The button will only be activated if a job has previously been validated.

- Lift the BMe entry tray (fig 1).

- Adjust the guides to paper size (fig 2).

- Insert the sheets or the blocks of sheets.
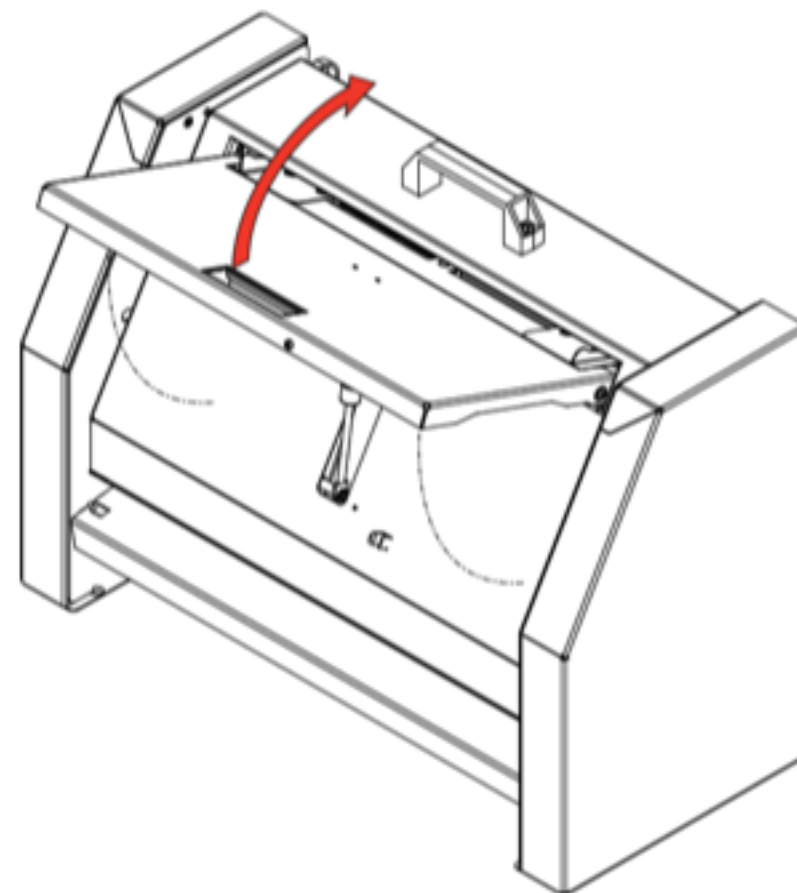
Fig.1
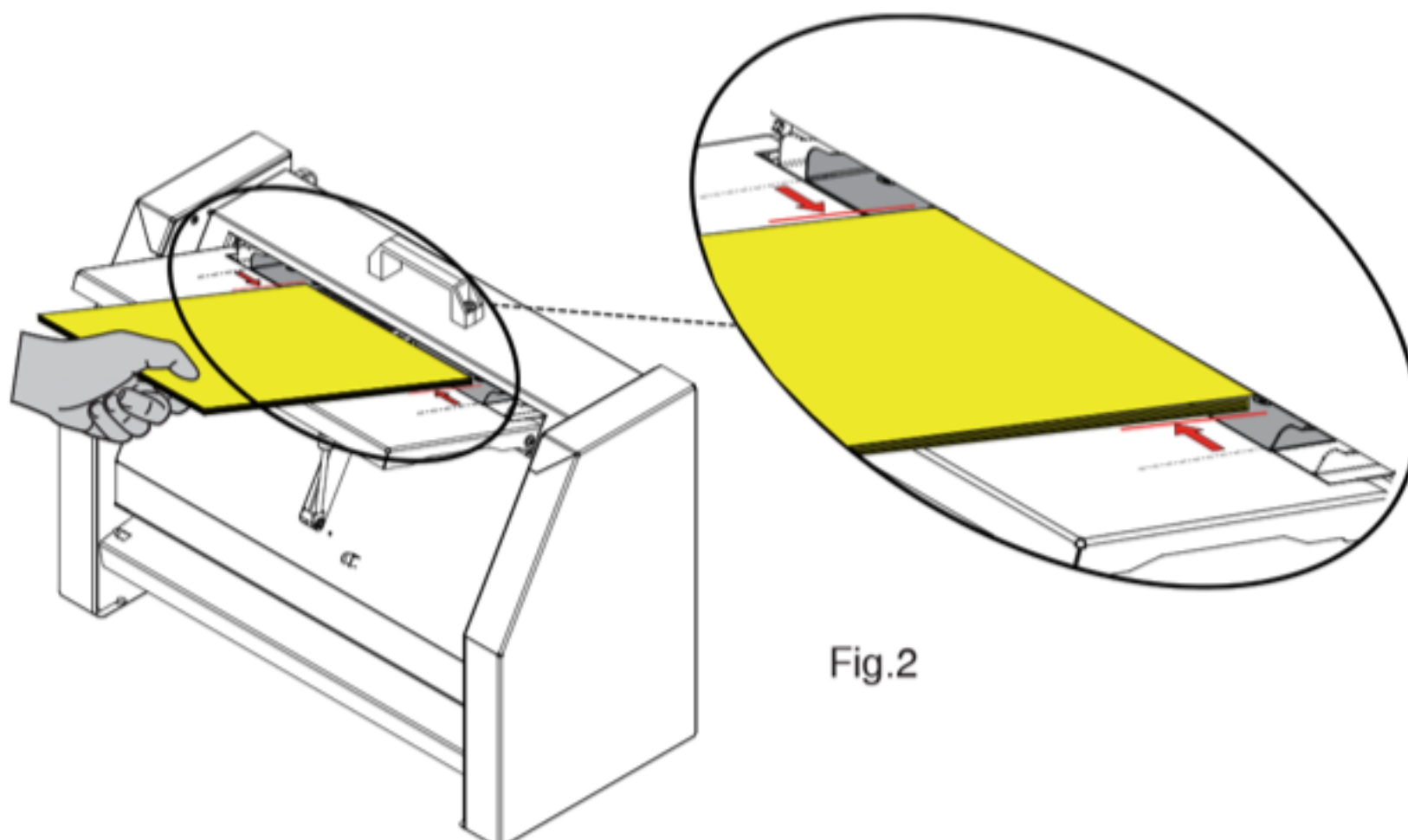
Fig.2
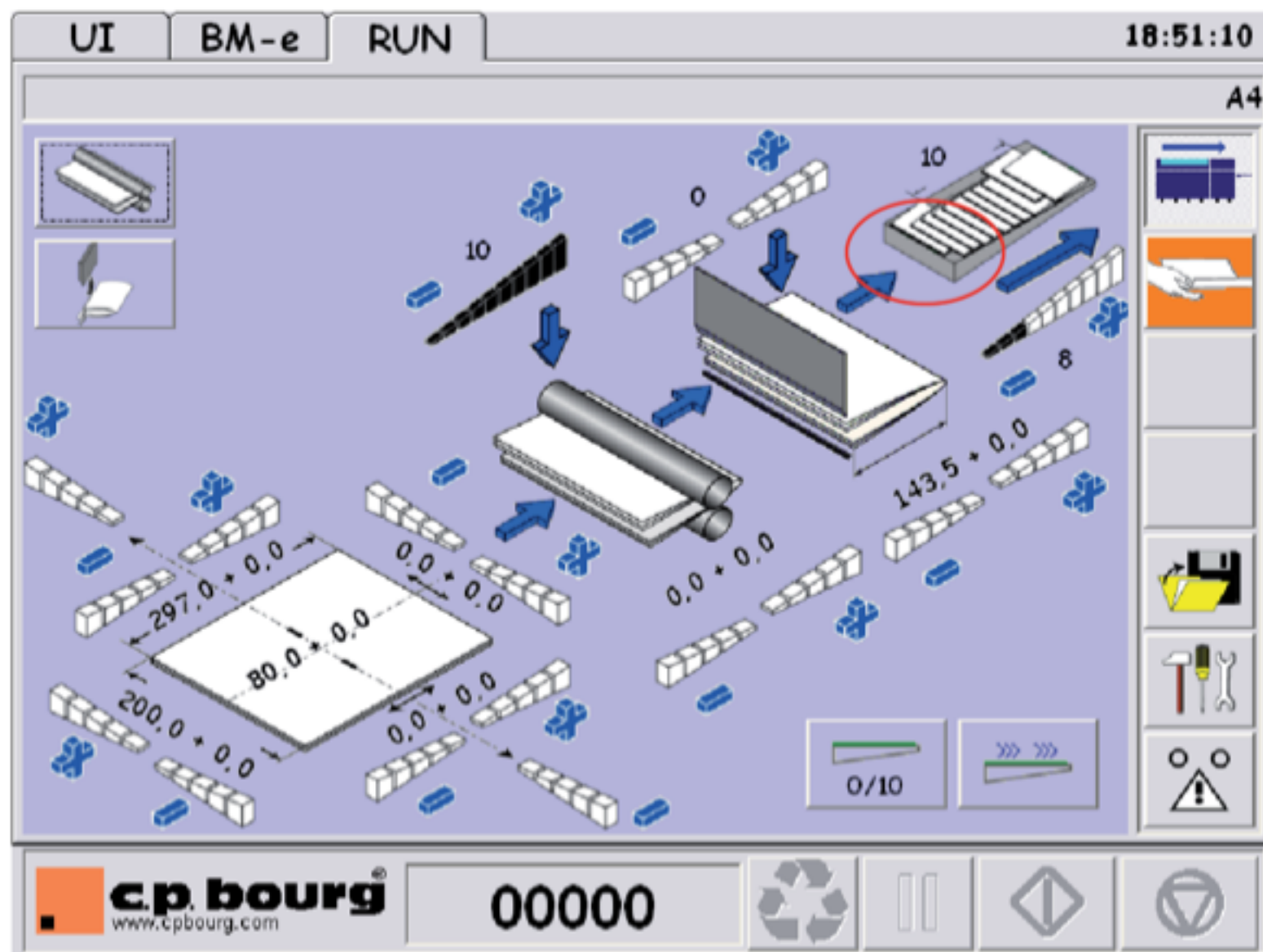
You may get back to the other screens any time.
The button will then become orange to show you that you are in manual feeding mode.

- Press STOP button 🛇 to stop the machine
- Press manual feeding button, then the "X" button to leave the manual feeding function.

For the BME:

Switch off the machine.
Open the upper cover and the doors.

Daily maintenance

1. Remove the metal parts (stitches) from clinchers by pushing on the handle 3 times. If you do not do it there is a risk of poor stitching or jam.
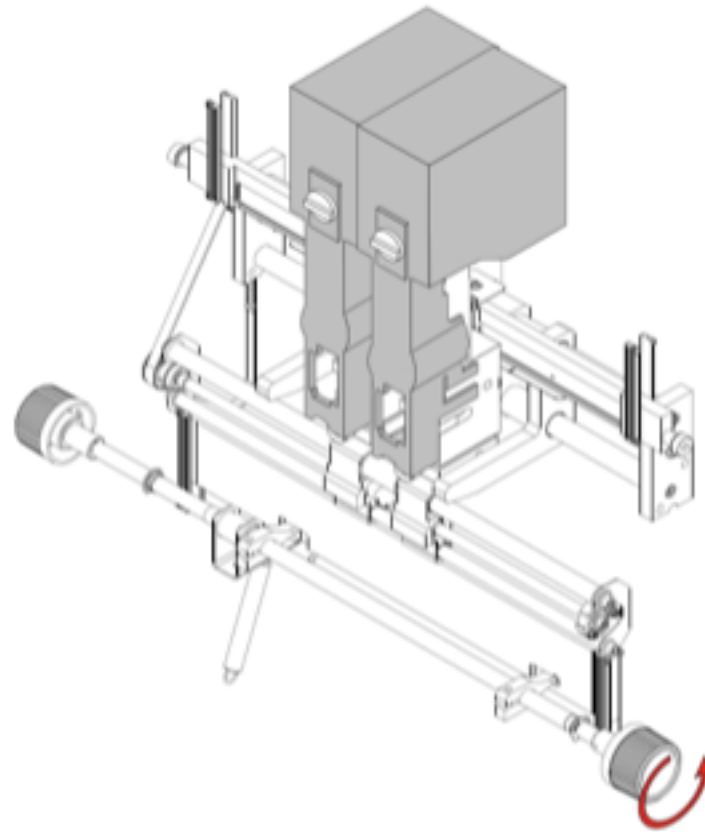
2. Empty the waste bin. If you do not do there is a risk of machine stop with the error message "waste bin full". Lift up to pull the bin.

Note: _it is possible to empty the waste bin during the running of the machine. The machine will stop if the bin is not back after 50 cycles_

Initial version : 11/08
Lastest revision : -

BOOKLET MAKER E-SERIES
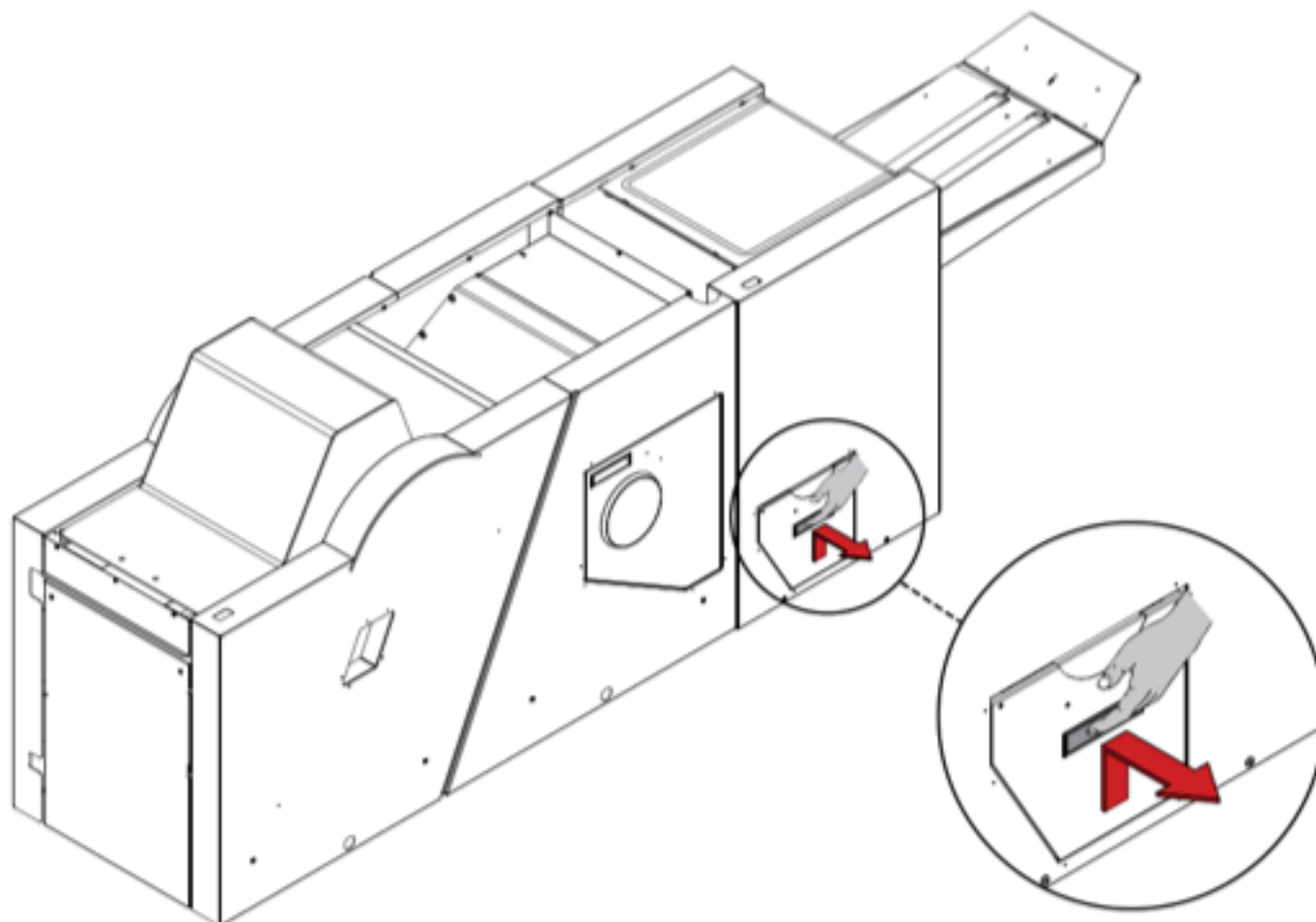
Weekly maintenance

1. Clean the belts, the transport wheels with a cloth and a specific cleaning solution. If you do not do it there is a risk of smeared sheets.

2. Clean the threaded rod of the stitching heads with a brush. If you do not do it there is a risk of not smooth movement.
    Never grease the threaded rod.

3. Refer to head manual for maintenance.
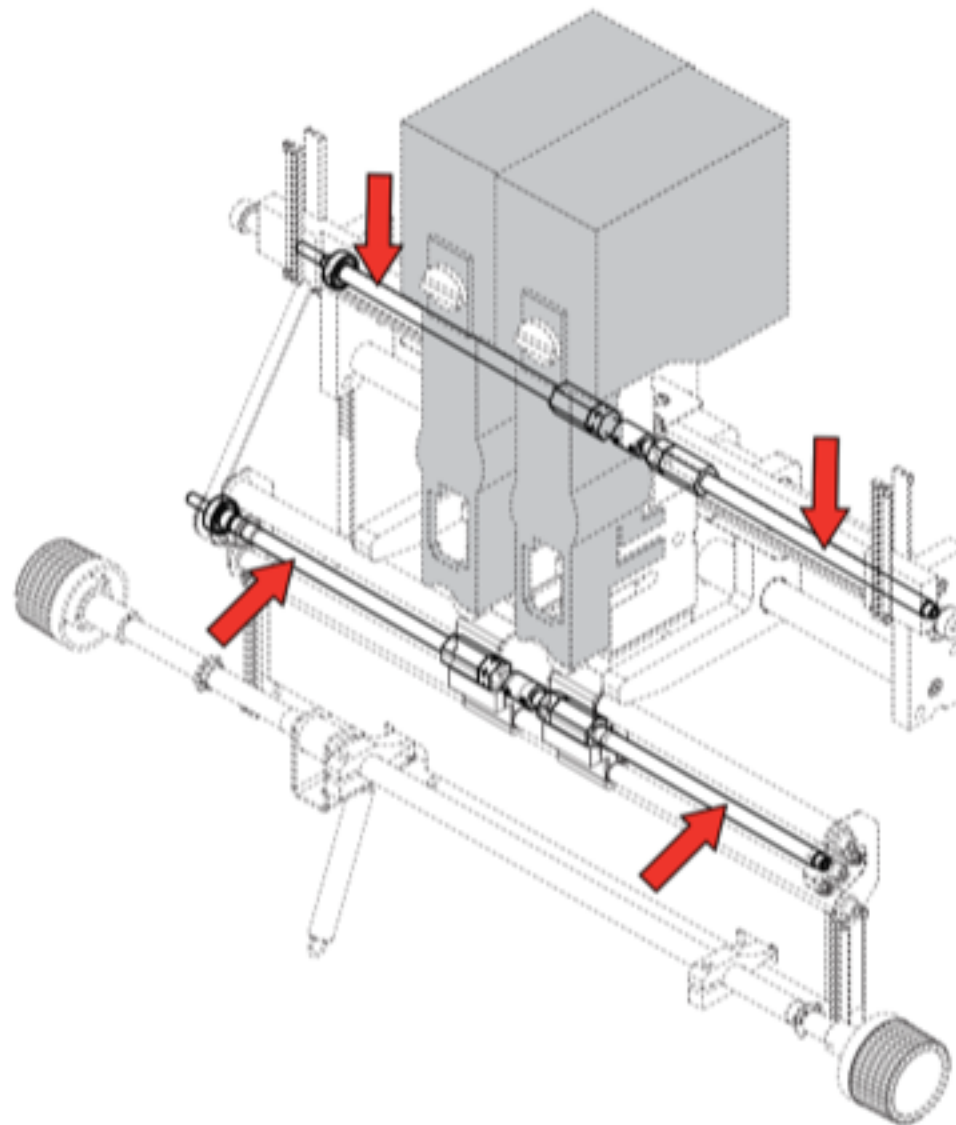
Monthly maintenance
Refer to head manual for maintenance.

Every 3 month maintenance
Clean stop fingers of the stitching area with compressed air and then offset cleaner with cotton cloth. If you do not do it there is a risk of jam due to stop jamming.
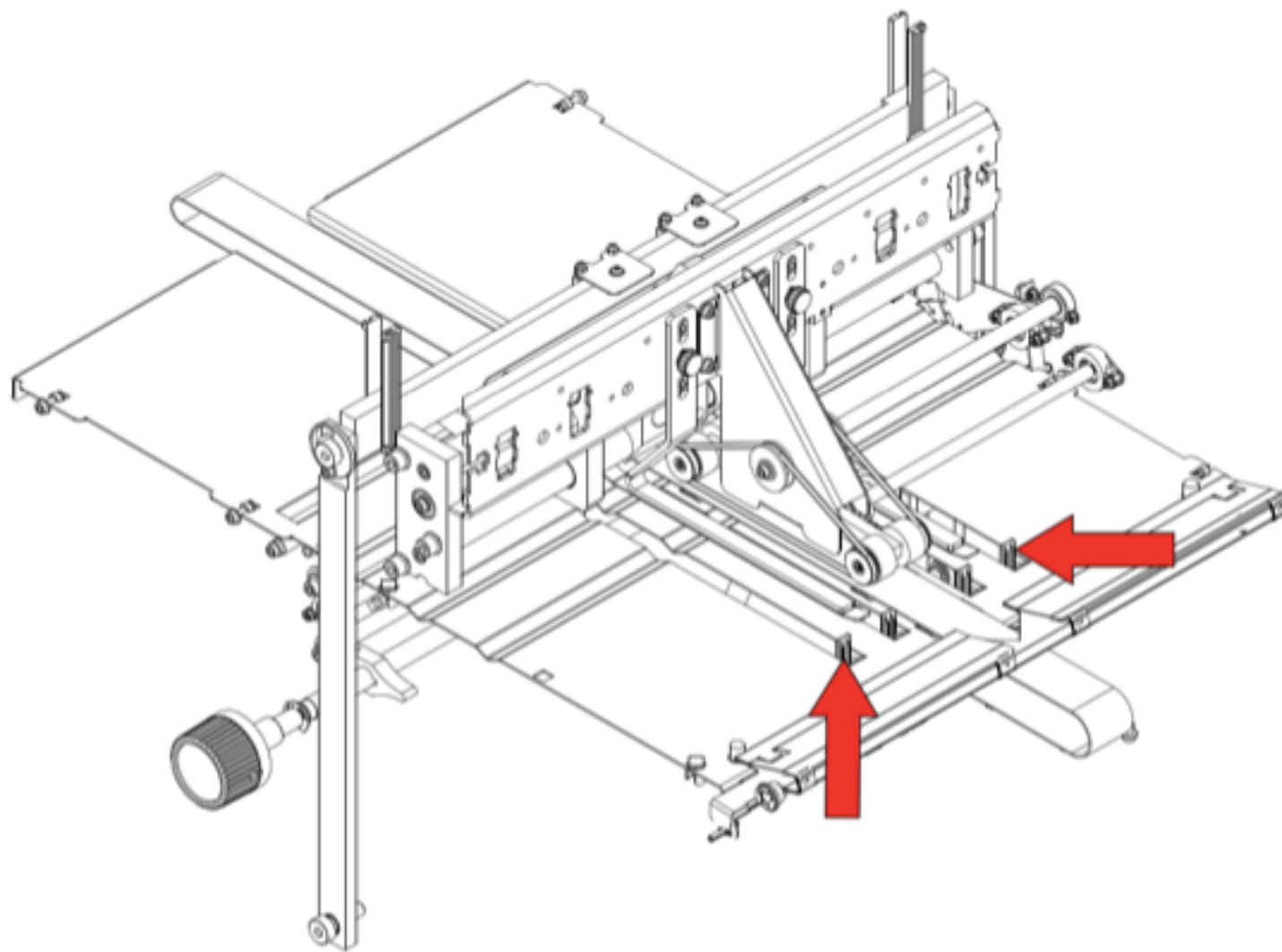
7.1 Squaring and stoppers

The following adjustments of the joggers and stops from the different modules allows to correct a paper default and the squareness of the fold.

7.1.1 Stitcher joggers squareness adjustment
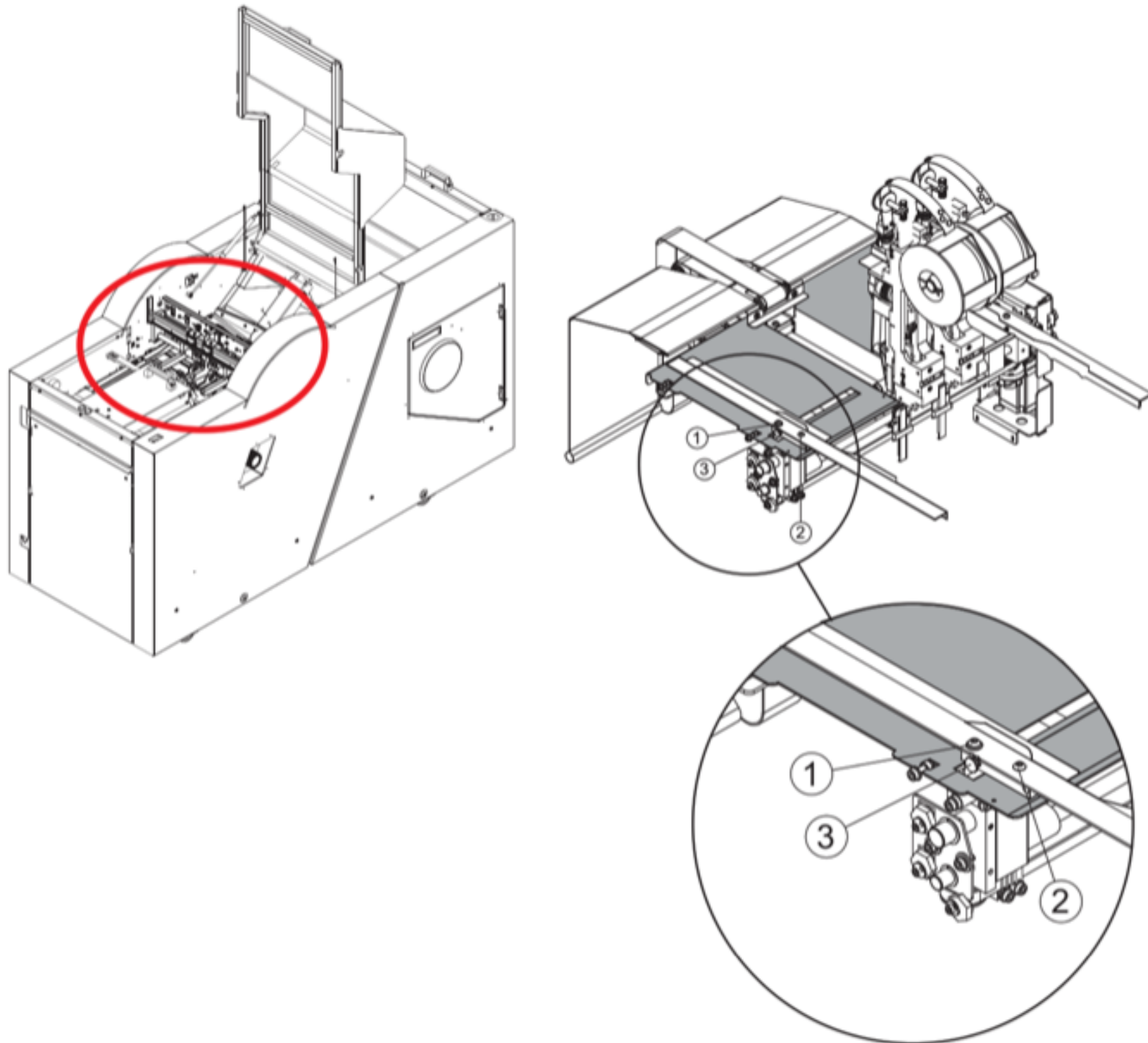
- Slighty unscrew the screws (1) and (2).

- Turn the knob (3) to change the jogger squareness.

- Tighten the screws (1) and (2).

7.1.2 Stitcher joggers squareness adjustment

- Adjust the squareness using screw (A).
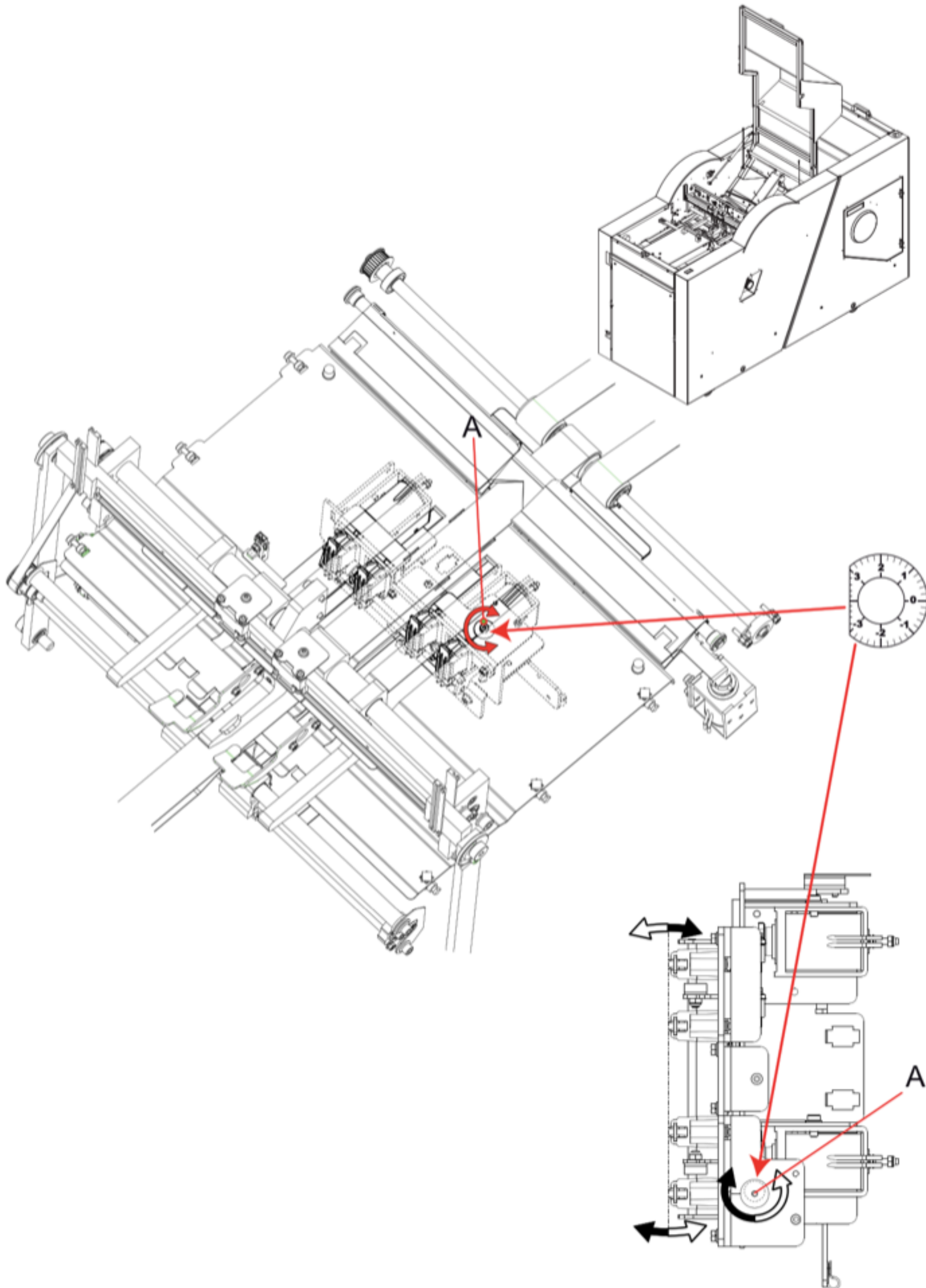
7.1.3 Folder trays squareness adjustment

- Adjust the squaresess using the knob (A).

(A)

7.1.4 Trimmer stop squareness adjustment

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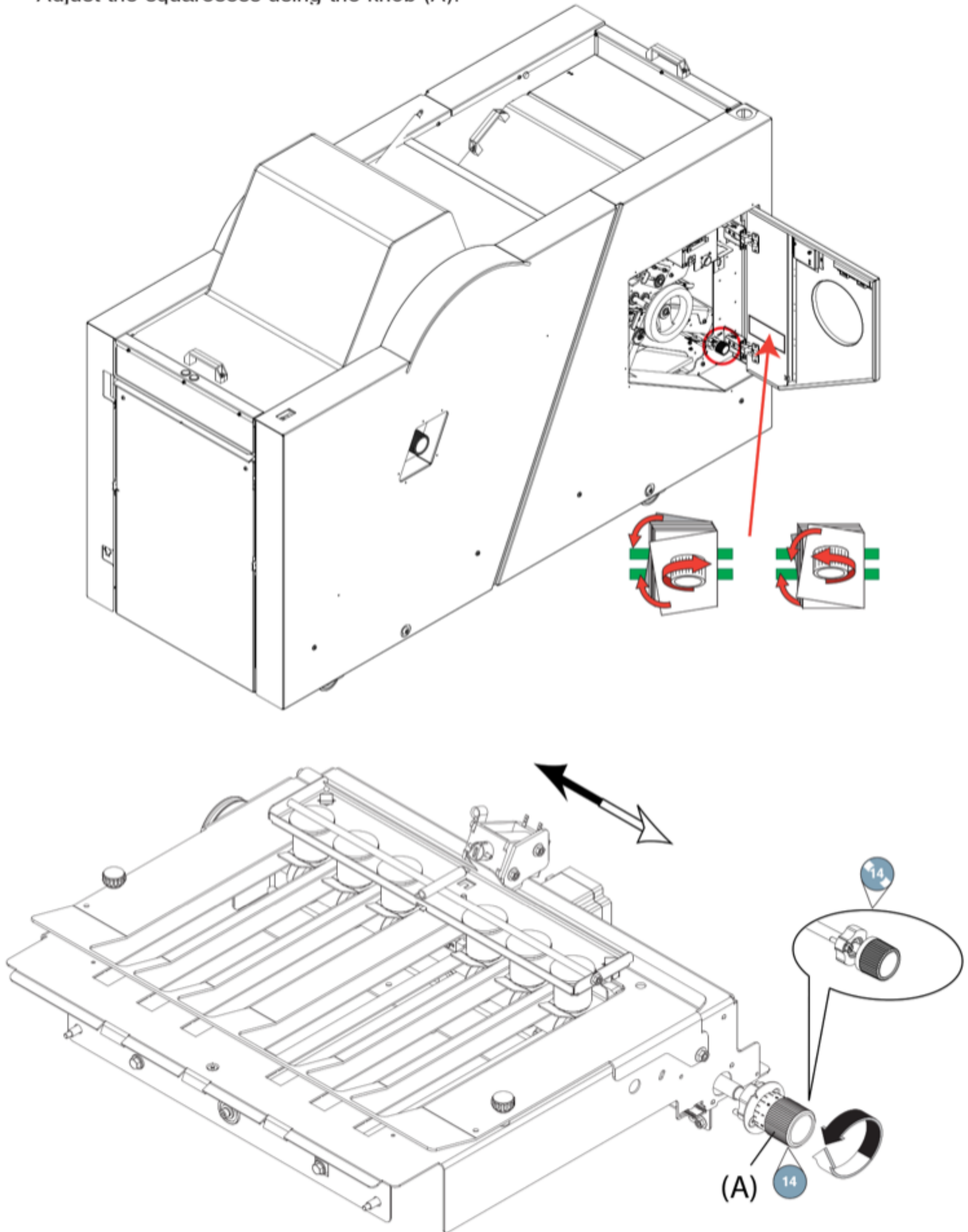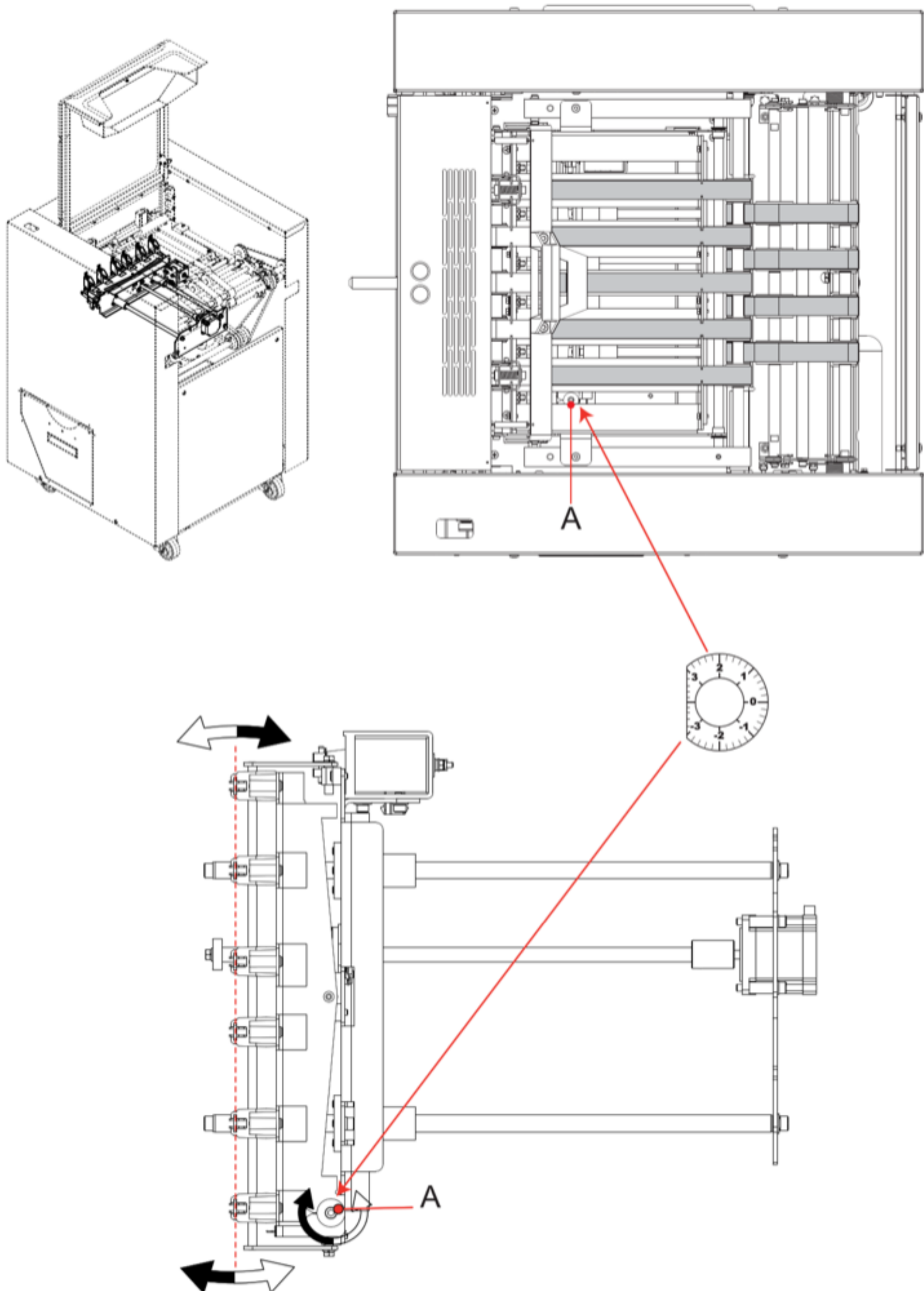
7.2 Trimmer stop squareness adjustment

The wheels position adjustment is done automatically, but a manual adjustment is possible using the (A) button.

7.3 PA ball replacement

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Lastest revision : -

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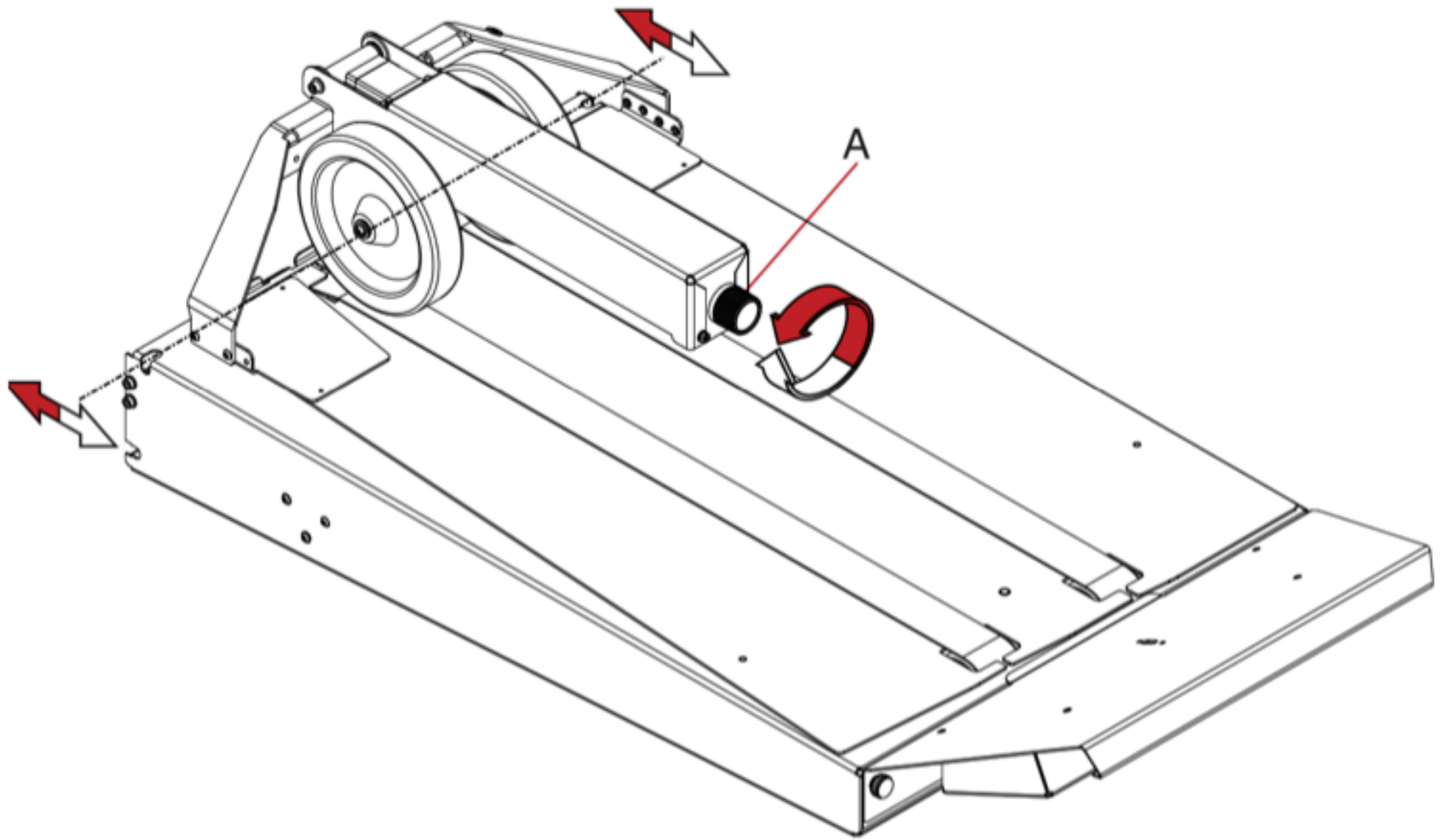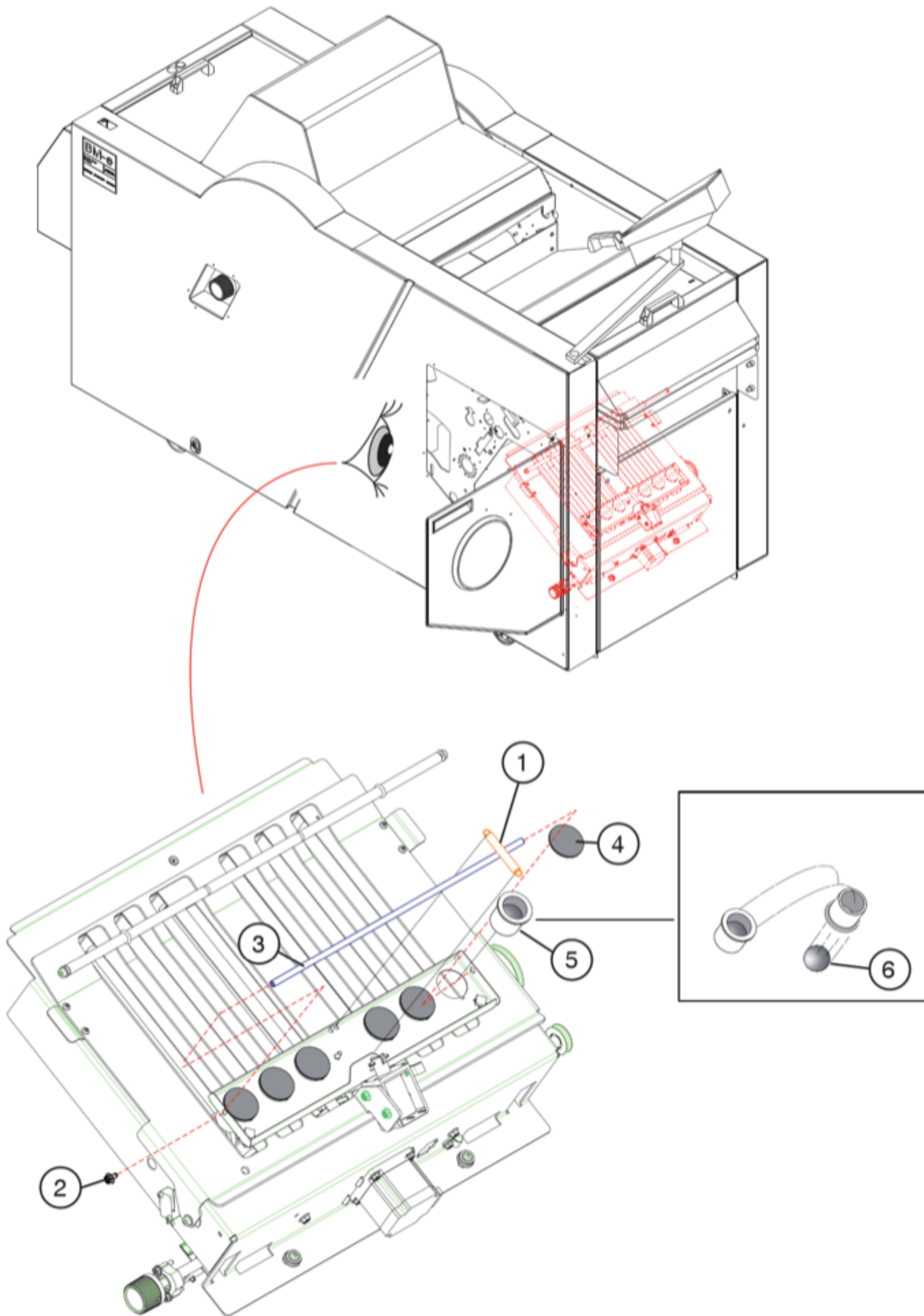
Product recycling and Disposal

ENGLISH:

Application of this symbol on your equipment is confirmation that you must dispose of this equipment in compliance with agreed national Procedures.

In accordance with European legislation dealing with "end of life electrical and electronic equipment", equipment subject to disposal must be managed within agreed procedures.

Prior to disposal please contact your local representative for end of life take back information.

FRANÇAIS:

La présence de ce symbole sur cet équipement indique que ce dernier doit être mis au rebut selon les conventions nationales.

Conformément à la législation européenne, tout équipement électrique et électronique en fin de vie et destiné au rebut doit être manipulé selon les procédures convenues.

Veuillez contacter votre distributeur pour en savoir plus sur la reprise du matériel avant toute mise au rebut.

ESPAÑOL:

La aplicación de este símbolo en el equipo es una confirmación de que en el momento de deshacerse de este equipo debe de hacerlo de acuerdo con los procedimientos nacionales acordados.

La legislación europea exige que para deshacerse de equipos eléctricos y electrónicos al final de su duración útil deben seguirse los procedimientos acordados.

Antes de deshacerse de un equipo póngase en contacto con su distribuidor local o con el representante para obtener información sobre su devolución.

DEUTSCH:

Geräte die dieses Symbol tragen, müssen den nationalen Richtlinien gemäß entsorgt werden.

Den europäischen Bestimmungen zum Umgang mit elektrischen und elektronischen Altgeräten ist Folge zu leisten.

Bei der Entsorgung des Geräts den Partner kontak-tieren.

ITALIANO:

Questo simbolo applicato sulla macchina indica la necessità di smaltire il prodotto in conformità con le normative nazionali vigenti.

La legislazione europea richiede che lo smaltimento dei dispositivi elettrici ed elettronici a fine vita venga gestito in conformità con le normative vigenti.

Prima di smaltire il dispositivo, rivolgersi al rivenditore autorizzato di zona per informazioni sul ritiro dei prodotti a fine vita.

NEDERLANDS:

De aanwezigheid van dit symbool op uw apparatuur geeft aan dat u zich van deze apparatuur moet ontdoen overeenkomstig de daarvoor in het betreffende land geldende procedures.

Krachtens de Europese wetgeving moet de verwerking van afval van gebruikte elektrische en elektronische apparatuur geschieden overeenkomstig de daarvoor geldende procedures.

Neem voordat u de apparatuur wegdoet contact op met uw plaatselijke dealer of vertegenwoordiger voor informatie over inzameling.

NOTES

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