

Operation guide



Océ BLM550⁺



A CANON COMPANY

Canon

Production Systems - Cutsheet

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Chapter 1

Preface

Notes for the reader

Introduction

This manual helps you to use the Océ BLM550⁺. The manual contains a description of the product and guidelines to use and operate the Océ BLM550⁺.

Definition

Attention-Getters








Parts of this manual require your special attention. These parts can provide the following:




- Additional general information, for example, information that is useful when you perform a task.
- Information to prevent personal injuries or property damage.

Symbols used in this manual

The following symbols are used in this manual to explain procedures, restrictions, handling precautions, and instructions that must be observed for safety.

Overview of the attention getters

Word	Icon	Indicates
WARNING		Indicates a warning concerning operations that may lead to death or injury to persons if not performed correctly. To use the machine safely, always pay attention to these warnings.
CAUTION		General hazard Indicates a caution concerning operations that may lead to injury to persons if not performed correctly. To use the machine safely, always pay attention to these cautions. This indication has several icons that warn against various hazards. The icons are shown below.
		Hot surface
		Electric shock
		Moving parts
		Laser beam
IMPORTANT		Indicates operational requirements and restrictions. Be sure to read these items carefully to operate the machine correctly and to avoid damaging the machine or property.

Word	Icon	Indicates
NOTE		Indicates a clarification of an operation or contains additional explanations for a procedure. Reading these notes is highly recommended.
		Indicates an operation that must not be performed. Read these items carefully and make sure not to perform the described operations.
		The use of heat-resistant gloves is mandatory when you carry out the actions concerned.

Safety information

Before using this Océ product, make sure that you read and understand the safety information which is part of the user documentation. You can download the safety information via "<http://downloads.oce.com>" or, if applicable, find it on the user documentation CD/DVD that is delivered together with the machine or obtain the safety information from your local Océ representative. To avoid potential hazards, maintenance is strictly preserved to properly qualified and trained service technicians.

Chapter 2

Introduction to the Booklet maker

Introduction

Introduction

This User Manual is applicable to all model Océ BLM550⁺ booklet makers from serial number 0800 onwards with software version 4.x. You can attach the optional Book Stacker to the Océ BLM550⁺ booklet maker. It is possible to retrofit the optional Book Stacker to the Océ BLM550⁺ models.



CAUTION

A CAUTION message tells you that a procedure or operation can be dangerous. To prevent injury, you must follow the instructions.



IMPORTANT

An IMPORTANT message tells you that a procedure or operation can damage the machine or the product. To prevent damage, you must follow the instructions.

Documentation

Your Manual

The User Manual for the Booklet maker describes how to perform these tasks:

- Operate the Booklet maker
- Find and correct error conditions
- Perform normal maintenance tasks

Operator training is given when the Booklet maker is installed. To make sure you use your Booklet maker correctly, read your manual.

The User Manual for the Booklet maker does not describe the operation of the printer. If needed, refer to your printer user manual.

Safety Information

Safety information is included in the separate “Safety Information Manual.” Read the safety information before you use your Booklet maker.

Installation

Your Booklet maker must be installed by a service engineer. Special knowledge is needed to install the machine.



IMPORTANT

Only connect the machine to a mains power supply of the correct voltage with a good earth connection. The correct machine voltage is shown on the label at the power supply input on the rear of the machine. If the machine is connected to the wrong supply, the warranty is voided.

How to Get Help

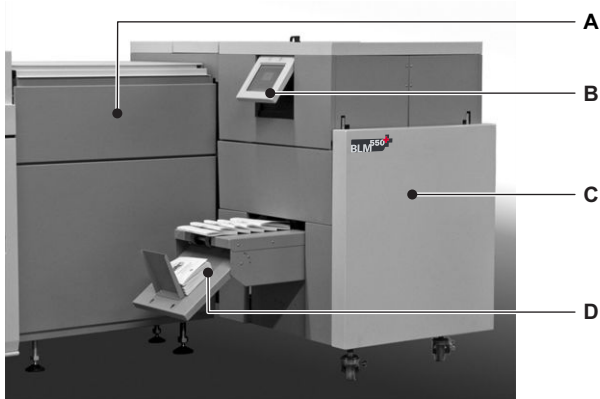
If you have any questions or problems, refer to the problem solving section in this manual ([Error Conditions, Problems and Solutions on page 59](#)). Contact your Booklet maker supplier for further help.

Description of the Booklet maker

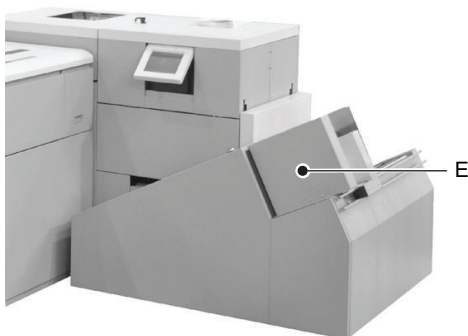
Introduction

The Booklet maker operates online with digital printers to process sets of printed pages into stitched books. The main parts are shown below.

Illustration



[1] Operator Side of the Booklet maker



[2] Book Stacker (optional)

Component - function table

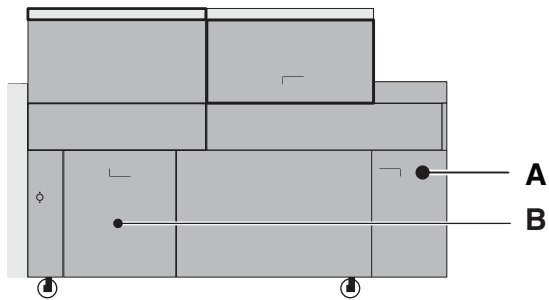
Operator Side of the Booklet maker

	Component	Function
A	The connecting bridge	The connecting bridge moves the printed sheets from the printer to the Booklet maker. If needed, the sheets are rotated into the correct direction. Rotation lets the printer operate at optimum print speed. Adjustment for the size of the paper and sheet rotation is automatic, according to the settings entered on the touch screen.
B	The user interface	The user interface has a color touch screen, a start button ⏪ and a stop ⏹ button .

	Component	Function
C	The Booklet maker	The Booklet maker stitches, folds, spine-forms, and trims the sheets to make a finished book.
D	The Stacker	The Stacker collects the finished books.
E	The Book Stacker	The optional Book Stacker is a high-capacity stacker for the finished books.

Right-Hand Side of the Booklet maker

Illustration



[3] Right-hand side of the Booklet maker

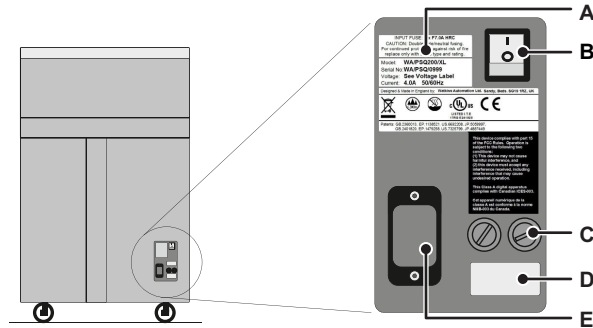
Component - function table

Right-hand side of the Booklet maker

	Component	Function
A	The stitch-wire cabinet	The stitch-wire cabinet holds the spool of stitch-wire.
B	Trim Bin	The trim bin collects the paper that is trimmed from the edge of the book

The Rear Panel of the Booklet maker

Illustration



[4] The Rear Panel of the Booklet maker

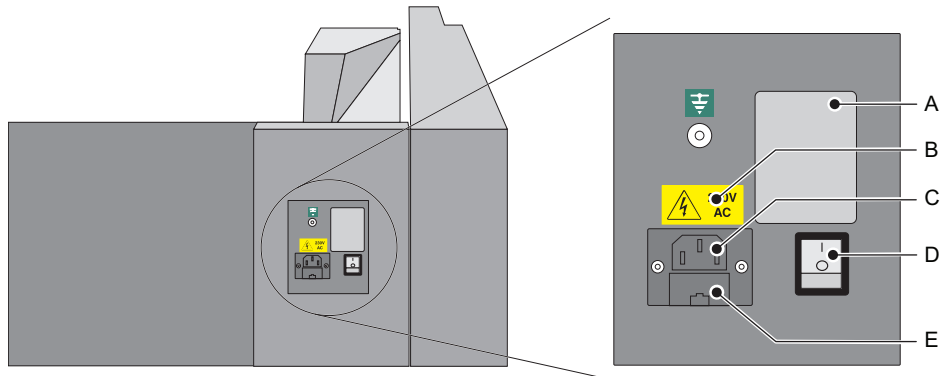
Component - function table

The Rear Panel of the Booklet maker

	Component	Function
A	Rating and serial label	The rating label displays the type of machine, serial number, power use, and fuse information.
B	Power ON/OFF switch	The mains power ON/OFF switch turns the Booklet maker ON or OFF. When you turn OFF the Booklet maker, the current settings are stored.
C	Fuses	The fuses make sure the operator and the machine are protected if there is an electrical problem or short circuit.
D	Voltage label	The voltage label is fitted to the Booklet maker during the installation procedure. The voltage label displays the selected voltage.
E	Power input connector	The power input connector is used to connect the Booklet maker to the electrical power supply.

The mains input panel of the optional Book Stacker

Illustration



[5] The mains input panel of the Book Stacker

Component - function table

The mains input panel of the Book Stacker

	Component	Function
A	Rating and serial label	The rating label displays the type of machine, serial number, power use, and fuse information.
B	Voltage advisory label	The voltage advisory label shows that the input voltage is 230 V AC. The 230 V power is supplied by the Océ BLM550 ⁺ .
C	Power input connector	The power input connector is used to connect the power supply from the Océ BLM550 ⁺ to the Book Stacker.
D	Power ON/OFF switch	The mains power ON/OFF switch turns the Book Stacker ON or OFF.
E	Fuses	The fuses make sure the operator and the machine are protected if there is an electrical problem or short circuit.

Chapter 3

How to run the Booklet maker

Introduction

This chapter gives information on how to run a job on the Booklet maker. For information on how to operate the printer, refer to the printer documentation.

Information about the user interface is included in the chapter "The User Interface."

Information about standard procedures, for example opening covers to clear a paper jam, is included in the chapter "Standard Tasks."

Quality instructions

Introduction

The size of the paper and the thickness of the set must be measured to ensure good book quality. The paper size must be measured with an accuracy of 0.5 mm. To do so, a ruler and a magnifying glass have been added to the bridge cover. The ruler has a scale of 0.5 mm to allow accurate measurements. Use the magnifying glass to read the values easily.

The measured value must be entered in the paper size setting on the touch screen with an accuracy of 0.5 mm. Because the paper size changes during the printing process, you have to measure the size immediately after the paper exits the printer. Otherwise, book quality issues can occur.

Paper and Book Quality Instructions

- Measure the size of the printed paper. The paper size changes during the printing process.
- Measure the set thickness as accurately as possible. Use the ruler and the magnifying glass on the bridge cover.
- To get the best accuracy, use millimeters to measure the set (see [Enter the Job Settings on page 21](#)).
- Enter accurate dimensions into the touchscreen.
- If the book is made from several different types of paper, make sure the different paper types are all the same size.

See [Book Quality on page 64](#) for further information.

Set thickness and Sheet thickness

To make a high quality finished book, the machine adjusts the length of the stitch and the amount of spine-form. The adjustment is done according to the set thickness. There are two operating modes.

- Sheet thickness and page count
Default operating mode
 - Measure the thickness of a single sheet.
Use the measuring tool supplied with the machine.
 - Enter the value into the touch screen.
 - The sheets are counted when they enter the machine. The settings are adjusted automatically.



NOTE

Measure 10 sheets of paper. Divide the value by 10. If you use the same type of paper frequently, record the value.

- Set thickness
 - Measure the thickness of a complete set.
 - Measure the set thickness as accurately as possible.

- Use the measuring tool supplied with the machine.
- Enter the value into the touch screen.

Turn ON the Booklet maker

Procedure

1. Connect the Booklet maker to the power supply.
2. Use the ON/OFF switch to turn ON the Booklet maker.

Result

The machine makes this sequence of beeps:

'beep __ beep beep beep beep _____ beep __ beep'.

The touchscreen illuminates and the machine calibrates.

When READY is displayed on the screen, the machine is ready for use.

Enter the Job Settings

Introduction

Make the settings for a new job in the BASIC  window on the touch screen. See the chapter “The User Interface” for more information.

The PAPER SIZE and PAGE DIRECTION settings are entered on the touch screen. These dimensions refer to the format of the paper when it enters the Booklet maker.




IMPORTANT

Do not operate the touch screen with a sharp object or with too much force. These actions can damage the touch screen.




NOTE

The paper size must be measured with an accuracy of 0.5 mm.

Step	Action	Information
1	Print a set to the stacker.	
2	Measure the sheet size. Measure the sheet thickness or the set thickness.	Measure the set accurately. To make an accurate book you must enter accurate paper dimensions into the touch screen. To get the best accuracy, use millimeters to measure the set. If needed, set the Booklet maker to use millimeters: <ul style="list-style-type: none"> • Touch MENU. • Select Supervisor access level. • Touch MENU > CONFIGURE  > MACHINE OPTIONS. • Touch mm > CLOSE.
3	Use these dimensions for the job setting.	

Procedure for a New Job

Step	Action	Information
1	Touch BASIC 	
2	Enter the paper size	Touch PAPER SIZE. Enter the dimensions of the paper. The job setting is easier if you first select a preset paper size, then adjust the settings as necessary Touch PAPER SIZE > PRESETS > A3 or A4. (USA: 11x17, 8.5x11 or 8.5x14)
3	Enter the page direction	Touch PAGE DIRECTION > LANDSCAPE or PORTRAIT. If the PAGE DIRECTION option is not available, the PAGE DIRECTION cannot be changed.
4	Enter the page rotation setting	For A4 paper size, the normal setting for ROTATE is ON. Rotation lets the printer operate at optimum speed. Touch ROTATE to turn the sheet rotation ON or OFF. Always select the page direction before you change the rotate setting. ▶

Step	Action	Information
5	Enter the sheet thickness. Or	Touch SET THICKNESS. Set AUTO to ON. Use '+' or '-' to enter the SHEET THICKNESS.
	Enter the set thickness. See Quality instructions on page 18 .	Touch SET THICKNESS. Set AUTO to OFF. Use '+' or '-' to enter the SET THICKNESS.
6	Enter the number of stitches.	Touch STITCHES and enter the number of stitches. If needed, the stitch pitch can be changed. See "STITCH PITCH," Button overview on page 33
7	Enter the spine form setting	The spine form setting is automatic, according to the SET THICKNESS setting. If needed, the setting can be changed. See "FORM" in Button overview on page 33
8	Enter the trim setting.	The trim setting is automatic, according to the PAGE SIZE and SET THICKNESS settings. To change the setting, touch TRIM. See "TRIM" in Button overview on page 35
9	Touch CLOSE	
	If needed, save the job settings to memory.	If the same job settings are used frequently, then save the job settings to memory. See Load and Save the Job Settings on page 42 .

Procedure for a Saved Job

Procedure

1. Touch LOAD & SAVE
2. Touch the job name or use the Up arrow or the Down arrow to select the job.
3. Touch LOAD.
4. Wait until the Booklet maker is ready.

Adjust the Stacker and the optional Book Stacker

Adjust the Stacker

Adjust the stacker according to the size and thickness of the finished book (see [Adjust the Stacker on page 53](#)).

Adjust the optional Book Stacker

Check if the Book Stacker is ready to accept books (see [Adjust the Book Stacker on page 56](#)).

Run the job

Procedure

1. Make sure the adjustments on the Booklet maker are complete before you release the print job from the print queue.
2. Start the print job. The Booklet maker starts automatically.
3. Check the quality of the first book.
4. If the quality is not acceptable, make adjustments (see [Book Quality on page 64](#)).

Result

During the job

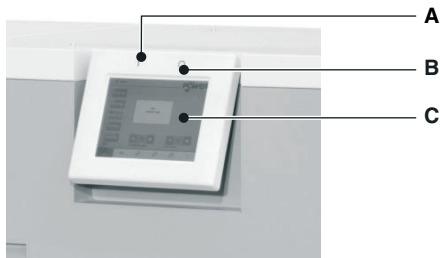
- Unload books from the Stacker before the Stacker is full. The Booklet maker displays no message when the Stacker is full.
- Unload books from the optional Book Stacker (see [Unload the Book Stacker on page 57](#)). The Booklet maker displays a message when the Stacker is full. The Booklet maker stops.
- Empty the trim bin from time to time. The Booklet maker displays a message when the trim bin is full [Empty the Trim Bin on page 51](#).

Chapter 4

The User Interface

The Touch Screen

Introduction



[6] The User Interface

A	START Button
B	STOP Button
C	Touch Screen

The user interface includes a color touch screen and START/STOP buttons.

Operate the touch screen with your fingertip. You can touch the screen with a blunt item, for example a palm-top 'wand' or the blunt end of a pen. Do not use too much force. A light touch is all that is needed.

Power save

The touch screen has a power-save function. After several minutes without use, the brightness of the touch screen decreases. After several hours, the touch screen turns off. Touch the screen to restore the normal brightness. The touch screen takes two or three minutes to reach full brightness.

If you hear a 'beep' when you operate the touch screen, the selected function is not available. Some functions are not available when the machine is in operation.

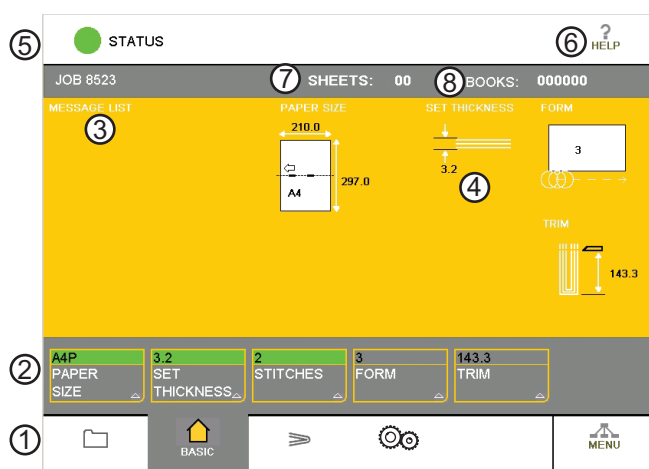
Some functions and buttons are only available at certain access levels. See "ACCESS LEVEL" [The MENU Window on page 39](#).



IMPORTANT

Do not operate the touch screen with a sharp object or with too much force. These actions can damage the touch screen.

Illustration



[7] The Touch Screen

Component - function table

No.	Component	Function
1	Window Tabs	The touch screen buttons are divided into groups that have related functions. Each group of buttons has a separate window. Touch the correct tab to select the window. <ul style="list-style-type: none"> 📁 LOAD & SAVE 🏠 BASIC ➤ ADVANCED ⚙️ CONFIGURE ⚠️ MENU
2	Window Buttons	Each window contains a group of buttons. Touch the button to select the function.
3	Message List	Information and error messages are shown in the MESSAGE LIST . To display the information about a message, touch HELP then touch the message list. Use the right-arrow and left-arrow to see the help text for each message.
4	Job Mimic	The job mimic shows the current machine settings.
5	Status	The STATUS line shows the machine status.
	- GREEN	The Booklet maker is READY or RUNNING .
	- ORANGE	PLEASE WAIT - wait until the Booklet maker is ready. ATTENTION - the Booklet maker needs intervention by the operator.
	- RED	The Booklet maker is in an ERROR condition. ▶

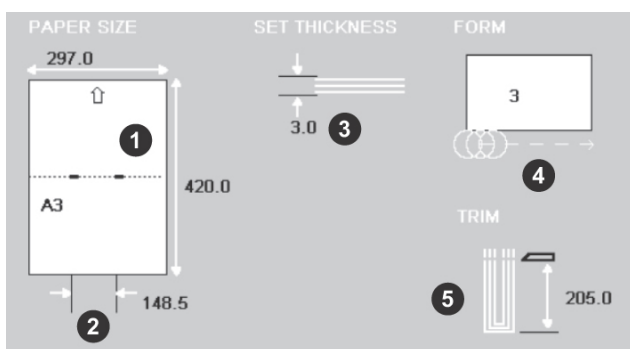
No.	Component	Function
6	Help	<p>Help text is available on the touch screen.</p> <ul style="list-style-type: none">• Touch HELP then touch any button or tab on the screen. Information about that button or tab is displayed.• To display the information about a message, touch HELP then touch the message list.• Use the Up arrow and the Down arrow to scroll up and down the screen.• Some text has more than one screen. Use the right arrow and left arrow to see the other screens. <p>To leave the help text, touch HELP or touch X.</p>
7	Sheet Counter	<p>The sheet counter shows the number of sheets in the gathering area. The counter starts again with each book.</p>
8	Book Counter	<p>The book counter shows the number of books made. The counter is reset to zero when the Booklet maker is turned off.</p>

The Job Mimic

Introduction

The job mimic shows the current machine status.



Illustration



[8] The Job Mimic


Component - function table

No.	Icon	Information
1		The following items are shown <ul style="list-style-type: none"> • the size of paper • the format of the paper in the gathering area • the broken line shows the fold line • the small thick lines show the stitches • the arrow shows the original feed edge in the printer
2	Stitch Pitch 	The stitch pitch is shown only when a non-standard setting is selected.
3	Sheet thickness Or Set thickness 	The sheet thickness, in mm, is shown. NOTE The arrows show a single sheet.
		The set thickness, in mm, is shown. NOTE The arrows show the complete set.

No.	Icon	Information
4	 The icon for the FORM function. It features the word "FORM" at the top, a central box containing the number "3", and a red "X" below the box. To the left of the box are two overlapping circles, and to the right is a dashed arrow pointing right.	The number of forms is shown. If the pressure is adjusted, the setting is shown in brackets. A red X shows that the form function is not active.
5	 The icon for the TRIM function. It features the word "TRIM" at the top, a vertical scale with a horizontal bar at the top, and the value "205.0" to the right of the scale. A red "X" is positioned above the value.	The trim setting is displayed. A red X shows that the trim function is not active.

The BASIC Window

Introduction

The **BASIC**  window gives you access to frequently-changed machine settings.

Button overview


The BASIC Window Buttons

Button	Information
PAPER SIZE	Measure the accurate size of the printed paper before you make a book. Touch PAPER SIZE to enter the paper size. When the machine is in operation, you can adjust the PAPER SIZE by a maximum of +/- 1 mm.
- PAGE DIRECTION	Touch PAGE DIRECTION to change the direction of the paper to Landscape or Portrait.
- ROTATE	Touch ROTATE to set the sheet rotation ON or OFF. If you select A4 portrait (USA: 8.5x11), ROTATE is set to ON automatically.
- PRESETS	Touch PRESET to select a standard paper size.
SET THICKNESS	Use the SET THICKNESS window to define the thickness of the set. Measure the thickness of the set before you make a book. Touch SET THICKNESS and enter the value. Or Use AUTO and SHEET THICKNESS to automatically calculate the SET THICKNESS .
- AUTO	Touch SET THICKNESS > AUTO to select automatic adjustment of SET THICKNESS . Enter the SHEET THICKNESS . The sheets are counted when they enter the machine. The SET THICKNESS is calculated from the SHEET THICKNESS and the sheet count.
- SHEET THICKNESS	Use SHEET THICKNESS to enter the measured thickness of one sheet of paper. SHEET THICKNESS determines the maximum number of sheets that is allowed. The maximum number is displayed on the screen.
STITCHES	Touch STITCHES to select the number of stitches. Available options are 1 - 6 . The machine automatically calculates the position of the stitches according to the size of the paper. Select 0 to turn off the stitch function.
-STITCH PITCH	The stitch pitch is the space between the stitches. The machine automatically calculates the stitch pitch according to the size of the paper. If a non-standard stitch pitch is needed, use STITCH PITCH to make the adjustment.
- AUTO	Touch AUTO to select the default stitch pitch. ▶

Button	Information
FORM	<p>To make the square spine of the book, pressure is applied to the spine. This process is called forming.</p> <p>Touch FORM to specify the amount of spine form.</p> <p>To make a good spine on different paper types, the amount of spine form can be changed.</p> <p>To change the amount of spine form:</p> <ul style="list-style-type: none"> • Touch NUMBER to change how many times the spine is processed • Touch PRESSURE to change the pressure
- AUTO	Touch AUTO to select the optimum amount of spine form, according to the set thickness.
- NUMBER	Touch NUMBER to select how many times the form roller processes the spine. The available options are 1, 2, 3 or 4. An increase in NUMBER increases the time taken to form the spine and can decrease the production rate for thin books. Alternatively, increase the PRESSURE .
- PRESSURE	<p>Touch PRESSURE to increase or decrease the pressure used to form the spine.</p> <p>Touch + to increase the amount of spine form. Touch - to decrease the amount of spine form. The range is -9 to +9. The default setting is 0.</p>
- THRESHOLD	<p>Use THRESHOLD to choose whether a square spine is formed.</p> <p>If the SET THICKNESS value is thinner than the THRESHOLD value, a square spine is not formed.</p> <p>If the SET THICKNESS value is thicker than the THRESHOLD value, a square spine is formed.</p> <p>If the SET THICKNESS value is 1.5 mm or thicker, a square spine is always formed.</p> <p>The default value is 0.8 mm. The allowed range is 0.1 mm to 1.5 mm</p>
TRIM	<p>The trim dimension is calculated automatically according to the PAPER SIZE and SET THICKNESS.</p> <p>If needed, the trim dimension can be changed. Touch TRIM to adjust the size of the finished book after the fore-edge is trimmed. The maximum trim is 28 mm. The trim function can be turned off.</p>
- AUTO	Touch AUTO to select the default trim position.

The LOAD & SAVE Window

Introduction

The **LOAD & SAVE**  window lets you save and reload job settings. Each job is given a name. The jobs are displayed in a list on the screen. Touch the job name or use the Up arrow or Down arrow to make the selection.

Button overview

The LOAD & SAVE Window Buttons

Button	Information
SAVE	Touch SAVE to save the current settings. An on-screen keyboard is displayed. Enter the job name. Touch OK or CLOSE . The new job appears in the list of saved jobs. You can reload a saved job to decrease set-up time in the future.
- REPLACE	If you change the settings of a saved job, touch REPLACE to save the new settings.
- CANCEL	Touch CANCEL if you do not need to save a job that you have changed.
- SAVE NEW	If you change the settings of a saved job, touch SAVE NEW to save the new settings as a new job. An on-screen keyboard is displayed. Enter the new job name. Touch OK or CLOSE . The original job is not changed. If the job name is not changed before OK or CLOSE is touched, the job will be saved with the current name followed by an asterisk *.
JOB DETAILS	JOB DETAILS shows the settings for each saved job. Select the job that you need to view from the job list. Touch JOB DETAILS to see a summary of the job settings.
LOAD	Touch the job name or use the Up arrow or the Down arrow to make the selection. Touch the LOAD button
PADLOCK SYMBOL	The padlock symbol shows when a saved job is locked or unlocked. There is a small padlock symbol next to each locked job. To lock or unlock a job. <ol style="list-style-type: none"> 1. select the job from the job list 2. touch the large key symbol. A padlock symbol displayed in light grey shows that a job has been locked by a supervisor to prevent changes to the settings
DELETE	To delete a particular job it must be unlocked. Touch the job name or use the Up arrow or Down arrow to make the selection from the job list. Touch and hold DELETE . A red line appears. The red line fills from left to right. Hold DELETE until the red line reaches the right-hand side.
VIEW OF JOB LIST	VIEW OF JOB LIST changes the order that saved jobs are listed. There is a line between Factory Template jobs and jobs saved by the operator. The Factory Template jobs are at the top of the list
- A->Z	Touch A->Z to list the jobs in alphabetical order. ▶




Button	Information
- BY USE	Touch BY USE to list jobs in the order they were last used. The most recently-run job is at the top of the list.
- BY INDEX	Touch BY INDEX to list jobs in numerical order. the machine gives a number to all jobs that are saved.

The ADVANCED Window

Introduction


The **ADVANCED** > window gives you access to special machine functions.

Button overview

Button	Information
RE-REF	If the machine calibration appears incorrect or if an 'axis moving' error message remains on the screen, touch RE-REF to re-reference the adjustment axes. The adjustment axes return to the current settings. At intervals, the machine will re-reference the axes during the set-up procedure.
STITCHER UP	Touch STITCHER UP before you lubricate the stitch head. This action moves the stitch head to the correct position for lubrication.
PURGE SET	If the print job has been canceled, a set or part of a set can remain in the gathering area. Touch START  , then touch PURGE SET to clear the set from the machine. The book is not stitched or trimmed According to the type of error that occurred, there can be a pause of 7 seconds before the PURGE SET button will operate. For safety reasons, this function is disabled when the gathering area cover is open.
- MAKE BOOK	If there is a set in the gathering area, you can make the set into a book.  NOTE Do not use this option if SET THICKNESS is set to AUTO . Touch START  , then touch MAKE BOOK to clear the set from the machine. The book is not stitched or trimmed. According to the type of error that occurred, there can be a pause of 7 seconds before the MAKE BOOK button will operate. For safety reasons, this function is disabled when the gathering area cover is open.

The CONFIGURE Window

Introduction

The **CONFIGURE**  window lets you make changes to the configuration of the machine.

Some functions and buttons are only available at certain access levels, see 'ACCESS LEVEL' [Button overview on page 39](#).

CONFIGURE Window Buttons

Button overview

Button	Information	Operator	Supervisor
MACHINE OPTIONS	Touch MACHINE OPTIONS to view the general machine setup. Some of the settings can be changed, depending on the current access level.	Hidden	Active
- MEASUREMENT	Select 'mm' or 'inch' as the unit of measurement.	Hidden	Active
- STITCH SENSOR	There is a sensor that checks for stitches. Touch STITCH SENSOR to turn the stitch sensor on or off. The default setting is ON.	Hidden	Active
- PRESET PAPER SIZES	The preset paper sizes can be either ISO A sizes or US paper sizes. To select which preset paper sizes are available, touch the relevant button.	Hidden	Active
- PBS INSTALLED	Touch BOOK STACKER to switch off communication to the Book Stacker. Only if the Book Stacker is disconnected.	Hidden	Active
SHUTTLE	Touch SHUTTLE to make adjustments to the tamper.	Hidden	Active
-TAMPER DELAY	This button is used by the service engineer.	Hidden	Visible
- TAMPER TIME	TAMPER TIME adjusts the time that the tamper touches the set. An increase in TAMPER TIME causes a decrease in the production rate for thin books.	Hidden	Active
FORM SETUP	This button is used by the service engineer.	Visible	Visible

The MENU Window

Introduction

MENU shows the settings that are not changed during day-to-day operation.

These settings include

- Change the Access Level
- Change the display language
- Advanced machine settings that are accessed by a person who has the correct access-code.

Button overview

The MENU Window Buttons

Button	Information
ACCESS LEVEL	<p>The Touch Screen has five different access levels</p> <ul style="list-style-type: none"> • Operator • Supervisor • Service • Distributor • Factory <p>Touch ACCESS LEVEL and select the correct level from the list. The last three levels are protected by access codes. To protect the job settings, the supervisor level allows jobs to be locked.</p>
CURRENT LANGUAGE	Touch one of the flags to select the language you need.
AXES	<p>Touch AXES to re-reference individual axes. Supervisor access level is needed for this function.</p> <p>Other functions on this button are used by the service engineer.</p>
BRIDGE	<p>Touch BRIDGE to re-reference the bridge axes. Supervisor access level is needed for this function.</p> <p>Other functions on this button are used by the service engineer.</p>
SERVICE OPTIONS	This button is used by the service engineer.
TEST	This button is used by the service engineer.
COUNTERS	<p>The counters display the</p> <ul style="list-style-type: none"> • number of books that have been made • number of sheets that have been processed • number of stitches that have been used
-RESET	<p>Touch RESET to reset the book, sheet and stitch counter. Use RE-SET after operator maintenance to the stitch head.</p> <p>Touch and hold RESET. A red line appears. The red line fills from left to right. Hold RESET until the red line reaches the right-hand side.</p>

Chapter 5

Standard Tasks

Introduction


This chapter describes the standard tasks that are needed in the day-to-day operation of your Booklet maker.

Load and Save the Job Settings


Introduction

The current job settings can be saved to memory and reloaded for use again at a later date. Load the 'Default Job Template' to reset the Booklet maker to normal settings.

Save a job

1. Touch **LOAD & SAVE**  **SAVE**.
2. If these options appear, select one.
 - **REPLACE** to over-write the previous job with the current job settings.
 - **SAVE NEW** to save the current job with a new name.
 - **CANCEL** to cancel the job save.
3. Enter the name for the job on the keyboard.
4. Touch **OK** or **CLOSE**.

Load a job

1. Touch **LOAD & SAVE** .
2. Touch the job name or use the Up arrow or the Down arrow to select the job.
3. Touch **LOAD**.
4. Wait until the Booklet maker has made the adjustments.

Reset the Booklet maker to default settings

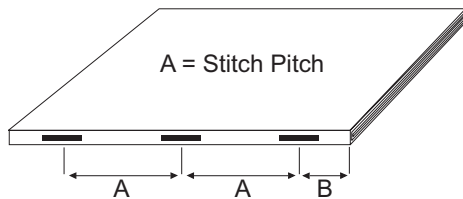
1. Touch **LOAD & SAVE** .
2. Select the **Default Job Template** from the list of jobs.
3. Touch **LOAD**.
4. Touch **YES**.

Adjust the Stitch Pitch

Introduction

The stitch pitch is the space between the stitches. The machine automatically calculates the stitch pitch according to the size of the paper and the number of stitches. The stitches are inserted symmetrically on the spine of the book.

If a non-standard stitch pitch is needed, use STITCH PITCH to make the adjustment.



[9] Stitch Pitch

Limitations:

- The minimum stitch pitch 'A' is 25 mm.
- The minimum distance from the center of the stitch to the edge of the sheet 'B' is 15 mm.

When to do

If you need the Booklet maker to insert the stitches in a non-standard position. For example, to keep the stitches away from the text on the spine of the book.

Select a non-standard stitch pitch

1. Touch BASIC \uparrow > STITCHES.
2. Touch AUTO. The STITCH PITCH value becomes green.
3. Change the stitch pitch value. Either use the "+" and "-" or touch the green stitch pitch value to open a numeric keypad.
4. Touch STITCHES to close the window.
The stitch pitch value is displayed in the job mimic and on the STITCHES button.

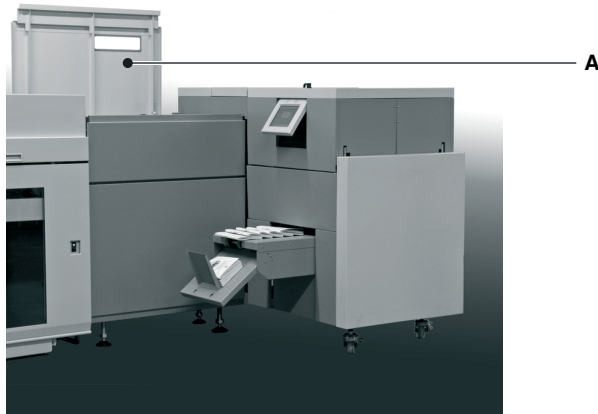
Select a standard stitch pitch

1. Touch BASIC \uparrow > STITCHES.
2. Touch AUTO to select ON.
3. Touch STITCHES to close the window.
The stitch pitch value is not displayed in the job mimic or on the STITCHES button.

Open the Connecting Bridge Cover

Introduction

The Booklet maker will not stop if you open the connecting bridge cover.



[10] Connecting Bridge Cover in the open position.

A	Connecting Bridge Cover
---	-------------------------

When to do

If a machine error occurs, or for maintenance.

- To clear a paper jam



CAUTION

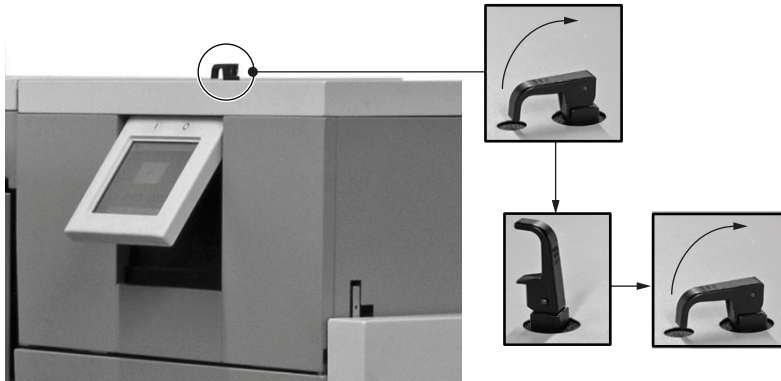
Keep your hands, clothing and hair away from the belts.

Procedure

1. Lift the connecting bridge cover.

Open and Close the Folder Cover

Introduction



[11] Unlock and lock the Folder Cover.

Open the Folder Cover

If a machine error occurs, or for maintenance.

- To access the stitch area
- To access the folder area



NOTE

The folder cover has an interlock switch. The Booklet maker stops if you open the folder cover.

1. Lift the black locking handle against the spring pressure.
2. Turn the handle through 90° to unlock.
3. Lift the folder cover carefully to the vertical position.

Close the Folder Cover



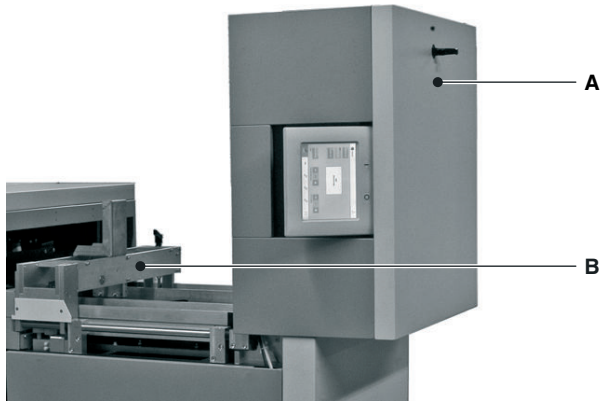
CAUTION

Check that the folder cover will not hit the clincher frame locking handle when you close the folder cover. If necessary, lift and rotate the clincher frame locking-handle to a new position [Lift and Lower the Clincher Frame](#) on page 46.

1. Lower the folder cover.
2. Turn the handle through 90° to lock.
3. Close the locking handle to lock the folder cover.

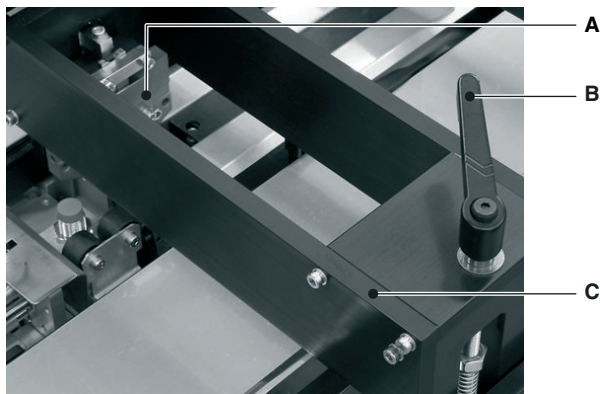
Lift and Lower the Clincher Frame

Introduction



[12] Folder Cover in the vertical position.

A	Folder Cover
B	Clincher Frame



[13] Clincher Frame Components

A	Clincher
B	Locking Handle
C	Clincher Frame

When to do

If a machine error occurs, or for maintenance.


- To clear a paper jam in the stitch area
- To unlock the Booklet maker main deck

Lift the Clincher Frame

1. Open the folder cover.
2. Turn the locking handle to the left , until the thread is disengaged.

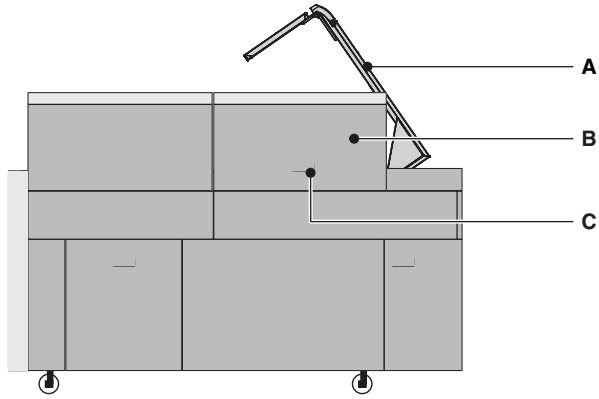
3. Lift the clincher frame to the vertical position.

Lower the Clincher Frame

1. Lower the clincher frame.
2. Turn the locking handle to the right , until the handle is tight.
3. Check that the locking handle will not be hit by the folder cover when you close the folder cover. The locking handle should point towards the middle of the machine. If necessary, lift and rotate the locking handle to a new position.

Open the Gathering Area Cover

Introduction



[14] Gathering Area Cover.

A	Connecting Bridge Cover open
B	Gathering Area Cover
C	Gathering Area Cover Handle

When to do

If a machine error occurs, or for maintenance.

- To access the gathering area

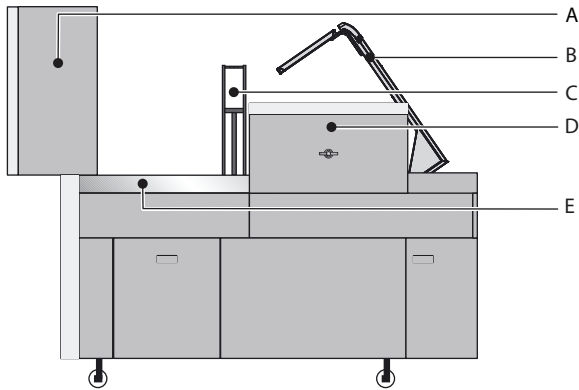
The Booklet maker will stop if you open the gathering area cover.

Procedure

1. Open the connecting bridge cover.
2. Use the gathering area cover handle to lift the gathering area cover.

Lift the Booklet maker Main Deck

Introduction



[15] Lift the Booklet maker Main Deck

A	Folder Cover open
B	Connecting Bridge Cover open
C	Clincher Frame lifted
D	Gathering Area Cover
E	Main Deck

When to do

If a machine error occurs, or for maintenance.

- To access the stitch head
- To access the former area
- To access the trim area

Check the touchscreen for the error message FOLD BLADE NOT PARKED .	
If the error message is displayed:	Open the folder cover, remove any paper, close the folder cover. Touch START Ⓞ, then follow the instructions on the screen. Wait for the message to clear. Then continue with the procedure below.
If the error message is not displayed:	Continue with the procedure below.



CAUTION

Keep your hands and fingers clear when you lift the main deck.



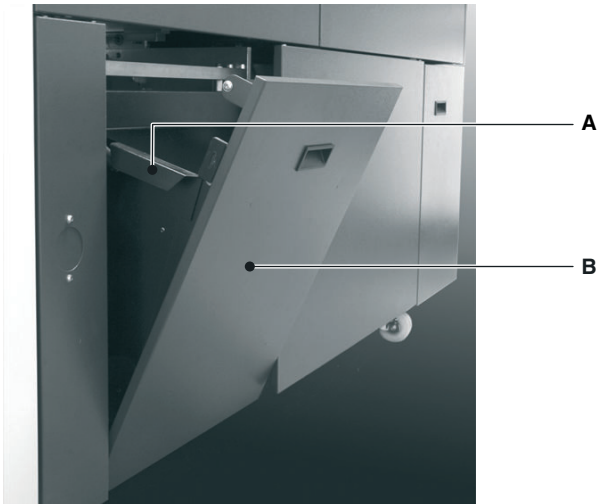
IMPORTANT

Do not lift the main deck if the error message **FOLD BLADE NOT PARKED** is shown on the screen.

Step	Action	Information
1	Open the connecting bridge cover.	<i>Open the Connecting Bridge Cover on page 44</i>
2	Open the folder cover.	<i>Open the Connecting Bridge Cover on page 44</i>
3	Lift the clincher frame.	<i>Lift the Clincher Frame on page 46</i>
4	Open the gathering area cover.	<i>Lift the Clincher Frame on page 46</i>
5	Lift the Booklet maker main deck.	The main deck lifts to approximately 60. The weight of the main deck is supported by a gas strut. Let the gas strut control the movement of the main deck.

Empty the Trim Bin

Introduction



[16] Trim Bin Open.

A	Trim Bin Side Handle
B	Trim Bin open



NOTE

The Booklet maker operates with the trim bin removed for a short period of time. The printer waits while the trim bin is removed, then continues when the trim bin is replaced. To prevent lost production, you must remove, empty, and return the trim bin to the Booklet maker as quickly as possible.

When to do

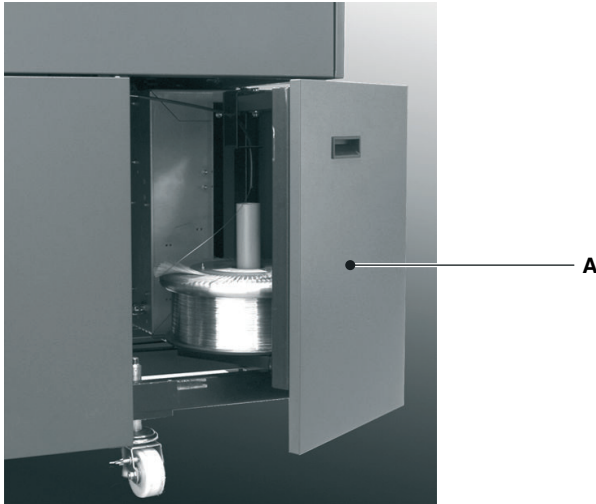
- An error message is displayed on the touch screen when the trim bin is full.
- You can empty the trim bin when you choose. For example, before you start a print job.

Procedure

1. Use the handle to open the trim bin.
2. Use the side handles to lift and remove the trim bin.
3. Empty the trim bin
4. Fit the bottom of the trim bin over the mounting rail.
5. Push the trim bin closed at the top.

Open the Stitch Wire Cabinet

Introduction



[17] Stitch Wire Cabinet.

A	Stitch wire cabinet open
---	--------------------------

When to do

- To see if the stitch wire is jammed or finished. An error message is displayed on the touch screen when the stitch wire is jammed or finished.
- To install a new stitch wire spool. [Install New Stitch Wire on page 123.](#)

Procedure

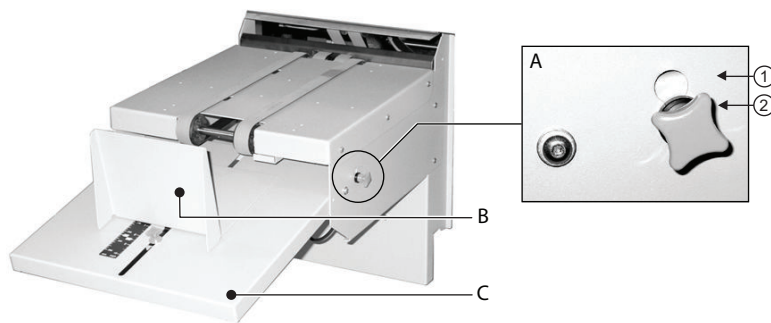
1. Open the stitch wire cabinet cover. The cover is held closed by a magnetic catch.

Adjust the Stacker

Introduction

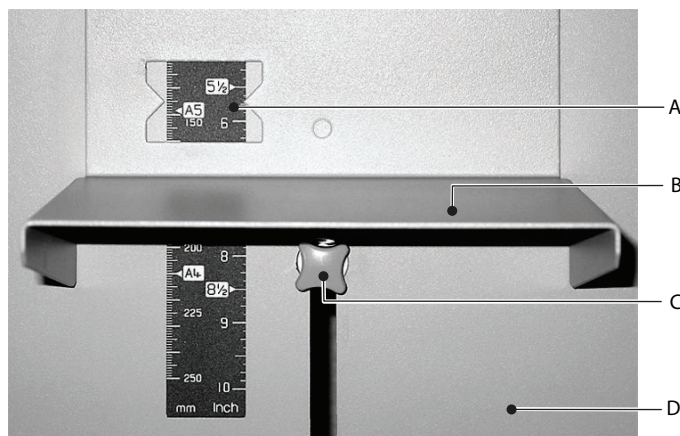
The collection table must be in the correct position for the stacker to operate. The position of the collection table depends on the finished size of the job.

- When you start a new job
- If the books do not stack correctly



[18] The Stacker

A	Catch tray adjustment
B	Collection table
C	Catch tray



[19] Collection table position

A	Book size in window
B	Collection table
C	Orange plastic hand screw

D	Catch tray
---	------------

Step	Action	Information
1	Set the catch tray angle according to the thickness of the book.	For books that are 1.5 mm thick or less, use position 1. For books that are more than 1.5 mm thick, use position 2.
2	Set the collection table position according to the size of the book.	Read the settings through the window.

These settings are recommendations. The settings can change with the size, thickness, and material of book. Make further adjustments if necessary.

Operate the Booklet maker offline

Introduction

You can hand feed sets into the Booklet maker if offline operation is needed. The machine operates when you push the two buttons.

When to do

- To check the settings are correct
- To make a small number of books offline



IMPORTANT

Do not put your hands in the gathering area while the machine is in operation. Use two hands to push the buttons. For safety reasons, this task is for a single operator. Do not allow another person to help you.



NOTE

Do not use this function when **SET THICKNESS** is set to **AUTO**. The **SET THICKNESS** must be the correct setting for the book.

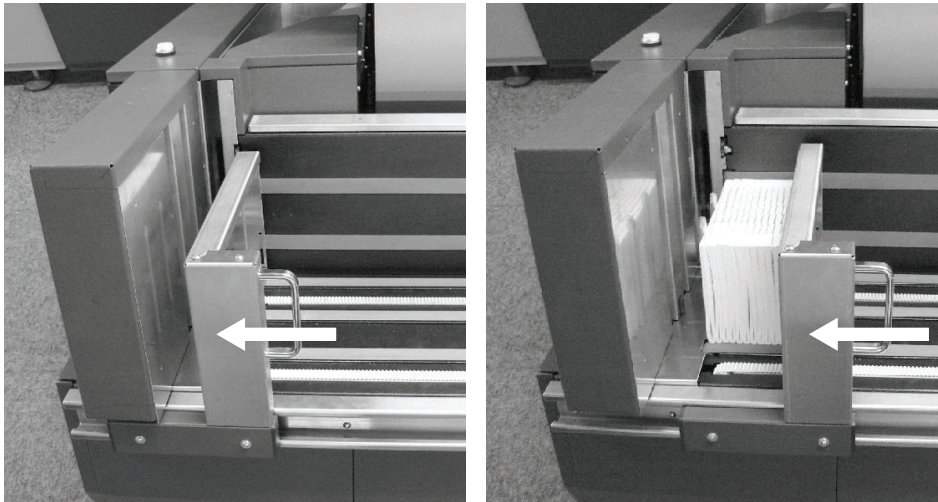
Procedure

1. Enter the correct settings on the touch screen, according to the size and thickness of the job.
2. Touch START ①
3. Open the connecting bridge cover.
4. Open the gathering area cover.
5. Put the set in the gathering area with the middle pages of the book face up.
6. Press the two buttons and hold for 9 seconds or until you hear the folder operate. The time interval changes according to the number of stitches.

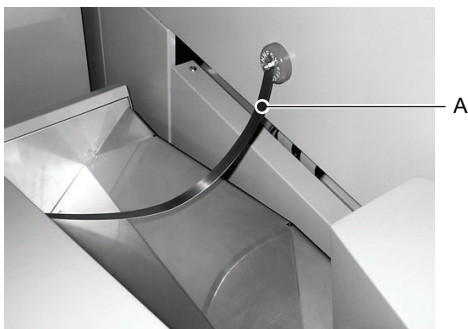
Standard Tasks of the optional Book Stacker

This section describes the standard tasks that are needed in the day-to-day operation of your Book Stacker.

Adjust the Book Stacker



[20] Push the book support to the left



[21] The magnetic paper guide for thin books

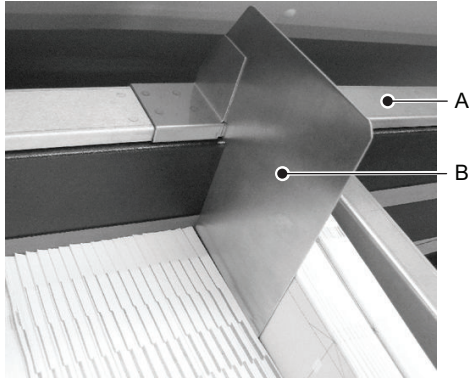
A	Magnetic paper guide
---	----------------------

Procedure

1. Before you use the Book Stacker, make sure the book support is pushed completely to the left. There is no need to empty the Book Stacker until the stacker is full.
2. If you are making thin books, attach the magnetic paper guide above the book outfeed on the Océ BLM550⁺. Insert the loose end of the magnetic paper guide into the slot opposite.

Unload the Book Stacker

Introduction



[22] The book divider

A	Guide rail
B	Book divider

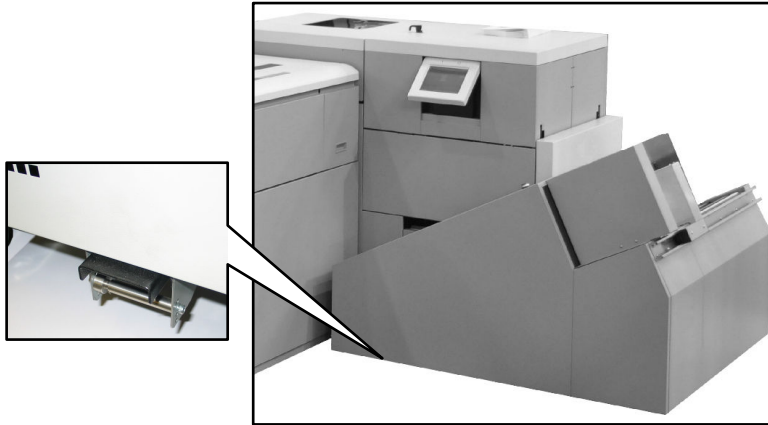
Procedure

1. If required, insert the book divider so that the stack does not slip while you unload the books.
2. Remove the books.
3. Push the book support completely to the left (see [Adjust the Book Stacker on page 56](#)).
4. Remove the book divider until it is needed. Store the book divider on the right-hand end of the guide rail of the stacker.

Move the Book Stacker

Introduction

The Book Stacker locks in position onto the Booklet Maker. A foot pedal releases the docking latch.



[23] Docking latch of the Book Stacker

When to do

- Access the mains ON/OFF switch.
- Replace the mains input fuses.

Procedure

1. Use your foot to release the docking latch.
2. Rotate the Book Stacker away from the Booklet Maker as far as the safety chain allows. The safety chain prevents damage to the power and communication cables.
3. When you completed your action, rotate the Book Stacker to the docked position. The latch clicks when closed.

Chapter 6

Error Conditions, Problems and Solutions

Introduction

This chapter describes how to correct problems that can occur with your Booklet maker. If a problem persists, contact your service engineer.

Clear a Printer Error

Introduction

If a paper jam or other error occurs in the printer, the printer and the Booklet maker stop.

Procedure

1. Clear the printer error.
2. Follow the instructions on the printer. If the printer tells you to remove paper from the Booklet maker, press START Ⓞ to start the machine.
3. Then touch **ADVANCED > PURGE SET > PURGE SET**.
4. The partial book is delivered to the stacker.
5. Discard the book.
6. Check the Océ BLM550+ screen. If an error message is displayed, take the corresponding action (see [Error Messages on page 76](#)).

Clear a Booklet maker error

Introduction

If a paper jam or other error occurs in the Booklet maker, the printer and the Booklet maker stop. The type of error is displayed on the touch screen [Error Messages on page 76](#).

Procedure

1. Clear the error. The error message on the touch screen tells you about the error.
2. Remove all sheets from the Booklet maker.
3. Follow the instructions on the printer.

General Problems

The Booklet maker does not start

Is the touchscreen illuminated?		
No	Yes	
: : : V	Are error messages displayed on the touchscreen?	
	No	Yes
	: : V	See Error Messages on page 76
	Is there an error message on the printer?	
	No	Yes
: : : : : : : : : V	Correct the printer error. If the printer error message is 'Check Third Party Finishing Device' or 'check custom', then check for an error message on the Booklet maker touchscreen. If the problem continues, then call your service engineer.	
	Turn OFF and turn ON the PSQ. If the problem continues, then call your service engineer.	
Is the touchscreen in power-save mode (see The Touch Screen on page 28)? Touch the screen to restore the normal brightness.		
No	Yes	
: V	Go back to the start of this fault-finding table.	
Is the mains power ON/OFF switch illuminated?		
No	Yes	
: V	Call your service engineer.	
Is the Booklet maker turned ON and connected to the mains power supply of the correct type and voltage?		
No	Yes	
: : : : V	Replace the fuse at the mains input (see Change the Fuses on page 101). If the problem continues, then call your service engineer.	
Connect the Booklet maker to the mains supply of the correct type and voltage and then turn the machine ON.		

The touchscreen does not work

Is the touchscreen in power-save mode (see The Touch Screen on page 28)? Touch the screen to restore the normal brightness.	
No	Yes
; V	No further action is needed.
Calibrate the touchscreen (see Calibrate the Touch Screen on page 100).	

Book Quality

Paper Size and Book Quality Instructions

- Careful measurement of the paper size and the set or sheet thickness is important.
- To make an accurate book you must enter accurate paper dimensions into the touch screen.
- To get best accuracy, use millimeters to measure the set (see [Enter the Job Settings on page 21](#)).
- Measure the size of the printed paper. The paper dimension changes when the paper is printed.
- If the book is made from several different types of paper, make sure the different paper types are all the same size. If the size of the paper is different, an accurate book cannot be made.
- The paper must be cut accurately. If the sheets are not cut squarely, an accurate book cannot be made.
- Adjustments to the **FORM** settings can be necessary for some types of paper.

Machine Adjustments

Machine adjustments can be made while the machine is in operation.

The **PAPER SIZE** adjustment is limited to a maximum of +/- 1 mm when the machine is in operation.


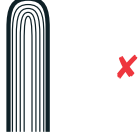

Untidy book problem

- The finished book is not tidy.
- The sheets are not aligned.
- The book is not folded squarely.

Are the covers of the books and the insides of the books made from the same paper weight and paper type?	
Yes	No
⋮	Accurately measure the different papers. Are the different types of paper exactly the same size?
⋮	Yes
⋮	No
⋮	You must use paper that is the same size.
⋮	⋮
⋮	⋮
⋮	⋮
⋮	⋮
V	V
Is the paper within specification (see Specifications on page 132)?	
Yes	No
⋮	Do not use paper that is outside the specification.
⋮	
⋮	
⋮	
V	
Have you accurately measured the paper-size after printing?	
Yes	No

⋮ ⋮ ⋮ ⋮ V	Print a sample to the stacker and measure the printed paper. Accurate measurement will improve book quality.
Have you entered the measured PAPER SIZE into the touchscreen?	
Yes	No
⋮ ⋮ ⋮ ⋮ V	Enter the correct, measured PAPER SIZE into the touchscreen.
Have you accurately measured the set thickness or the sheet thickness?	
Yes	No
⋮ ⋮ ⋮ ⋮ V	Measure the set thickness or the sheet thickness and enter the correct SET THICKNESS or SHEET THICKNESS into the touch screen.
Have you entered the measured set thickness or sheet thickness into the touch screen?	
Yes	No
⋮ ⋮ ⋮ ⋮ V	Enter the correct SET THICKNESS or SHEET THICKNESS into the touch screen.
Touch ADVANCED > RE-REF > RE-REF to re-reference the machine. Does the problem persist?	
Yes	No
⋮ ⋮ ⋮ ⋮ V	No further action is required.
Is the paper thin and/or curly?	
Yes	No
⋮ ⋮ ⋮ ⋮ V	Call your service engineer.
Increase the TAMPER TIME to give the paper more time to settle. Supervisor access level is needed (see The MENU Window on page 39). This may reduce the production speed for thin books. Press CONFIGURE > SHUTTLE . Increase the TAMPER TIME in increments of 200. Does the problem persist?	
Yes	No
⋮ ⋮ ⋮ ⋮ V	No further action is required.
Call your service engineer.	

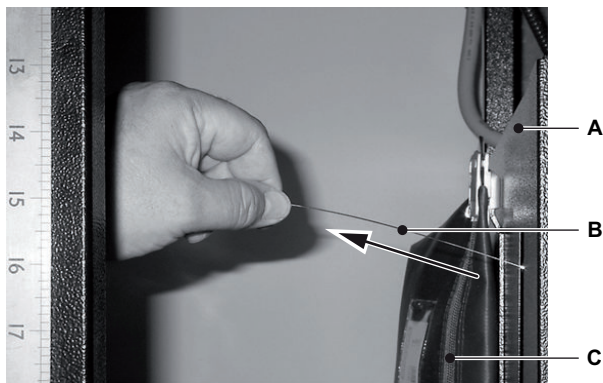
Spine form problems

<p>Correct spine form</p> 	<p>Incorrect spine form. The square spine is part formed or not formed.</p> 	<p>Incorrect spine form. The spine is over-formed and the book is damaged.</p> 
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<p>Is the spine form different at each end of the spine?</p>																					
<p>Yes</p>	<p>No</p>																				
<p>⋮ ⋮ ⋮ V</p>	<p>The spine is incorrect along the full length. Is the folder cover closed fully?</p> <table border="1"> <tr> <td data-bbox="550 772 845 817"> <p>Yes</p> </td> <td data-bbox="845 772 1433 817"> <p>No</p> </td> </tr> <tr> <td data-bbox="550 817 845 974"> <p>⋮ ⋮ ⋮ V</p> </td> <td data-bbox="845 817 1433 974"> <p>Lock the folder cover (see Close the Folder Cover on page 45).</p> </td> </tr> </table>		<p>Yes</p>	<p>No</p>	<p>⋮ ⋮ ⋮ V</p>	<p>Lock the folder cover (see Close the Folder Cover on page 45).</p>															
<p>Yes</p>	<p>No</p>																				
<p>⋮ ⋮ ⋮ V</p>	<p>Lock the folder cover (see Close the Folder Cover on page 45).</p>																				
<p>⋮ ⋮ ⋮ V</p>	<p>Is the SET THICKNESS or the SHEET THICKNESS correct?</p> <table border="1"> <tr> <td data-bbox="550 1019 845 1064"> <p>Yes</p> </td> <td colspan="2" data-bbox="845 1019 1433 1064"> <p>No</p> </td> </tr> <tr> <td data-bbox="550 1064 845 1355"> <p>⋮ ⋮ ⋮ V</p> </td> <td colspan="2" data-bbox="845 1064 1433 1355"> <p>Measure the SET THICKNESS or the SHEET THICKNESS and enter the value in the touch screen. Does the problem persist?</p> <table border="1"> <tr> <td data-bbox="845 1187 1141 1232"> <p>Yes</p> </td> <td data-bbox="1141 1187 1433 1232"> <p>No</p> </td> </tr> <tr> <td data-bbox="845 1232 1141 1355"> <p>⋮ ⋮ ⋮ V</p> </td> <td data-bbox="1141 1232 1433 1355"> <p>No further action is required.</p> </td> </tr> </table> </td> </tr> <tr> <td data-bbox="550 1355 845 1736"> <p>⋮ ⋮ ⋮ V</p> </td> <td colspan="2" data-bbox="845 1355 1433 1736"> <p>Check the THRESHOLD setting. If the SET THICKNESS is less than the THRESHOLD, a square spine is not formed (see The BASIC Window on page 33). Adjust THRESHOLD if needed. Does the problem persist?</p> <table border="1"> <tr> <td data-bbox="845 1568 1141 1612"> <p>Yes</p> </td> <td colspan="2" data-bbox="1141 1568 1433 1612"> <p>No</p> </td> </tr> <tr> <td data-bbox="845 1612 1141 1736"> <p>⋮ ⋮ ⋮ V</p> </td> <td colspan="2" data-bbox="1141 1612 1433 1736"> <p>No further action is required.</p> </td> </tr> </table> </td> </tr> </table>		<p>Yes</p>	<p>No</p>		<p>⋮ ⋮ ⋮ V</p>	<p>Measure the SET THICKNESS or the SHEET THICKNESS and enter the value in the touch screen. Does the problem persist?</p> <table border="1"> <tr> <td data-bbox="845 1187 1141 1232"> <p>Yes</p> </td> <td data-bbox="1141 1187 1433 1232"> <p>No</p> </td> </tr> <tr> <td data-bbox="845 1232 1141 1355"> <p>⋮ ⋮ ⋮ V</p> </td> <td data-bbox="1141 1232 1433 1355"> <p>No further action is required.</p> </td> </tr> </table>		<p>Yes</p>	<p>No</p>	<p>⋮ ⋮ ⋮ V</p>	<p>No further action is required.</p>	<p>⋮ ⋮ ⋮ V</p>	<p>Check the THRESHOLD setting. If the SET THICKNESS is less than the THRESHOLD, a square spine is not formed (see The BASIC Window on page 33). Adjust THRESHOLD if needed. Does the problem persist?</p> <table border="1"> <tr> <td data-bbox="845 1568 1141 1612"> <p>Yes</p> </td> <td colspan="2" data-bbox="1141 1568 1433 1612"> <p>No</p> </td> </tr> <tr> <td data-bbox="845 1612 1141 1736"> <p>⋮ ⋮ ⋮ V</p> </td> <td colspan="2" data-bbox="1141 1612 1433 1736"> <p>No further action is required.</p> </td> </tr> </table>		<p>Yes</p>	<p>No</p>		<p>⋮ ⋮ ⋮ V</p>	<p>No further action is required.</p>	
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<p>⋮ ⋮ ⋮ V</p>	<p>Adjust the PRESSURE setting. Increase the PRESSURE to give more spine form and decrease the PRESSURE to give less spine form. Does the problem persist?</p> <table border="1"> <tr> <td data-bbox="550 1848 845 1892"> <p>Yes</p> </td> <td colspan="2" data-bbox="845 1848 1433 1892"> <p>No</p> </td> </tr> <tr> <td data-bbox="550 1892 845 2016"> <p>⋮ ⋮ ⋮ V</p> </td> <td colspan="2" data-bbox="845 1892 1433 2016"> <p>No further action is required.</p> </td> </tr> </table>		<p>Yes</p>	<p>No</p>		<p>⋮ ⋮ ⋮ V</p>	<p>No further action is required.</p>														
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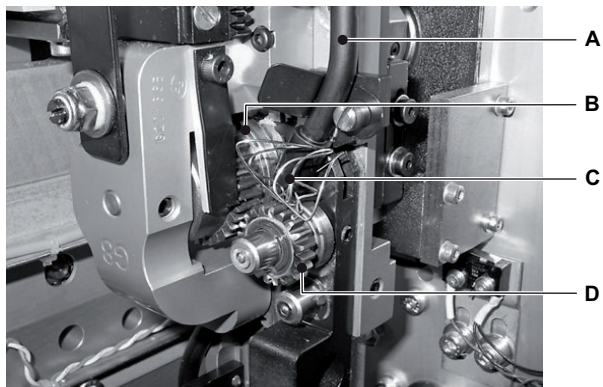
: : : : V	Adjust the NUMBER of forms setting. Increase the NUMBER of forms to create more spine form and decrease the NUMBER of forms to create less spine form. Does the problem persist?	
	Yes	No
	: : V	No further action is required.
: : : : V	Load a Default Job. This will reset the FORM settings, including PRES-SURE , NUMBER and THRESHOLD (see Reset the Booklet maker to default settings on page 42). Does the problem persist?	
	Yes	No
	: : V	No further action is required.
: : : : V	Run a standard job using paper of 80 g/m ² (20 lb bond). Does the problem persist?	
	Yes	No
	: : : : V	The problem is caused by the cover material or the finish on the cover. Change the cover material.
: : : : V	Re-reference the machine. Touch ADVANCED > RE-REF > RE-REF to re-reference the machine. Does the problem persist?	
	Yes	No
	: : V	No further action is required.
Call your service engineer.		

Stitching problems - the book is not stitched



[24] Pulling stitch-wire

A	Stitch-wire cabinet
B	Stitch-wire
C	Accessory bag



[25] Stitch-wire jam

A	Middle wire-tube
B	Large feed gear
C	Stitch-wire jam
D	Small feed gear

Is the number of STITCHES set between 1 and 6?	
Yes	No
⋮ V	Select STITCHES 1 - 6 (see The BASIC Window on page 33).
Check the stitch-wire spool. Is there stitch-wire present?	
Yes	No

⋮ ⋮ V	Load a new stitch-wire spool (see Install New Stitch Wire on page 123).
Open the PSQ main deck (see Lift the Booklet maker Main Deck on page 49). Pull approximately 100 mm -150 mm of stitch-wire from the stitch wire spool. Does the wire move freely?	
Yes	No
⋮ ⋮ ⋮ ⋮ V	Open the stitch-wire cabinet. Discard any tangled wire and reload the stitch-wire spool (see Install New Stitch Wire on page 123).
Check the stitch head for stitch-wire jams. Is the stitch head clear of stitch-wire jams?	
Yes	No
⋮ ⋮ V	Clear the stitch-wire jam (see Clear a Stitch-wire Jam on page 95).
Lubricate the stitch head (see Lubricate the Stitch Head on page 118). Does the problem persist?	
Yes	No
⋮ ⋮ V	No further action is required.
Call your service engineer	

Stitching problems - the book is badly stitched

A correctly formed stitch:

- has equal leg length
- has straight legs
- the distance between the ends of the stitch legs is approximately 1 mm, the distance can vary by +/- 0.5 mm
- has a flat crown.

Is the stitch formed correctly?	
Yes	No
⋮ ⋮ V	Call your service engineer
The stitches should be aligned centrally on the spine. Are the stitches positioned correctly?	
Yes	No


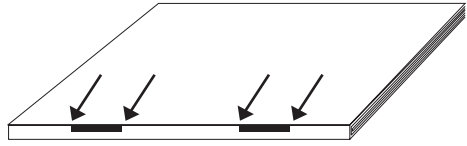
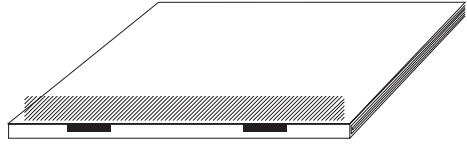
⋮ ⋮ V	Turn on the TRIM option.	
Is AUTO turned off in the TRIM window?		
No	Yes	
⋮ ⋮ ⋮ ⋮ ⋮ ⋮ ⋮ ⋮ ⋮ ⋮ V	Set TRIM to AUTO . Does the problem persist?	
	Yes	No
	⋮ ⋮ ⋮ ⋮ ⋮ ⋮ ⋮ ⋮ ⋮ V	No further action is required. If you need to use a custom trim size, enter the trim dimension in the TRIM window. Make sure the size is not larger than the book size, or the book will not be trimmed.
Touch ADVANCED > RE-REF > RE-REF to re-reference the machine. Does the problem persist?		
Yes	No	
⋮ ⋮ V	No further action is required.	
Call your service engineer.		

Trimming problem - the book is not trimmed to the correct size

Is TRIM turned on?	
Yes	No
⋮ ⋮ V	Turn on the TRIM .
Make sure the size is not larger than the book size, or the book will not be trimmed. Is the correct trim size entered in the touchscreen?	
Yes	No
⋮ ⋮ V	Enter the correct size in the touchscreen.
Re-reference the machine. Touch ADVANCED > RE-REF > RE-REF to re-reference the machine. Does the problem persist?	
Yes	No

No	Yes
⋮ V	Call your service engineer.
No further action is needed.	

Dirty marks on book

Are there dirty marks on the spine?	
No	Yes
⋮ V	Clean the former roller (see Clean the Former Roller on page 112).
Are there grease or oil spots on the spine of the book?	
No	Yes
⋮ V	Clean grease from the top of the stitch head (see Clean excess grease from the Stitch Head on page 117).
Are there dirty marks on the cover of the book near to the spine?	
No	Yes
⋮ V	Clean the polyurethane form strips (see Clean the Polyurethane Strips in the Form Clamp on page 113).

Is there damage to the spine at the stitch positions or is the cover falling off?		
No	Yes	
: : : : : : : : V	Run a standard job using paper of 80 g/m ² (20 lb bond). Does the problem persist?	
	Yes	No
	: : : : V	The problem is caused by the cover material or the finish. Change the cover material.
	Call your service engineer.	
Print a sample to the printer stacker and inspect the pages. Is the printer the cause of the damage?		
No	Yes	
: : : V	Printer service is required.	
Call your service engineer.		

Error Messages

Message list

Information and error messages are shown in the message list.

The error messages are shown in order of priority.



Follow the action needed for the messages, starting with the message at the top of the list.





To display the information about a message:

- Touch **HELP** then touch the message list.
- Use the right-arrow and left-arrow to see the help text for each message.

Problem	Cause	Solution
AXES MOVING	Some of the machine axes are moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF	
BOOK CYCLE TIME TOO LONG	The printer has delivered the sets faster than the books can be made. To decrease the book cycle time, adjust the machine settings: <ul style="list-style-type: none"> • decrease the number of FORMS • decrease the number of STITCHES • decrease the TAMPER TIME • touch STOP ⓘ to clear the message from the screen 	
BOOK DELIVERY TOO FAST	Books are being delivered to the stacker too quickly. This error can occur when you insert books into the stacker by hand. Press the reset button on the stacker. If the problem continues, then call your service engineer.	
Bridge axis moving	The bridge axis is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF .	
BRIDGE INFEED COVER OPEN	The bridge infeed cover is open. The machine will not operate until the cover is closed.	See Clear Paper Jams on page 85



Problem	Cause	Solution
BRIDGE MOTOR STALL	<p>Check for a paper jam in the connecting bridge.</p> <ul style="list-style-type: none"> • Touch STOP ⓘ to stop the Booklet maker. • Clear the paper jam. • Touch STOP ⓘ to clear the message from the screen. • Continue the print job. 	See Clear Paper Jams on page 85
BRIDGE - No comms	<p>Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.</p>	
CHECK PAPER SIZE	<p>Remember to check the paper size.</p> <p>To make an accurate book you must enter accurate paper dimensions into the touch screen.</p> <p>Measure the size of the printed paper. The paper dimension changes when the paper is printed.</p>	
CHECK THE TRIM BIN	<p>The trim bin is either open or full. Check the trim bin. Empty the trim bin if necessary.</p>	
COVER OPEN	<p>A safety cover is open. The machine will not operate until the cover is closed.</p>	
DFA INTERFACE - No comms	<p>Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.</p>	
DRIVE MOTOR STALL	<p>There is a paper jam. Check the machine and correct the error.</p> <p>Touch STOP ⓘ to clear the message from the screen.</p>	
Endlay axis moving	<p>The endlay axis (size adjustment) is moving. This message clears when the adjustment is complete.</p> <p>If the message does not clear, touch ADVANCED > RE REF.</p>	



Problem	Cause	Solution
ENDLAY - No comms	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
ERROR IN TRIM AREA	There is an error at the trimmer. Check the trimmer for a paper or book jam. Touch STOP  to clear the message from the screen.	
ERROR - No comms	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
FLOW ERROR - BRIDGE	There is an error at the connecting bridge. Open the connecting bridge cover and check for a paper jam. Touch STOP  to clear the message from the screen.	See Clear Paper Jams on page 85
FLOW ERROR - FORMER	There is an error at the former. Open the folder cover and remove the book. If necessary, open the main deck to remove the book.	See Jam in the Folder or Former Area on page 90
FLOW ERROR - GATHER AREA	There is a paper jam in the gathering area. Open the connecting bridge cover, lift the gathering area and remove the paper jam.	See Jam in the Gathering Area on page 88
FLOW ERROR - OUTFEED	There is an error at the outfeed. Remove the trim bin and open the trim stop guard to remove the book. If necessary, open the main deck to remove the book.	See Jam in the Trim Area on page 93
FLOW ERROR - STITCHER	There is an error at the stitcher. Open the folder cover and remove the book. If the problem continues, then call your service engineer.	See Jam in the Stitch Area on page 89

Problem	Cause	Solution
Fold blade axis moving	The fold blade axis (book thickness adjustment) is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF	
FOLD BLADE NOT PARKED	Open the folder cover, remove the paper, close the folder cover. Touch START  , then follow the instructions on the screen.	
FOLD - No comms	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
FORM CLAMP CLOSED	The form clamp is in the wrong position. Touch START  to reset the position. Follow the instructions on the screen.	
FORM ROLLER ERROR	Open the folder cover, remove the paper, close the folder cover.	See Jam in the Folder or Former Area on page 90
FORM ROLLER NOT PARKED	The form roller is in the wrong position. Touch START  to reset the position. Follow the instructions on the screen.	
FORM CLAMP ERROR	There is an error at the former. Open the folder cover and remove the book. If necessary, open the main deck to remove the book.	See Jam in the Folder or Former Area on page 90
GATHERING AREA COVER OPEN	Close the gathering area cover if you need to operate the machine online.	
INVERTER ERROR	Check for a paper jam and clear if necessary. Touch STOP  to clear the message from the screen. If the problem continues, contact your service engineer.	
JAM AT BRIDGE INFEED	There is a paper jam at the infeed to the connecting bridge. Clear the jam and continue.	See Clear Paper Jams on page 85
JAM AT FORM ROLLER	Open the folder cover, remove the paper, close the folder cover.	See Jam in the Trim Area on page 93

Problem	Cause	Solution
JAM AT STACKER INFEED	There is a jam in the stacker infeed. Remove the books from the stacker infeed. Press the reset button on the stacker.	See Jam at Book Stacker infeed on page 104
JAM AT STACKER OUTFEED	There is a jam in the stacker outfeed or there are paper trimmings in the stacker outfeed. Remove the books from the stacker outfeed. Check for paper trimmings and remove them if present. Press the reset button on the stacker.	See Jam at Book Stacker outfeed on page 105
JAM BEFORE TRIMMER	There is a book jammed before the trimmer. Open the main deck to remove the book.	See Jam before the Trimmer on page 91
JAM IN CONNECTING BRIDGE	There is a paper jam in the connecting bridge. Clear the jam and continue.	See Jam in the Connecting Bridge on page 87
JAM IN GATHERING AREA	There is a paper jam in the gathering area. Open the connecting bridge cover, lift the connecting bridge and remove the paper jam.	See Jam in the Gathering Area on page 88
JAM IN STACKER AREA	There is a paper jam at the outfeed of the machine. Remove the jammed books and continue.	
JAM IN STITCHER AREA	There is a paper jam in the stitch area. Open the folder cover, remove the paper jam and continue.	See Jam in the Stitch Area on page 89
JAM IN STITCH HEAD	There is a jam in the stitch head.	See Clear a Stitch Head Jam on page 97
JAM IN TRIMMER	There is a book jammed in the trimmer. Clear the jam and continue.	See Jam in the Trim Area on page 93
MAIN CONTROL - No comms	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	

Problem	Cause	Solution
MANUALLY PARK SHUTTLE	The shuttle is not parked correctly. Open the folder cover and move the shuttle to the park position. Close the folder cover. The shuttle will reset. When the message list is clear, continue operation.	See Manually park the Shuttle on page 102
MISSING STITCHES	The machine has detected missed stitches. Check if the stitch wire is jammed or if the stitch wire spool is empty.	See Clear a Stitch-wire Jam on page 95 See Install New Stitch Wire on page 123
MOTOR CONTROLLER NOT READY	The drive motor controller is not ready. If the problem continues, contact your service engineer.	
OPERATOR MAINTENANCE	The machine needs routine maintenance by the operator.	See Operator Maintenance on page 110
REBOOT THE MACHINE	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
REMOVE SET FROM FOLD AREA	Open the folder cover and remove the set.	
REMOVE SET - GATHERING AREA	Open the gathering area and remove the sheets.	
REMOVE SET - STITCH AREA	Open the folder cover and remove the set.	See Jam in the Stitch Area on page 89
Rotate axis moving	The rotate axis is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
ROTATE - No comms	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	

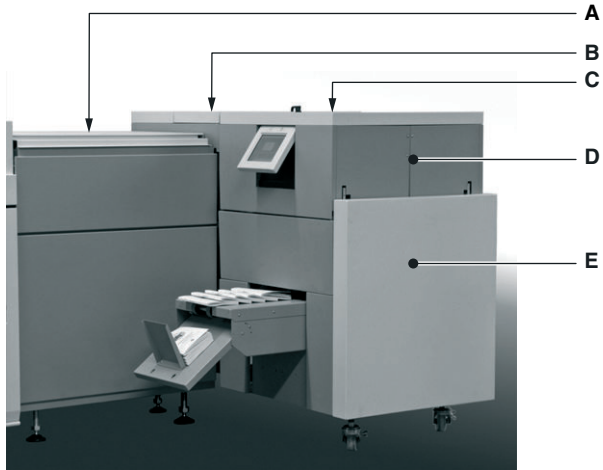
Problem	Cause	Solution
SET IN GATHERING AREA	There is a set or partial set in the gathering area. Open the gathering area and remove the sheets. If the print job has been canceled, open the gathering area and remove the sheets. Or touch START  , then touch ADVANCED > PURGE SET > PURGE SET to clear the set from the machine.	
Shuttle axis moving	The shuttle axis is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
SHUTTLE MOTOR COMMS FAIL	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
SHUTTLE MOTOR ERROR	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
SHUTTLE - No comms	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
SHUTTLE NOT PARKED	The shuttle is in the wrong position. Touch START  , then follow the instructions on the screen to reset the position.	
Sidelay axis moving	The sidelay axis (size adjustment) is adjusting. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
SIDELAY - No comms	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
STACKER FULL	The stacker is full. Unload the books from the stacker.	

Problem	Cause	Solution
Stitch axis moving	The stitch axis is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
Stitch length will change soon	The stitch length cannot adjust at the moment. The stitch leg length will adjust after the next book.	
STITCH - No comms	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
Stitch position adjusting	The stitch position is adjusting. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
STITCH TIMEOUT	Press STOP  . Open the folder cover, remove the paper, close the folder cover.	
SYSTEM ERROR 00.20 40.21 40.22	Touch STOP to clear the message from the screen. If the message is not cleared, use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
SYSTEM ERROR 39.xx	Press the reset button on the stacker. If the message is not cleared, use the stacker mains ON/OFF switch. Turn the stacker OFF, then turn the stacker ON. If the problem continues, then call your service engineer.	
TOO MANY PAGES	The printer has delivered too many sheets into the gathering area. Remove the incorrect set. Correct the printer setting. Touch STOP  to clear the message from the screen. Check the settings for SET THICKNESS or SHEET THICKNESS .	See Open the Gathering Area Cover on page 48

Problem	Cause	Solution
TOUCH PAD ERROR	There is a fault with the START and STOP touch pads. If the problem continues, then call your service engineer.	
Touch START to clear machine	There may be some paper in the machine. Touch START ⓪ to clear the machine before you start a new job.	
Trim axis moving	The trim axis (size adjustment) is moving. This message clears when the adjustment is complete. If the message does not clear, touch ADVANCED > RE REF.	
TRIM BIN OPEN	The trim bin is not fitted or is not contacting the safety switch. Fit the trim bin.	
TRIM BLADE NOT PARKED	The trim blade is in the wrong position. Touch START ⓪ to reset the position. Follow the instructions on the screen.	
TRIM - No comms	Use the mains ON/OFF switch. Turn the machine OFF, then turn the machine ON. If the problem continues, then call your service engineer.	
USER STOP	The user has touched the STOP Ⓣ button while the machine is in operation. Touch START ⓪ to restart the machine.	

Clear Paper Jams

Introduction

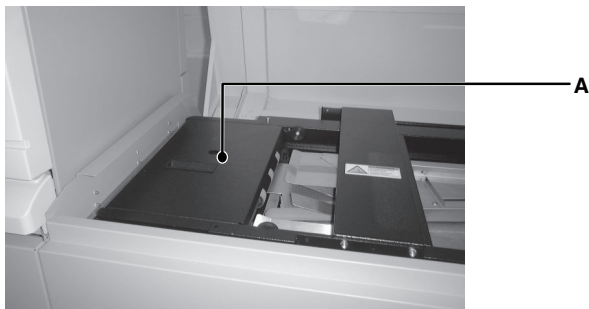


[29] Paper Jam Locations

A	Connecting Bridge
B	Gathering Area
C	Stitch Area
D	Fold and Forming Areas
E	Trim Area

Jam in the Bridge Infeed

Illustration



[30] Paper Jam Location - Bridge Infeed

A	Bridge Infeed Cover
---	---------------------

Procedure

1. Open the connecting bridge cover.

- 2.** Open the bridge infeed cover.
- 3.** Remove the jammed paper.
- 4.** Close the bridge infeed cover.
- 5.** Close the connecting bridge cover.

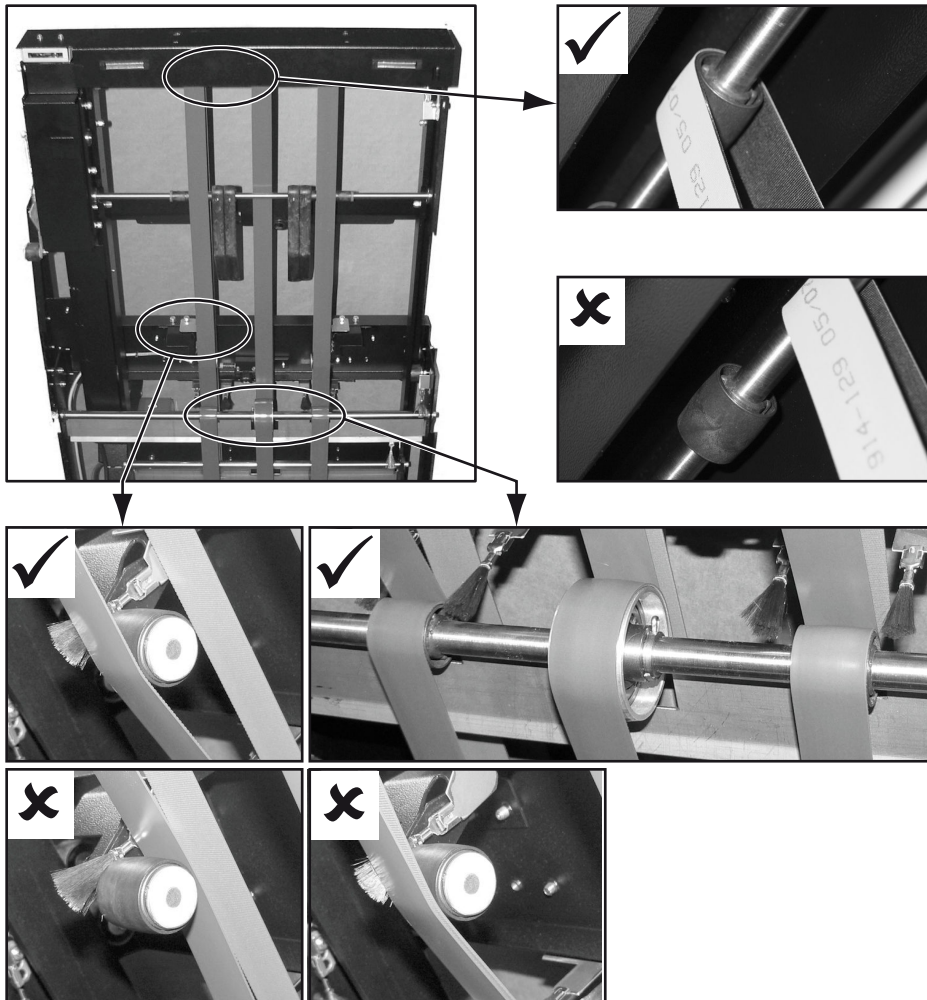
Jam in the Connecting Bridge

Procedure

1. Open the connecting bridge cover.
2. Remove the jammed paper.
3. Close the connecting bridge cover.

Jam in the Gathering Area

Illustration

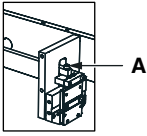


[31] Gathering Area Belt Positions

Procedure

1. Open the connecting bridge cover.
2. Lift the gathering area cover.
3. Remove the jammed paper.
4. Check the belts are in the correct position. Adjust the position of the belts if necessary (see illustration 'Gathering Area Belt Positions').
5. Close the gathering area cover.
6. Close the connecting bridge cover.

Jam in the Stitch Area

Step	Action	Information
1	Open the folder cover.	See Open the Folder Cover on page 45
2	Lift the clincher frame.	See Lift and Lower the Clincher Frame on page 46.
3	Remove the jammed paper.	
4	Check for broken or damaged stitches in the clincher area. Manually operate the clincher to clear any stitches that are jammed.	 <p>A: Press to manually operate the clincher.</p>
5	Lower the clincher frame.	See Lift and Lower the Clincher Frame on page 46
6	Close the folder cover.	

Jam in the Folder or Former Area

Procedure

1. Open the folder cover.
2. Remove the jammed paper. See [Jam in the Trim Area on page 93](#) if you cannot see the paper in the former area.
3. Close the folder cover.

Jam before the Trimmer

The error message **JAM BEFORE TRIMMER** is displayed. This error can be

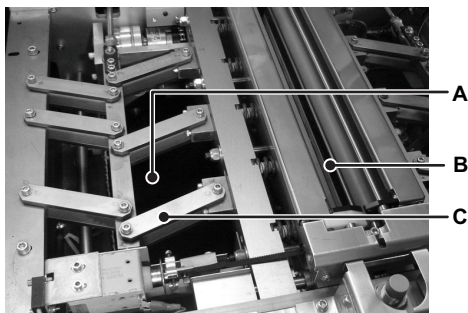
1. a book jammed before the trimmer.
2. a piece of paper trimming covered the jam sensor.

Illustration



[32] Trimmer Infeed Conveyor viewed from above.

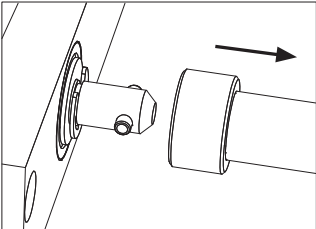
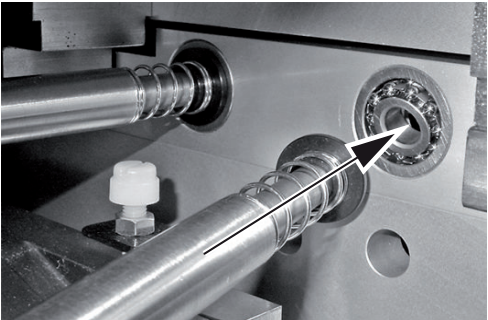
A	Trimmer Infeed Conveyor
B	Former clamp mechanism



[33] Access to the Trimmer Infeed Conveyor

A	Reach in here to access the trim-infeed conveyor
B	Former clamp - look in here for paper trimmings
C	Former clamp mechanism.

Step	Action	Information
1	Open the Booklet maker main deck	See Lift the Booklet maker Main Deck on page 49
2	Remove the trim bin.	

Step	Action	Information
3	Loosen the trimmer infeed conveyor.	<p>The procedure can be seen from the top of the machine.</p> <p>Access to the parts is through the former-clamp mechanism.</p> <p>Hold the shaft and push to the right, against spring pressure to disengage the shaft from the drive pin.</p>  <p>Lift the left hand end clear.</p>
4	Remove the book, if one is found.	
5	Remove any paper offcuts from the trimmer infeed conveyor.	<p>Look down through the former clamp. Small pieces of paper trimmings can cover the jam sensor and cause an error message.</p>
6	Fit the trimmer infeed conveyor.	 <p>Look down through the former clamp.</p> <ul style="list-style-type: none"> • Insert the right hand end of the shaft into the bearing, against the spring pressure. • Rotate the trimmer infeed conveyor, so that the green belts are vertical. • Insert the left-hand end, so that the shaft engages with the drive pin.
7	Fit the trim bin.	
8	Close the Booklet maker main deck and covers.	

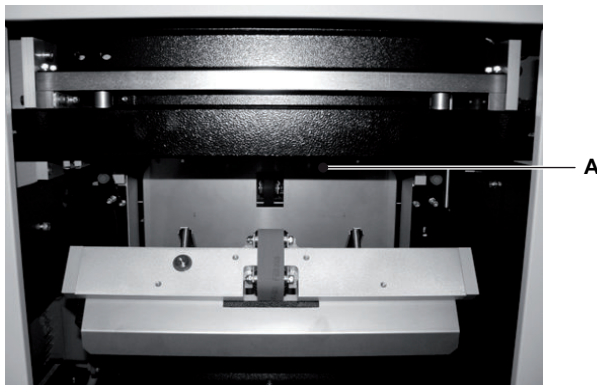
Jam in the Trim Area

Illustration



[34] Trim Stop Guard

A	Orange Plastic Hand Screw
B	Locking Plate
C	Trim Stop Guard



[35] Location of the sensor

A	Check under here for paper trimmings
---	--------------------------------------

Step	Action	Information
1	Remove the trim bin.	
2	Open the trim stop guard.	See illustration 'Trim Stop Guard'. Loosen the 2 orange plastic hand screws to release the locking plates. The locking plates can rotate to release the trim stop guard. Pull the trim stop guard towards you.
3	Remove the jammed book.	

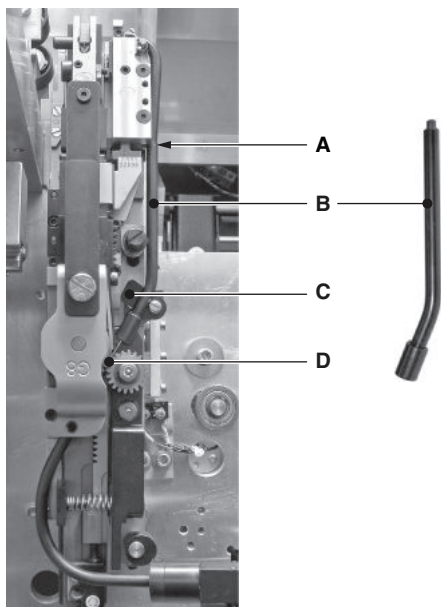
Step	Action	Information
4	Check the trim stop and remove any pieces of trimmed paper.	In particular, check around the sensor. The sensor is where you can see a red and a green light (see illustration 'Location of the sensor'). Small pieces of paper trimmings can cover the sensor and cause an error message.
5	Close the trim stop guard.	Push the trim stop guard into position. Hold the locking plates in position and tighten the orange hand screws.
6	Attach the trim bin.	

Clear a Stitch-wire Jam

Introduction

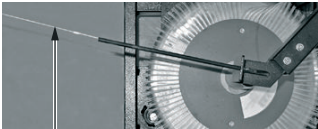
Before you begin:

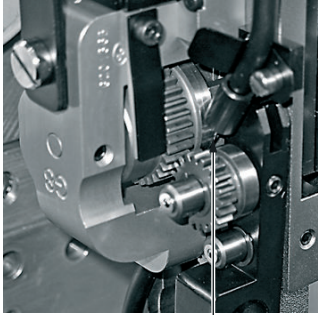
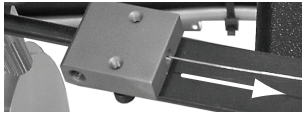
Lift the Booklet maker main deck. See *Lift the Booklet maker Main Deck* on page 49



[36] Stitch Head.

A	Top location of Middle Wire Tube
B	Middle Wire Tube
C	Metal Spring Clip
D	Feed Gears

Step	Action	Information
1	Cut the stitch-wire at position 'A' approximately 50 mm (2-inches) from where the stitch-wire leaves the stitch-wire guide.	 <p>Detail A: Cut stitch wire here.</p>

Step	Action	Information
2	Cut the stitch wire at position 'B' between the feed gears and the middle wire tube.	 <p style="text-align: center;">B</p> <p>Detail B: Cut stitch wire here.</p>
3	Pull the stitch wire from the stitch wire guide block.	 <p>Pull stitch wire in direction of arrow</p>
4	Remove the middle wire tube.	
5	Pull the wire from the stitch head.	
6	Install the stitch wire into the stitch head.	See Install the Stitch Wire into the Stitch Head on page 126

Clear a Stitch Head Jam

Introduction

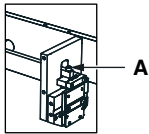

The error message **JAM IN STITCH HEAD** is displayed.

This may be caused by

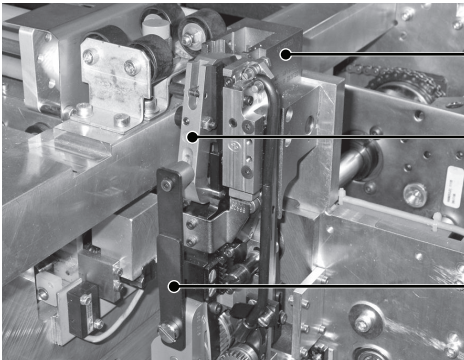
- the **SET THICKNESS** setting is incorrect
- the stitch head is jammed by broken wire
- the stitch head needs lubrication

Do Procedure 1. If the error message continues, do Procedure 2.

Procedure 1

Step	Action	Information
1	Open the folder cover.	See Open and Close the Folder Cover on page 45
2	Lift the clincher frame.	See Lift and Lower the Clincher Frame on page 46 .
3	Remove the jammed paper.	
4	Check for broken or damaged stitches in the clincher area. Manually operate the clincher to clear any stitches that are jammed.	 <p>A: Press to manually operate the clincher.</p>
5	Lower the clincher frame.	See Lift and Lower the Clincher Frame on page 46
6	Close the folder cover.	
7	Press the START button  . Follow the on-screen instructions.	

Procedure 2



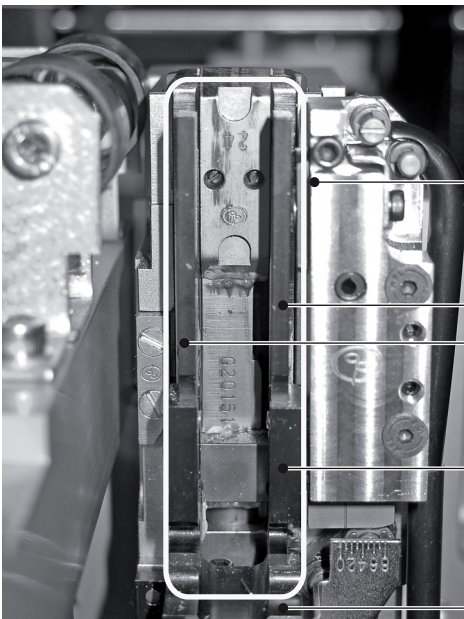
[37] Remove the stitch head wire holder

A	Stitch head
B	Wire holder
C	Wire holder retaining spring



IMPORTANT

Do not apply force to the wire guide bars or the pivot block when you do this procedure. Force on these parts will damage the stitch head.




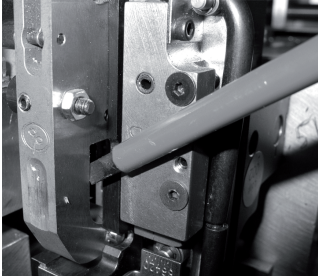
[38] Inspect for stitch wire

A	Inspect this area for pieces of stitch wire
B	Wire guide bars
C	Pivot block

Tools and Materials

- Klüber Isoflex NBU 15 Grease, 50g.
- Air duster. Supplied with the machine.
- Wire cutters. Supplied with the machine.

- Flat blade screwdriver.

Step	Action	Information
1	Lift the Booklet maker main deck.	See Lift the Booklet maker Main Deck on page 49
2	Remove the wire-holder from the stitch head.	<ul style="list-style-type: none"> • Move the wire-holder retaining spring to the right. • Remove the wire-holder <p>If the wire-holder is held in position, use a screwdriver to help remove the wire-holder from the stitch head.</p> <p> IMPORTANT Attention: Do not apply force to the wire guide bars or the pivot block.</p> 
3	Inspect the area behind the wire-holder for stitch-wire.	
4	Remove any stitches or pieces of stitch-wire and clean the area with the air duster.	Use wire cutters to remove any jammed stitches or pieces of stitch-wire.
5	Lubricate the stitch-head.	Lubricate the Stitch Head on page 118
6	Fit the wire-holder.	Remember to put the wire-holder retaining spring in position.
7	Close the Booklet maker.	
8	Start the Booklet maker.	<p>If the head operates normally and returns to the parked position, then further action is not needed.</p> <p>If the stitch-head remains jammed, then repeat the procedure again.</p> <p>If the problem continues, contact your service engineer.</p>

Calibrate the Touch Screen

When to do

Calibrate the touch screen if the buttons do not operate or the buttons do not operate correctly.



IMPORTANT

Use a pencil, the blunt end of a pen or a palm top wand for this procedure. Do not use a sharp object. Sharp objects damage the screen.

Procedure

1. Touch the STOP button ☉ 5 times.
2. Follow the instructions on the touchscreen.
You must touch the screen, where shown, as accurately as possible.
3. Touch **DONE** in the center of the screen.

Change the fuses of the Booklet Maker

Introduction

The Booklet Maker has 2 fuses located at the mains power input (see [The Rear Panel of the Booklet maker on page 14](#)). If either fuse is blown, the Booklet maker will not operate.

Required tools

Fuse description: 7A, HRC Quick Acting, F



IMPORTANT

Turn OFF the machine and remove the mains power supply cable before you change the fuses. This machine uses two fuses in parallel. To avoid the risk of fire, replace fuses using only the same type and rating.

Procedure

1. Turn OFF the Booklet maker.
2. Disconnect the Booklet maker from the power supply.
3. Turn one fuse-holder to the left and remove the fuse-holder from the Booklet maker.
4. Check the fuse.
5. If the fuse is blown, then replace with a fuse of the correct specification.
6. Repeat the procedure for the other fuse.



NOTE

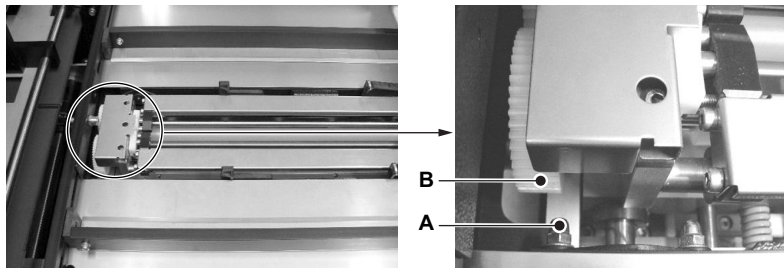
If the fuse blows again, call your service engineer.

Manually park the Shuttle

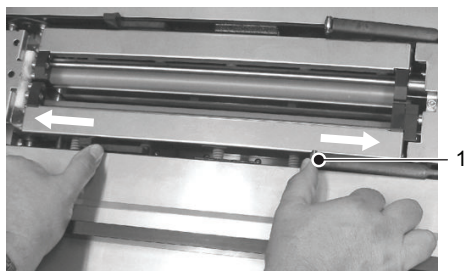
When to do

The error messages 'MANUALLY PARK SHUTTLE' and 'SHUTTLE NOT PARKED' are displayed.

Illustration



[39] Shuttle Assembly Position - CORRECT



[40] Pick-up fingers

1	Pick-up fingers
---	-----------------

Step		
1	Open the folder cover.	See Open and Close the Folder Cover on page 45
2	Push the shuttle-assembly to the end.	The illustration above shows the correct position for the shuttle assembly. Screw 'A' must be aligned with white gear 'B'. If the shuttle assembly does not move to the correct position, push the pick-up fingers away from each other by 2-3 mm and try again. Repeat if necessary. See illustration above.
3	Wait until the error message SHUTTLE NOT PARKED is cleared from the screen.	If the message does not clear, check that the shuttle assembly is in the correct position. Repeat Step 2 if necessary.
4	Close the folder cover.	

Result

The error message '**MANUALLY PARK SHUTTLE**' is cleared from the screen. The shuttle axis references and the message **Shuttle axis moving** is displayed.

When the message list is clear, you can continue operation

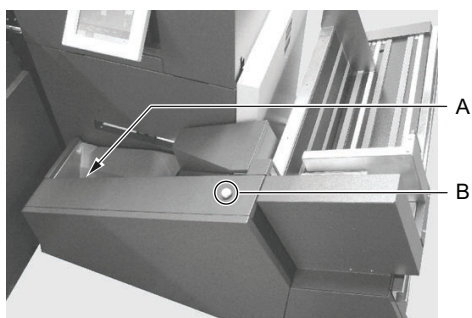
Clear Paper Jams of the optional Book Stacker

Jam at Book Stacker infeed

When to do

The error message **JAM AT STACKER INFEED** is displayed. This means a book covers the sensor at the Book Stacker infeed.

Illustration



[41] Book Stacker infeed

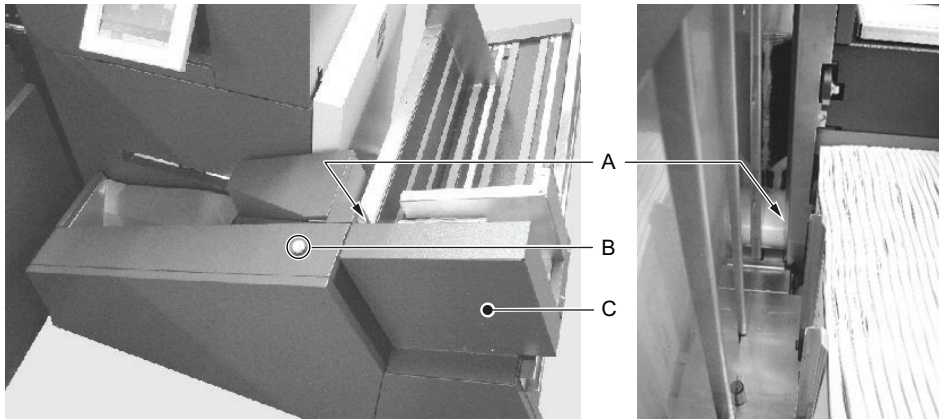
A	Book Stacker infeed
B	Book Stacker reset button

Procedure

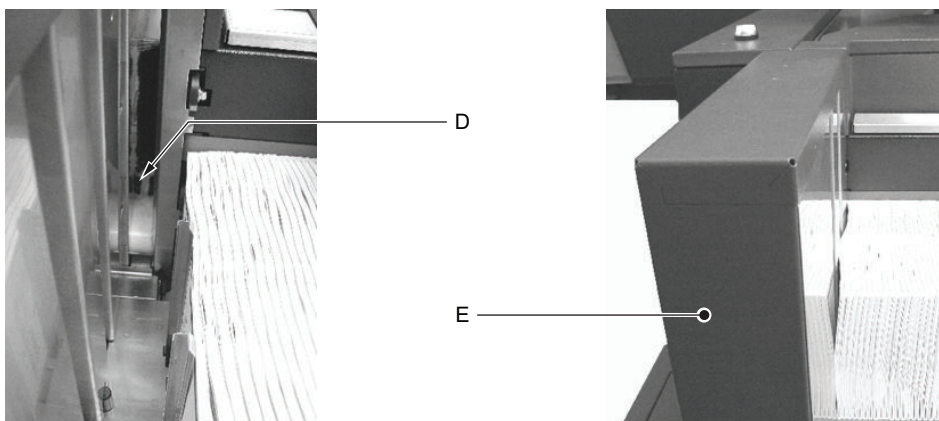
1. Remove the book.
2. If you are making thin books, attach the magnetic paper guide (see [Adjust the Book Stacker on page 56](#)).
3. Press the reset button on the Book Stacker.

Jam at Book Stacker outfeed

Illustration



[42] Book Stacker outfeed - 1



[43] Book Stacker outfeed - 2

A	Book Stacker outfeed
B	Book Stacker reset button
C	Pusher
D	Book Stacker outfeed is visible.
E	The pusher is in forward position. The Book Stacker outfeed is not visible.

The error message **JAM AT STACKER OUTFEED** is displayed. This means a book or some paper trimmings cover the sensor at the Book Stacker outfeed.

If the Book Stacker outfeed is visible:

Step	Action	Information
1	Remove the book, if present.	
2	Check for paper trimmings and remove them, if present.	

Step	Action	Information
3	Press the reset button on the Book Stacker.	

If the pusher is in the forward position so that the Book Stacker outfeed is not visible:

Step	Action	Information
1	Use your hand to move the pusher to the left, against the spring pressure.	
2	Remove the book, if present.	
3	Check for paper trimmings and remove them, if present.	
4	Press the reset button on the Book Stacker.	

Change the fuses of the optional Book Stacker

Introduction

The Book Stacker has 2 fuses at the power input connector (see [The mains input panel of the optional Book Stacker on page 15](#)).

If either fuse has blown, the Book Stacker will not operate.

Required tools

Fuse description: 3A, HRC Quick Acting, F



IMPORTANT

Turn OFF the machine and remove the mains power supply cable before you change the fuses. This machine uses two fuses in parallel.



IMPORTANT

To avoid the risk of fire, replace fuses using only the same type and rating.

Procedure

1. Turn OFF the Book Stacker.
2. Disconnect the Book Stacker from the power supply.
3. Check each fuse.
4. If the fuse is blown, then replace with a fuse of the correct specification.



NOTE

If the fuse blows again, call your service engineer.

Chapter 7

Maintenance

About Maintenance

Service Interval

- The Booklet maker needs service every six months.
- After every one million stitches, the stitch head needs service. This interval is every third spool of stitch-wire.

Only a service engineer can service the Booklet maker. Contact your supplier for further information.

Operator Maintenance

Correct maintenance by the operator makes sure that

- The machine operates correctly
- The machine makes high-quality books
- The machine is safe to use
- Small problems can be identified early

Operator Maintenance Plan

Interval	Task	Reference
• Every week	Clean the machine.	See Booklet maker cleaning on page 111
When the message OPERATOR MAINTENANCE is displayed on the screen.	Lubricate the stitch head.	See Lubricate the Stitch Head on page 118
	Clean the former roller.	See Clean the Former Roller on page 112
	Clean the polyurethane strips in the form clamp.	See Clean the Polyurethane Strips in the Form Clamp on page 113
	Clean the trimmings-removal fingers.	See Clean the Trimmings Removal Fingers on page 115
	Clean excess grease from the stitch head.	See Clean excess grease from the Stitch Head on page 117

Booklet maker cleaning

Introduction

Clean the Booklet maker every week to remove surface dust.



IMPORTANT

Only clean the machine with materials that are recommended in this manual. Do not use other chemicals or abrasive material.

Outside of the Booklet maker

Use a moist cloth to clean the outside of the Booklet maker.

Touch screen

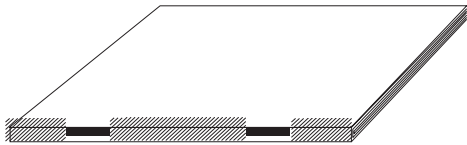
Clean the touch screen with a clean, dry cloth. Never use an abrasive material or chemical to clean the touch screen. Light pressure with a clean, dry cloth is enough to remove fingerprints. Do not use too much force.

Clean the Former Roller

Introduction

Clean the former roller:


- Every month, as part of the operator maintenance plan.
- If the spines of the books are dirty. Ink and toner can collect on the former roller.



[44] Dirty marks on the spine

Required tools

Clean, plain paper that is not printed. A3 size (USA: 11 x 17") is recommended. 4mm thickness is needed for each cycle. More than one cycle can be needed

Step	Action	Information
1	Enter the correct settings on the touch screen.	<ul style="list-style-type: none"> • Set the touch screen to the correct PAPER SIZE • Set the SET THICKNESS to 4.0 • Set the number of STITCHES to 0. • Set the number of FORMS to 4.
2	Touch START 	
3	Open the connecting bridge cover.	
4	Lift the gathering area cover.	
5	Put 4mm of clean paper in the gathering area.	
6	Press the two orange buttons and hold for 9 seconds, or until you hear the folder operate.	

Result

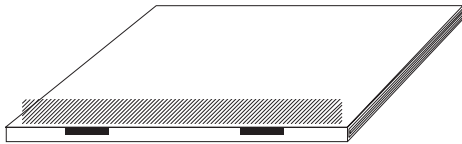
The book is delivered to the stacker. Check the book. Repeat the procedure until the book spine is clean.

Clean the Polyurethane Strips in the Form Clamp

Introduction

Clean the polyurethane strips in the form clamp:

- Every month, as part of the operator maintenance plan.
- If there are dirty marks near the spine on the front and back cover of the book. Ink and toner can collect on these parts, especially when you make thin books.



[45] Dirty marks beside the spine

Required tools

Alcohol wipe or

A lint free cloth and alcohol (isopropanol)



IMPORTANT

Only use alcohol to clean this part of the machine. Other chemicals can damage the machine.



CAUTION

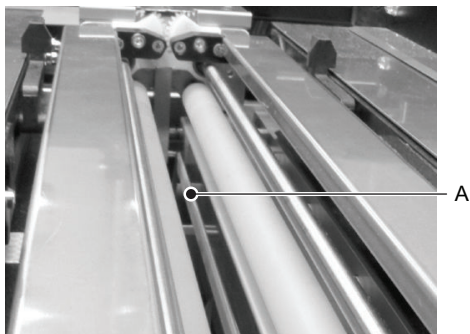
Wear protective gloves when you use the alcohol wipe.



NOTE

If you push the eject rollers, the rollers can move together against your hand. This movement can alarm you, but is not dangerous.

Illustration



[46] Polyurethane strips

A	Polyurethane strip
---	--------------------

Step	Action	Information
1	Open the folder cover	

Clean the Polyurethane Strips in the Form Clamp

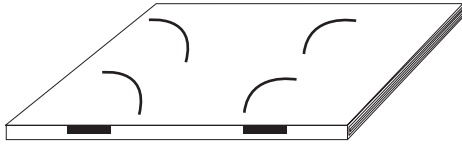
Step	Action	Information
2	Use an alcohol wipe, or apply a small amount of alcohol to a lint free cloth.	Wear protective gloves when you use the alcohol wipe.
3	Reach into the form clamp and clean each of the polyurethane strips.	There is a polyurethane strip on the face of each side of the clamp. Repeat this step until the polyurethane strips are clean.
4	Close the folder cover	

Clean the Trimmings Removal Fingers

Introduction

Clean the trimming removal fingers:

- Every month, as part of the operator maintenance plan.
- If there are small, dirty marks on the book. Ink and toner can collect on the trimmings removal fingers and cause marks on the book.



[47] Curved marks on the book

Required tools

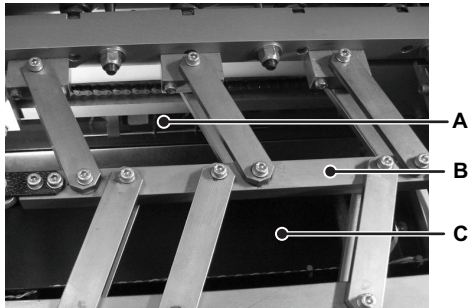
Alcohol wipe



CAUTION

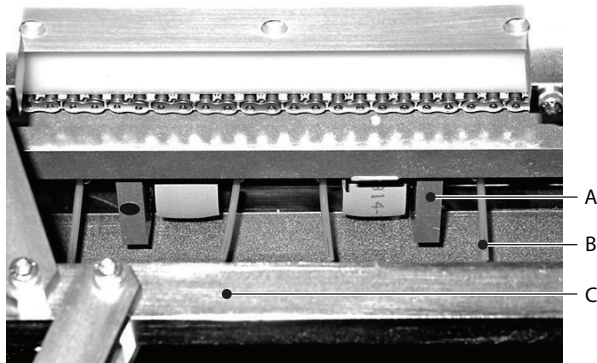
Wear protective gloves when you use the alcohol wipe.

Illustration



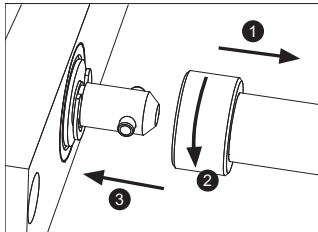
[48] Trimmer infeed conveyor viewed from above 1

A	Trimmer infeed conveyor
B	Former clamp mechanism
C	Reach in here to access the trim-infeed conveyor



[49] Trimmer infeed conveyor viewed from above 2

A	Trimmer infeed conveyor
B	Trimmings removal fingers
C	Former clamp mechanism

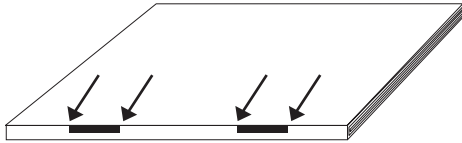
Step	Action	Information
1	Lift the Booklet maker main deck.	See Lift the Booklet maker Main Deck on page 49 .
2	Remove the trim bin.	
3	Clean the four visible trimmings-removal fingers with an alcohol wipe.	The procedure can be seen from the top of the machine. Access to the parts is through the former-clamp mechanism (see illustration 'Trimmer infeed conveyor viewed from above 1'). Wear protective gloves when you use the alcohol wipe.
4	Rotate the conveyor shaft by half a turn.	1. Hold the shaft and push to the right, against spring pressure to disengage the shaft from the drive pin.  2. Rotate the shaft by half a turn. 3. Align the shaft with the drive pin and release.
5	Clean the four visible trimmings-removal fingers with an alcohol wipe.	Wear protective gloves when you use the alcohol wipe.
6	Fit the trim bin.	
7	Close the Booklet maker.	

Clean excess grease from the Stitch Head

Introduction

Clean excess grease from the stitch head:

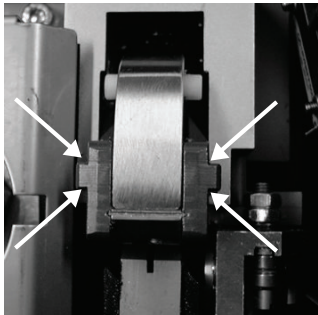
- Every month, as part of the operator maintenance plan.
- If there are grease marks around the stitches on the book.



[50] Grease marks around the stitches

Required tools

Lint free cloth

Step	Action	Information
1	On the user interface, touch ADVANCED > STITCHER UP > STITCHER UP	The folder cover must be closed. This action moves the stitch head to the correct position for lubrication.
2	Open the folder cover.	Open and Close the Folder Cover on page 45
3	Lift the clincher frame.	Lift and Lower the Clincher Frame on page 46
4	Clean grease from the sides of the stitch head.	
5	Lower the clincher frame.	
6	Close the folder cover.	

Lubricate the Stitch Head

Introduction

Lubricate the stitch head:

- Every month, as part of the operator maintenance plan.
- When a new stitch-wire is installed if this interval is shorter.

Required tools

Klüber Isoflex NBU15 Grease, 50g

Air duster



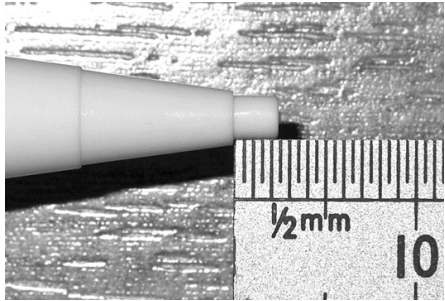
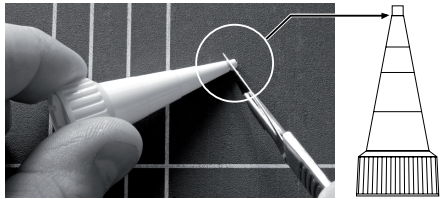
IMPORTANT

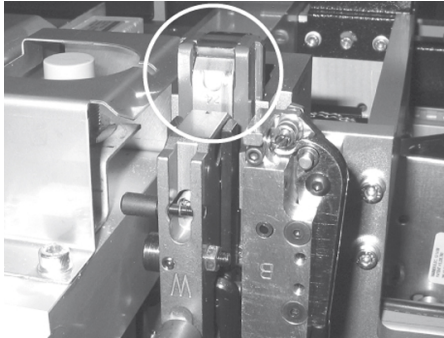

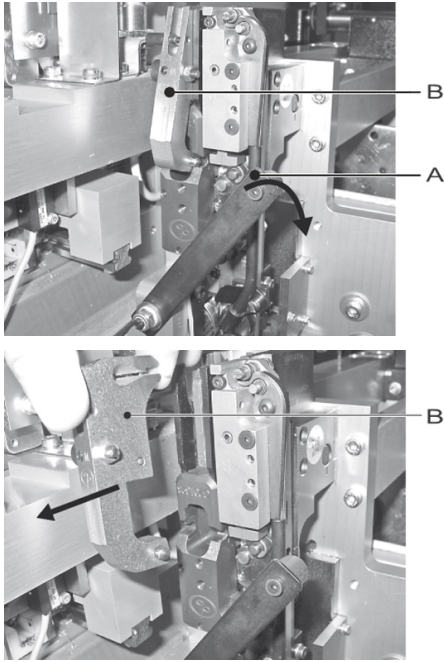
Only use the grease shown in this manual. Correct lubrication extends the performance and service life of the stitch head. Other types of grease do not protect the stitch head.



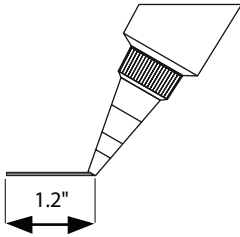

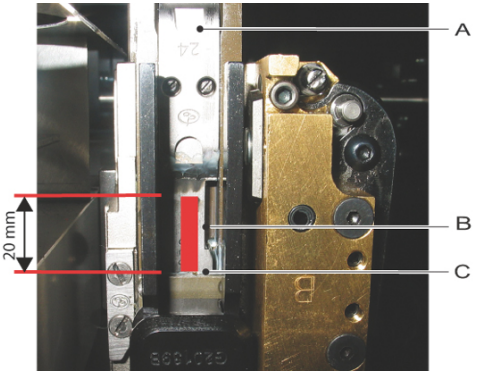

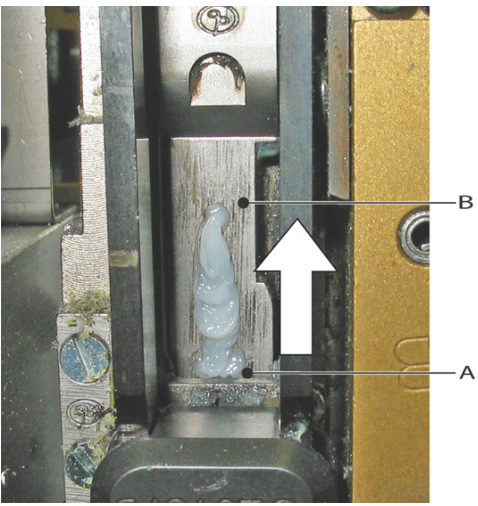
IMPORTANT

Only apply the grease as shown. If you apply additional grease, the paper will become stained.

Step	Action	Information
1	Trim the first 2.5 mm from the nozzle.	 <p>[51] Tip of the nozzle</p>  <p>[52] Trim the nozzle of the tube of grease</p>
2	Remove the cap from the tube of grease.	
3	Fit the nozzle to the tube of grease.	
4	On the user interface, touch ➤ ADVANCED > STITCHER UP > STITCHER UP	The folder cover must be closed. This action moves the stitch head to the correct position for lubrication. ▶

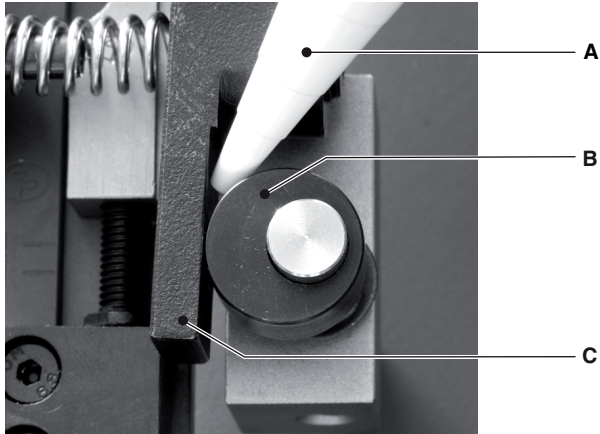
Step	Action	Information
5	Lift the Booklet maker main deck	<p>See Lift the Booklet maker Main Deck on page 49</p> <p>You will see that the stitch head is in the 'STITCHER UP' position.</p> 
6	Use the supplied air duster to remove dust from the stitch head.	
7	<p>Remove the wire holder from the stitch head:</p> <ul style="list-style-type: none">• Move the wire holder retaining spring 'A' to the right.• Remove the wire holder 'B'.	

Apply Grease to the Driver Bar

Step	Action	Information
1	Apply a thin line of grease from the tube (20 mm long and maximum 0.5 mm thick) to the visible surface of the driver bar.	 <p>[53] Maximum dimensions of the line of grease</p>
	<p> NOTE Make sure that you apply the grease in an upward direction, from the bottom of the driver bar.</p>	 <p>[54] Driver bar A = Driver B = Apply grease here C = Driver bar</p>
	<p> NOTE Only apply the grease as shown. If you apply additional grease, the paper will become stained.</p>	 <p>[55] Apply the grease to the driver bar A = Start B = Stop</p>
2	Fit the wire holder.	

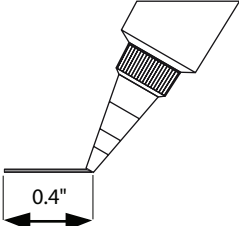
Lubricate the wire-feed cam

Illustration



[56] Lubricate the wire-feed cam

A	Nozzle of the tube of grease
B	Wire-feed cam
C	Feed lever

Step	Action	Information
1	Apply 10 mm of grease from the tube between the bearing surface of the wire-feed cam and the feed lever.	See the 'Lubricate the wire-feed cam' illustration above. 
2	Lower the Booklet maker main deck.	
3	Lower the clincher frame.	See Lower the Clincher Frame on page 47
4	Close all of the covers.	
5	Make some test books.	
6	Clean excess grease from the top of the stitch head.	See Clean excess grease from the Stitch Head on page 117

Reset the Operator Maintenance Counter

Procedure

1. Touch **MENU**.
2. Touch and hold **RESET**. A red line appears. The red line fills from left to right. Hold **RESET** until the red line reaches the right-hand side.
3. Touch **MENU**.

Install New Stitch Wire

Introduction

Only use stitch-wire that is approved by your supplier. Stitch-wire that is not approved by your supplier can cause poor performance and voids the warranty.

Stitch-wire Description: Sticher wire S33.

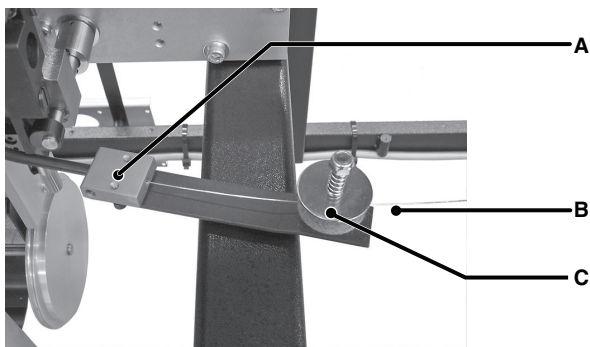
Before you begin

Lift the Booklet maker main deck.

See [Lift the Main Deck on page 49](#)

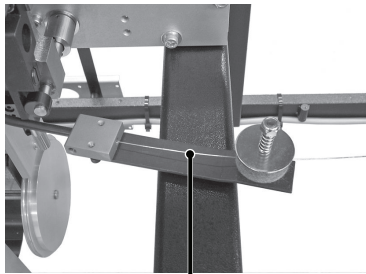
Remove the Stitch-wire from the Stitch Head

Illustration



[57] Stitch-wire Guide Block

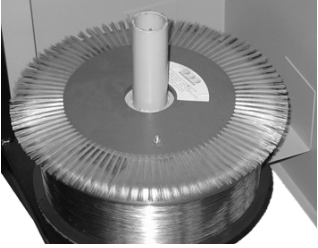
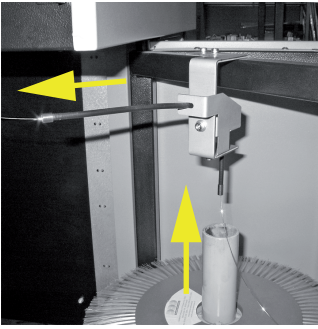
A	Stitch-wire Guide Block
B	Stitch-wire
C	Felt wire-cleaning pads

Step	Action	Information
1	Cut the stitch-wire to the right of the stitch-wire guide block.	 <p>Detail A: Cut here</p>
2	Pull the stitch wire from the stitch wire guide block.	

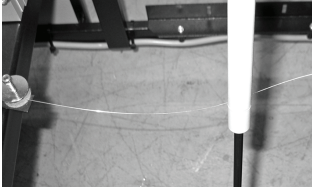
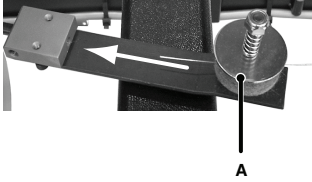
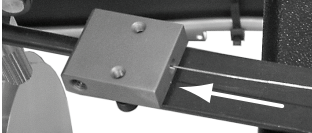
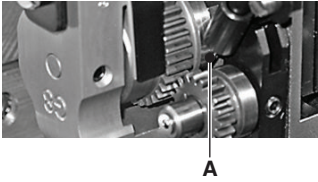
Remove the Stitch-wire from the Stitch Head

Step	Action	Information
3	Fit a new stitch-wire spool.	<i>Fit a New Stitch-wire Spool</i> on page 125

Fit a New Stitch-wire Spool

Step	Action	Information
1	Open the stitch-wire cabinet	
2	Remove the stitch-wire cap and finished stitch-wire spool.	
3	Fit a new stitch-wire spool.	
4	Fit the stitch-wire cap	
5	Loosen the end of the stitch-wire from the edge of the stitch-wire spool.	
6	Use wire-cutters to remove the damaged end of the stitch-wire.	Remove enough stitch-wire to leave the end of the stitch-wire clean and straight.
7	Feed the stitch-wire through the stitch-wire guide.	
8	Install the stitch-wire.	<i>Install the Stitch Wire into the Stitch Head on page 126</i>


Install the Stitch Wire into the Stitch Head

Step	Action	Information
1	Pull the stitch-wire from the end of the stitch-wire guide.	
2	Make sure the stitch-wire runs behind the gas-strut.	
3	Feed the end of the stitch-wire between the felt wire-cleaning pads.	 <p data-bbox="884 840 1278 869">Detail A: Felt Wire-Cleaning Pads</p>
4	Push the stitch-wire into the stitch-wire guide block.	 <p data-bbox="884 1037 1329 1066">Push stitch-wire in direction of arrow</p>
5	Push the stitch-wire as far as possible.	 <p data-bbox="884 1281 1422 1377">Detail A: Make sure the stitch-wire runs between the wire feed rollers and into the middle wire tube.</p>

Close the Booklet maker

Step	Action	Information
1	Close the stitch-wire cabinet.	
2	Lower the Booklet maker main deck.	Lower the Clincher Frame on page 47.
3	Lower the clincher frame.	
4	Close the folder cover.	
5	Close the connecting bridge cover.	

Feed the Stitch-wire

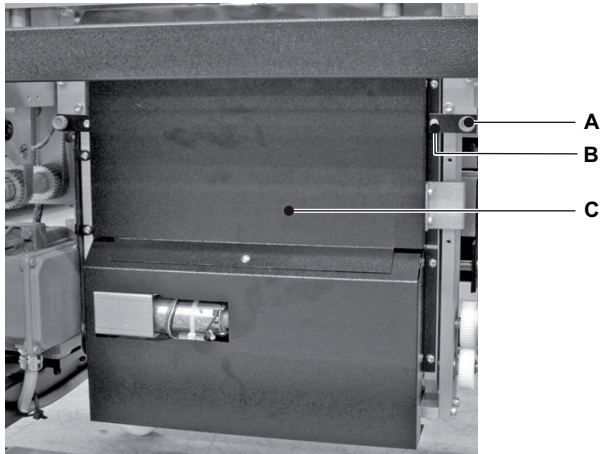
Step	Action	Information
1	Touch START  .	
2	Set the number of stitches to 6.	Touch BASIC > STITCHES .
3	Hand-feed or print an A4 or larger size test job.	Enter the correct settings on the touch screen according to the size and thickness of the job. The stitch-wire loads automatically during the stitch head cycle.
4	Check that the stitch-wire is loaded.	Check that a stitch is made. If needed, repeat the previous step. If a stitch is still not made, repeat the procedure. Install the Stitch-wire into the Stitch Head. <i>Install the Stitch Wire into the Stitch Head on page 126.</i>
5	Reset the number of stitches on the touch screen.	

Clear paper from the trim stop

Introduction

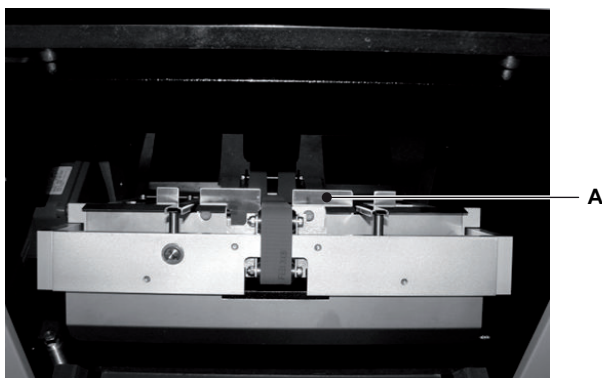
Clear paper from the trim stop if the books are not trimmed square. If paper trimmings collect on the trim stop, the books are not trimmed square.

Illustration



[58] Trim Stop Guard

A	Orange Plastic Hand Screw
B	Locking Plate
C	Trim Stop Guard



[59] Trim Stop

A	Trim Stop
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Step	Action	Information
1	Remove the trim bin.	

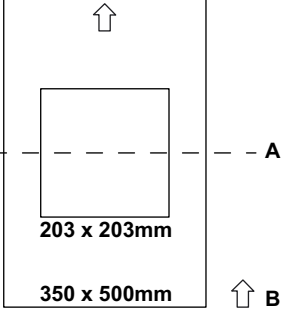
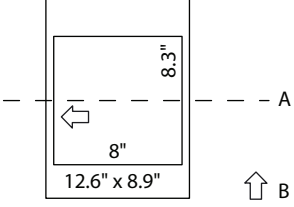
Clear paper from the trim stop

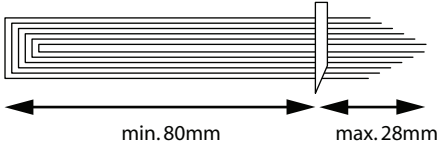
Step	Action	Information
2	Open the trim stop guard.	Loosen the 2 orange plastic hand screws to release the locking plates. The locking plates can rotate to release the trim stop guard. Pull the trim stop guard towards you.
3	Check the trim stop and remove any pieces of trimmed paper.	
4	Close the trim stop guard.	Push the trim stop guard into position. Hold the locking plates in position and tighten the orange hand screws.
5	Attach the trim bin.	

Appendix A

Specifications

Specifications

<p>Operating Conditions</p>	<p>10-35 °C 35-85% relative humidity Up to 2,000 m above mean sea level</p>
<p>Production</p>	<p>Cycle time: Printer dependent Inter-set gap: 1 second (if printer has DFD2, then 1 or 2 seconds, depending on job settings) Minimum set time: 4.2 seconds (if printer has DFD2, then 4.5 or 7.8 seconds, depending on job settings) Maximum set time: 12.5 seconds</p>
<p>Stock Sizes</p>	<p>Minimum input size: 203 mm x 203 mm Maximum input size: 350 mm x 500 mm</p>  <p>A = Stitch & fold line B = indicates original lead edge from the printer</p>
<p>Sheet Rotation</p>	<p>Integrated rotator ensures maximum printer productivity. Maximum rotation sheet size: 320 mm x 227 mm Minimum rotation sheet size: 210 mm x 203 mm The cross-track dimension of the sheet (before rotation) must be at least 7 mm greater than the in-track dimension.</p>  <p>A = Stitch & fold line B = indicates original lead edge from the printer</p>
<p>Stock Range</p>	<p>80 - 160 g/m² normal paper types 60 - 250 g/m² dependent on paper type and quality</p>
<p>Book Thickness</p>	<p>Maximum finished book thickness: 10.4 mm (208 pages of 80 g/m²; 224 pages of 70 g/m² dependent on paper type and paper quality) Maximum set thickness: 5.2 mm (52 sheets of 80 g/m²; 56 sheets of 70 g/m²; dependent on paper type and paper quality)</p>
<p>Stitching</p>	<p>1 - 6 stitches, evenly spaced on the spine of the book Stitches/spool: up to 291,500 Books*/spool: approximately 127,000</p>

<p>Trimming</p>	<p>Maximum fore-edge trim: 28 mm Minimum trimmed book size: 80 mm</p>  <p>The diagram shows a side view of a book with multiple pages. A double-headed arrow below the book indicates a minimum length of 80mm. Another double-headed arrow at the fore-edge indicates a maximum trim of 28mm.</p>
<p>Stacker Capacity</p>	<p>Standard Stacker: 35 books* Book Stacker (optional): 930 mm</p>
<p>Paper Input Requirements</p>	<p>Input sheets must be of consistent size and cut square. Machine setting must match paper size at the input to the Océ BLM550+ Book quality is dependent upon quality of input sheets.</p>
<p>Dimensions</p>	<p>Footprint With Standard Stacker: 1870 mm x 1675 mm With Book Stacker: 2420 mm x 1770 mm Height 1330 mm maximum</p>
<p>Weight</p>	<p>Booklet maker including stitching wire: 542 kg As above, plus bridge and bridge covers: 702 kg/1548 lbs. Book Stacker: 150 kg/330 lbs.</p>
<p>Power Supply</p>	<p>Adjustable to 200, 208, 220, 230 and 240V 50/60Hz, single phase</p>
<p>Power Consumption</p>	<p>Océ BLM550+ Stand-by: 92VA (75W) In operation: 700VA (500W) Book Stacker Stand-by: 35VA (16W) In operation: 75VA (53W)</p>
<p>Noise Emission</p>	<p>Stand-by: ambient In operation: 66 dB (A), peak 87 dB (A)</p>
<p>Approvals</p>	<p>Complies with CE and UL. Conforms to FCC rules Part 15 Class A and VCCI Class A.</p>
<p>* Standard book is made from 20 sheets of 80 g/m² paper, with 2 stitches.</p>	
<p>Production may vary according to operating conditions. In line with a policy of continual product improvement, the manufacturer reserves the right to alter the materials or specification of this product at any time without notice.</p>	

Appendix B

Declaration of Conformity

Declaration of Conformity

According to ISO/IEC 17050-1

Name of Manufacturer:	Watkiss Automation Limited
Address of Manufacturer:	Watkiss House Blaydon Road Sandy, Bedfordshire SG19 1RZ United Kingdom
Declares that the product:	
Name of Product:	<ul style="list-style-type: none"> • Océ BLM550⁺ Serial Number: WA/PSQ/---/0800 onwards • Book Stacker Serial Number: WA/PBS/---/0001 onwards
Conforms to the following Directives:	
Safety:	2006/95/EC Council Directive 'on the approximation of laws of Member States relating to electrical equipment designed for use within certain voltage limits'. EN 60950-1:2006 (ed.2) + A11:2009 + A1:2010 + A12:2011
EMC:	2004/108/EC Council Directive 'on the approximation of laws of Member States relating to electromagnetic compatibility'. EN55022:2010 Class A EN55024:2010 EN61000-3-2:2006 + A1:2009 + A2:2009 EN61000-3-3:2008
RoHS:	2006/65/EC Council Directive
WEEE:	2002/96/EC Council Directive amended by 2008/34/EC and 2008/35/EC
Reach:	REGULATION (EC) No. 1907/2006
	M C Watkiss Technical Director, Watkiss Automation Ltd. May 21, 2013

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