Operator Manual BLM6700
DBCB-0512-0081-V003

BLM6700 for Booklet Maker 6700 Line

SDD
Smart Dedicated Design

BOOKLET MAKER
BLM6700

OPERATOR MANUAL

About this manual.

Machines have much in common but there are differences because they can be mirrored, have different colours or additional options. Therefore the machine on the pictures in this manual may be different.

This machine must be installed by a qualified technician.

Safety.

Carefully read the Safety Instruction Document (**DBCH-0512-0000-V000**) before installing, servicing or operating your equipment.

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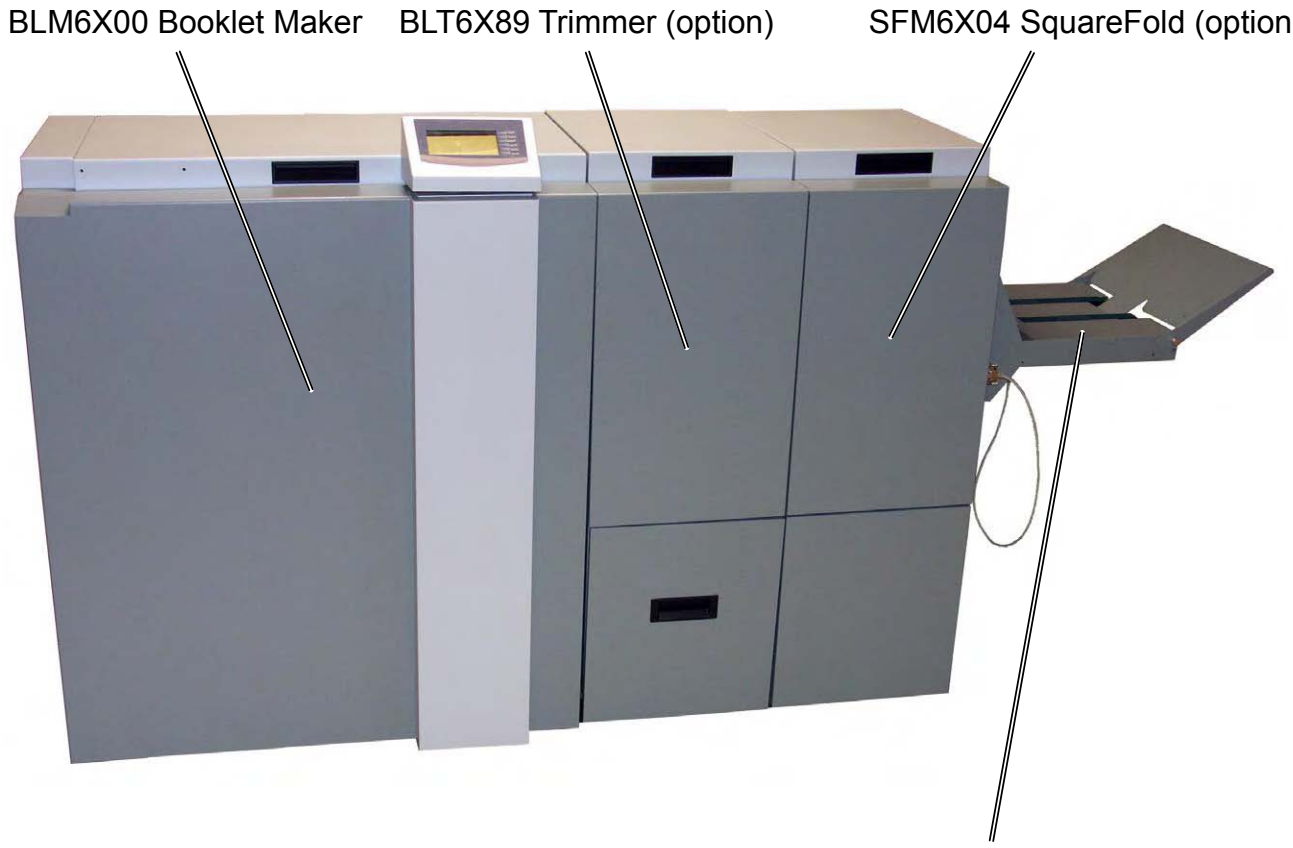
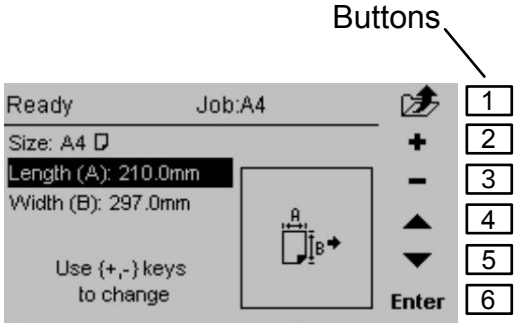
What You Can Do With This Machine



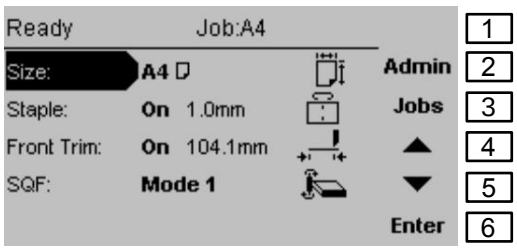
The Booklet Maker BLM6X00, Trimmer BLT6X89 and SquareFold SFM6X04 form a booklet making system that works online with Copiers or Printers.

The print-outs from the Copier or Printer are transported sheet by sheet into the BLM Booklet Maker and collected in the stapler area of the BLM Booklet Maker. The Booklet Maker now jogs and then staples the set. The set is then transported further to the folding area where the set is folded into a booklet and then fed out to the belt stacker.
When a larger number of sheets are folded an effect called creeping occurs. In order to rectify creep, the BLT Trimmer (optional) can be connected to the Booklet Maker. The booklets are then transported from the Booklet Maker into the Trimmer where the front edge (face) will be cut off.
The Two-side Trimmer can be (optional) used for trimming the bleed out off the booklet. By using the Two-Side Trimmer, the booklets can be trimmed off 2mm to 35mm each side, to a minimum of 200mm and a maximum of 320mm. It is also possible to trim a-symmetrical.
Another option, the SFM SquareFold Module, can be installed if a BLT Trimmer is installed on the BLM Booklet Maker. The prints, which have been stapled, folded and trimmed will be fed into the SFM. The SFM will flatten the spine of the booklet into a square shape. The booklets will, after passing through the SFM, have the look of a perfect bound book.
The booklets are then fed out to the Belt Stacker.

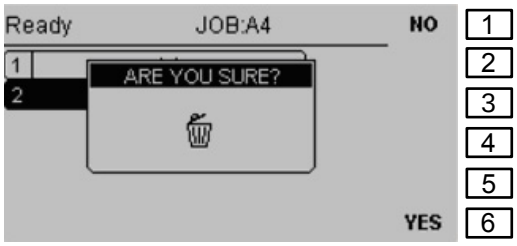
The entire BLM Booklet making system is controlled from a single control panel on the Booklet Maker. The control panel has only six buttons which will allow you to easily set up, adjust and operate the complete system.



The buttons are multi functional, meaning that the function of each button depends on the information displayed.
For example: In this screen, the icon next to button 1 indicates you will go up one level in the menu when the button is pressed.



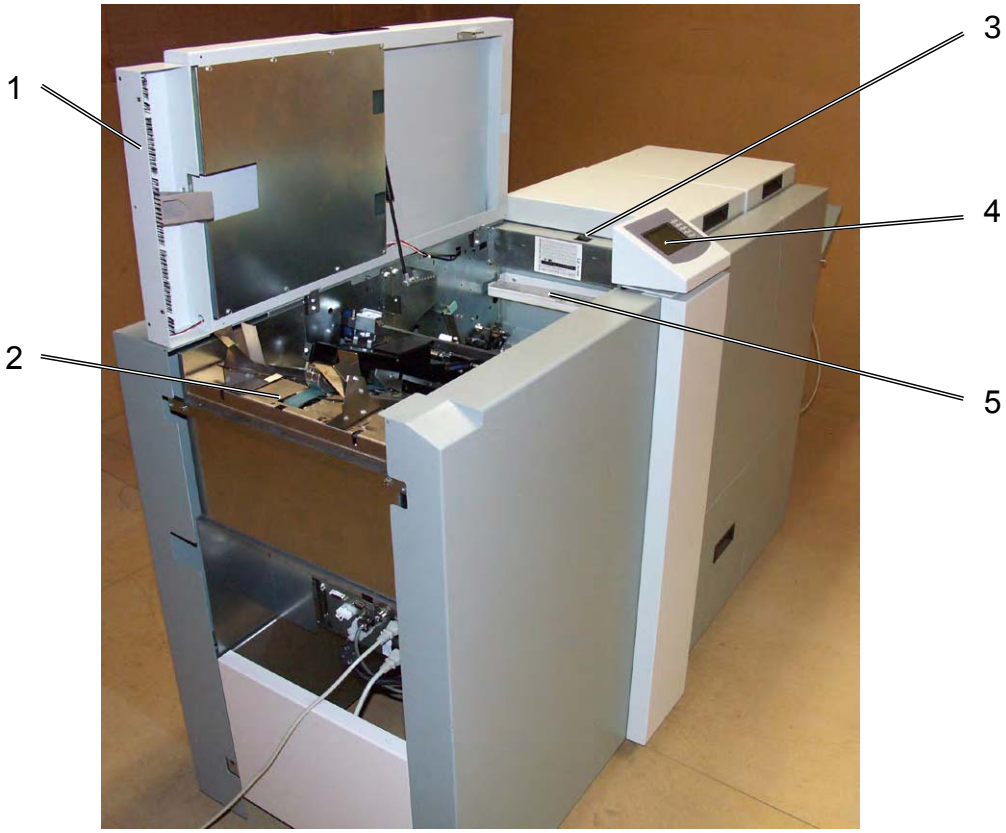
Example 2: In this screen, button 1 has no function.

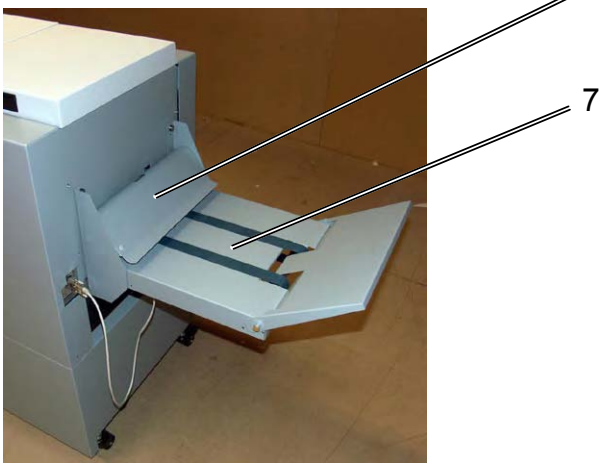


Example 3: Pressing button 1 here will answer “No” to the question on the screen.

Guide To Components

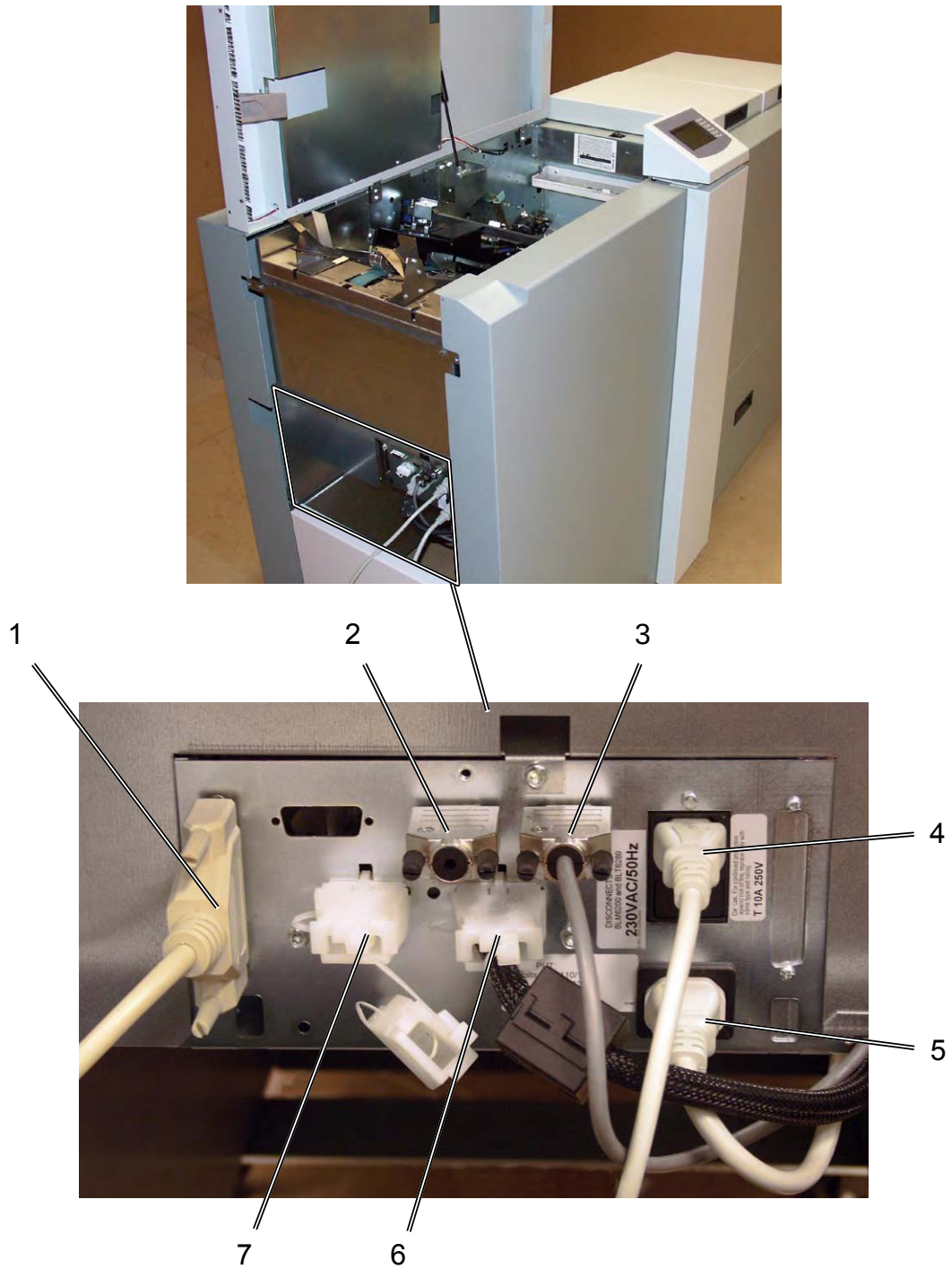
Booklet Maker





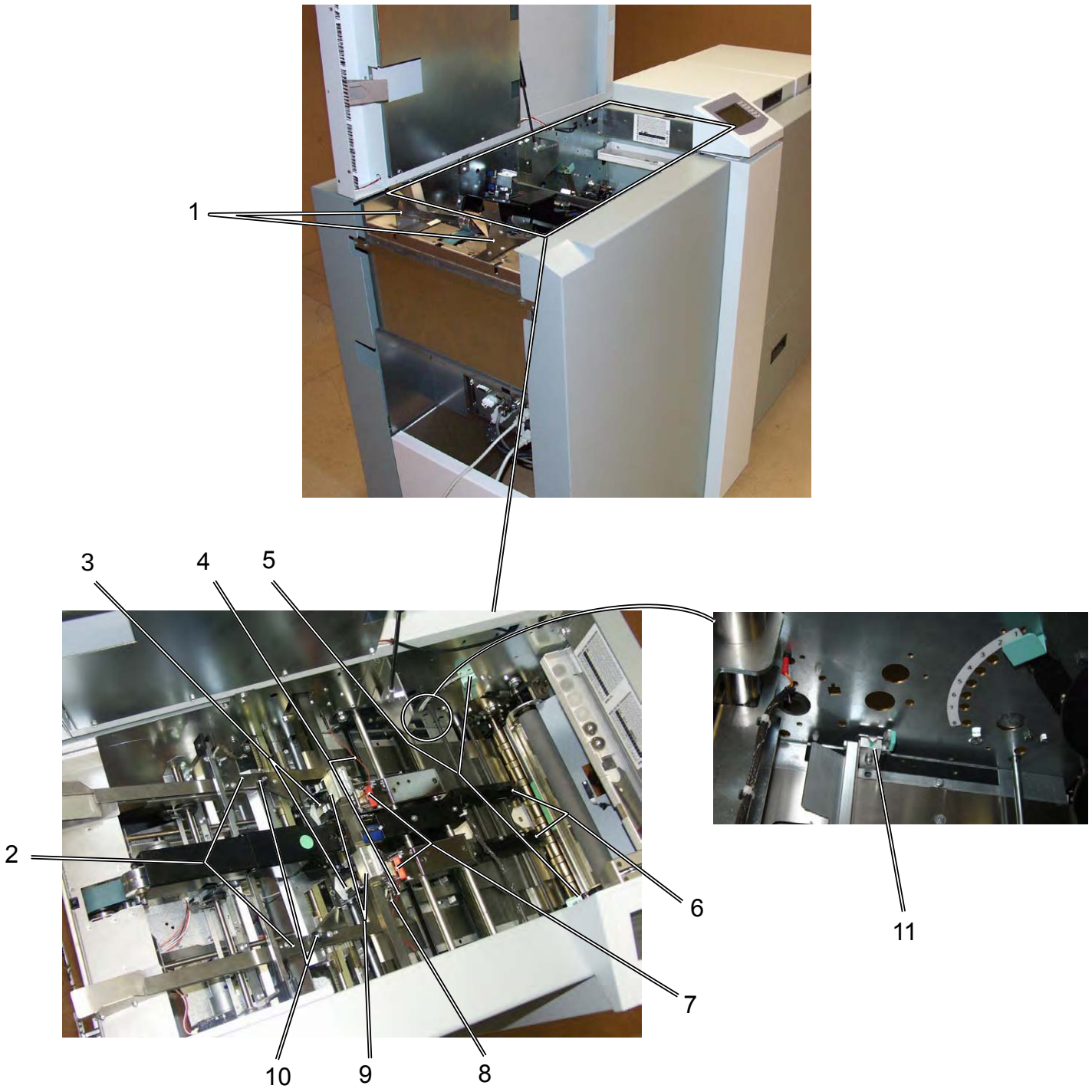
1	Top cover	5	Tool box
2	Infeed assembly	6	Belt Stacker Cover
3	Power switch	7	Belt Stacker
4	Control panel		

Booklet Maker, continued



1	Communication with Printer/Rotator	4	Power socket
2	CAN In: Termination socket	5	Power out to SFM6X04 / BLT6X02
3	CAN Out: Termination socket / Communication with BLT6X89	6	Interlock jumper / Power out to BLT6X89
		7	Interlock jumper

Booklet Maker, continued



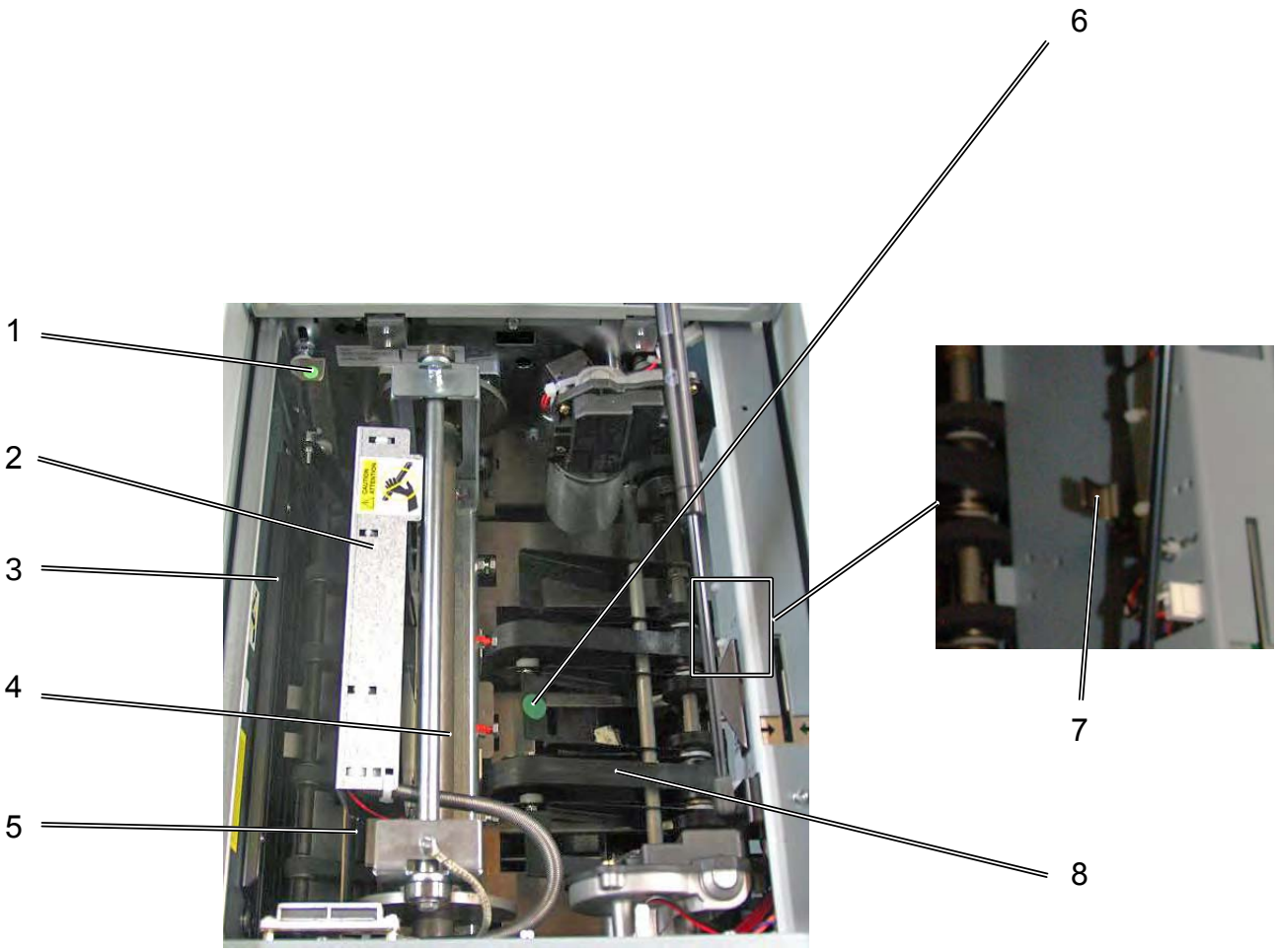
1	Side guides	7	Cartridge locking levers
2	Side guide extension	8	Locking pin
3	Stapler heads	9	Stapler lift bracket
4	Staple detection leads	10	Thumb screw for Side guide extension
5	Fold adjust lever	11	Fold stop adjustment lever
6	Ball cage		

Trimmer

1 Top cover
2 Trim bin

Trimmer, continued

The Trimmer interior has parts that you will come into contact with if a jam occurs.



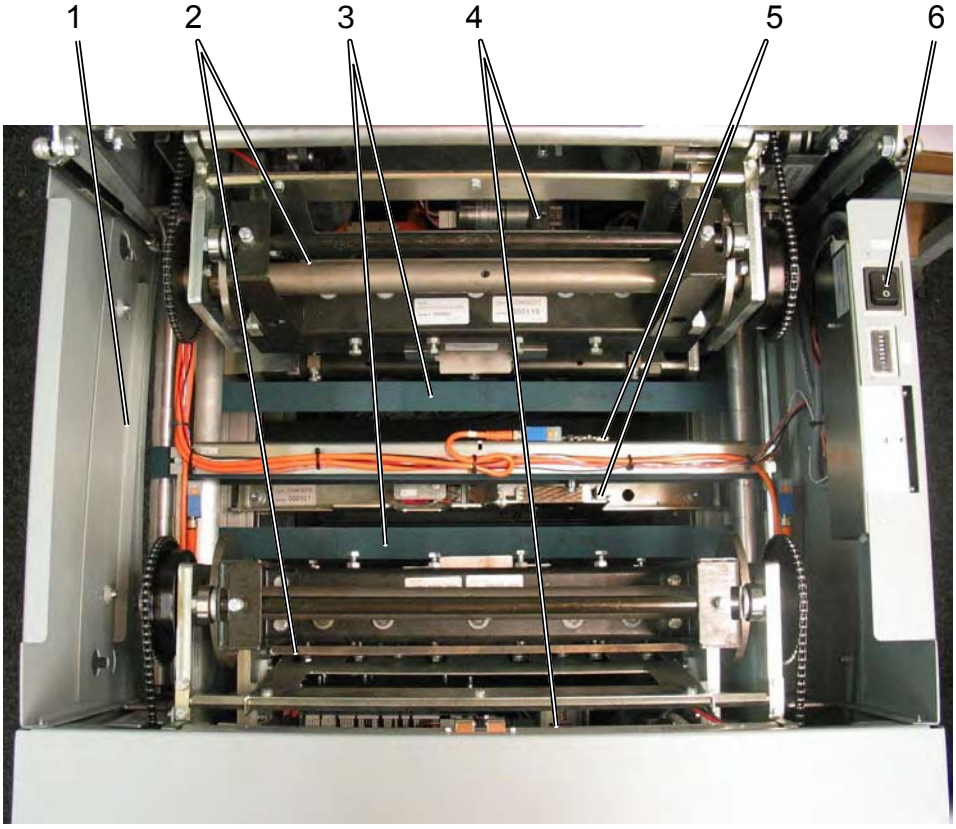
Trimmer, top view

1	Infeed latch	6	Exit compression brackets
2	Trimmer fan	7	Outfeed latch
3	Docking bracket	8	Transport belt
4	Knives (not shown in picture)		
5	Infeed roller shaft		

Two-side Trimmer

1 Top Cover
2 Trim Bins

The Trimmer interior has parts that you will come into contact with if a jam occurs.

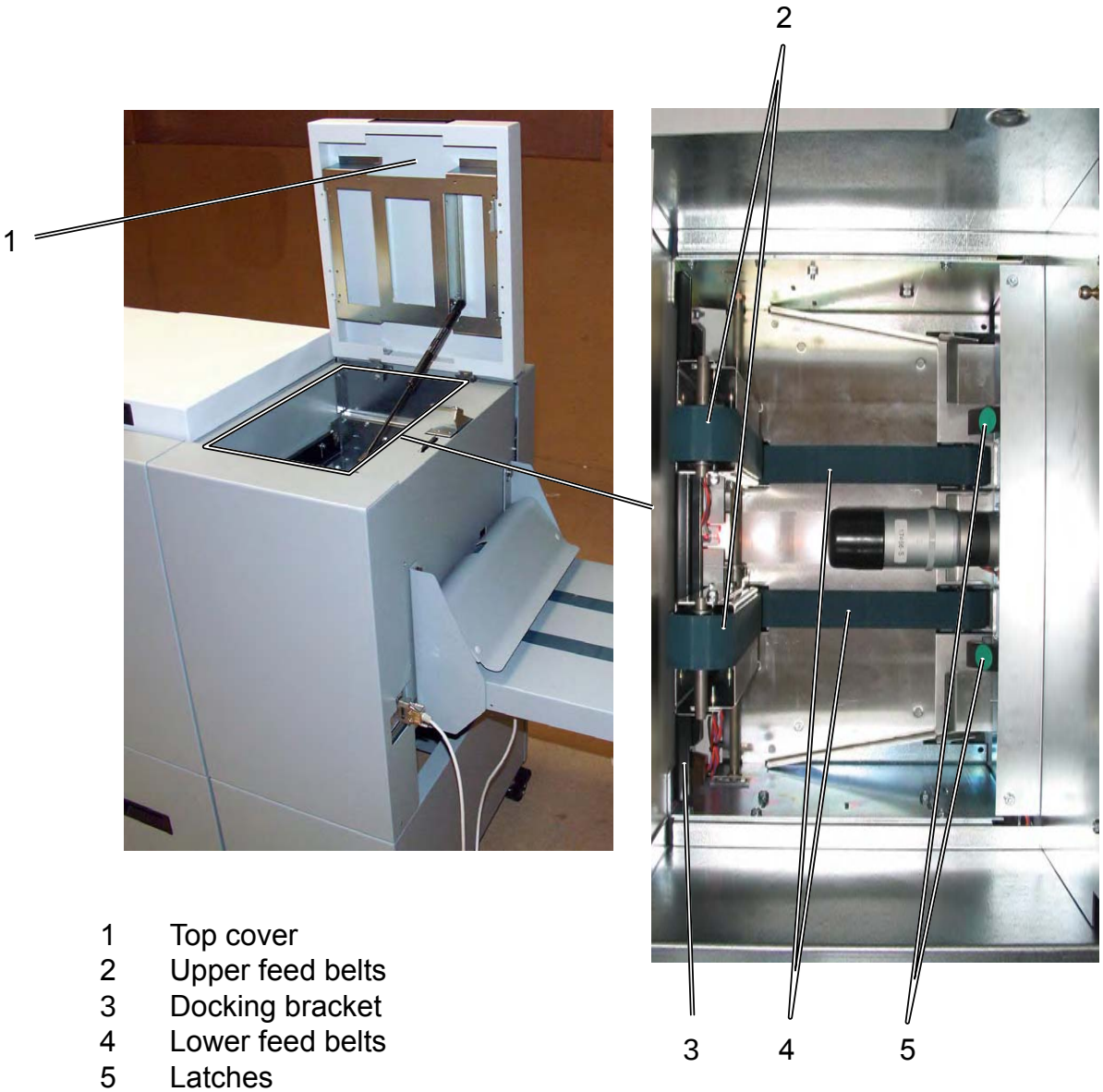


Two-side Trimmer, top view

1 Docking bracket
2 Knives
3 Transport belts
4 Knockers
5 Trimmer stop
6 Power switch

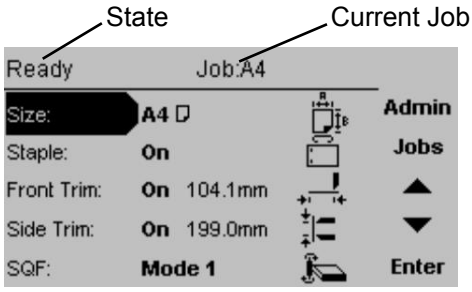
s quare fold

The SquareFold interior has parts that you will come into contact with if a jam occurs.

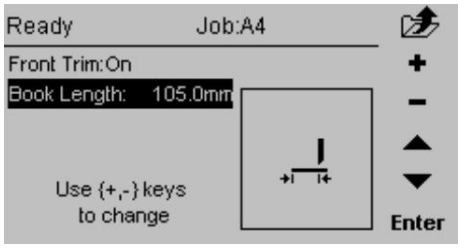


1 Top cover
2 Upper feed belts
3 Docking bracket
4 Lower feed belts
5 Latches

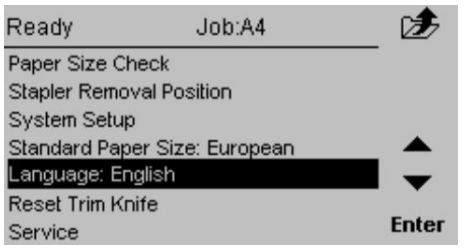
Control Panel



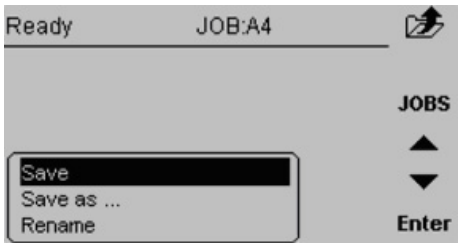
The Main screen.
When the system power is switched on the Main screen will be shown. Here you will find information showing the actual set up. From this screen you can also access other screens, that will help you operate the complete BLM Booklet making system.
At the top, throughout the screens you can see the current state of the machine and the current job.



Changing settings.
To change or adjust settings; Select an item in the Main screen with the [arrow] button and press the [Enter] button. For example you can fine adjust the trimming, change stapling mode or set the SquareFold to the correct mode. Settings are explored more thoroughly in section 2 Making Booklets.



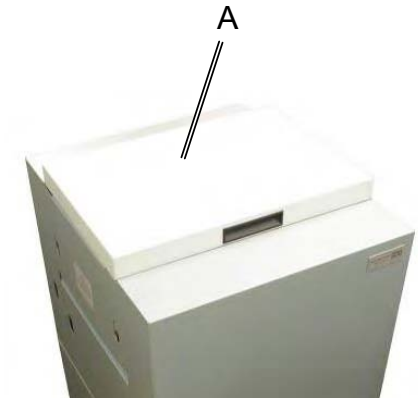
The Admin screen.
Pressing the [Admin] button in the Main screen takes you to the Admin screen. From here you can change the display language, set paper size standard and more. See section 3 Admin, for how to navigate in the Admin screen.

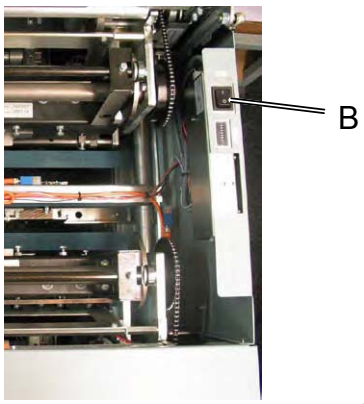


The Jobs screen.
Pressing the [Jobs] button in the Main screen opens the Jobs screen. From here you customize and save job settings. Press [Jobs] again and you can load previously saved jobs. These procedures are described in section 4 Jobs.

Turning On / Off the Power

Booklet Maker, Trimmer, Two-side Trimmer and s quaref old





1. Plug the Booklet Maker power cord into the wall outlet.
   Trimmer (optional), Two-side Trimmer (optional) and SquareFold (optional) are powered from the Booklet Maker.
2. Open the Top cover (A) on the Two-side Trimmer and check that the power switch (B) is set to ON.
3. Close the Two-side Trimmer top cover.
4. Open the Booklet Maker Top cover (C).
5. Set power switch (D) on Booklet Maker to ON position.

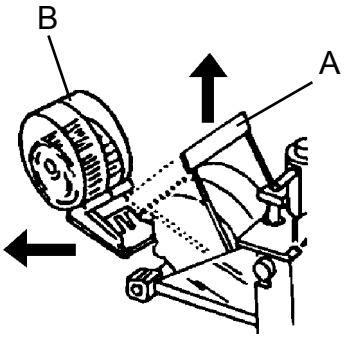
n ote

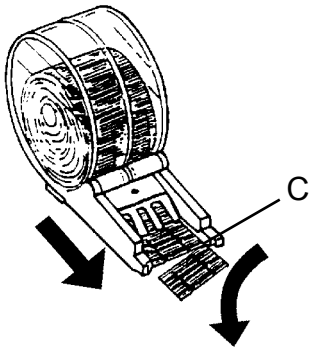
The Power switch also controls Trimmer (optional) and SquareFold (optional).

6. Close the Top cover.

Check staples, staple Cartridge and stapler Head

Removing / replacing staple Cartridge



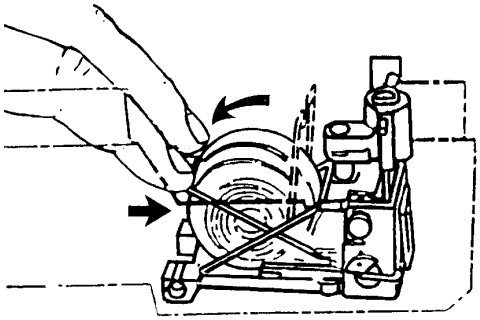


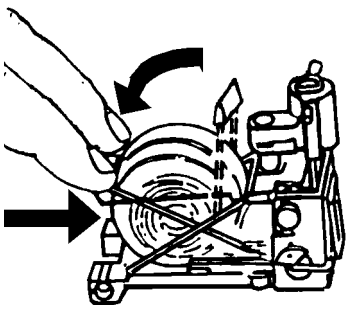
You may remove and replace the staple cartridge while the stapler head assembly is in place.

Removing the staple cartridge

1. Open the top cover.
2. Raise the staple cartridge locking lever (A) as indicated in the drawing.
3. Gently twist the staple cartridge (B) from side to side, and pull out the staple cartridge (B) from the stapler head.
4. If the staple cartridge is empty or almost empty*, discard it and replace it with a new one. Before replacing the cartridge, pull at least 20 mm of the staples out and tear off at the staple tear line (C) which is marked on the cartridge. If there has been a misfeed, and the cartridge still contains staples, pull 20 mm of staples out of the cartridge and tear off at the stapler tear line. Check that the first staple is flat. If not, tear off another 20 mm, using less force.

*containing 300 staples or less





Replacing the staple cartridge

note

The staple cartridge **must not** move away from the stapler head before the locking lever is engaged. If that occurs, remove cartridge and again tear off 20mm of staples along the staple tear line before inserting the cartridge.

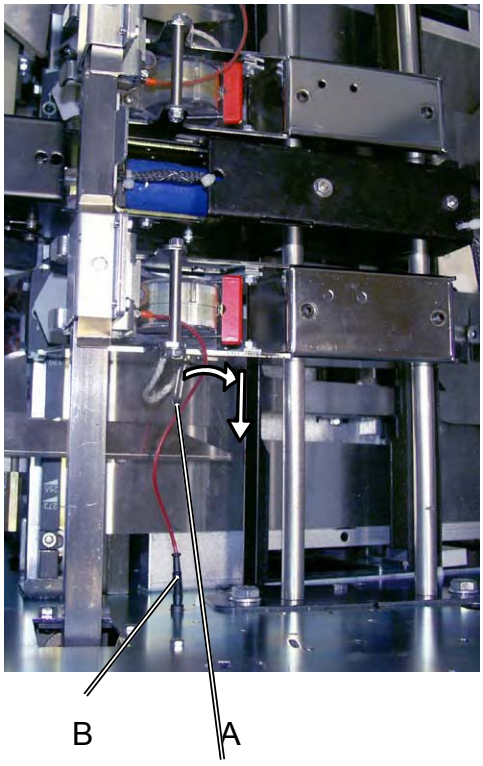
5. Insert the cartridge into the stapler head with the staples facing towards the head mechanism. The cartridge should be placed flat on the slide on the bottom of the stapler head. Push the cartridge firmly into the stapler head and keep holding it pressed. While holding the staple cartridge firmly pressed into the stapler head, push down the cartridge locking lever.

Removing / replacing staple Cartridge, continued

After staple jam or empty staple cartridge has been detected, the BLM will automatically advance and feed staples. This feature is called staple recovery. Follow procedure below after a staple jam or empty staple cartridge indication.

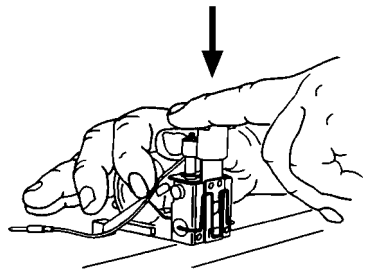
1. Follow step 1-5 on the previous page.
2. Put the printer on hold.
3. Close the top cover.
4. Feed in a four page set into the manual feed slot. The staple recovery will commence now.
5. Now the BLM has recovered and the printer can be restarted. In case problem persists and no staples were fed, the display will indicate that again.
   In such a case:
   Repeat this procedure. If problem still persists, perform the Removing/replacing Stapler Head procedure.

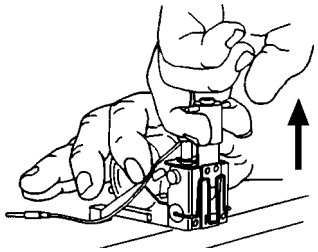
Removing / replacing stapler Head



1. From the Main Screen, press [Admin]. Select Stapler removal position and press [Enter].
2. Select the A3 (11”x17”) position to ensure that the side joggers are away from the stapler head. See section 2 Making Booklets for how to change paper size.
3. Open the Top Cover.
4. Rotate the locking pin (A) towards the out-feed side and pull out the locking pin from the stapler head assembly.
5. Disconnect the staple detection lead (B). Push the stapler head towards the in-feed side, out of the stapler head assembly.

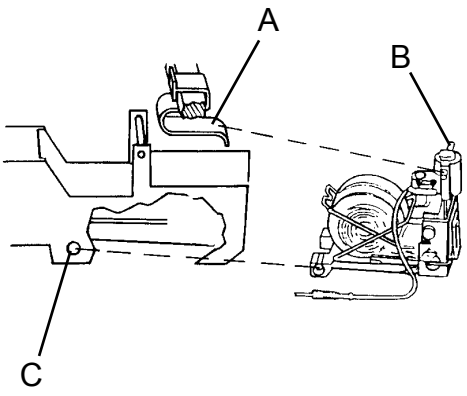
Removing/replacing stapler Head, continued





note
Whenever you remove a stapler head, be sure to manually eject some staples before replacing it in the BLM. To do this, rest the stapler head on a firm surface (for example, the top of a table) and actuate the staple driver post up/down through full travel. Do this a number of times to ensure that the staples are ejected on each down movement. If you need to change the staple cartridge, see previous section, removal/ replacement of staple cartridge.

⚠ Warning
When manually ejecting the stapler, stay clear from stapler output area.

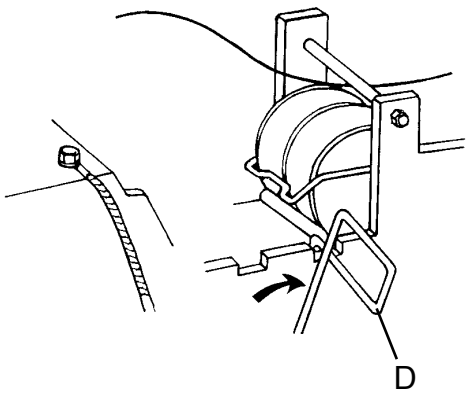


4 Before inserting the stapler head, centre the stapler lift bracket (A) over the area that will receive the stapler head. Ensure that the staple driver post (B) is in its uppermost position.

5 Place the stapler head back into the BLM. The driver post arm (B) must be placed into the stapler lift bracket (A).

⚠ Caution
If the driver post arm is not correctly positioned into the stapler lift bracket (B) it will cause permanent damage to the stapler head as well as the bracket. Subsequently, also future correctly mounted stapler heads will be damaged.

6 Press on the lower front edge of the stapler head to align the hole (C) in the stapler bracket with the hole in the stapler head. Insert the locking pin (D) so that it engages the stapler head and the metal sides of the stapler assembly.



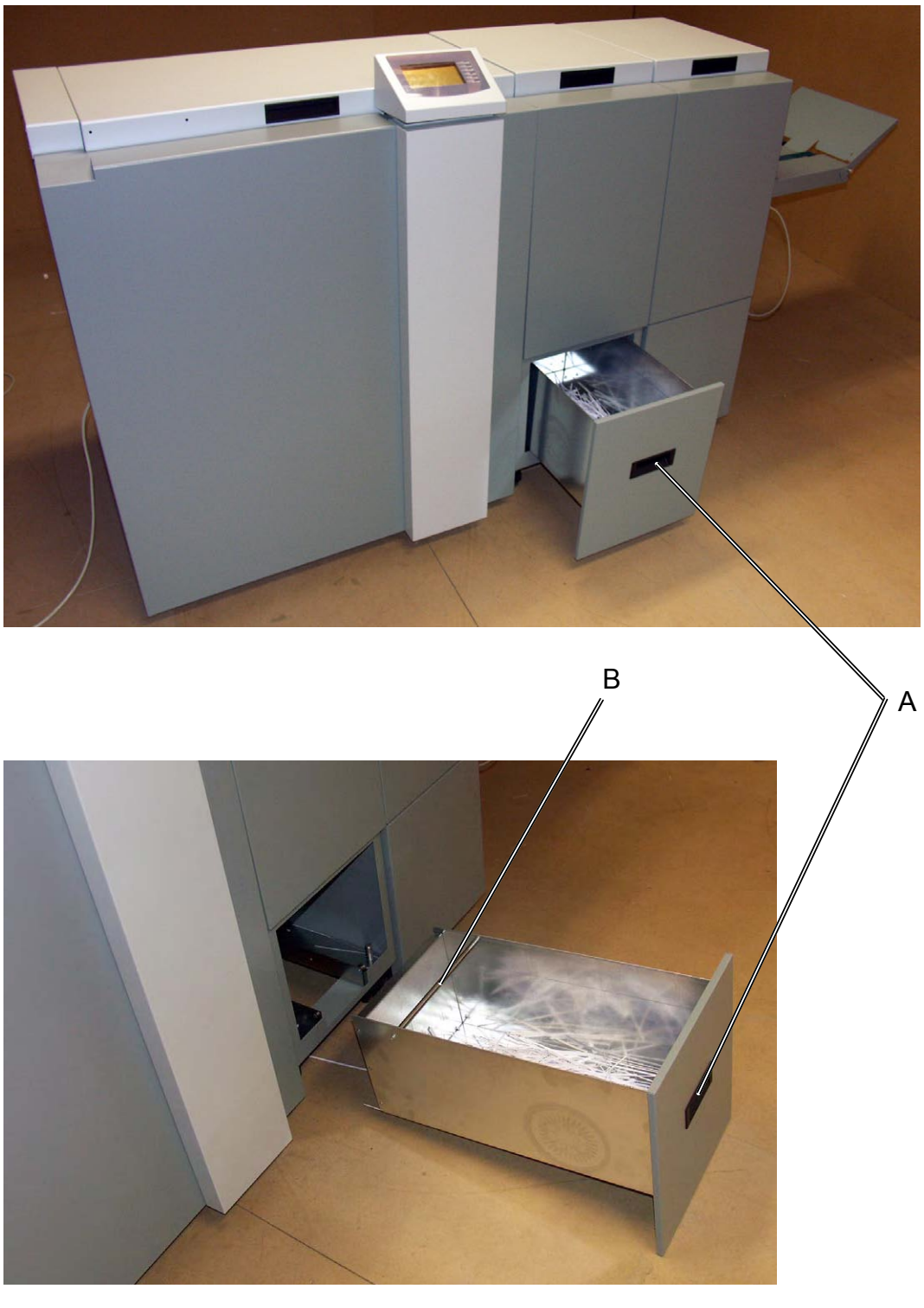
7 Lock the pin (D) by rotating it towards the in-feed side. Check that the stapler head is correctly mounted by pushing the stapler head towards the infeed area. If it is still loose, it is not correctly mounted.

8 Insert the staple detection lead into its socket.

Trim Bins

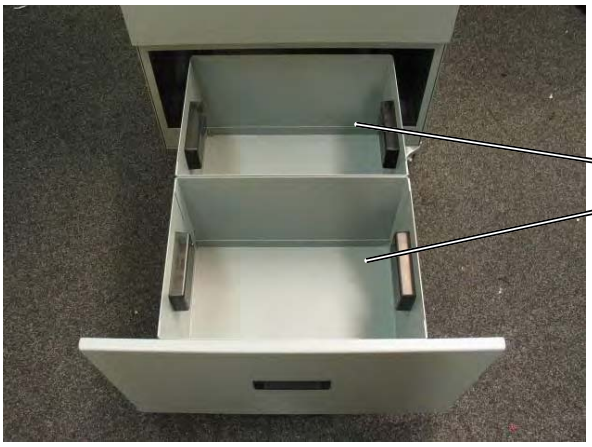
Emptying the Trimmer bin

Remove the trim bin by pulling handle (A) then lift it out by grasping the rod (B) and handle (A). Empty the trim bin and remove loose trim strips from inside the Trimmer.



Emptying the Two-side Trimmer bins

Open the drawer (A). Empty both trim bins (B) and remove loose trim strips from inside the Two-side Trimmer.



2. Making Booklets

Changing settings

General Procedure

Changing settings can be performed in two ways. Temporary, which means that the changes will remain until a new job is loaded or permanent, which means that the changes will be stored as a job. This job can later be recalled.

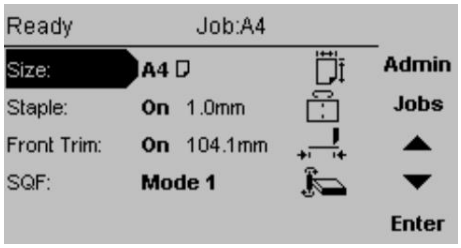
Procedure for temporary changes:
From the Main screen, select the option you wish to change and press the [Enter] button. Confirm changes by pressing the [Enter] button in the next screen.

Procedure for permanent changes:
Same procedure as for temporary changes. But, in addition, from the Main screen, press the [Jobs] button to reach the Jobs screen. Select Save if you want to incorporate the change in the current job or Save as... if you want to store the changed job as a new job.

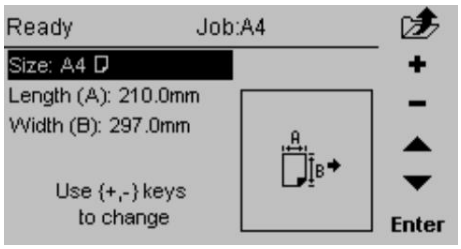
note
Choose either of the above mentioned procedures when changing size, stapling, trimming or Square folding as follows.

setting Paper size

selecting standard Paper sizes

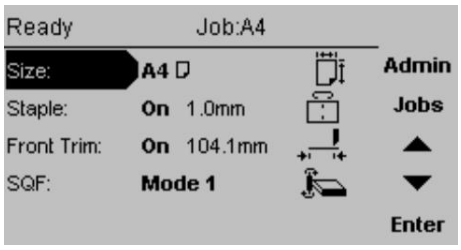


From the Main screen, select Size and press the [Enter] button.

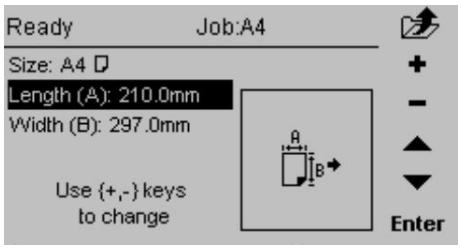


Current Size is highlighted. Press [+] or [-] to scroll within the preset paper sizes. Press [Enter] to select.

Custom Paper size



From the Main screen, select Size and press the [Enter] button.

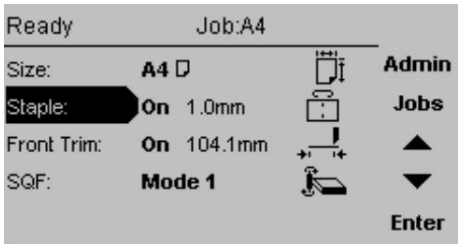


Select Length or Width, whichever you wish to change. Press the [+] or [-] button to correct paper size.
The paper size can be changed in increments of 0.1 mm or approx.. 0.01 inches. Press the [Enter] button to confirm.

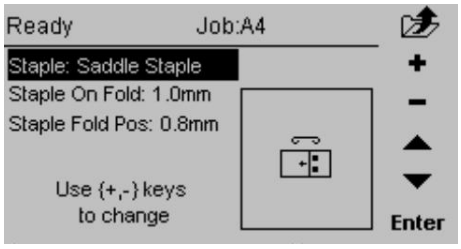
note
In the main screen the paper size is shown without the decimal point. The machine has however recognised and set up according to the exact size including the decimal point.

stapling and folding

selecting stapling Mode

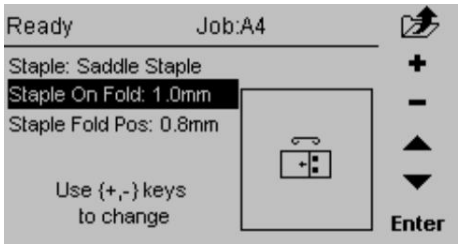


From the Main screen, select Staple and press the [Enter] button.



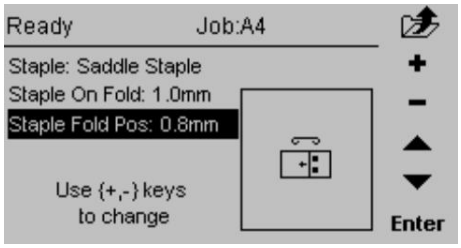
With the Staple line highlighted, press [+] or [-] to choose stapling option. Press the [Enter] button.

Adjusting staple and fold Alignment



If the booklets exiting the system do not have the staples centered on the fold, or if stapling position is desired on the top or bottom of the spine, that can be adjusted from the control panel.
With Staple On Fold highlighted, press [+] or [-] to move staple positioning on the spine. Press the [Enter] button.

note
The adjustment can also be done during booklet making.



If the booklet fold line is not in the center of the sheet, or if it is desirable to move the fold line to match the print, that can be adjusted from the control panel.
Contrary to the above situation, this adjustment moves both the staple and fold together.
With Staple Fold Pos highlighted, press [+] or [-] to move the staple and fold line position. Press the [Enter] button.

Adjusting fold Quality

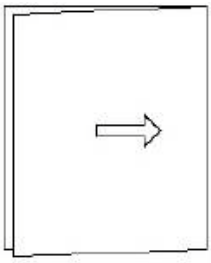
If the the adjustments from the control panel result in inconsistencies or inaccuracies it could be due to paper quality and/or set size. For those cases it is possible to change the ball configuration in the ball cages in the pre-fold transport. The purpose is to apply adequate pressure on the set to ensure proper alignement against the fold stop before the set is folded.
The default configuration for BLM is with glass balls closest to the outfeed and plastic balls closest to the infeed. Additional replacement steel, glass and plastic balls are located in the tool box above the fold section. See table below for ball configuration guidelines.

note
The table below is meant purely to be a guide. Other configurations might work better depending on the characteristics of the paper quality in conjunction with the set size.

Ball configuration guidelines	1	2	3
Single large sheets, in fold only mode, with low paper weight/stiffness	-	-	Plastic
Small quantity of sheets, with low paper weight/stiffness	Plastic	-	Plastic
Default configuration	**Plastic**	**-**	**Glass**
Large quantity of sheets	Glass	-	Glass
Large quantity of sheets, with higher paper weight/stiffness	Glass	-	Steel
If markings occur on the centre fold when running larger quantities of sheets	Plastic	Plastic	Glass

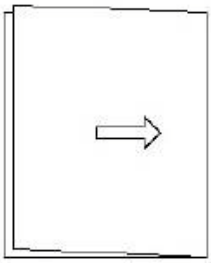
Adjusting Fold Quality, continued

If booklets are skew like this...



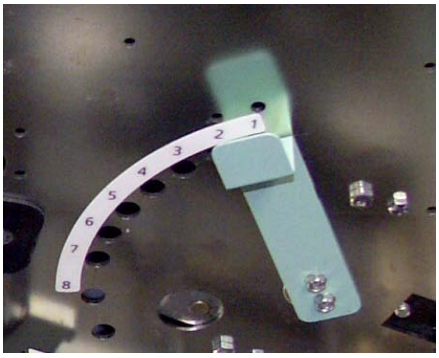
...move adjustment lever towards outfeed

If booklets are folded skew, correct by moving the fold stop adjustment lever towards the infeed or outfeed following the illustrations.
The arrow indicates the direction the booklets travel.



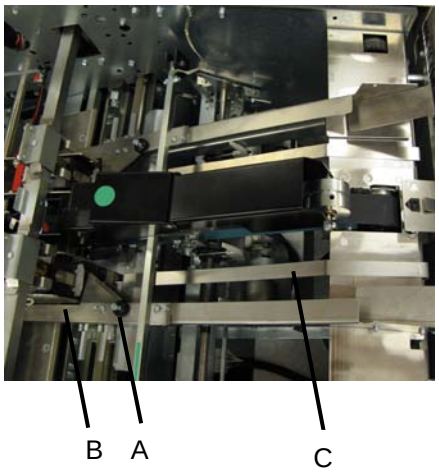
If booklets are skew like this...

...move adjustment lever towards infeed



In extreme circumstances, when the cover sheet tends to be torn from the rest of the set, this can be rectified by adjusting the Fold Adjust Levers located above the pre-fold transport. There are eight positions for each lever. The topmost notch (1) is the default position. Move the lever notch by notch until performance is satisfactory.
In case of BLM300C put the Fold Adjust Levers in the default position.

Setting up Narrow Width Paper Sizes



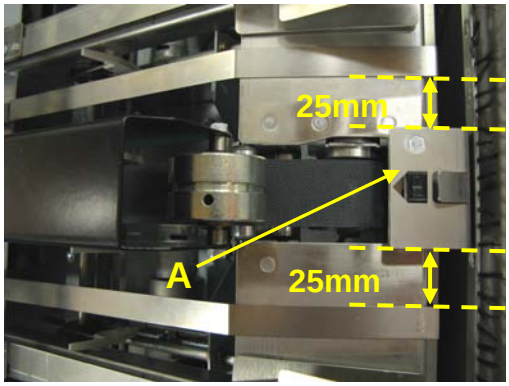
If setting up narrow width paper sizes such as A5, 5.5x8.5” or CD-size, the side guide extensions (B) and the Infeed Guide strips (C) must be removed.

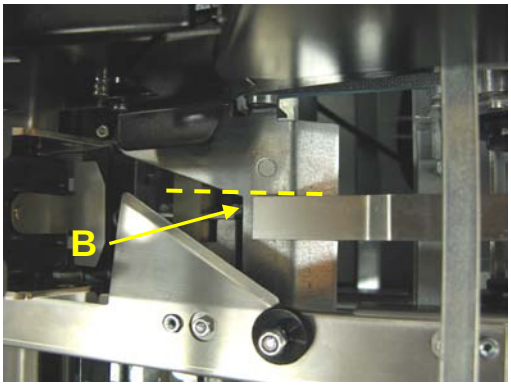
1 Remove thumb screws (A), one on each side guide.

2 Remove side guide extension (B) one on each side guide and remove the Infeed Guide strips (C),

Note
Make sure to re-install the side guide extensions after the run. Otherwise paper jams might occur.
Make sure to re-install the Infeed Guide strips.
(see next page for adjustment)

Adjusting Infeed Guide strips



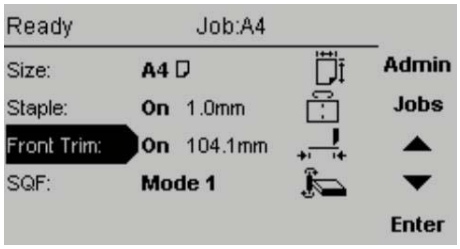


Place the Infeed Guide strips on a distance of 25mm from the Sensor bracket (A).

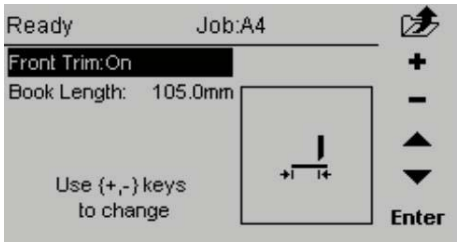
Align the end of the strips with the corner (B).

Trimming

Selecting Trimming On or Off

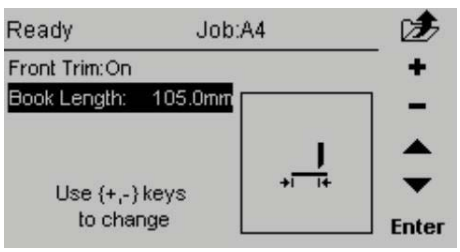


From the Main screen, select Front Trim and press the [Enter] button.



Press the [+] or [-] button to change Front Trim on or off. Press the [Enter] button.

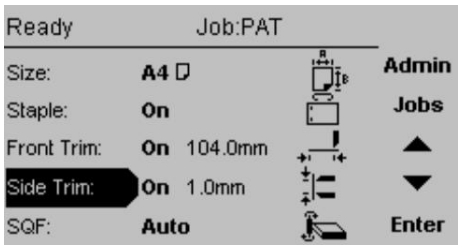
Adjusting the Cutting Margin



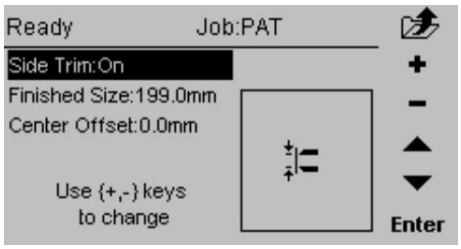
Select Book Length and press the [Enter] button. Press the [+] or [-] buttons to make fine adjustments. The measurement displayed is the width of the finished, trimmed booklet. Press the [Enter] button to confirm.

Two-side trimming

selecting Trimming On or Off

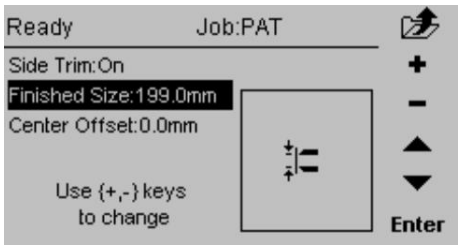


From the Main screen, select Side Trim and press the [Enter] button.



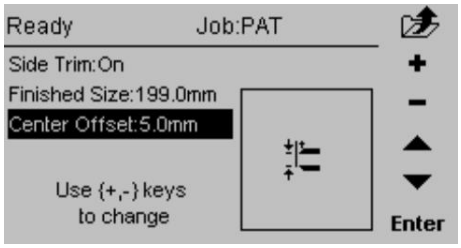
Press the [+] or [-] button to change Side Trim on or off. Press the [Enter] button

Adjusting the Cutting Margin



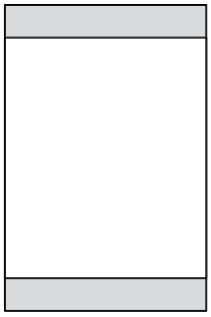
Select Finished Size and press the [+] or [-] button to make fine adjustments. The measurement displayed is the height of the finished, trimmed booklet. Press the [Enter] button to confirm.

Using Offset Trimming



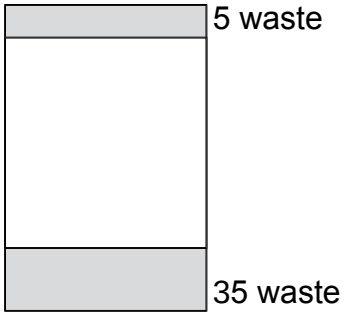
Select Center Offset and press the [+] or [-] button to make fine adjustments. The measurement displayed is the Center Offset of the finished, trimmed booklet. A positive measurement will end up in a booklet trimmed more on the upperside of the booklet. A negative measurement will end up in a booklet trimmed more on the lower side of the booklet.

note
Switched when STR6X02



Finished size: 267
Center offset: 0

Finished size: 257
Center offset: 15



Finished size: 257
Center offset: -15

square folding

General

The SquareFold has seven different settings. It can be set to [Auto], [Mode 1], [Mode 2], [Mode 3], [Mode 4], [Mode 5] or [Off].

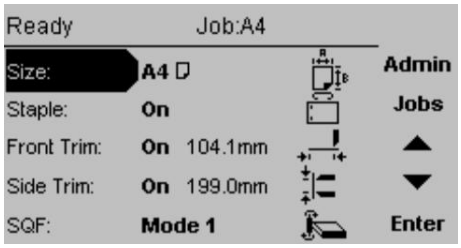
In [Auto] mode, the Booklet Maker detects how many sheets there are in the booklet, and automatically set the SquareFold to the correct mode.

note
When the SquareFold is set to [Auto] and the booklet has less than approximately 6 sheets/ booklet, the SquareFold will bypass the Square folding action, transporting the booklet out to the Belt stacker.
Use the manual modes to override the auto function. There are five different manual modes to select from.

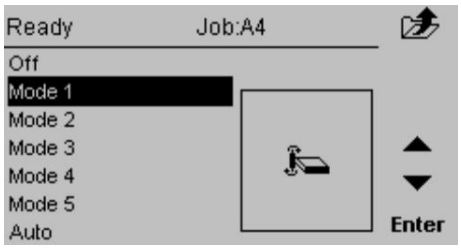
Mode 1: Approximately 6 - 10 sheets.
Mode 2: Approximately 11 - 15 sheets.
Mode 3: Approximately 16 - 20 sheets.
Mode 4: Approximately 21 - 25 sheets.
Mode 5: Approximately 26 - sheets.

Select [Off] to bypass the SquareFold

Procedure

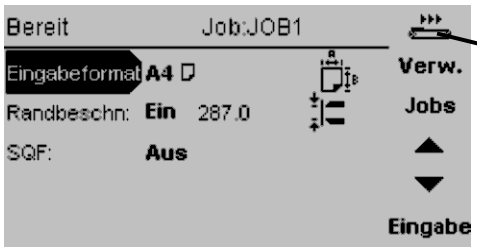


From the Main screen, scroll down to SQF and press the [Enter] button.



Select [Auto], [Mode 1], [Mode 2], [Mode 3], [Mode 4], [Mode 5] or [Off] with the [arrow] button and press the [Enter] button.

Belt Stacker



Use the [Purge button] to transport the booklets forward on the Belt Stacker.

Online / Offline

The Booklet Maker can be operated in two modes. Online mode, when used together with the printer, or offline mode, when used for hand feeding.

Offline Mode

1. Make sure Booklet Maker is in stand-by mode, i.e. that an online print job is not in progress.
2. Make necessary settings according to “Changing settings” earlier in this section.
3. The Booklet Maker is now in stand-by mode and will start automatically when a set is manually fed into the Booklet Maker.

Online Mode

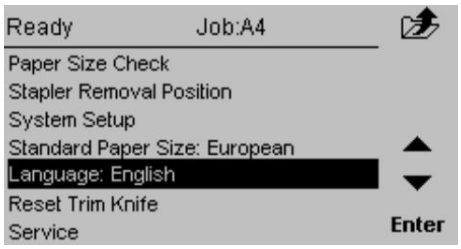
1. Make necessary settings according to “Changing settings” earlier in this section.
2. The Booklet Maker is now in stand-by mode and will start automatically when a set is fed from the printer.

3. Admin

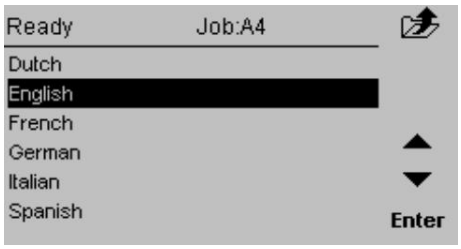
The Admin screen

From the Main screen, press the [Admin] button to get to the Admin screen. Here you will find additional features and settings.

Language

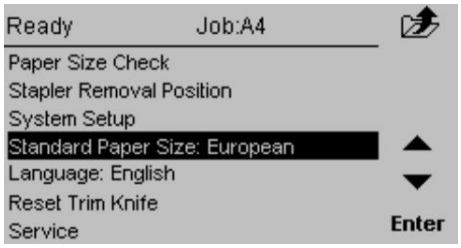


From this screen you can change the language in the user interface.
Select Language and press the [Enter] button.

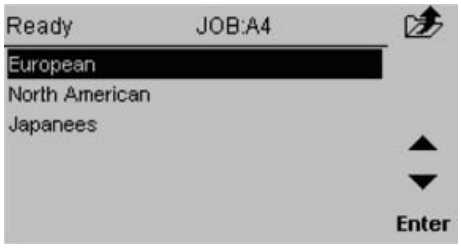


Select desired language with the [arrow] buttons and press the [Enter] button.

size standard



From this screen you can change the paper size standard. By changing the paper size standard the preset paper sizes are altered to best fit your regional standard. Also, the units will change between millimeters and inches accordingly. Select Size Standard and press the [Enter] button.



Select the desired standard and then press the [Enter] button.

service

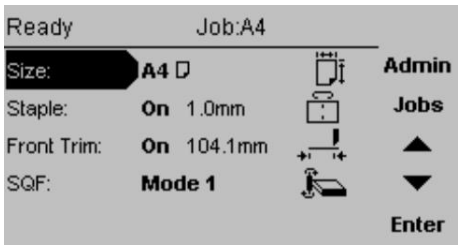
This screen to access service is for authorized service personnel only and is password protected.

4. Jobs

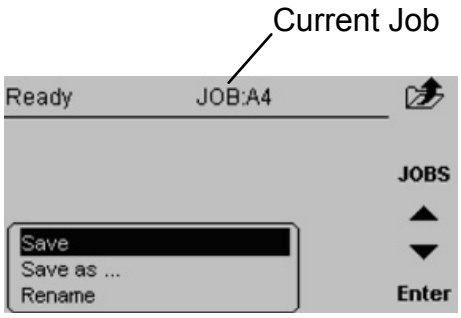
storing and Deleting Jobs

The Booklet Maker has a maximum storage capacity of 10 different jobs. Also see section 2 Making Booklets.

storing a Job



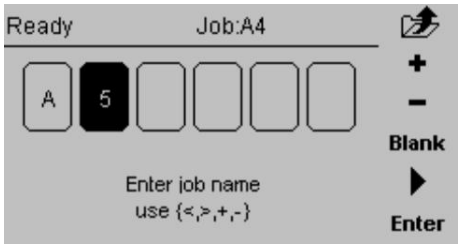
Change all settings according to section 2 for a particular job.
Now the changes are just temporary. You can run the system with these changes but as soon as you change something again the previous settings will be lost.
To store the settings, press [Jobs] from the Main screen.



Now you have three choices:

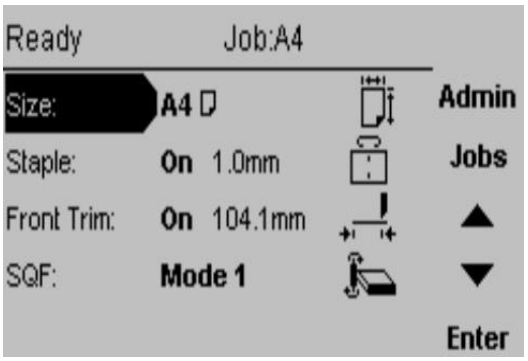
- Save
- Save as...
- Rename

Choosing Save will overwrite the current Job. The Current Job name is displayed on top of the screen.
Choosing Save as... gives you the option to save it as a new job or overwriting another job.
Choosing Rename will overwrite the Current Job (if changes were made). This is the same as the Save option, but now you have the possibility to enter or change the name for the current job.

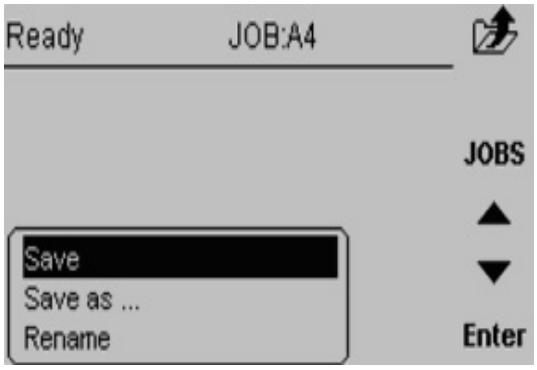


This screen is displayed if Rename is Entered from the Jobs screen.
Press [+] or [-] to change highlighted character. Press [Blank] for no character. Move the cursor by pressing the [Arrow]. Press [Enter] when done.

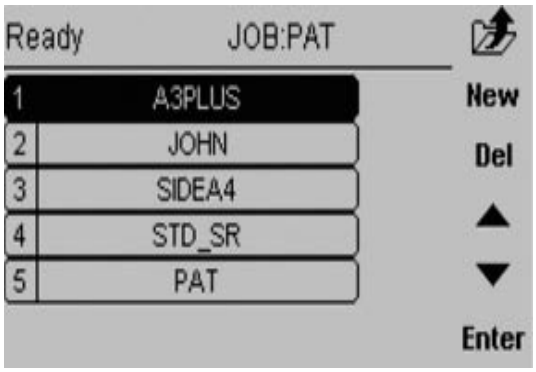
Recalling a Job



To recall a stored job press the [Jobs] button from the Main screen.

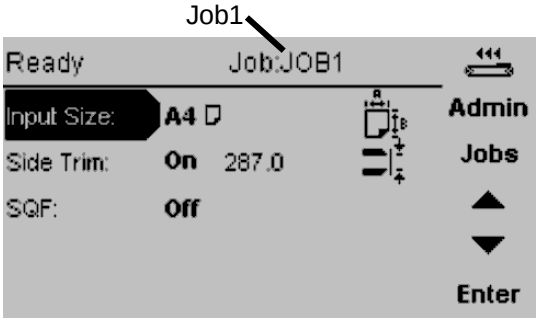


Then press the [Jobs] button from the Jobs screen.



Select one of the previously stored jobs from the list. Press the [Enter] button to recall the job. This Job is now uploaded and becomes the current job.

Auto Jobs Changing



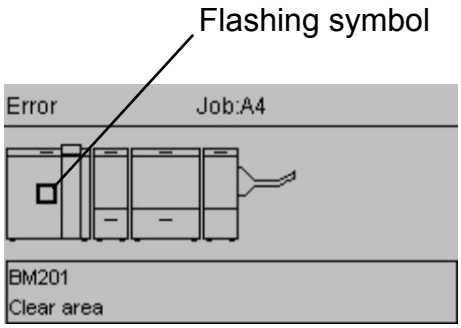
Job1 and Job2 are fixed jobs.
Automatic paper format change between the 1st and 2nd job when the correct job is send from the printer. The 1st job always have to be the job with the smallest paper size [A4]. The 2nd job always have to be a larger paper size [A3] than the 1st job.

Do not delete them.

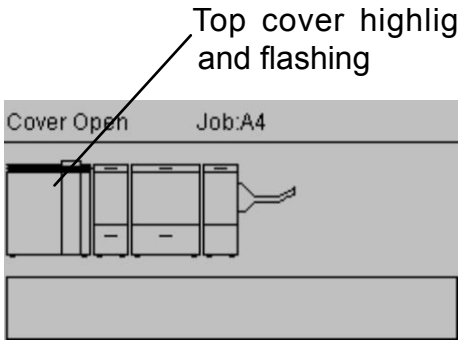
Clearing a Paper Jam

General

If an error such as a paper jam condition should occur, it is indicated on the Booklet Maker display. The nature of the fault is generally displayed in clear text at the top. In the center of the diplay the diagram shows in which module the error has occured. At the bottom of the display usually an error code is displayed and a text explaining the error. See examples below.



Jams in the Booklet Maker are indicated by a square shaped symbol flashing in the display.



If one of the top covers is open, the symbol on the sceen shows the top cover flashing.

Booklet Maker

Clearing a Paper Jam

Inside the Booklet Maker

To clear a paper jam in the infeed or staple area

1. Open the top cover.

2. Remove jammed sheets.

3. Check for jammed staples at clinchers (see page 50 for location of clinchers).

4. Close the top cover.

To clear a jam indicated in the folding area

1. Open the top cover.

2. Close top cover.
If a jam still remains:

1. Switch off the Power.

2. Put Fold Adjust Levers on max. (positions 8).

3. Remove jammed sheets.

4. Put Fold Adjust Levers on default (positions 1).

5. Switch on the Power.
If a jam still remains:

Switch off the Power.

1. If a Trimmer is installed, first remove the Trim Bin to get access to the fold stop. This gives you access underneath the trimmer, where you can pull down the fold stop.

2. Remove jammed sheets.

3. Push the fold stop back into the upper position.

4. Replace the Trim Bin, if the Trim Bin was removed.

5. Switch on the Power.

Trimmer

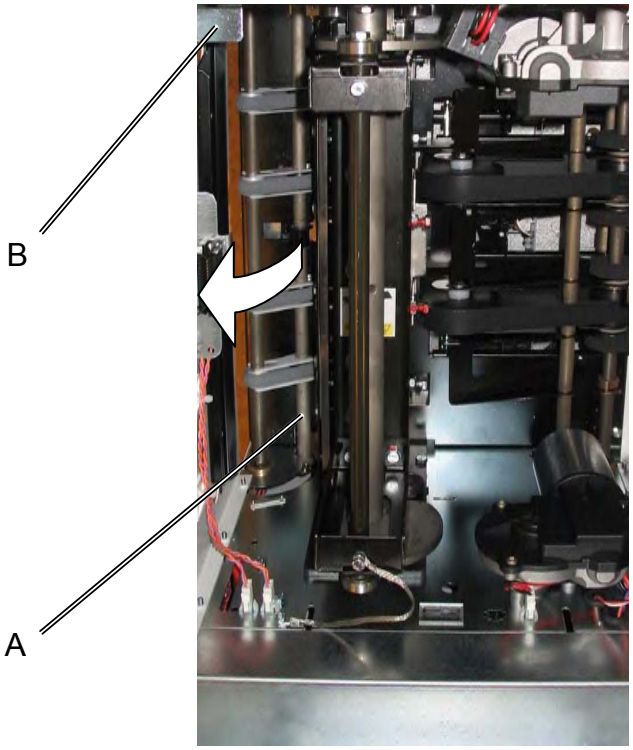
Clearing a Paper Jam

The upper trimmer blade on the trimmer is protected by a knife protection plate that moves away during the cutting stroke. Jams can occur in the input area or the exit area.

⚠ ***WARNING:***
Never put fingers or other parts of the body between the upper and lower trimmer knives.

Clearing Jam in Input Area

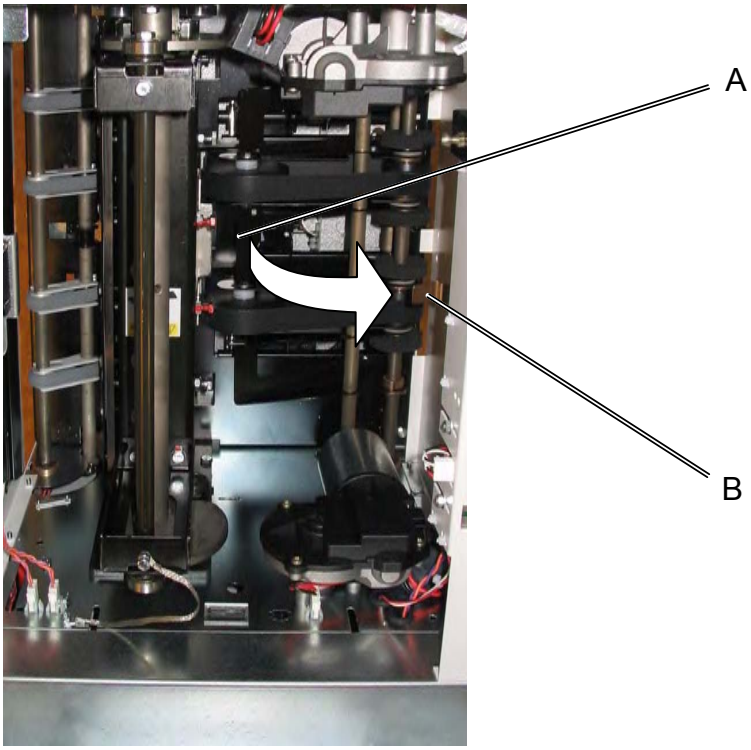
1. Lift up the infeed roller shaft (A).
2. Secure under latch (B)
3. Remove the jammed sheets in the infeed area.
4. After the jammed sheets are removed, lift up the latch (B) and place the infeed roller shaft in the operating position.



Clearing a Paper Jam, continued

Clearing Jam in Exit Area

1. Lift the exit compression brackets (A).
2. Secure them under the latch (B).
3. Remove the jammed sheets from the exit area.
4. After the jammed sheets are removed, lift up the latch (B) and place the compression brackets in the operating position.



Two-side Trimmer

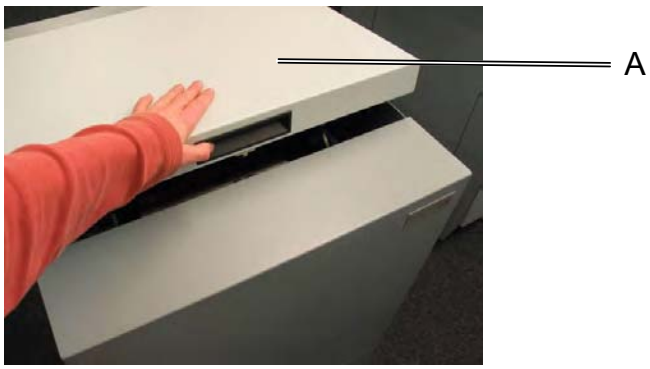
Clearing a Paper Jam

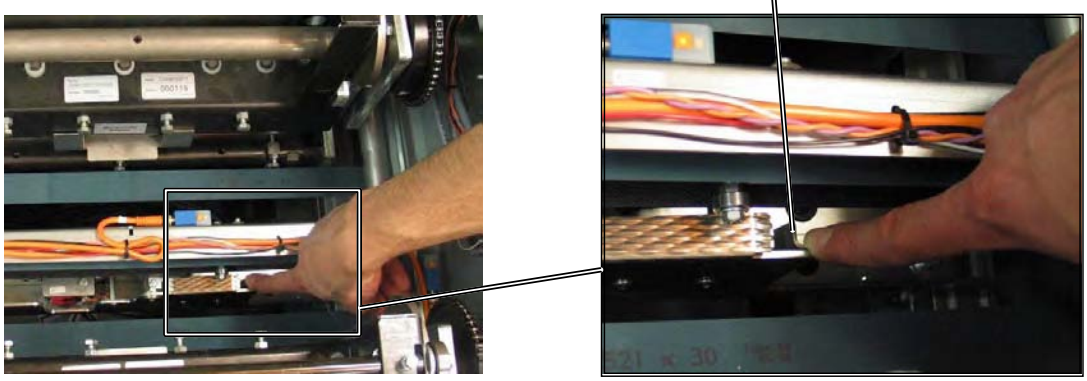
The upper trimmer blade on the trimmer is protected by a knife protection plate that moves away during the cutting stroke. Jams can occur in the input area or the exit area.

⚠ ***WARNING:***
Never put fingers or other parts of the body between the upper and lower trimmer knives.

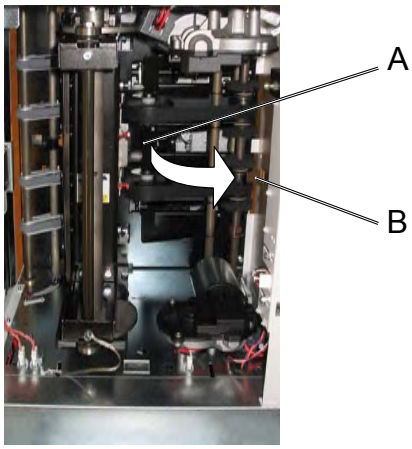
Clearing Jams inside the Two-side Trimmer

1. Open the top cover (A).
2. Close the top cover (A).
3. The BLT will automatically try to empty the machine.
4. When the jam isn't solved, open the top cover (A) and turn off the machine.
5. Push the Trimmer Stop (B) down and Push the booklet towards the exit.
6. Turn the machine on.
7. Close the top cover (A), the BLT will automatically empty the machine.



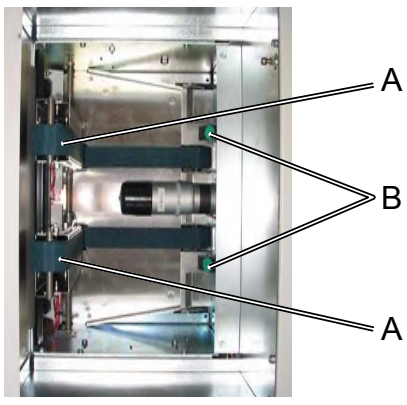


Clearing Jam at the input area of the Two-side Trimmer



1. Open the top covers of the Two-Side Trimmer and the Trimmer.
2. Turn off the two-side Trimmer.
3. Push the paper jammed in the Two-Side Trimmer towards the input area. The paper will move into the Trimmer.
4. Lift the exit compression brackets (A).
5. Secure them under the latch.
6. After the jammed sheets are removed, lift up the latch (B) and place the compression brackets in the operating position.
7. Turn on the Two-side Trimmer.
8. Close both top covers.

Clearing Jam at the exit area of the Two-side Trimmer



1. Open the top covers of the Two-Side Trimmer and the SquareFold.
2. Turn off the two-side Trimmer.
3. Push the paper jammed in the Two-Side Trimmer towards the exit area. The paper will move into the SqareFold.
4. Lift up both upper feed belts (A).

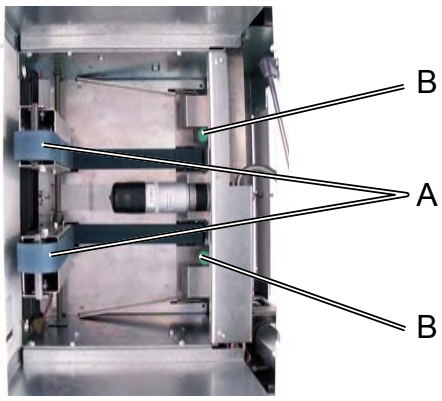
note
Press the green-labelled latches (B) to release.

5. Remove the jams.
6. Place the upper feed belts in normal position.
7. Turn on the Two-side Trimmer.
8. Close both top cover.

square fold

Clearing a paper jam

Inside the squaref old

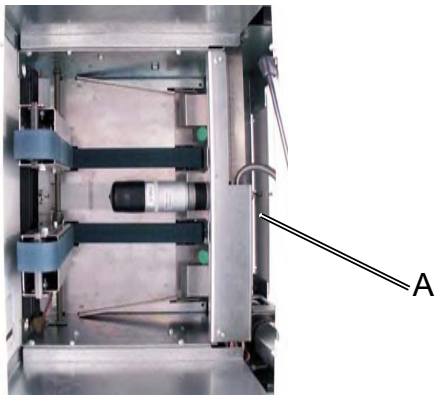


1. Open the top cover.
2. Lift up both upper feed belts (A).

note
Press the green dots (B) on the latches to release.

3. Remove the misfeeds.
4. Place the upper feed belts in normal position.
5. Close the top cover.

Exit area



1. Open the top cover.
2. Remove the misfeeds through the jam clearance area (A).
3. Close the top cover.

6. Troubleshooting

f ault codes

General

When there is a jam or fault condition in the Booklet Maker system, a message will be displayed on the Booklet Maker. See section 5 Clearing a Paper Jam. Some faults can be rectified by the operator and some faults only by an authorized technician.

Fault codes that generally can be rectified by the operator:

Booklet Maker:	BM-201 to BM-213 and BM-401
Trimmer:	TR-201 to TR-205, TR-501 and TR-502
Two-side Trimmer	STR-100 to STR-150
SquareFold:	SQF-201 to SQF-206

As well as a fault code, a brief description is given on the display.

n ote

If procedures in this manual do not rectify the problem, switch off the power and clear machine completely from sheets. Switch on the power.
If error condition still remains, an authorized technician will be needed. Call for service.

Booklet Maker f ault Codes

Check s taples

This message will be displayed when a staple cartridge is near empty or when stapling could not be performed.
Pause the printer before opening the Booklet Maker Top Cover and check in the following order:

– If a staple cartridge is empty, replace according to section 1 Basics.

  n ote

  The staple cartridge contains far more than 5000 staples. So it is normal that the cartridge still holds about 500 staples when replacement is due.

– If staple cartridges are OK; remove the set and check that the number of sheets is within specifications.
– If staple cartridges are OK and the set is within specification, remove and check stapler head according to section 1 Basics.
  Also check for jammed staples at clinchers (see page 50 for location of clinchers).

Booklet Quality f ault

Booklet Quality

– If booklet quality is inconsistent, first make sure the actual paper size is matching the paper size set on the control panel. If that is perfectly correct, see Adjusting Fold Quality under section 2.
– If booklet quality is consistently poor such as staples not aligned with the fold or staple and fold line do not match the print, see Adjusting Staple and Fold Alignment under section 2.
– If booklets or sheets are not folded straight when machine is well adjusted and folds white sheets perfectly , see Adjusting Fold Quality under section 2.
– If the cover of the booklet tends to be torn from the set, see Adjusting Fold Quality under section 2.

Trimmer f ault Codes

Trim Bin f ull

This message will be displayed when the trim bin is full or when a trim strip is prevented from falling down into the trim bin. Empty the trim bin and remove loose trim strips from inside the Trimmer. See section 1 Basics for how to remove the trim bin.

Two-side Trimmer f ault Codes

Trim Bin f ull

This message will be displayed when the trim bin is full or when a trim strip is prevented from falling down into the trim bin. Empty the trim bin and remove loose trim strips from inside the Trimmer. See section 1 Basics for how to remove the trim bin.

squaref old f ault Codes

f eed Errors

If feed errors occur, the feed belts need to be cleaned or the pressure on the upper feed belts needs to be increased. To clean the feed belts, see section 7 General Remarks, Maintaining Your Machine. To increase the pressure on the upper feed belts follow this procedure.

1 Open the top cover.

2 Place both springs in the upper position.

3 Close the top cover.

Spring in normal position

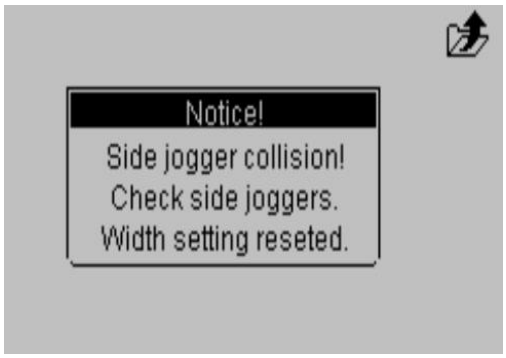
Spring in upper position

squaref olding Quality

If the booklets are not square folded properly, especially regarding heavier booklets, do the following:
- Perform action according to above.
- Clean the clamps according to Cleaning Square Folding Clamps under section 7.

Error messages

Side jogger collision



This message will be displayed when the side guide extensions collide with the stapler assembly or the clinch housing. Make sure that the side guide extensions are mounted correctly. Check that paper width setting not is less than 208 mm.

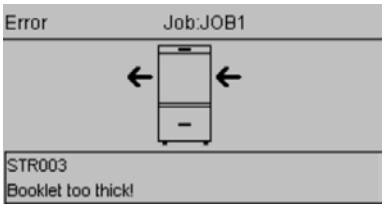
Booklet is too thick

The Thickness control system in the STR measure the thickness of the booklet. When the booklet is thicker than 5mm, there will be a warning on the display and the booklet will not be trimmed.
There are 3 different possible warnings (the type of warning is depending on a setting in the System setup of the STR):

Warning 1
No stop. Only message on the display

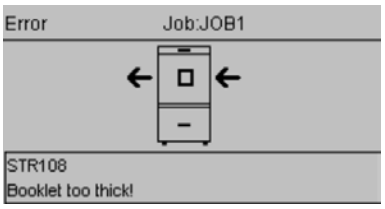
Push [Escape]

Warning 2
STR003 Soft stop. Booklet transported outside the machine



Open and close the Top Cover

Warning 3
STR108 Hard stop. STR will stop directly. Booklet still inside the machine.



Open the Top Cover.
Turn off the STR.
Clear the indicated area.
Turn on the STR.
Close the Top Cover.

7. General Remarks

Do’s And Don’ts

- Always follow all warnings marked on, or supplied with, the equipment.
- Always exercise care in moving or relocating the equipment.

⚠ **Caution**:

- Unplug the power cord from the wall outlet and machine before you move or relocate the equipment.
- Do not remove the covers or guards that are fastened with screws.
- Do not override or bypass electrical or mechanical interlock devices.
- Do not operate the equipment if you notice unusual noises or odours. Disconnect the power cord from the power source and call your authorized technician to correct the problem.

⚠ **Warning**:

- This is a Class A product. In a domestic environment this product may cause radio interference in which case the user may be required to take adequate measures.
  note
  The domestic environment is an environment where the use of broadcast radio and television receivers may be expected within a distance of 10 m of the apparatus concerned.
- Do not put fingers or other parts of the body between the upper and lower trimmer knives.
- Do not switch off the power while the machine is running. Make sure the machine cycle has ended.
- Do not open covers while the machine is running.
- Do not move machine while the machine is running.
- Do not make arbitrary changes to the machine

Placing Your Machine

Machine Environment

- Always locate the equipment on a solid support surface with adequate strength for the weight of the machine.
- Always keep magnets and all devices with strong magnetic fields away from the machine.

If the place of installation is air-conditioned or heated, do not place the machine where it will be:

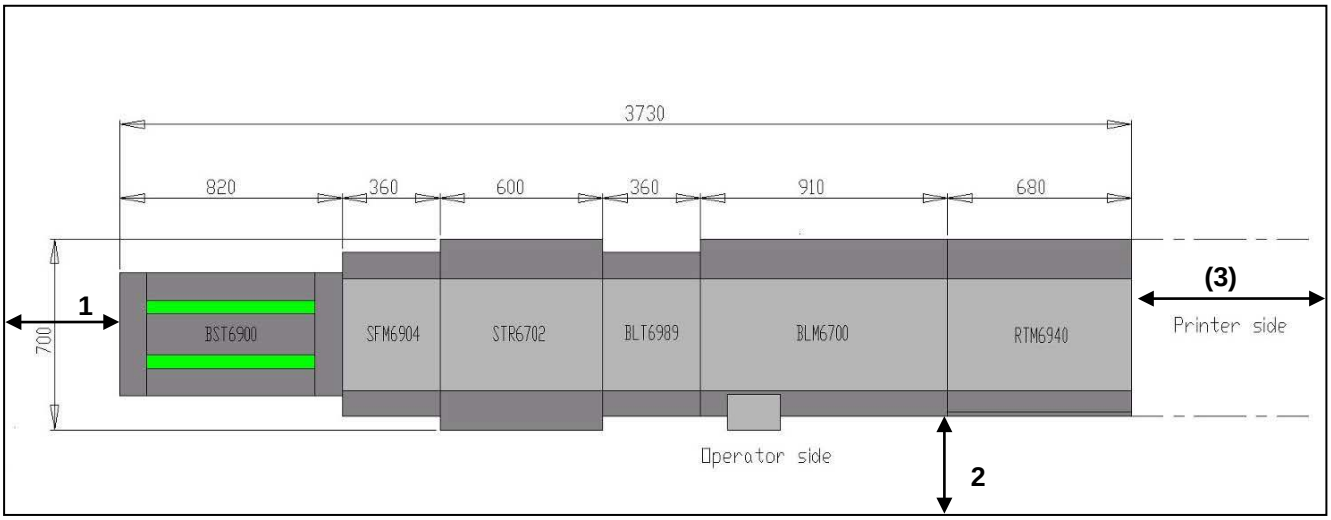
- Subjected to sudden temperature changes.
- Directly exposed to cool air from an air-conditioner.
- Directly exposed to heat from a heater.

Power Connection

- **Always** connect the equipment to a properly grounded power source. If in doubt, have the power source checked by a qualified electrician.
- **WARnInG:** Improper grounding of the equipment can result in electrical shock.
- **never** connect the machine to a power source that lacks a ground connection terminal.

Access to Machine

Place the machine near power source, providing clearance as scown.



1. Right: more than 400 mm / 15 3/4”
2. Front: more than 555 mm / 21 7/8”
(3). Left: more than 400 mm / 15 3/4” (for stand alone installation only)

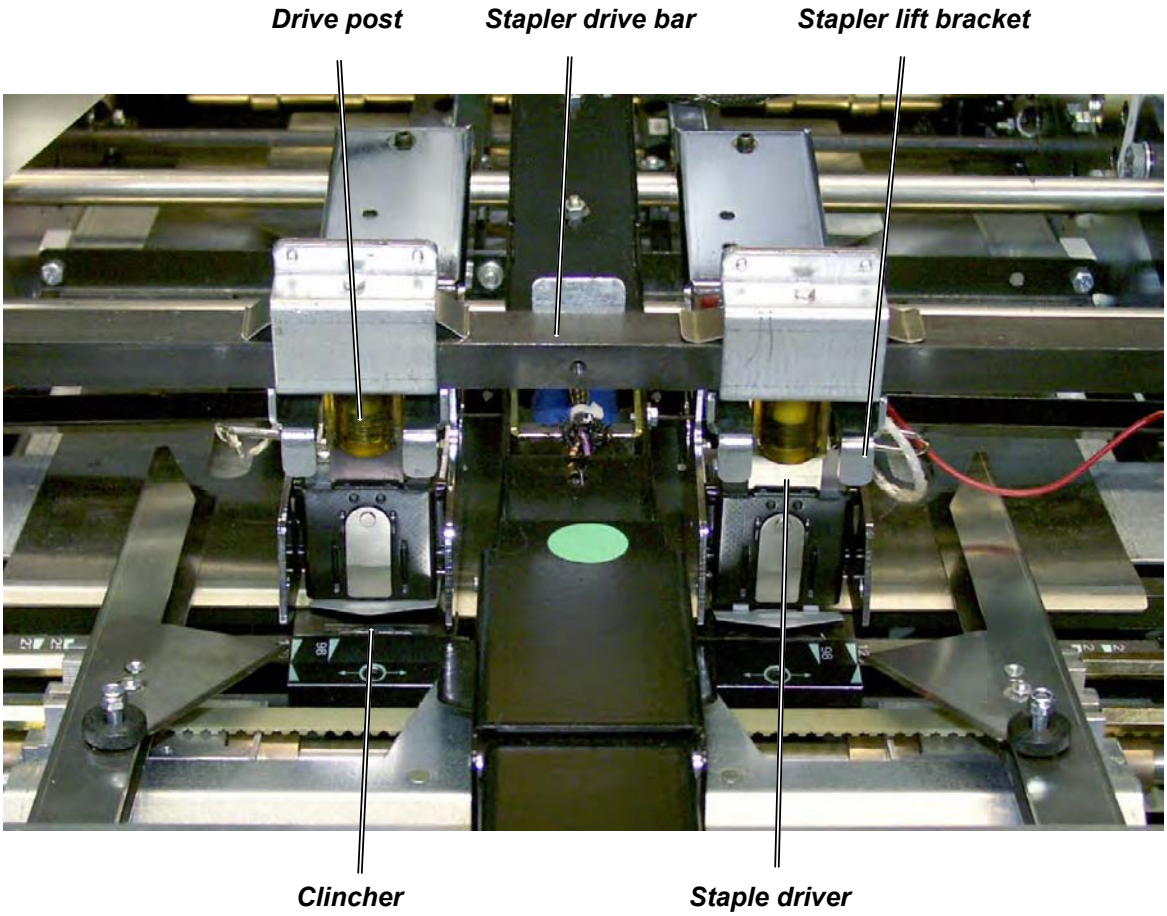
Maintaining Your Machines

never attempt any maintenance function that is not specifically described in this documentation.

Booklet Maker

Lubricating staplers and Clinchers

The parts that need lubrication are shown in the table below.



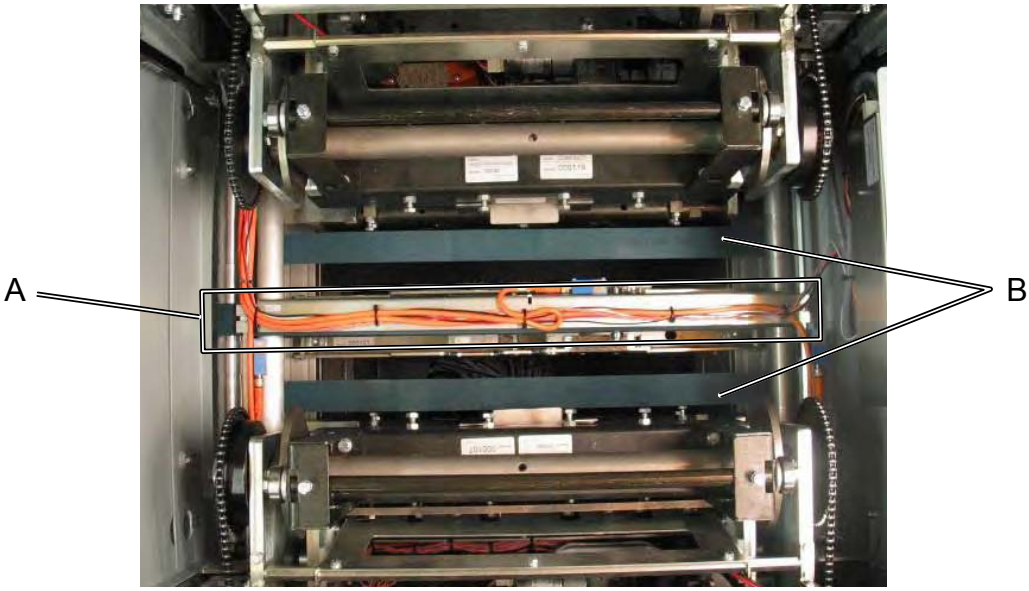
PART	f REQUEnCY	PART LOCATIOn
Clinchers	Every 20,000 booklets	Beneath the stapler head assembly (thin oil)
Drive posts	Every 20,000 booklets	Staple cartridge (grease)
Stapler drive bar	Every 20,000 booklets	Above the stapler head (grease)
Stapler lift bracket	Every 20,000 booklets	Above the stapler head (grease)
Staple driver	Every 20,000 booklets	Staple driver (thin oil)

Two-side Trimmer

Cleaning f eed Belts

The feed belts need to be cleaned regularly when in use, and if the unit has not been used for a period of time. How often this should be done, depends on the paper type and print quality. An increasing number of jams is one indication of the need to clean the feed belts. Clean the feed belts with water and a lint free cloth.

1. Set the Finished size of the Two-Side Trimmer to 330mm.
2. Turn the Two-Side Trimmer off.
3. Clean the upper belt (A). The upper belt can easily be rotated in either direction.
4. Clean the lower belts (B). The lower belts can be rotated in either direction by pulling them.
5. Place the upper feed belts in normal position.
6. Switch the Two-Side Trimmer on
7. Close the top cover.

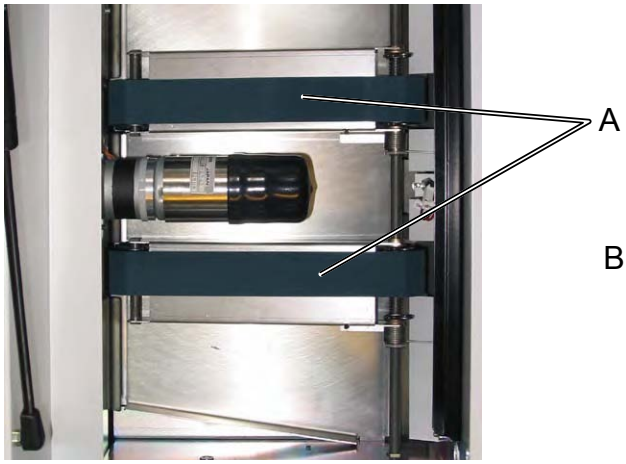


square fold

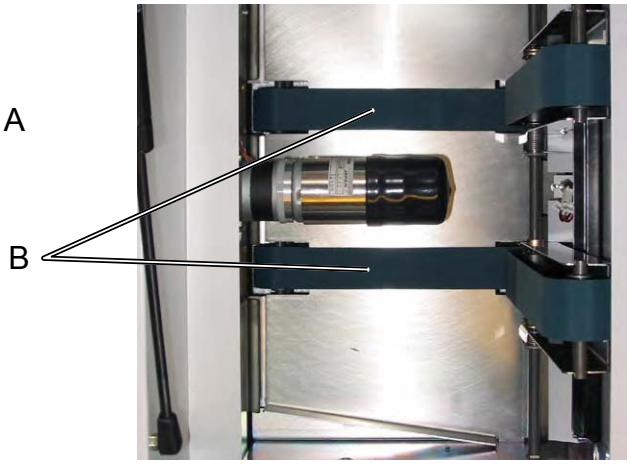
Cleaning feed Belts

The feed belts need to be cleaned regularly when in use, and if the unit has not been used for a period of time. How often this should be done, depends on the paper type and print quality. An increasing number of jams is one indication of the need to clean the feed belts. Clean the feed belts with water and a lint free cloth.

1. Open the top cover.
2. Clean the upper feed belts (A). The upper feed belts can easily be rotated in either direction.
3. Lift up the upper feed belts to access the lower feed belts.
4. Clean the lower feed belts (B). Rotate the lower feed belts towards the outfeed side for complete cleaning.
5. Place the upper feed belts in normal position.
6. Close the top cover.



Upper feed belts in normal position



Upper feed belts raised

Cleaning square folding Clamps

Clean/Peal off any silicon residue from upper and lower clamps (A), which is the area clamping/contacting the booklet. Pay special attention to the right angled corners of the clamp profiles.

8. Specifications

Booklet Maker BLM6700

Capabilities:

Compatibility:	*Océ* DP-line & Canon ImagePRESS equipped with HCS-3 stacker

Physical:

	Operational	On Pallet in box
Height	1150mm	1300mm
Width	700mm	800mm
Length	910mm	1200mm
Weight	≈165 Kg	≈215Kg

Booklet:

	Width	*Length*
Min. paper size:	140mm	248mm
Max. paper size:	320mm	470mm
Paper Weight (min-max):	60 g/m2 - 300 g/m2	
Max. number of sheets:	30 sheets of 80 g/m2	

Technical:

Speed:	
A4	2980 booklets/hour
A3	2610 booklets/hour
Noise Level (max)	70dB

Electrical:

Power source:	
50Hz:	220/230V, 4.0A
60Hz:	220/230V, 4.0A
60Hz:	100/110/120/127V, 8.0A (upon request)

Environmental:

Temperature Range	+17 to 32 °C
Humidity Range	30% – 65% RH

Trimmer BLT6989 (option)

Capabilities:

Compatibility:	*Online:* BLM6700 System

Physical:

	Operational	On Pallet in box
Height	1100mm	720mm
Width	600mm	800mm
Length	360mm	1200mm
Weight	≈85Kg	≈120Kg

Booklet:

	Width	*Length*
Min. - Max. paper size:	from Booklet Maker	
Paper Weight (min-max)	60 g/m^2 - 300 g/m^2	
Trimming size (min-max):	2-16mm	
Recommended trimming size (min-max):	4-12mm	
Trimmed booklet max.	220mm	

Technical:

Speed:	
A4	1965 booklets/hour
A3	1797 booklets/hour
Noise Level (max)	70dB

Electrical:

Power source:	from Booklet Maker

Environmental:

Temperature Range	+17 to 32°C
Humidity Range	30% – 65% RH

Two-side Trimmer STR6702 (option)

Capabilities:

Compatibility:	*Online:* BLM6700 System

Physical:

	Operational	On Pallet in box
Height	1100mm	1570mm
Width	700mm	800mm
Length	600mm	1200mm
Weight	≈205 Kg	≈270 Kg

Booklet:

	Before trimming:	*Bypass:*	*Trimmed:*
Min. booklet size:	204mm	150mm	200mm
Max. booklet size:	340mm	320mm	320mm
Note:	Booklet heights between 320 mm and 340 mm must be trimmed back to 320 mm or less.		
Min. booklet Width (X):	50mm		
Max. booklet Width (X):	245mm		
Max. booklet thickness (trimming):	5mm		
Max. booklet thickness (bypass):	6mm		
Trimming size (min-max)	2mm – 35mm each side		
A-symmetrical trim (min-max)	±15mm		
Booklet Staple Clearance from top/bottom (minimal)	40mm		
Paper Weight (min-max)	60 g/m^2 - 300 g/m^2		
Note:	On booklets of approx. 20 sheets or more, always use cover-sheets of 120 g/m^2 or higher to prevent possible deviations (like crinkles) on the booklet.		

Technical:

Speed	
A4	1800 booklets/hour
A3	1800 booklet/hour
Noise Level (max)	70dB

Electrical:

Power source:	from Booklet Maker
Note:	The 2-Side Trimmer only to be connected to an approved electrical system which is rated at a maximum of 16A and protected by circuit breakers.

Environmental:

Temperature Range	+15 – 30 °C
Humidity Range	30% – 60% RH

Squarefold SFM6904 (option)

Capabilities:

Compatibility:	*Online:* BLM6700 System

Physical:

	Operational	On Pallet in box
Height	1100mm	720mm
Width	600mm	800mm
Length	360 mm	1200mm
Weight	≈65 Kg	≈100Kg

Booklet:

	Width *Length*
Min. - Max. paper size:	from Booklet Maker
Paper Weight (min-max)	60 g/m^2 - 300 g/m^2

Technical:

Speed	
A4	1800 booklets/hour
A3	1800 booklets/hour
Noise Level (max)	70dB

Electrical:

Power source:	from Booklet Maker

Environmental:

Temperature Range	+17 to 32°C
Humidity Range	30% – 65% RH

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