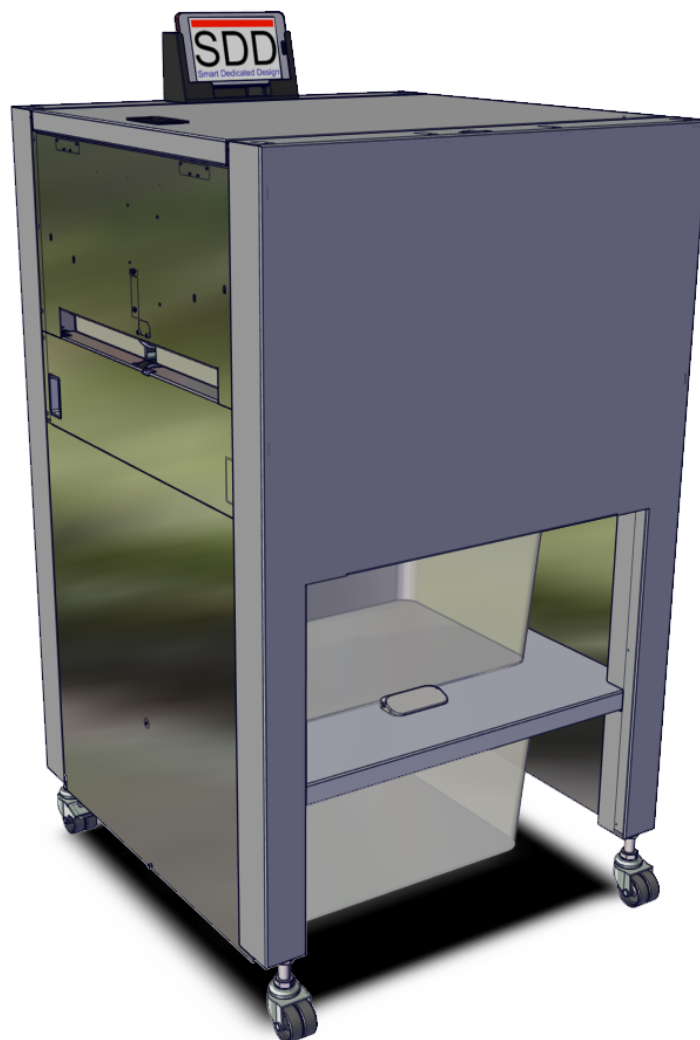


2-SIDE TRIMMER 2ST7210

OPERATOR MANUAL



About this manual



IMPORTANT:

This machine must have been installed by a qualified technician.



IMPORTANT:

The pictures of the machine in this manual can differ with the actual machine.



NOTE:

User Interface screens shown may vary based on tablet or smartphone used and display orientation.

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1. Safety



IMPORTANT:

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

1.1. Symbols

Symbols used in this manual

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



WARNING / CAUTION:

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 / cautions.



WARNING:

Indicates a warning concerning operations that may lead to death or injury to persons due to high voltage. To use the machine safely, always pay attention to these warnings.



CAUTION:

Indicates a caution concerning operations that may lead to injury to persons due to hazardous moving parts. To use the machine safely, always pay attention to these cautions.



CAUTION:

Indicates a caution concerning operations that may lead to injury to persons due to sharp (cutting) objects. To use the machine safely, always pay attention to these cautions.



CAUTION:

Indicates a caution concerning operations that may lead to injury to persons due to crushing or squeezing of body parts. To use the machine safely, always pay attention to these cautions.



CAUTION:

Indicates a caution concerning operations that may lead to injury to persons due to hot surface. To use the machine safely, always pay attention to these cautions.



CAUTION:

Indicates a caution concerning operations that may lead to injury to persons due to optical radiation. To use the machine safely, always pay attention to these cautions.

1. Safety (continued)

1.1. Symbols (continued)



IMPORTANT:

Indicates operational requirements and restrictions. Be sure to read these items carefully to operate the machine correctly and avoid damage to the machine or property.



IMPORTANT:

Indicates the use of an additional manual to be used or read. Be sure to read this carefully to avoid damage to machine, persons or property.



NOTE:

Indicates a clarification of an operation or contains additional explanations for a procedure. Reading these notes is highly recommended.



NOTE:

Do not use the machine when it shows defects or makes unusual noises. Turn the machine off and disconnect the machine from the main power supply. Contact your dealer.



PROHIBITION:

Indicates an operation that must not be performed. Do not step on marked surfaces.

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1. Safety (continued)

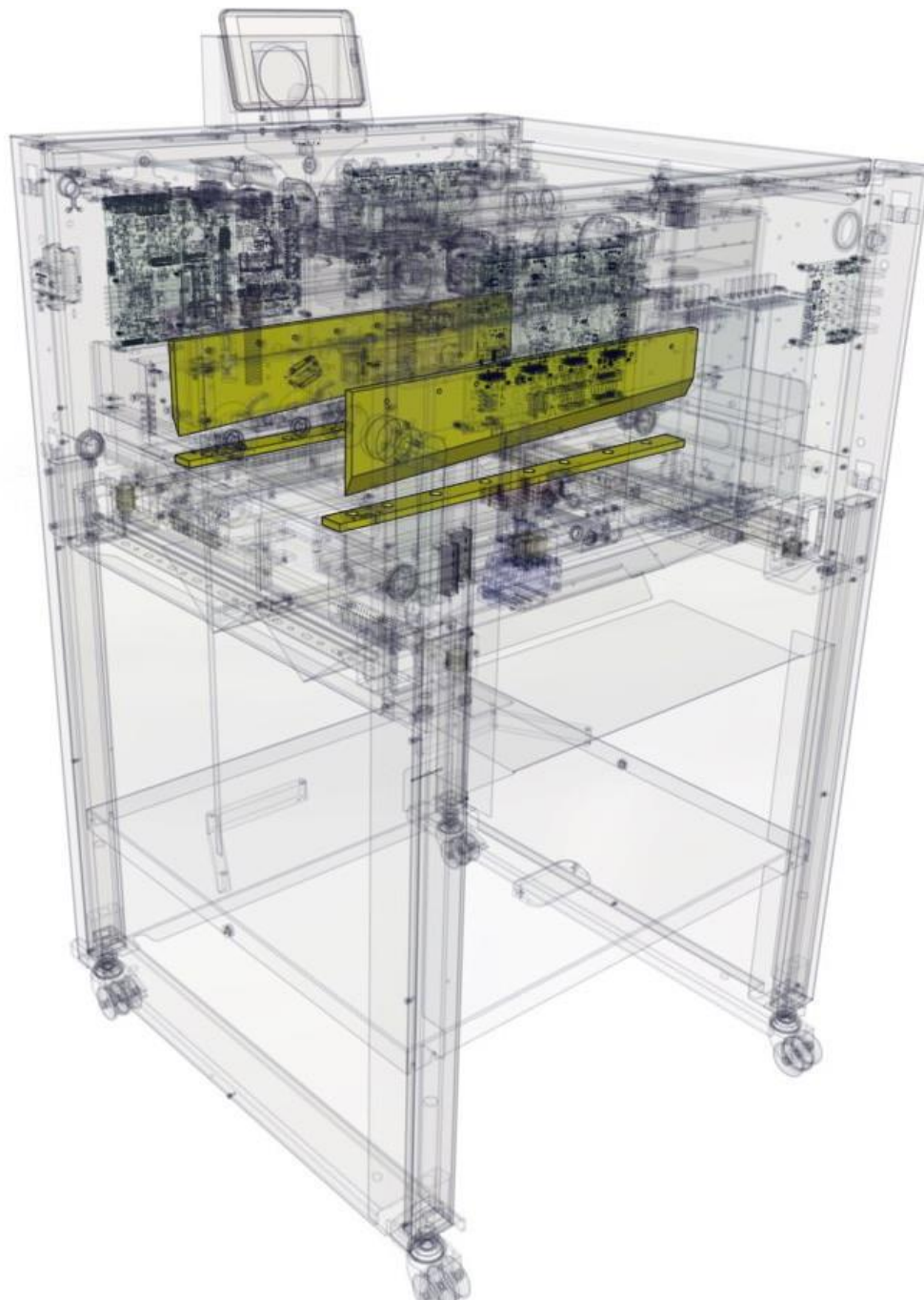
1.2. Cautions

1.2.1. Knives



CAUTION:

Knives (indicated in yellow) may lead to injury to persons due to sharp edges when improperly and/or irresponsibly approached and/or used.



1. Safety (continued)

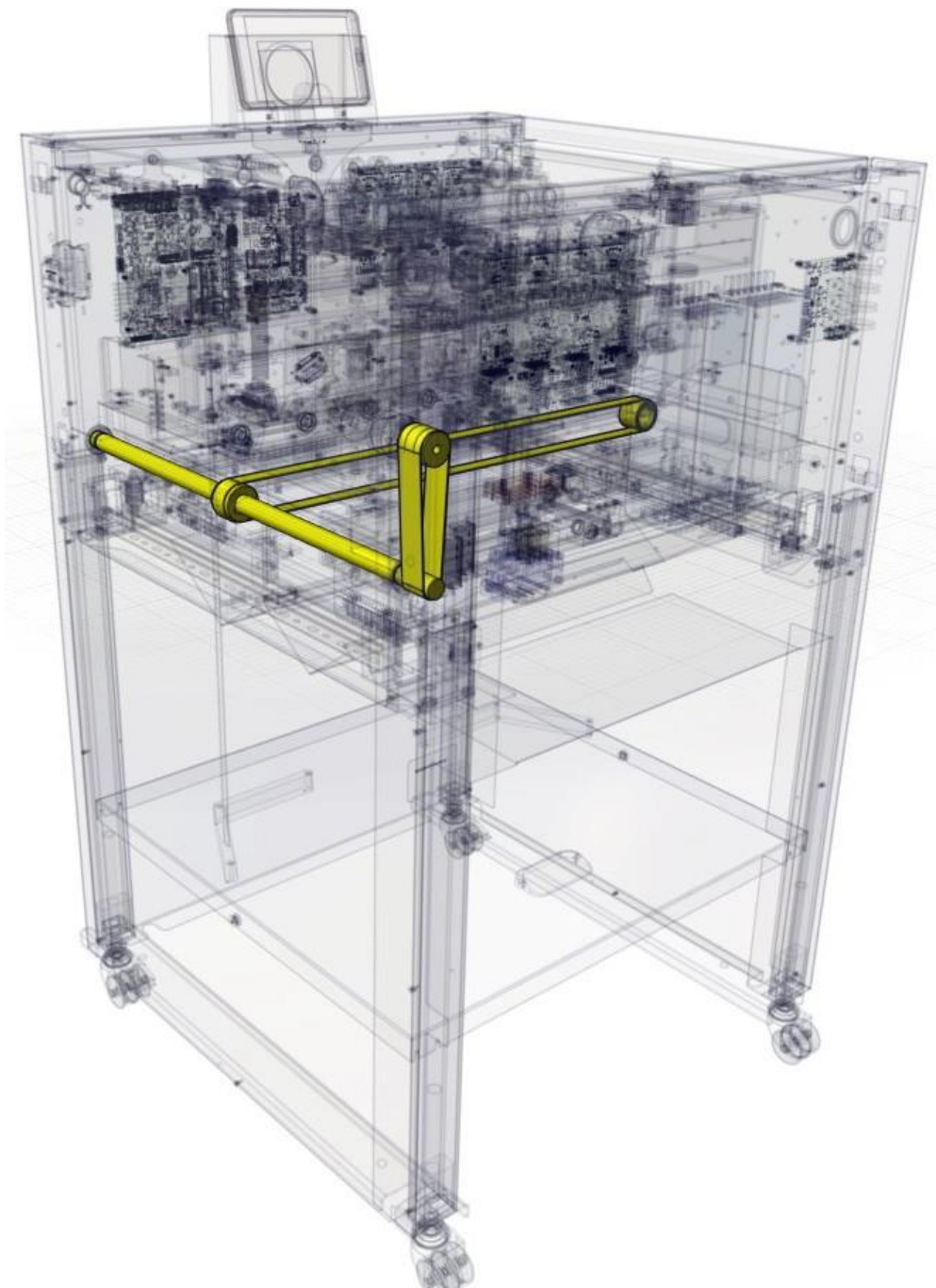
1.2. Cautions (continued)

1.2.2. Belt



CAUTION:

Belt (indicated in yellow) may lead to injury to persons due to hazardous moving parts when improperly and/or irresponsibly approached and/or used.



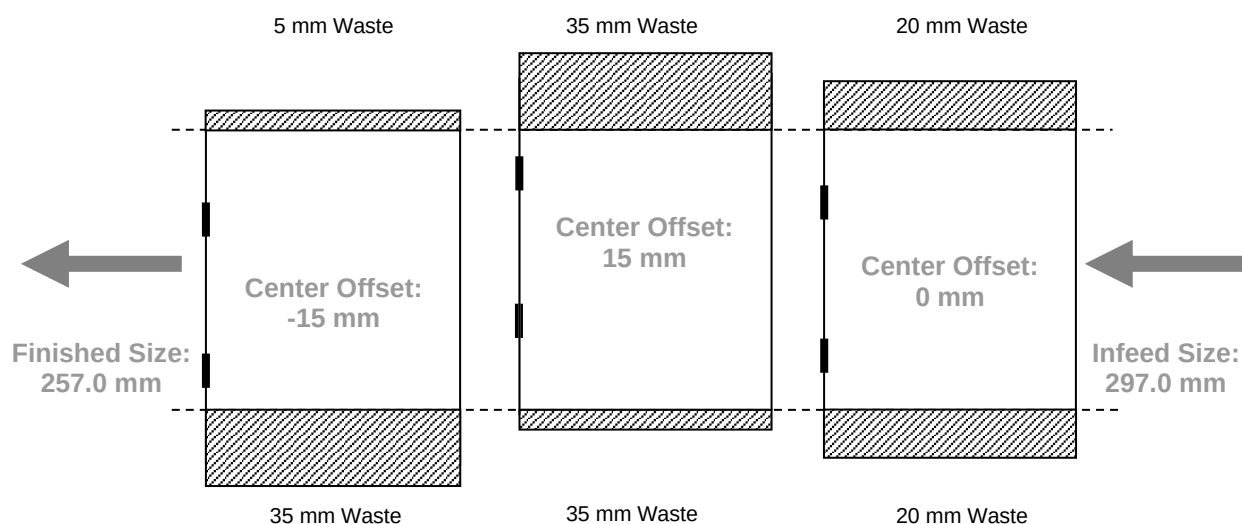
2. General

With the addition of the 2-Side Trimmer 2ST7210 to the SDD product range, a cost effective full-bleed solution is available which has a small footprint and is easy to operate. This machine is designed with high reliability in mind resulting in cost effective operation due to long production with minimal service requirements.

The 2-Side Trimmer 2ST7210, further referred to as 2ST, is for online use with Canon Booklet Trimmer F1/G1.

The 2ST is used for trimming the bleed off a booklet. Booklets with a maximum thickness of 10 mm can be trimmed from 2 mm to 51 mm on the top and bottom of the booklet, to a minimum of 120 mm and a maximum of 340 mm finished size. It is also possible to trim asymmetrical. Operating the 2ST and adjusting the trim settings is achieved via a remote User Interface (UI).

In the schedule below some results are shown which are possible with the 2ST by using a different Center Offset (symmetrical or asymmetrical):



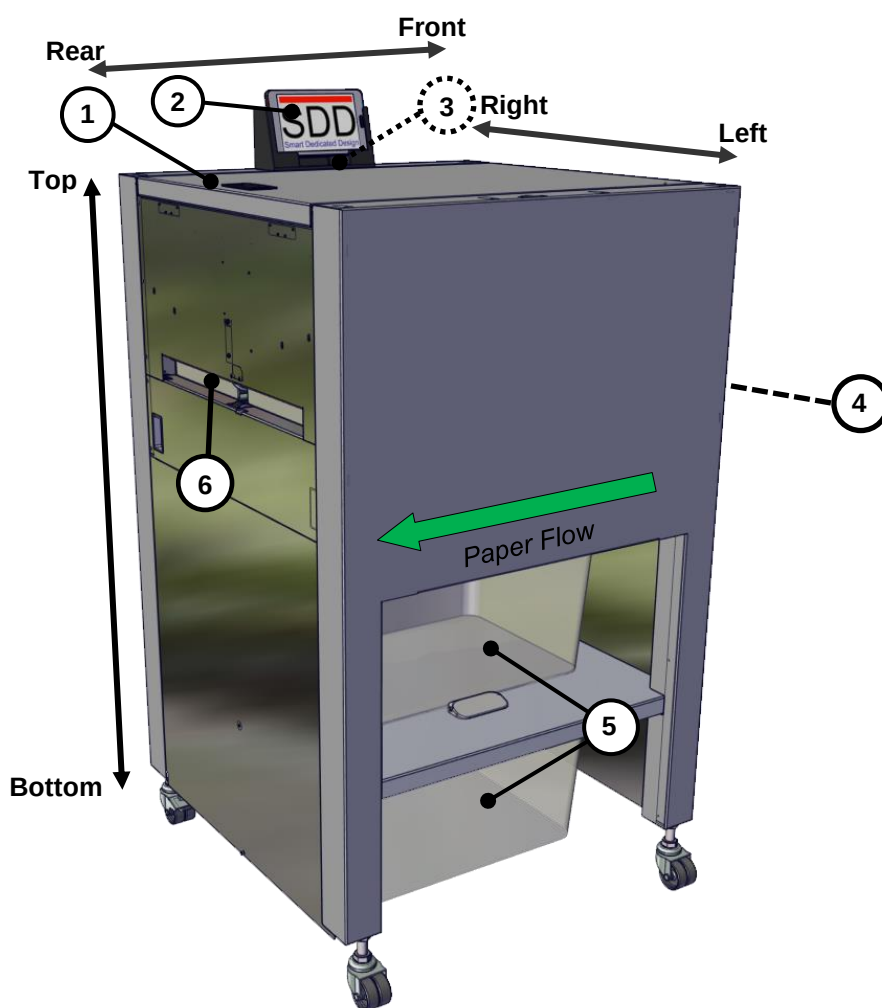
3. Basic Information

3.1. Overview

Study the picture below to become familiar with the main components.



NOTE:
Orientation is based on the paper flow direction.

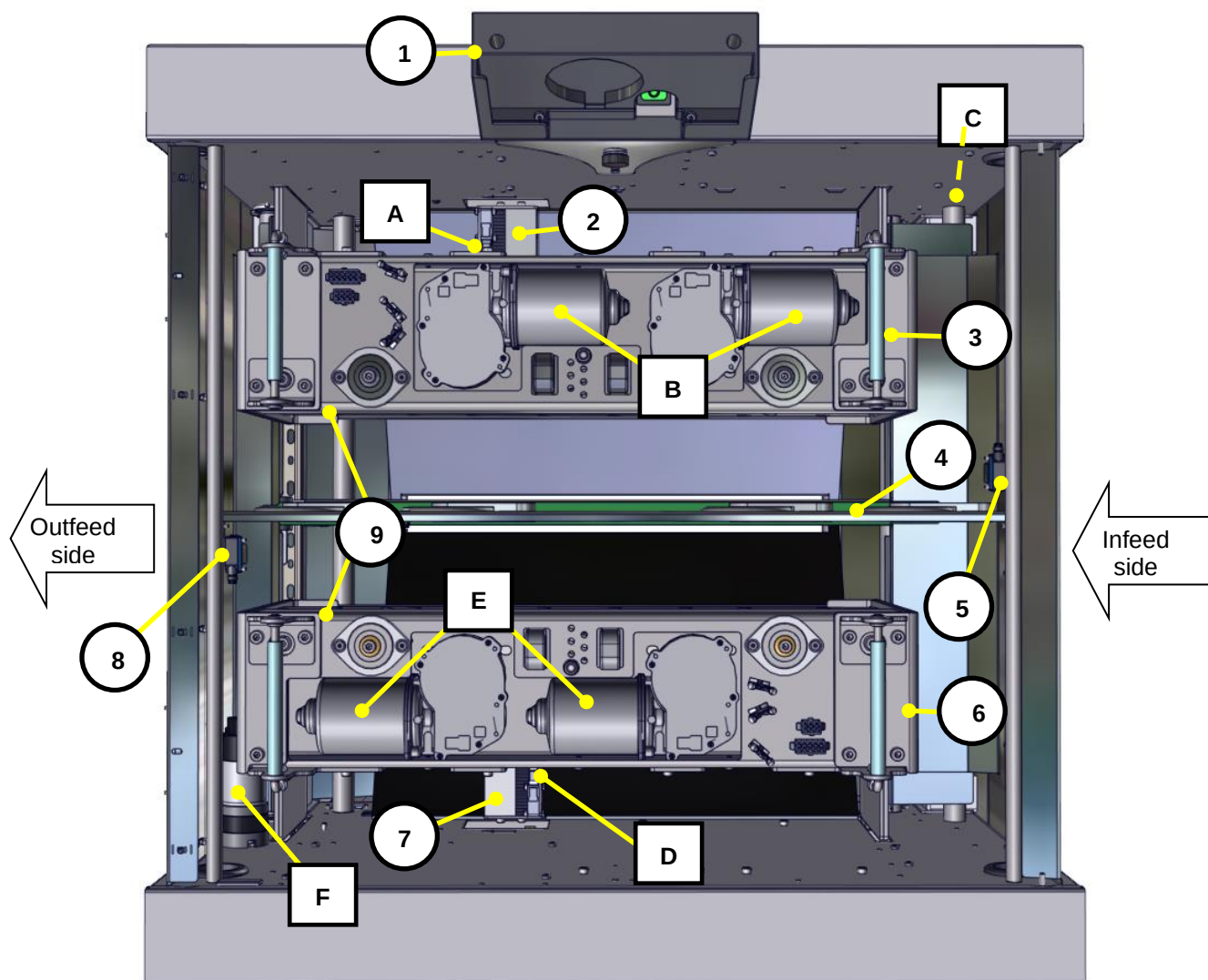


No.	Description
1.	Top Cover 2ST
2.	User Interface (UI) Mount & Tablet
3.	Power switch (inside UI Mount)
4.	Infeed
5.	Trim Waste Bins
6.	Outfeed

3. Basic Information (continued)

3.2. Top view

See the Top View below to become familiar with the components inside the machine.



No.	Description
1	User Interface Mount
2	Jogger Right
3	Knife Block Right
4	Transport Belt
5	Infeed Sensor
6	Knife Block Left
7	Jogger Left
8	Outfeed Sensor

No.	Description
9	Stoppers
A	Motor Jogger Right
B	Knife Motors Right
C	Motor Width Position
D	Motor Jogger Left
E	Knife Motors Left
F	Motor Paper Transport

3. Basic Information (continued)

3.3. Controls

NOTE:



1. User Interface screens shown in this manual may appear different on your tablet, smartphone or laptop due to browser and display settings.
2. The standard supplied Tablet will be charged when it is placed in the UI holder and the wireless charging pad adapter is connected to the power source.
3. For Tablet operation refer to the Manufacturers User Manual.

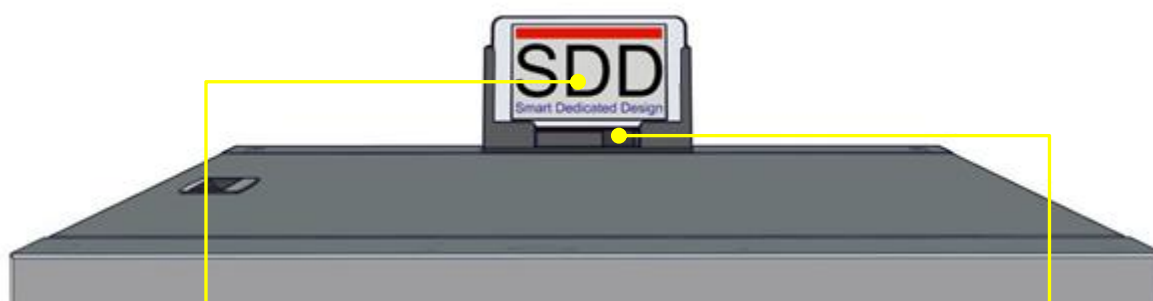


Fig. 3.3.1



Fig. 3.3.2

No.	Description	Symbol	Remarks
1.	User Interface		See chapter 3.4 User Interface
2.	Power switch		Off (= O) or On (= I)

3. Basic Information (continued)

3.4. User Interface



IMPORTANT:

The User Interface will only show when the 2ST7210 is switched on.



NOTE:

The User Interface display is dependent on the screen size and orientation.

The 2ST User Interface is a Web based application that will run on compatible computers, Tablets and Smartphones. The Home-screen is shown below. A Tablet is supplied with the 2ST by default, but the operator can choose to operate the machine from his compatible Smartphone. See [Chapter 4.2.3](#) for details on connecting a Smartphone to the 2ST.



Fig. 3.4.1

No.	Description	Remarks
1.	Current Job field	See Chapter 4.7
2.	Input Size field	See Chapter 4.4
3.	Finished Job field	See Chapter 4.5
4.	Info/Settings field	Ready status shown

3. Basic Information (continued)

3.5. Square Fold Module (Optional)



NOTE:

The Square Fold Module is an optional accessory that will be placed and connected on installation if ordered.



IMPORTANT:

For Operation refer to SFM7804 Operator Manual - DBC-B-0512-0112-0000.

3. Basic Information (continued)

3.6. Conveyor Belt Stacker (Optional)



NOTE:

The Belt Stacker is an optional accessory that will be fitted on installation if ordered.

The Belt Stacker End Plate can be reversed to take up less space when the 2ST7210 is not in use.



Fig. 3.6.1

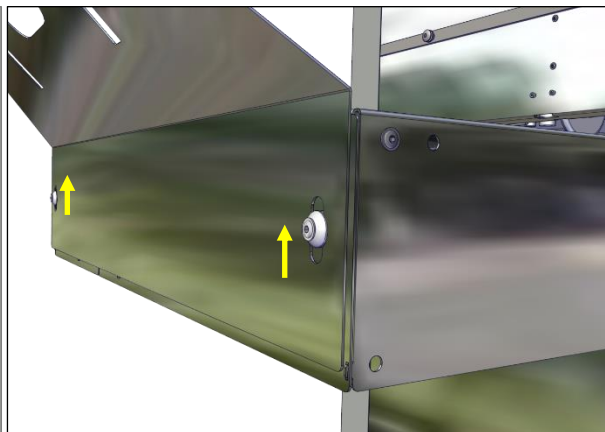


Fig. 3.6.2

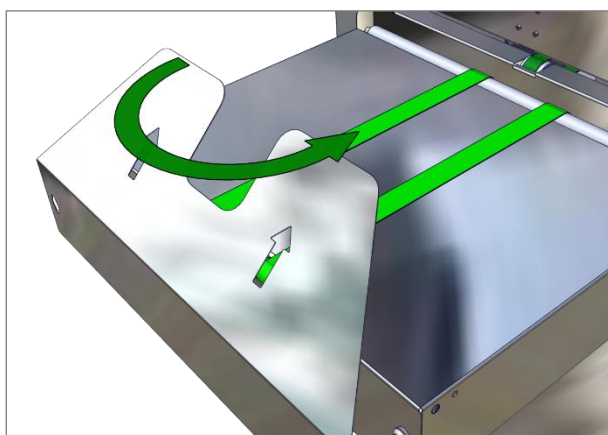


Fig. 3.6.3

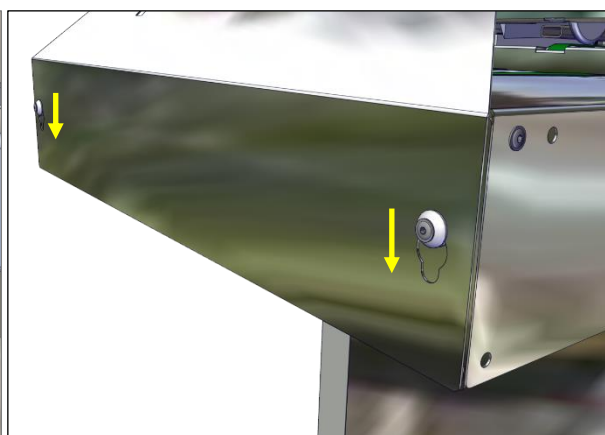


Fig. 3.6.4

Step	Action	Remarks
1.	End Plate in standard position.	Fig. 3.6.1
2.	Slide up till retainers are free in keyhole.	Fig. 3.6.2
3.	Turn End Plate 180°.	Fig. 3.6.3
4.	Fit End Plate on retainers and slide downward.	Fig. 3.6.4

3. Basic Information (continued)

3.6. Conveyor Belt Stacker (Optional) (continued)

3.6.1. Outfeed pressure strip adjustment



NOTE:

This section only applies to CBS6060 and CBS6150.
If you have a CBS6061/CBS6151, this section does not apply.

The Belt Stacker comes with an adjustable pressure strip to control correct stacking of the booklets. The pressure on the strip can be adjusted by sliding the slider up and down. If more pressure is required, the mounting position of the slider can be adjusted to the low position.

Basic Pressure Setting

If needed the pressure on the strip can be adjusted with the following steps.

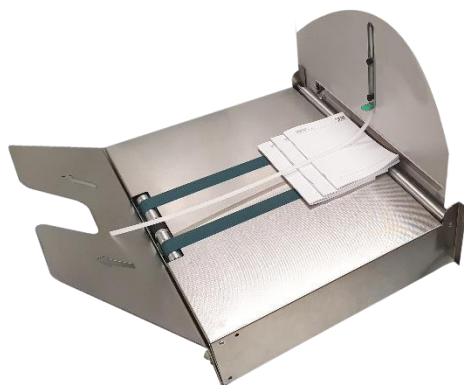


Fig. 3.6.1.1



Fig. 3.6.1.2

Step	Action	Remarks
1.	Loosen the slider a bit (by turning the knobs counter-clockwise).	Fig. 3.6.1.2
2.	Move the slider to the desired position with the green handle.	Fig. 3.6.1.2
3.	Fasten the slider (by turning the knobs clockwise).	Fig. 3.6.1.2

Changing Slider Mounting Position

The mounting position of the slider can be changed with the following steps.

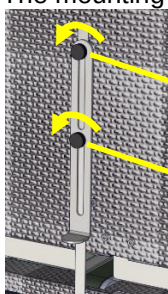


Fig. 3.6.1.3



Fig. 3.6.1.4

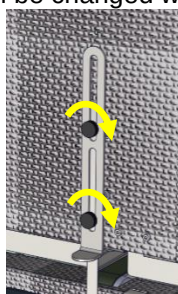


Fig. 3.6.1.5

Step	Action	Remarks
1.	Remove the slider by unscrewing the knobs.	Fig. 3.6.1.3
2.	Move the slider to lower mounting position.	Fig. 3.6.1.4
3.	Fasten the slider (incl. pressure strip) with the 2 knobs.	Fig. 3.6.1.5

3. Basic Information (continued)

3.6. Conveyor Belt Stacker (Optional) (continued)

3.6.1. Outfeed pressure strip adjustment (continued)

Standard setting

The standard setting / starting point for the pressure strip is to have slider in upmost position to have no additional pressure on the strip.



Fig. 3.6.1.6

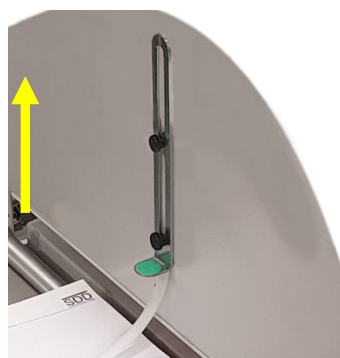


Fig. 3.6.1.7

Step	Action	Remarks
1.	Adjust the slider to the upmost position.	Fig. 3.6.1.7

Regulating pressure for overshooting booklets

For some specific applications it may occur that the books coming out the machine overshoot the previous book(s). If this happens, the pressure on the strip can be increased to a level where the books get stacked normally again.



Fig. 3.6.1.8



Fig. 3.6.1.9



Fig. 3.6.1.10

Step	Action	Remarks
1.	Lower the slider a bit to increase the pressure on the strip. - Place the slider to lower mounting position if needed.	Fig. 3.6.1.9
2.	Check the results and adjust accordingly if necessary.	Fig. 3.6.1.10

4. Operation



IMPORTANT:

To ensure safe operation the finished size cannot be smaller than the staple distance. The default staple distance is set to 140 mm. (Service Engineer can change the staple distance for a smaller finished size).



NOTE:

System Setup is done on installation. Contact your Service Technician in case the Setup has to be changed.

4.1. Power on



NOTE:

Power On Screen sequence is shown for information.



Fig. 4.1.1

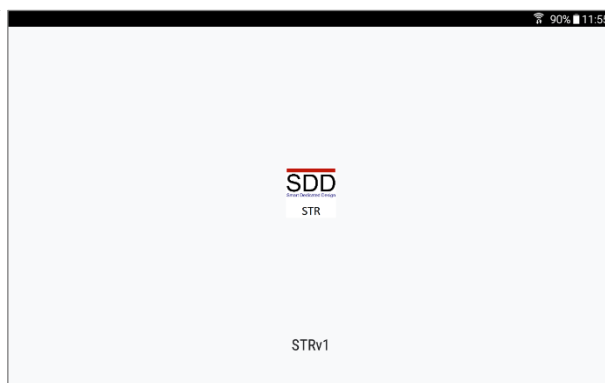


Fig. 4.1.2

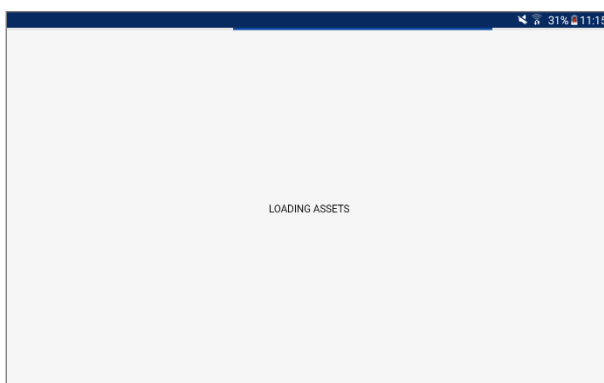


Fig. 4.1.3

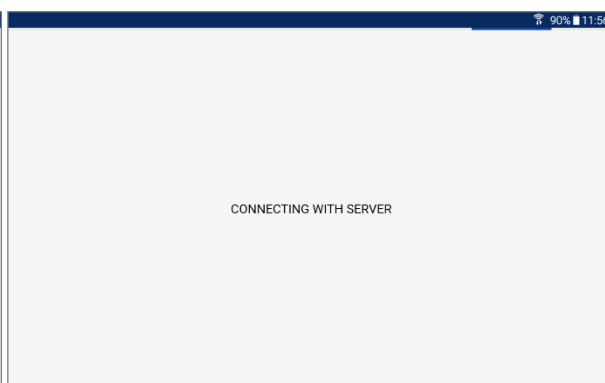


Fig. 4.1.4

Step	Action	Remarks
1.	Turn on UI device.	Make sure Wifi function is active.
2.	Turn on the 2ST7210.	See Chapter 3.3
3.	Tap the SDD App screen button	Fig. 4.1.1
4.	Application will start	Fig. 4.1.2. – 4.1.5

4. Operation (continued)

4.1. Power On (continued)

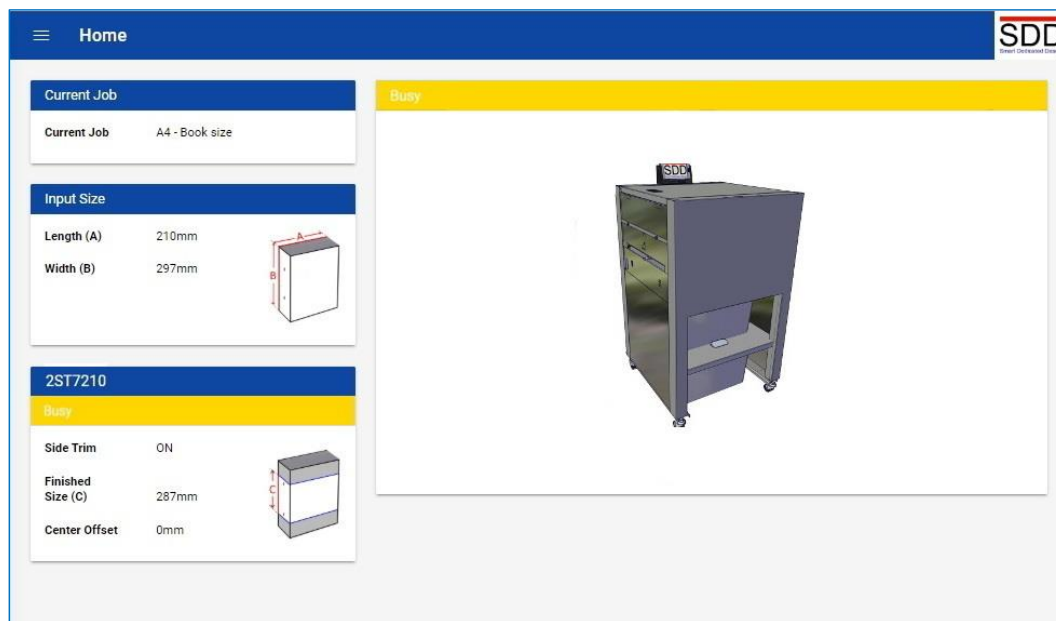


Fig. 4.1.5

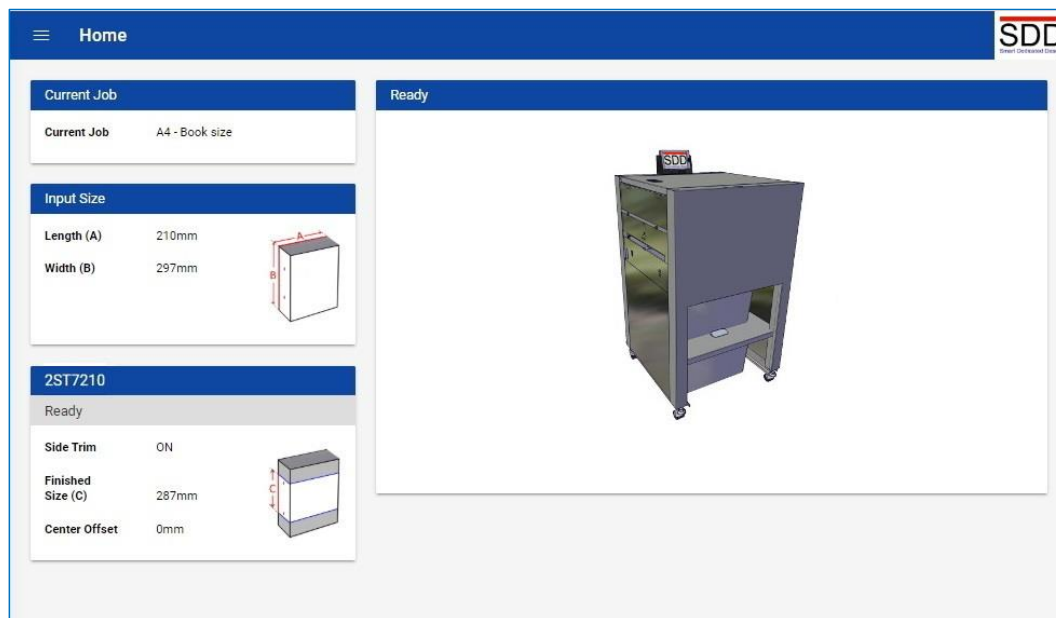


Fig. 4.1.6

Step	Action	Remarks
5.	2ST is ready for operation when 'Home' screen is displayed and 'Busy' is replaced by 'Ready'.	Fig. 4.1.5 & Fig. 4.1.6

4. Operation (continued)

4.2. Operator Settings



NOTE:

Standard Paper size is set to EU or USA size on installation. If this needs to be changed afterwards, this must be done by a Service Engineer.

4.2.1. Language



NOTE:

Language is default set on English but may be changed if so required.

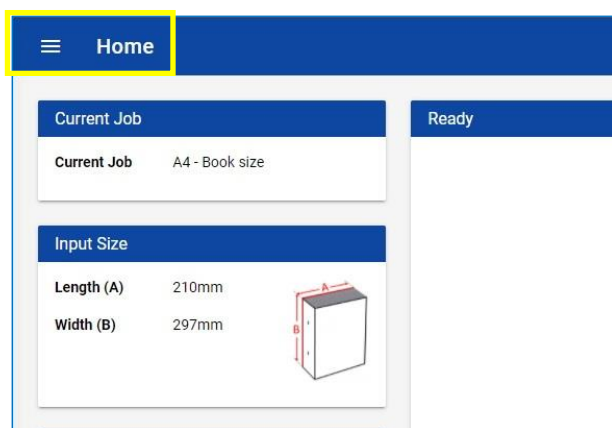


Fig. 4.2.1.1

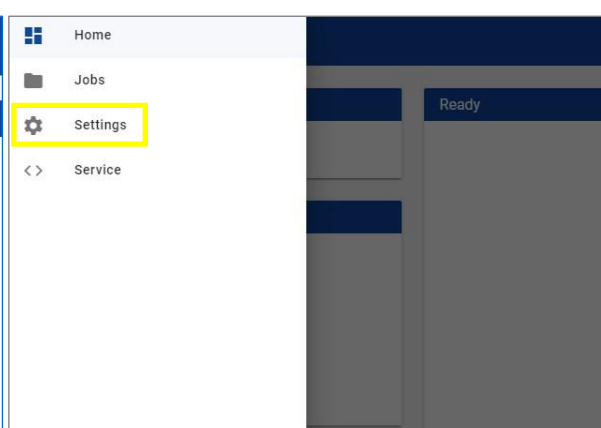


Fig. 4.2.1.2

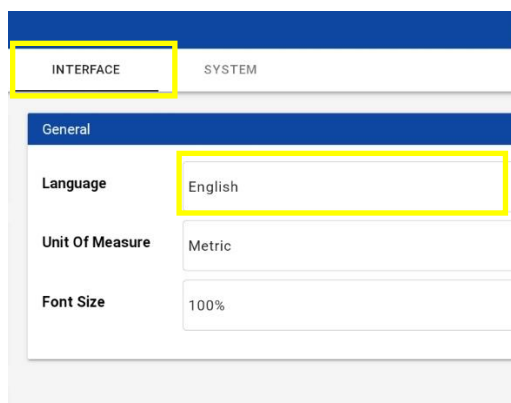


Fig. 4.2.1.3

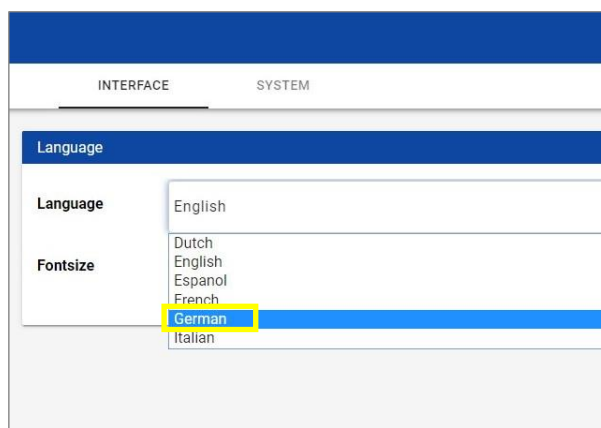


Fig. 4.2.1.4

Step	Action	Remarks
1.	Tap the Menu (☰) icon.	Fig. 4.2.1.1
2.	Tap 'Settings'	Fig. 4.2.1.2
3.	Tap 'Interface'	Fig. 4.2.1.3
4.	Tap in 'Language' field.	Fig. 4.2.1.3
5.	Select and tap required Language in pull-down menu.	Fig. 4.2.1.4

4. Operation (continued)

4.2. Operator Settings (continued)

4.2.1. Language (continued)

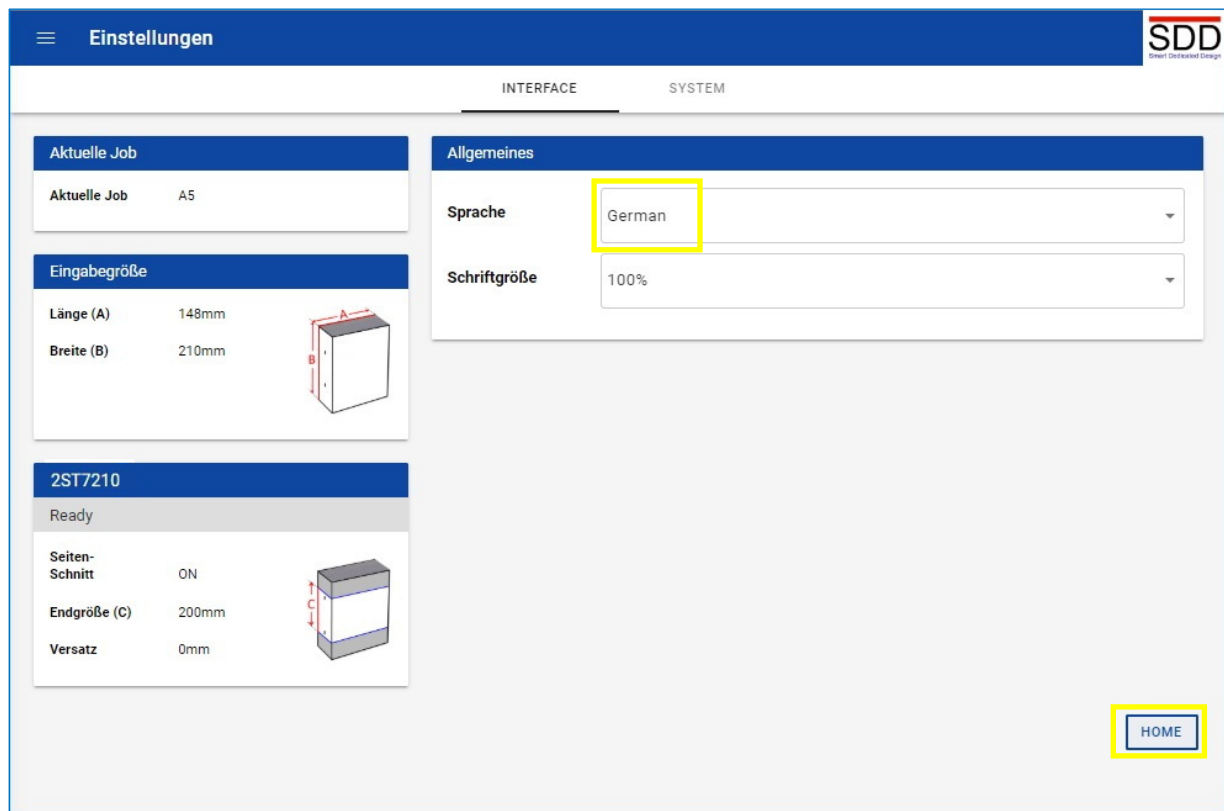


Fig. 4.2.1.5

Step	Action	Remarks
6.	Selected Language applied	Fig. 4.2.1.5
7.	Tap 'Home' to return to Home screen.	Fig. 4.2.1.5

4. Operation (continued)

4.2. Operator Settings (continued)

4.2.2. Unit of Measure



NOTE:

Unit of Measure is set to metric by default but may be changed to imperial if so required.

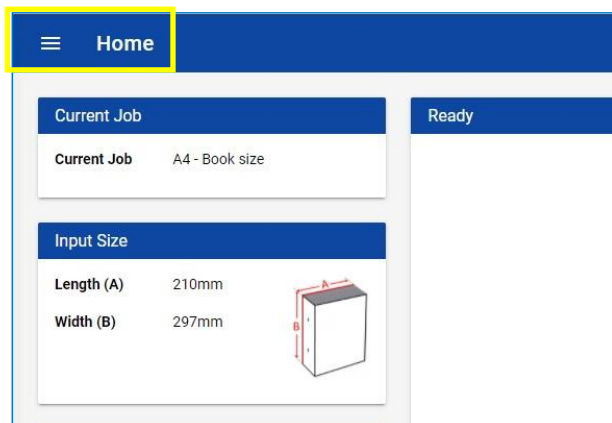


Fig. 4.2.2.1

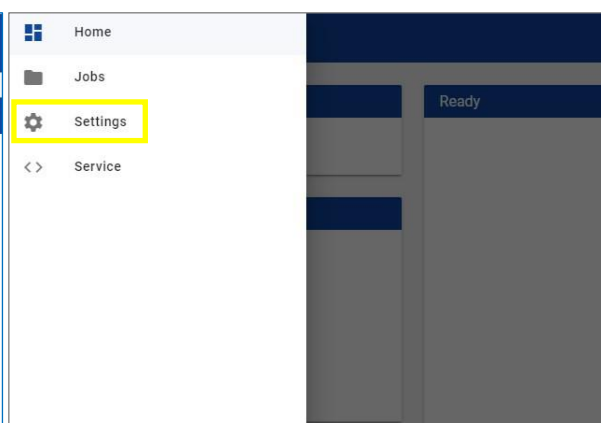


Fig. 4.2.2.2

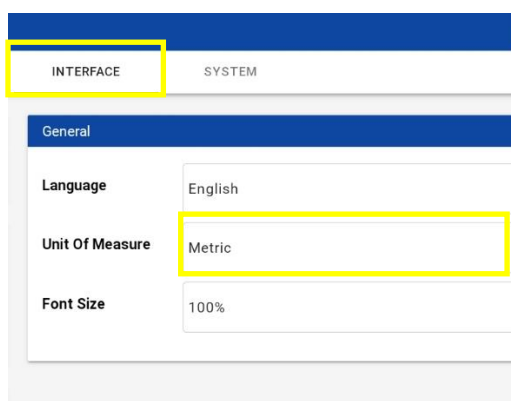


Fig. 4.2.2.3

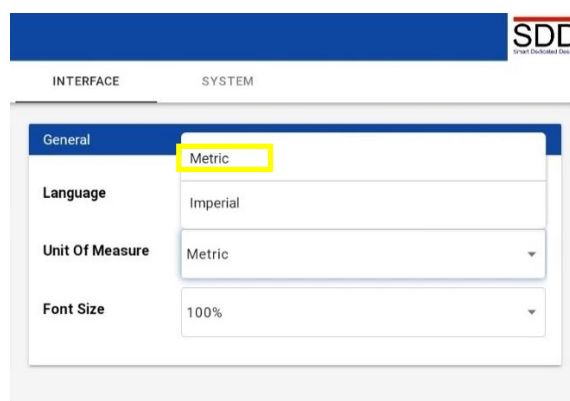


Fig. 4.2.2.4

Step	Action	Remarks
1.	Tap the Menu (☰) icon.	Fig. 4.2.2.1
2.	Tap 'Settings'	Fig. 4.2.2.2
3.	Tap 'Interface'	Fig. 4.2.2.3
4.	Tap in 'Unit Of Measure' field.	Fig. 4.2.2.3
5.	Select and tap required unit of measure in pull-down menu.	Fig. 4.2.2.4
6.	Tap 'Home' to return to Home screen.	

4. Operation (continued)

4.2. Operator Settings (continued)

4.2.3. Font size



NOTE:

Font size is default set at 100% but may be changed if so required.

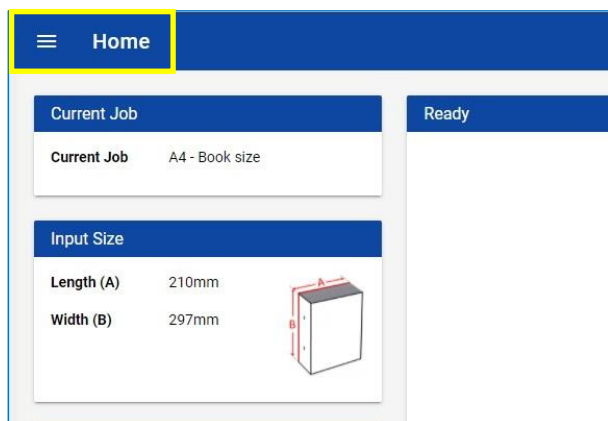


Fig. 4.2.3.1

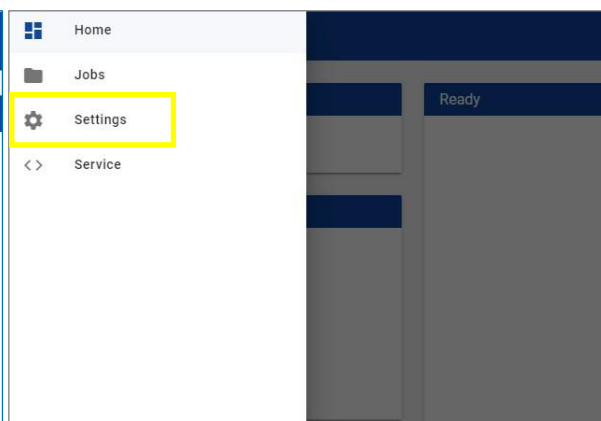


Fig. 4.2.3.2

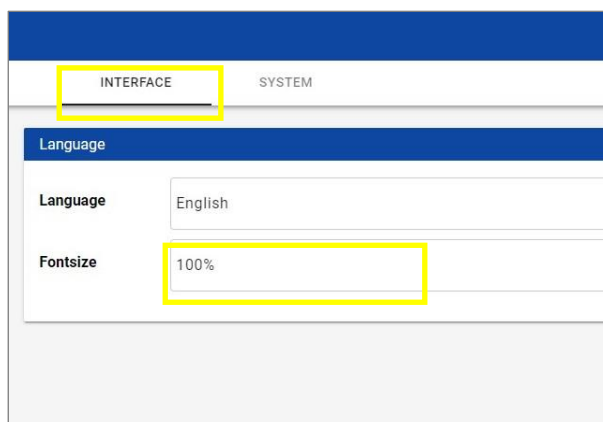


Fig. 4.2.3.3

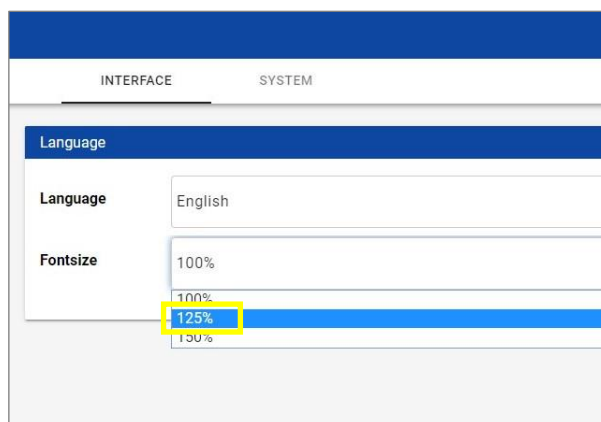


Fig. 4.2.3.4

Step	Action	Remarks
1.	Tap the Menu (☰) icon.	Fig. 4.2.3.1
2.	Tap 'Settings'	Fig. 4.2.3.2
3.	Tap 'Interface'	Fig. 4.2.3.3
4.	Tap in 'Font Size' field.	Fig. 4.2.3.3
5.	Select and tap required Font Size in pull-down menu.	Fig. 4.2.3.4

4. Operation (continued)

4.2. Operator Settings (continued)

4.2.2. Font size (continued)

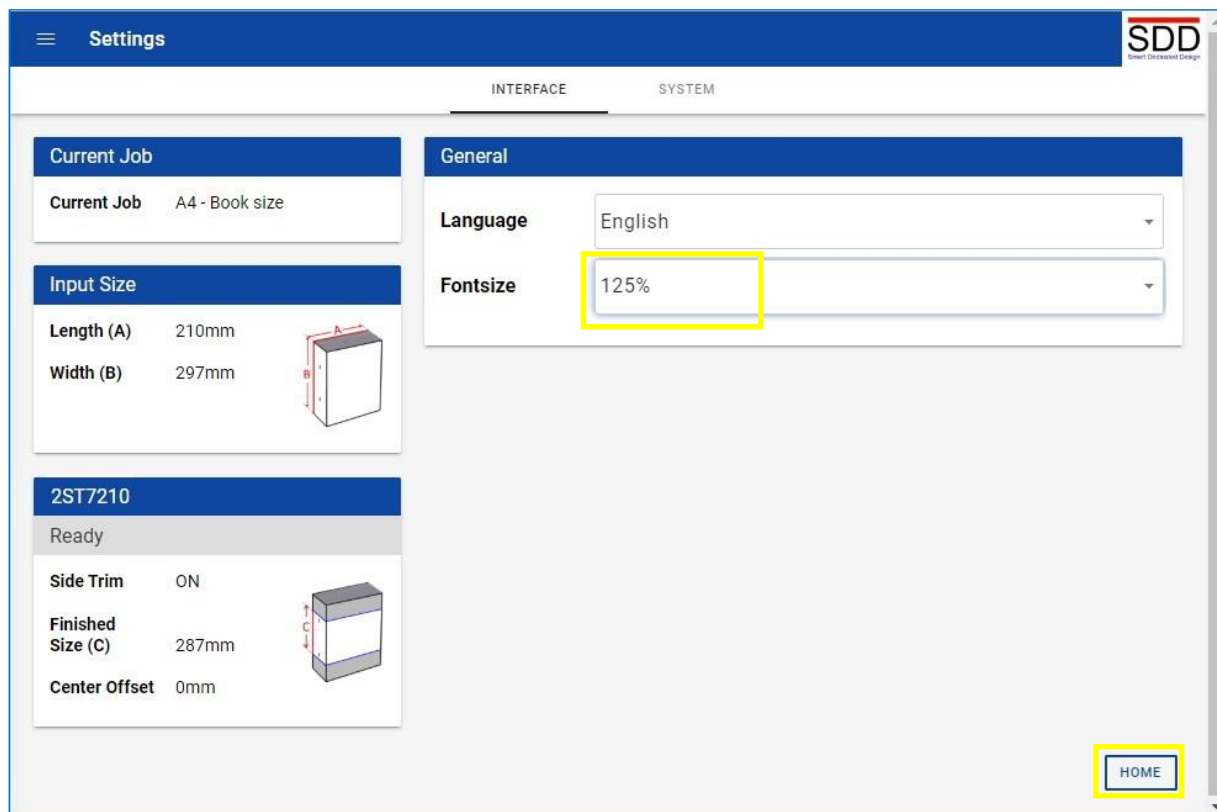


Fig. 4.2.3.5

Step	Action	Remarks
6.	Selected Font applied	Fig. 4.2.3.5
7.	Tap 'Home' to return to Home screen.	Fig. 4.2.3.5

4. Operation (continued)

4.2. Operator Settings (continued)

4.2.4. Smartphone connection



NOTE:

A compatible Smartphone can be used to operate the 2ST.

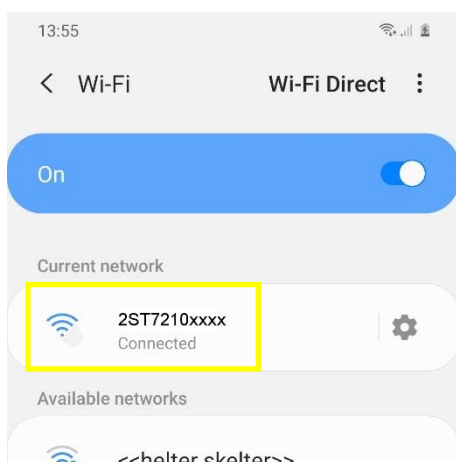


Fig. 4.2.4.1

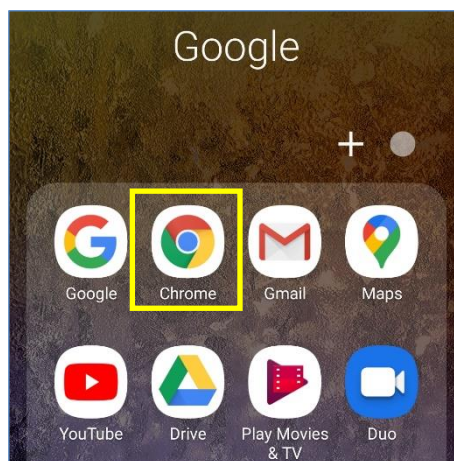


Fig. 4.2.4.2

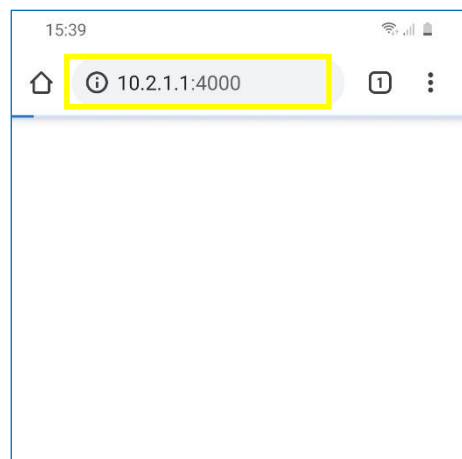


Fig. 4.2.4.3

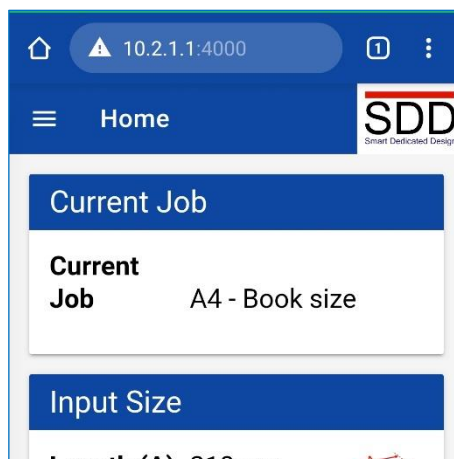


Fig. 4.2.4.4

Step	Action	Remarks
1.	Open the 'Wifi' screen on the Smartphone.	
2.	Connect with the Wifi network 2ST7210xxxx where 'xxxx' is the unique part of the Machine number.	Fig. 4.2.4.1
3.	Next open the Smartphone's Browser (here: Chrome).	Fig. 4.2.4.2
4.	Type in the machine's Wifi address: 10.2.1.1:4000.	Fig. 4.2.4.3
5.	UI website will open on the Smartphone.	Fig. 4.2.4.4

4. Operation (continued)

4.3. Jobs, general info



NOTE

Preset jobs based on European or US paper sizes can be set by a qualified Service Engineer.

Use below table and diagram to set up the Trim Job:

1.	Determine and set the Input Length (A) and Width (B) of the booklet before trimming in mm. See Chapter 4.4 Input Size
2.	Set the required Finished Width (C) of the booklet after trimming in mm. See Chapter 4.5. Finished Size .
3.	Trimwaste will be divided equally over the Top (Wt) and Bottom Waste (Wb) unless an Offset is applied. See Chapter 4.6 Center Offset .
4.	For Square Fold operation refer to the SFM7804 Operator Manual – DBCB-0512-0112-0000
5.	Trim settings can be saved as a Job for future use. See Chapter 4.7 Jobs

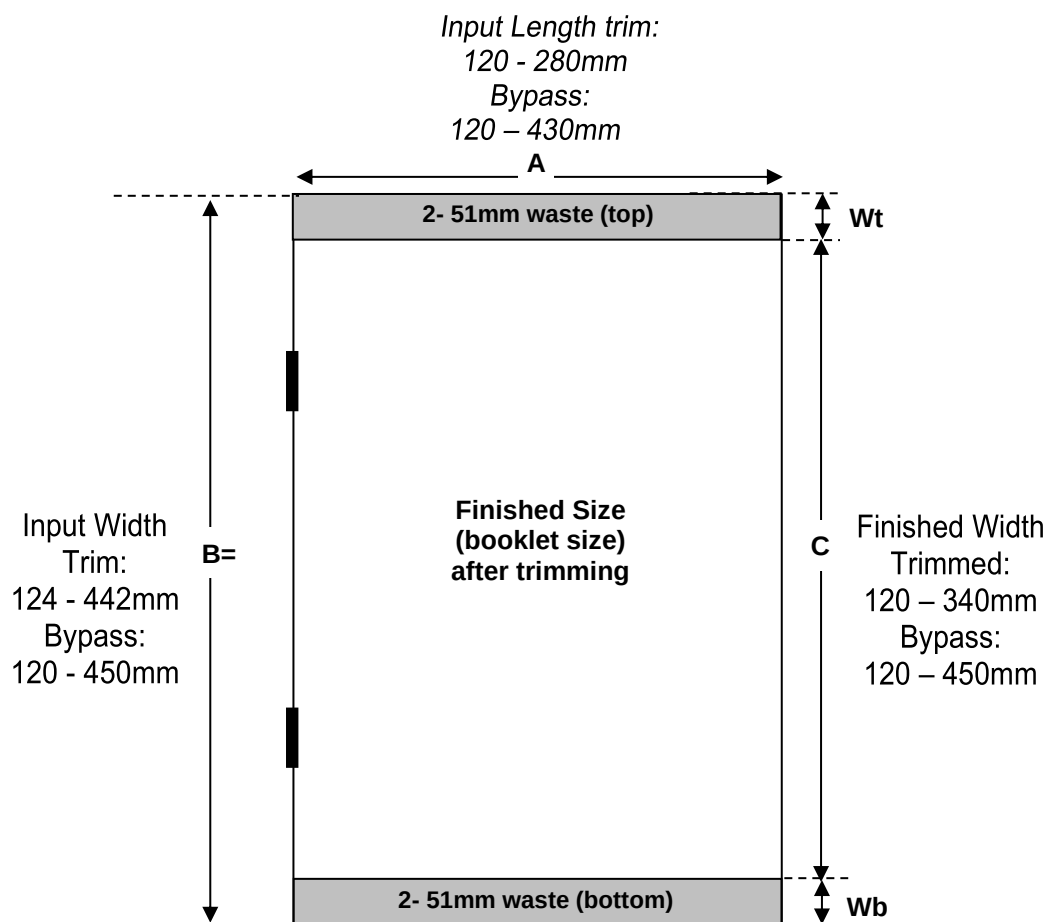


Fig. 4.3.1



IMPORTANT:

To ensure safe operation the finished size cannot be smaller than the staple distance. The default staple distance is set to 140 mm. (Service Engineer can change the staple distance for a smaller finished size).

4. Operation (continued)

4.4. Input Size

4.4.1. Standard Input Size



NOTE

Most Standard Paper Sizes are available as pre-set Input Sizes.

Fig. 4.4.1.1

Fig. 4.4.1.2

Fig. 4.4.1.3

Fig. 4.4.1.4

Step	Action	Remarks
1.	Tap 'Input Size' field.	Fig. 4.4.1.1
2.	Tap in 'Format' field.	Fig. 4.4.1.2
3.	Select 'Format' (here 'A4' format).	Fig. 4.4.1.3.
4.	Standard Format shown.	Fig. 4.4.1.4

4. Operation (continued)

4.4. Input Size (continued)

4.4.1. Standard Input Size (continued)

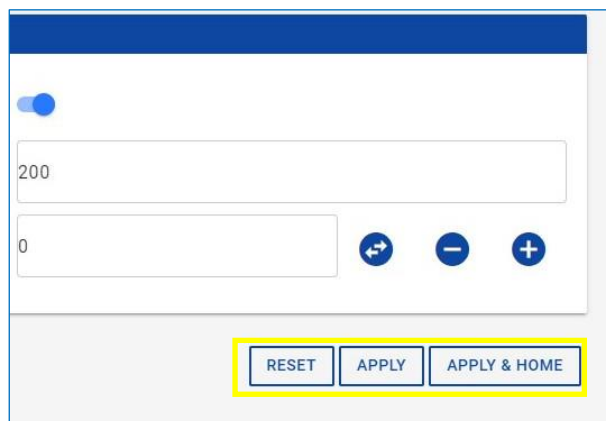


Fig. 4.4.1.5

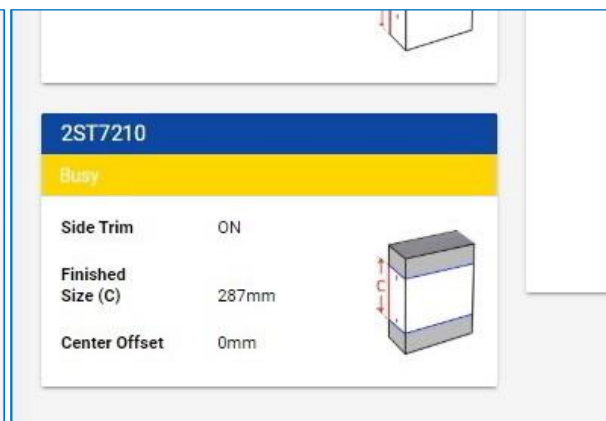


Fig. 4.4.1.6

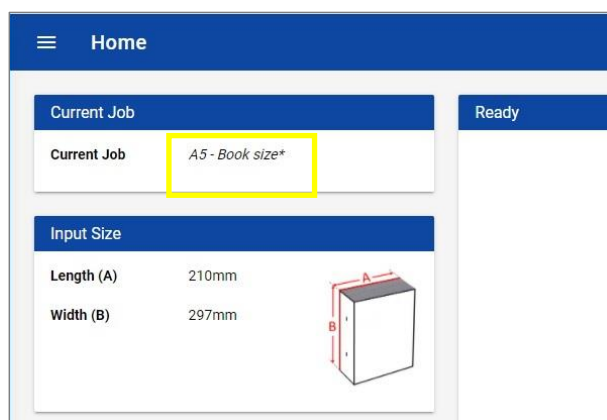


Fig. 4.4.1.7

Step	Action	Remarks
5.	Tap: 1. Reset - Resets to last used Job. 2. Apply - Applies changes and remains on Settings screen. 3. Apply & Home - Applies changes and returns to Home screen.	Fig. 4.4.1.5
6.	Machine 'Busy' indicates Format being processed	Fig.4.4.1.6
7.	Job name in <i>italics</i> and * indicate settings to the stored job have changed. NOTE Go to Chapter 4.7.2 Amending Jobs if you want to save the changed settings to a new job or amend an existing Job.	Fig. 4.4.1.7

4. Operation (continued)

4.4. Input Size (continued)

4.4.2. Custom Input Size



IMPORTANT:

When setting the Input Width, the Finished size must be between 4 and 120 mm less than the Input Width (see [Chapter 4.5 Finished size](#))



NOTE

Non-standard Paper Formats must be set as **Custom**.

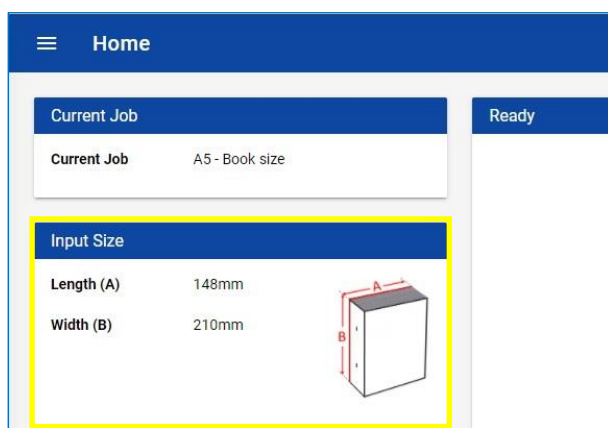


Fig. 4.4.2.1

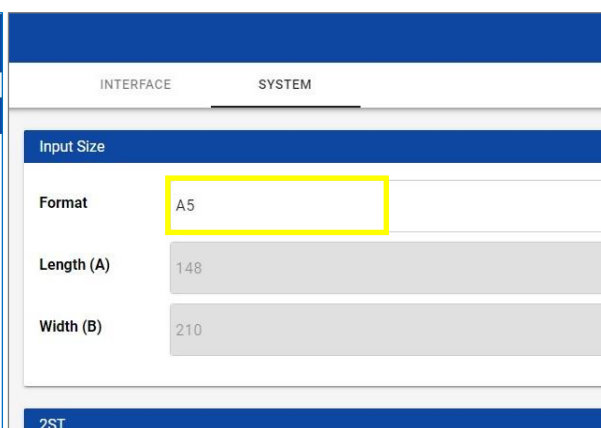


Fig. 4.4.2.2

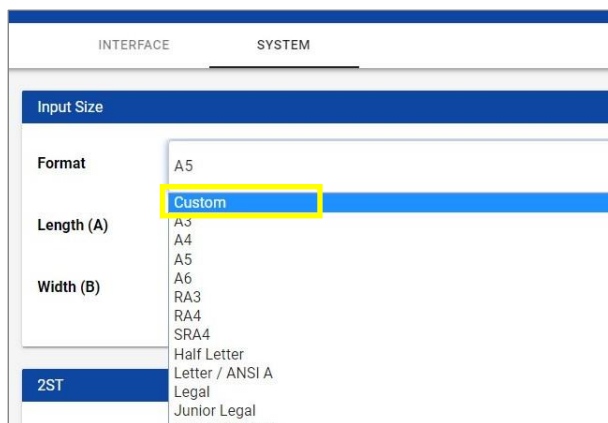


Fig. 4.4.2.3

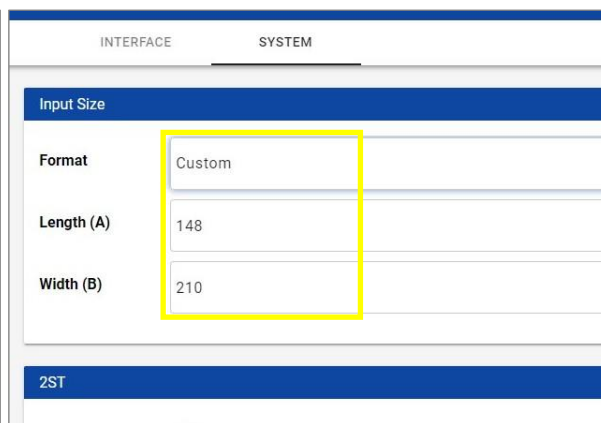


Fig. 4.4.2.4

Step	Action	Remarks
1.	Tap 'Input Size' field.	Fig. 4.4.2.1
2.	Tap in 'Format' field.	Fig. 4.4.2.2
3.	Select 'Format'.	Here 'Custom' Format Fig. 4.4.2.3.
4.	Custom Format shown.	Both 'Length' and 'Wide' fields can be accessed Fig. 4.4.2.4

4. Operation (continued)

4.4. Input Size (continued)

4.4.2. Custom Input Size (continued)

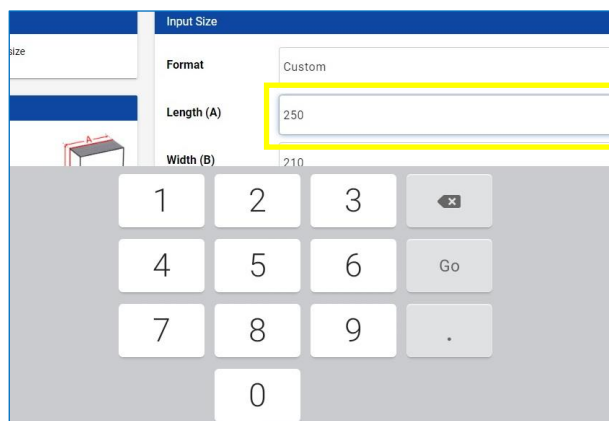


Fig. 4.4.2.5

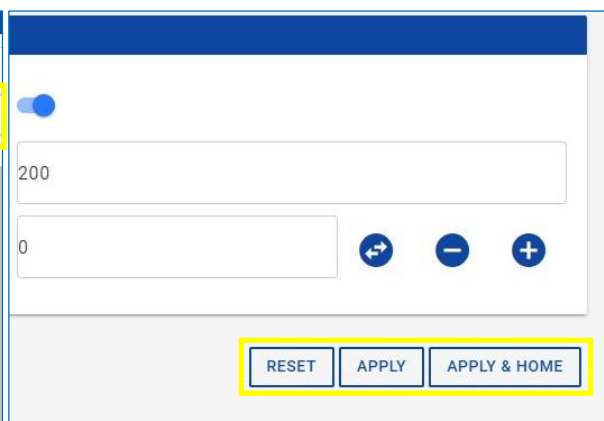


Fig. 4.4.2.6



Fig. 4.4.2.7

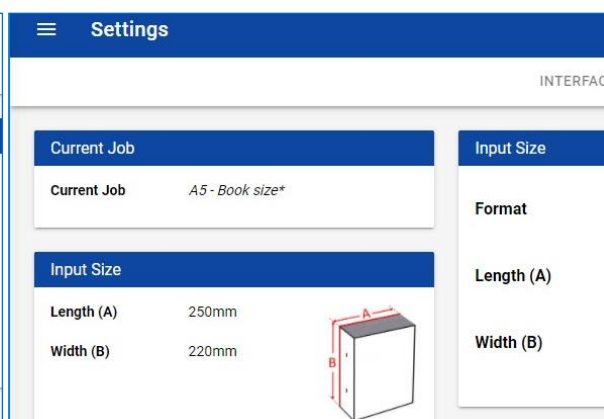


Fig. 4.4.2.8

Step	Action	Remarks
5.	Tap 'Length' field to use on-screen keyboard to set Paper Length [A] as per required Infeed size.	Fig. 4.4.2.5
6.	Tap 'Width' field to set Paper Width [B].	
7.	Tap: 1. Reset - Resets to last used Job. 2. Apply - Applies changes and remains on Settings screen. 3. Apply & Home - Applies changes and returns to Home screen.	Fig. 4.4.2.6
8.	'Busy' indicates Format being processed	Fig.4.4.2.7
9.	Job name in <i>italics</i> and * indicate settings to the stored job have changed. NOTE Go to Chapter 4.7.2 Amending Jobs if you want to save the changed settings to a new job or amend an existing Job.	Fig. 4.4.2.8

4. Operation (continued)

4.5. Finished Size



IMPORTANT:

Finished size must be between 4 and 120 mm less than the Input Width (see [Chapter 4.4 Input Paper Size](#))



Fig. 4.5.1

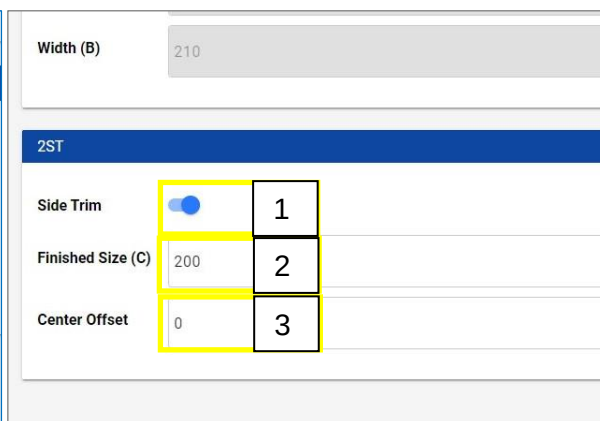


Fig. 4.5.2

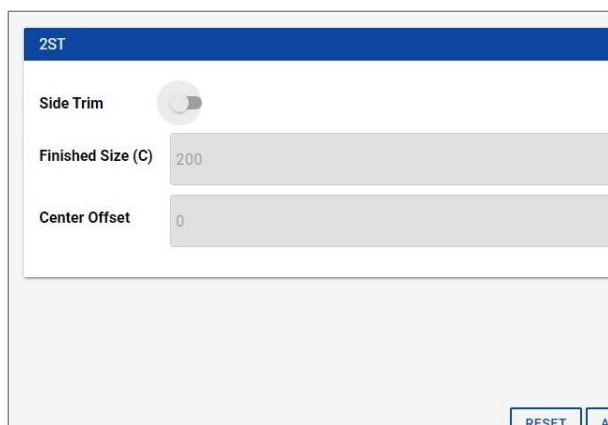


Fig. 4.5.3

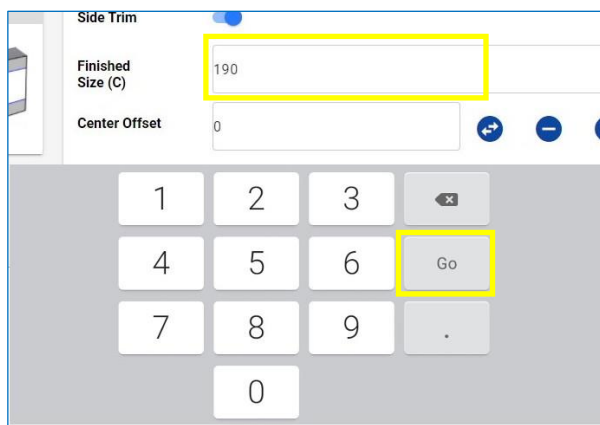


Fig. 4.5.4

Step	Action	Remarks
1.	Tap '2ST7210' field.	Fig. 4.5.1
2.	Set Output: 1 - Select On (=Trimming) or Off (=Bypass); 2 - Set Finished Size C in mm; 3 - Set Center Offset in mm. See Chapter 4.5	Fig. 4.5.2
3.	'Side Trim' Off is Bypass enabled	Fig. 4.5.3
4.	With Side Trim On tap 'Finished Size' field and use on-screen keyboard to set Finished Size [C] and tap 'Go'.	Fig. 4.5.4

4. Operation (continued)

4.5. Finished Size (continued)

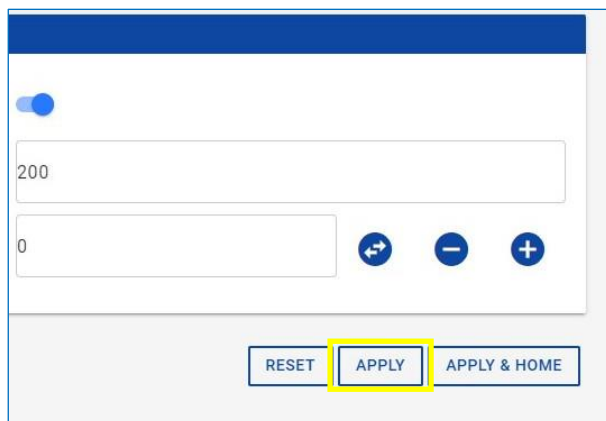


Fig. 4.5.5

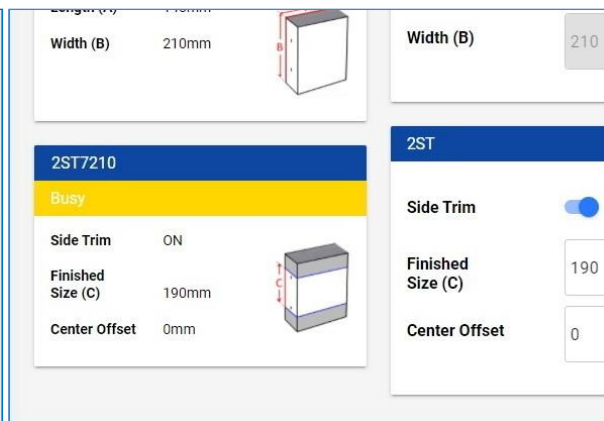


Fig. 4.5.6

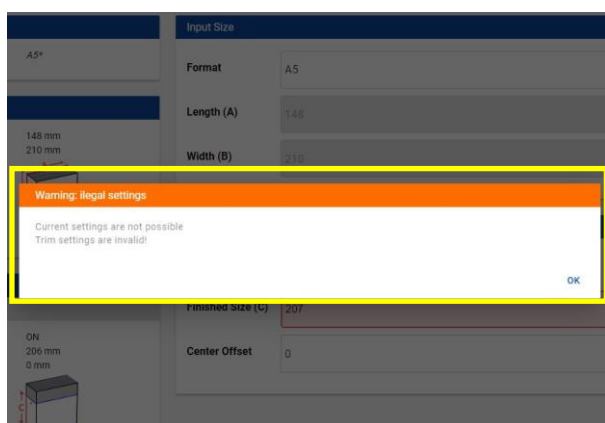


Fig. 4.5.7

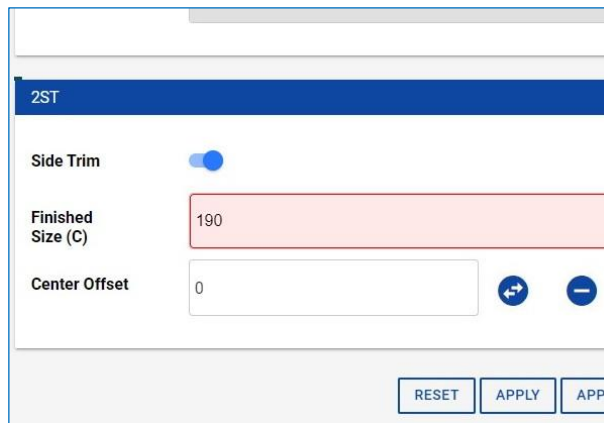


Fig. 4.5.8

Step	Action	Remarks
5.	Tap: 1. Reset - Resets to last used Job. 2. Apply - Applies changes and remains on Settings screen (shown here). 3. Apply & Home - Applies changes and returns to Home screen.	Fig. 4.5.5
6.	Machine 'Busy' indicates Trim Size being processed.	Fig.4.5.6
7.	Invalid Setting outside of Trim specifications is not possible. Adjust setting marked in red.	Fig. 4.5.7. & Fig. 4.5.8

4. Operation (continued)

4.5 Finished Size (continued)

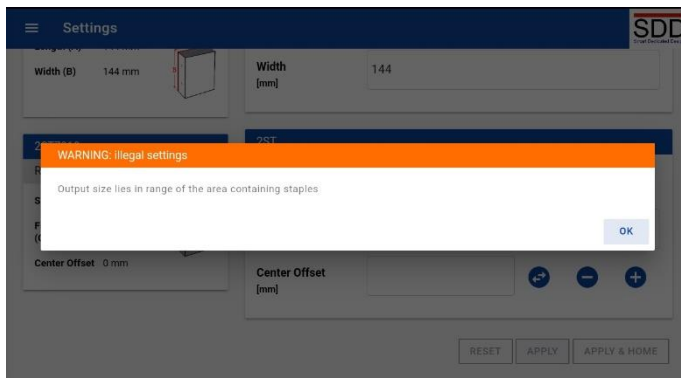


Fig. 4.5.9

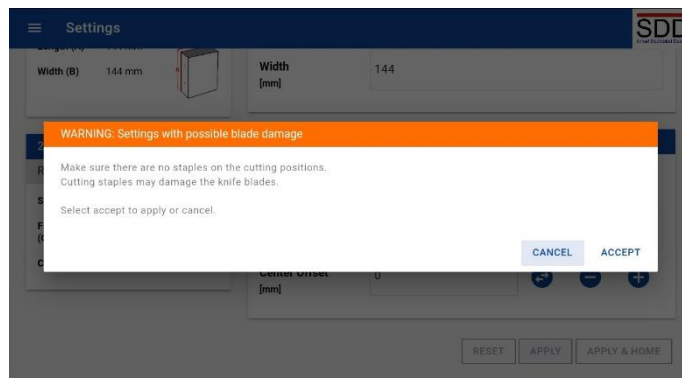


Fig. 4.5.10

No.	Action	Remarks
8.	Illegal settings, finished size is smaller than the staple distance. Adjust setting marked in red (Service Engineer can change the staple distance).	Fig. 4.5.8 & Fig. 4.5.9
9.	Warning, knives are close to the staples and could possibly cut the staples, which can damage the knives. This warning will only occur when the staple distance is set between 120 mm and 138 mm and the knives are within 10 mm of the staples. Tap: 1. Cancel - 2. Accept -	Fig. 4.5.10 Doesn't apply the Finished Size setting. Applies changes and remains on Settings screen.

4. Operation (continued)

4.5. Finished Size (continued)

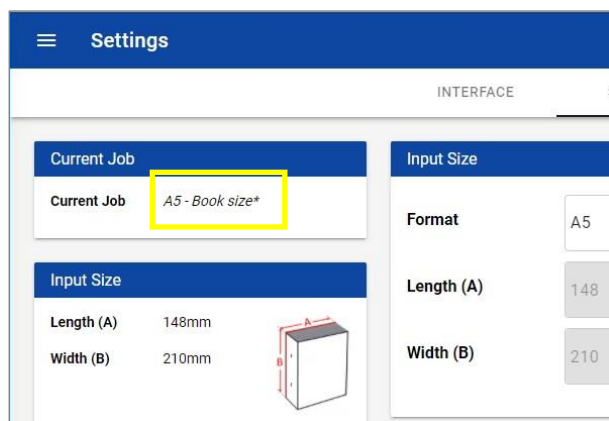


Fig. 4.5.9

Step	Action	Remarks
8.	Current Job name A5-Book size* indicates settings for the stored A5-Book size job have changed NOTE Go to Chapter 4.7.2 Amending Jobs if you want to save the changed settings to a new job or amend an existing Job.	Fig. 4.5.9

4. Operation (continued)

4.6. Center Offset

In order to asymmetrically trim the bleed off a booklet, a Center Offset can be set.

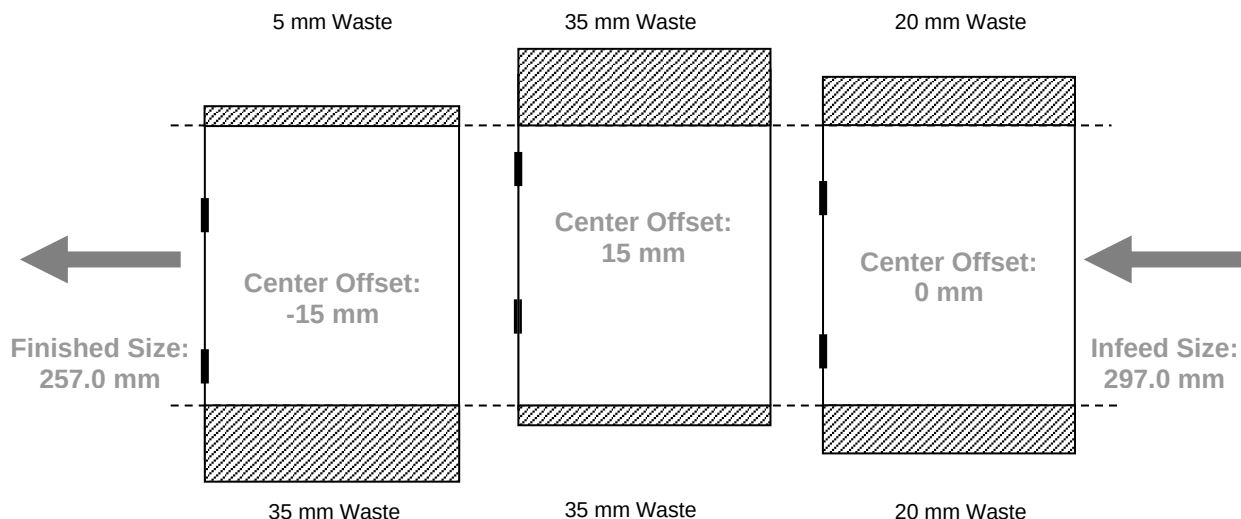


Fig. 4.6.1



IMPORTANT:

To ensure safe operation the finished size cannot be smaller than the staple distance. The default staple distance is set to 140 mm. (Service Engineer can change the staple distance for a smaller finished size).



NOTE:

When offset is set the machine monitors the staple distance.

If the Finished Size (C) minus Center Offset is smaller than the staple distance, then it is an illegal setting.

If the staple distance is set between 120-138 mm and the Finished Size (C) minus Center Offset is within 10 mm of the staple distance, a warning will be shown.

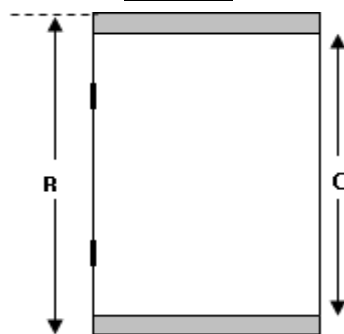
The following rules apply for Center Offset:



NOTE:

Incompatible settings will be rejected by the 2ST7210.

- A **positive** Center Offset will result in a booklet with more trim on the **left**.
- A **negative** Center Offset will result in a booklet with more trim on the **right**.



- Booklet Width (B) minus Finished Size (C) minus Center Offset must be more than 4 mm.
- Booklet Width (B) minus Finished Size (C) plus Center Offset must be less than 120 mm.
- The Trim waste width on any side can never be less than 2 mm.

4. Operation (continued)

4.6. Center Offset (continued)

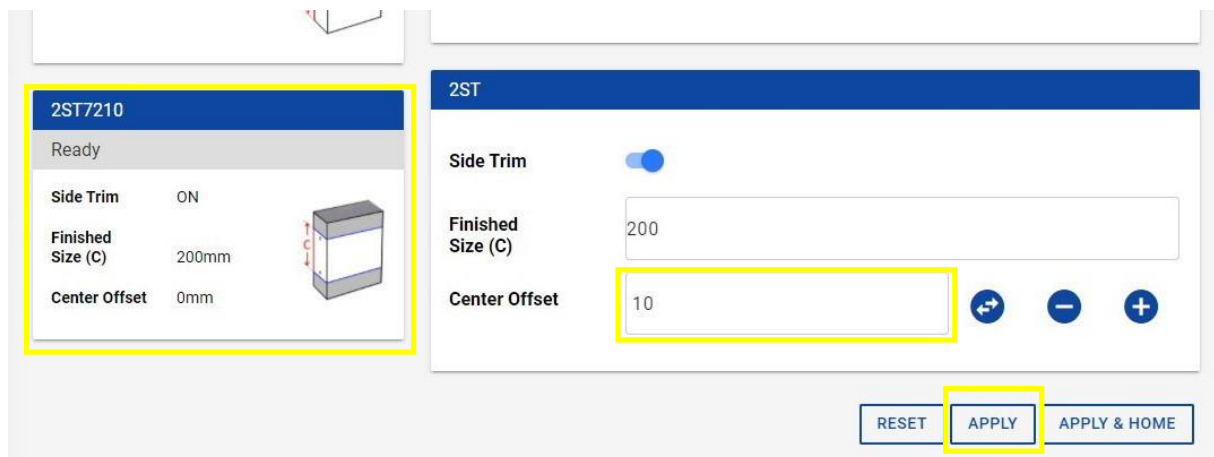


Fig. 4.6.2

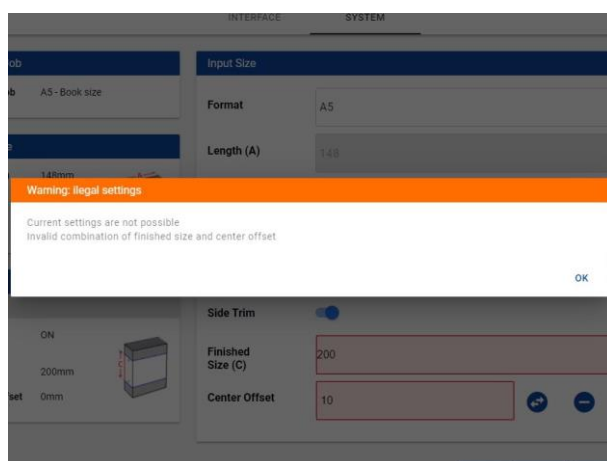


Fig. 4.6.3

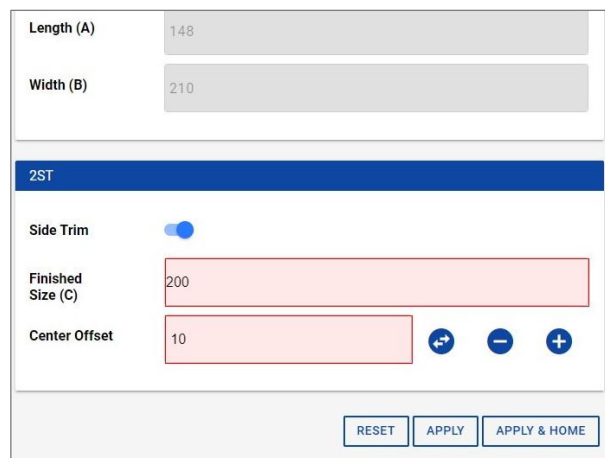


Fig. 4.6.4

Step	Action	Remarks
1.	Tap '2ST7210' field to open 'Settings' screen..	Fig. 4.6.2
2.	Tap 'Center Offset' field to set Center Offset in mm with either '+' & '-' screen buttons or UI 'Keyboard'.  NOTE Use the  button to change the Center Offset polarity.	Fig. 4.6.2
3.	Tap: 1. Reset - Resets to last used Job. 2. Apply - Applies changes and remains on Settings screen (shown here). 3. Apply & Home - Applies changes and returns to Home screen.	Fig. 4.6.2
4.	Warning Illegal Settings shows Trim and Offset setting are incompatible.	Fig. 4.6.3 & Fig. 4.6.4.

4. Operation (continued)

4.6. Center Offset (continued)

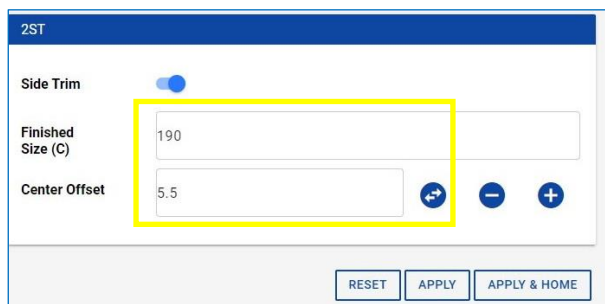


Fig. 4.6.5



Fig. 4.6.6

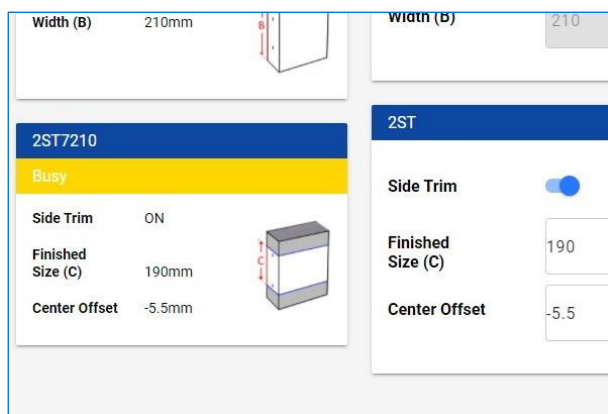


Fig. 4.6.7

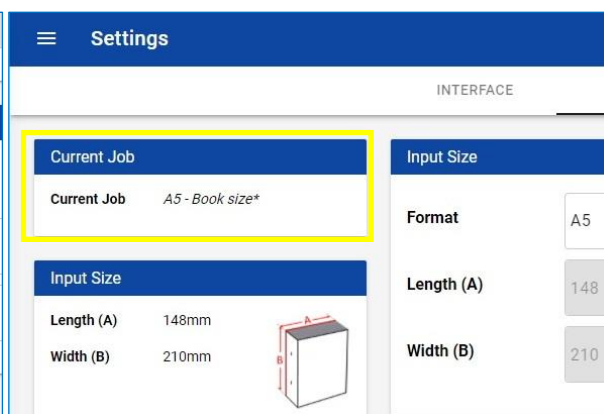


Fig. 4.6.8

Step	Action	Remarks
5.	Adjust Finished Size and Center Offset values in 2ST field.	Fig. 4.6.5
6.	Use the  screen button to set a negative Center Offset.	Fig. 4.6.6
7.	Machine 'Busy' indicates Offset being processed	Fig. 4.6.7
8.	Current Job name A5 – Book size* indicates settings to the stored A5 – Book Size job have changed.  NOTE Go to Chapter 4.7.2 Amending Jobs if you want to save the changed settings to a new job or amend an existing Job.	Fig. 4.6.8.

4. Operation (continued)

4.6 Center Offset (continued)

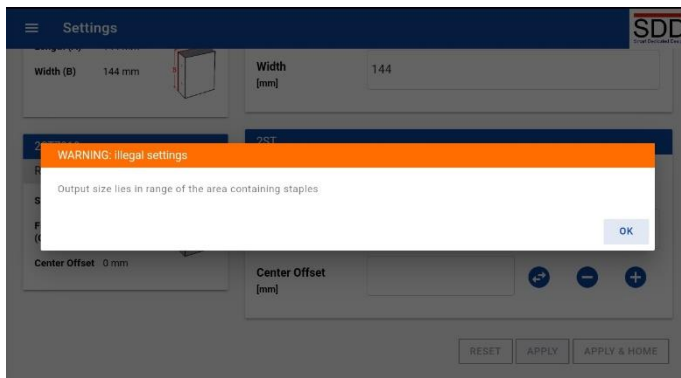


Fig. 4.6.9

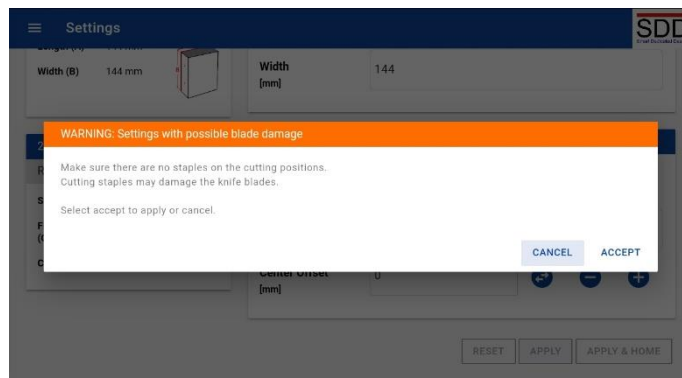


Fig. 4.6.10

No.	Action	Remarks
9.	Illegal settings, finished size minus Center Offset is smaller than the staple distance. Adjust setting marked in red (Service Engineer can change the staple distance).	Fig. 4.6.9 & Fig. 4.6.4
10.	Warning, knives are close to the staples and could possibly cut the staples, which can damage the knives. This warning will only occur when the staple distance is set between 120 mm and 138 mm and the knives are within 10 mm of the staples. Tap: 1. Cancel - Doesn't apply the Finished Size setting. 2. Accept - Applies changes and remains on Settings screen.	Fig. 4.6.10

4. Operation (continued)

4.7. Jobs

4.7.1. Using Jobs



NOTE

Default jobs are 'A5 - Book size' and 'A4 - Book size'.

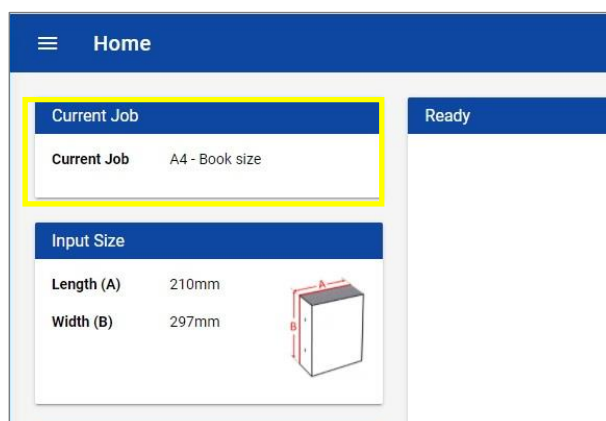


Fig. 4.7.1.1



Fig. 4.7.1.2

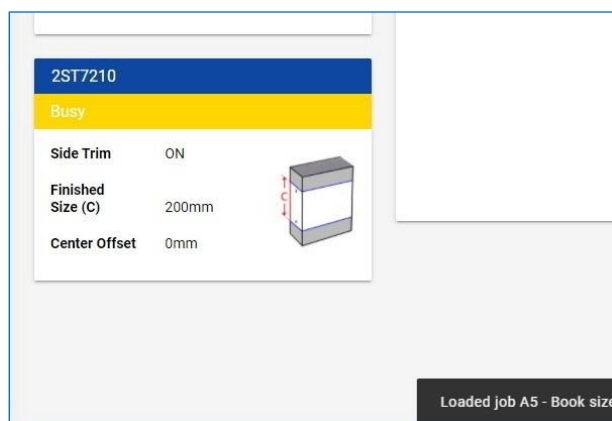


Fig. 4.7.1.3

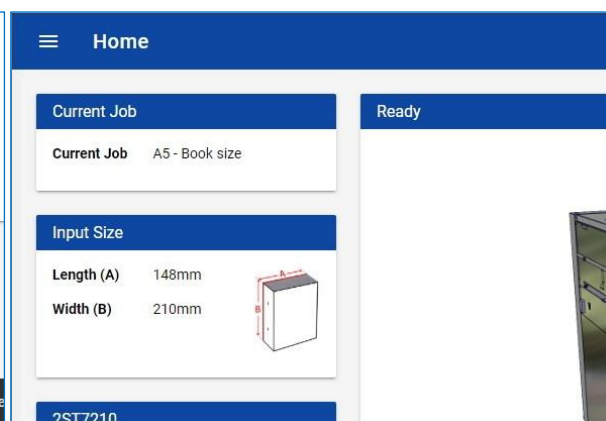


Fig. 4.7.1.4

Step	Action	Remarks
1.	Tap 'Current Job' field	Fig. 4.7.1.1
2.	Tap  in 'A5 - Book size' line.	Fig. 4.7.1.2
3.	'Current Job' loading - changed from A4 - Book size to A5 - Book size.	Fig. 4.7.1.3
4.	'Current Job' A5 - Book size	Fig. 4.7.1.4

4. Operation (continued)

4.7. Jobs (continued)

4.7.2. Amending Jobs



NOTE

All changes in Input Size, Finished Size and Offset can be used to amend an existing job. See Chapter 4.7.3. to save as a new job.

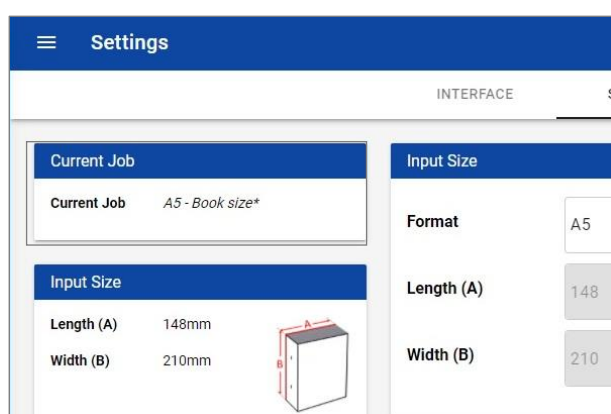


Fig. 4.7.2.1

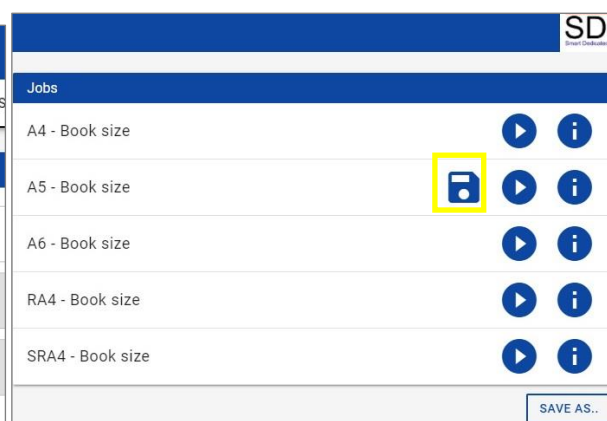


Fig. 4.7.2.2

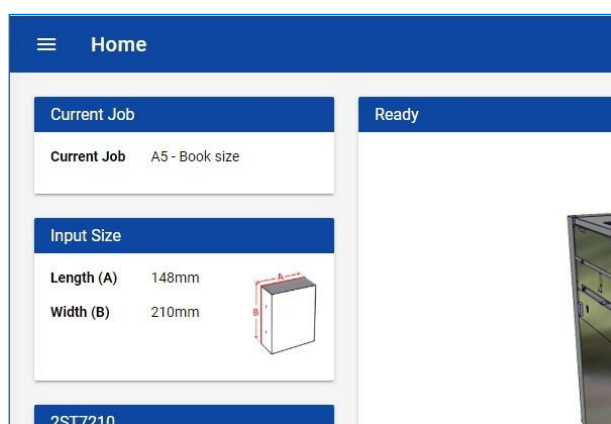


Fig. 4.7.2.3

Step	Action	Remarks
1.	Tap 'Current Job' fields. ' A5 - Book size* ' indicates Saved A5 - Book size Job has changed.	Fig. 4.7.2.1
2.	Tap	Fig. 4.7.2.2
3.	Amended job saved from A5 - Book size* to A5 - Book size	Fig. 4.7.2.3

4. Operation (continued)

4.7. Jobs (continued)

4.7.3. New Job



NOTE:

All changes in Input Size, Finished Size and Offset can be used to save an existing job as a new job.

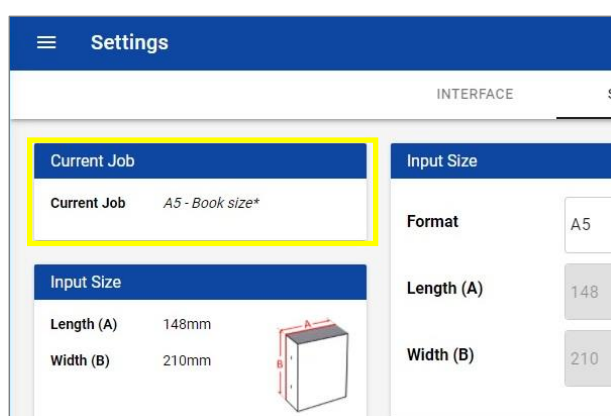


Fig. 4.7.3.1

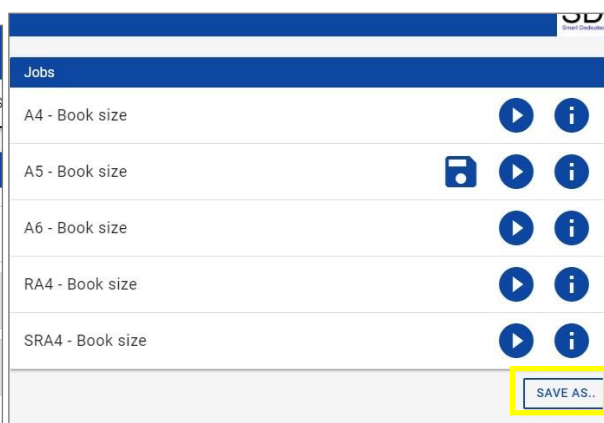


Fig. 4.7.3.2

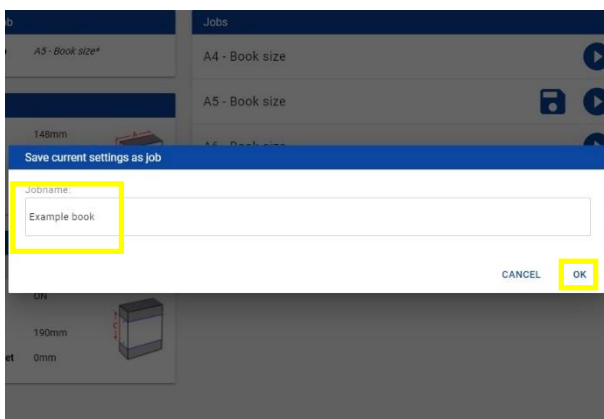


Fig. 4.7.3.3



Fig. 4.7.3.4

Step	Action	Remarks
1.	Tap 'Current Job' fields. ' A5 - Book size* ' indicates Saved A5 - Book size Job has changed.	Fig. 4.7.3.1
2.	Tap 'SAVE AS'.	Fig. 4.7.3.2
3.	Type new Job name and tap 'OK' to save as a job.	Fig. 4.7.3.3
4.	New job added in list.	Fig. 4.7.3.4

4. Operation (continued)

4.7. Jobs (continued)

4.7.4. Removing Jobs

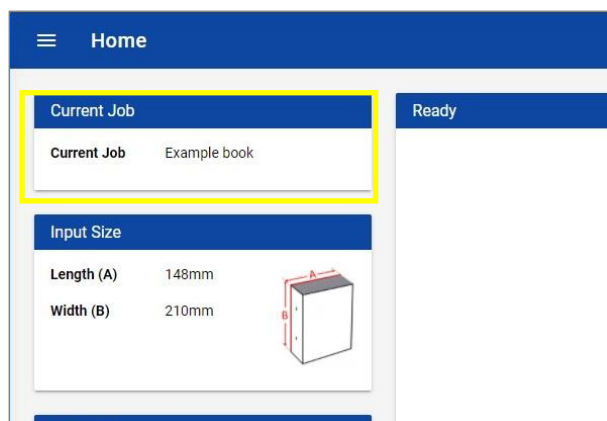


Fig. 4.7.4.1

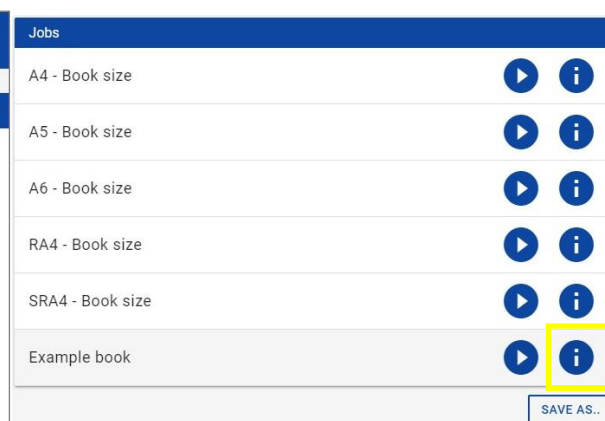


Fig. 4.7.4.2

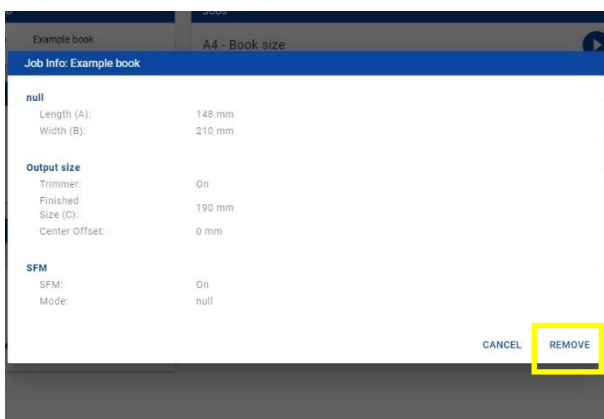


Fig. 4.7.4.2

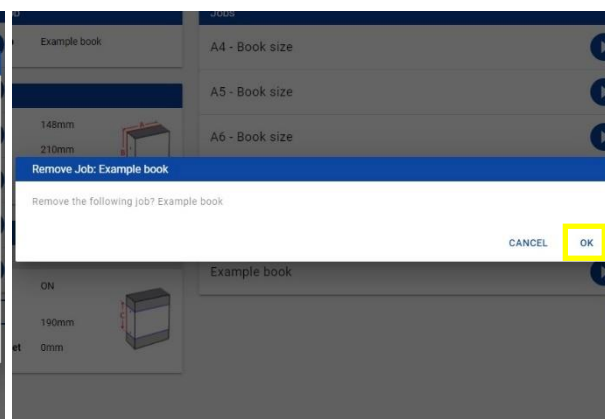


Fig. 4.7.4.4

Step	Action	Remarks
1.	Tap 'Current Job' field.	Fig. 4.7.4.1
2.	Tap  .	Fig. 4.7.4.2
3.	Tap 'REMOVE'.	Fig. 4.7.4.2
4.	Tap 'OK' confirm removal of Saved Job.	Fig. 4.7.4.4

4. Operation (continued)

4.7. Jobs (continued)

4.7.4. Removing Jobs (continued)



Fig. 4.7.4.5

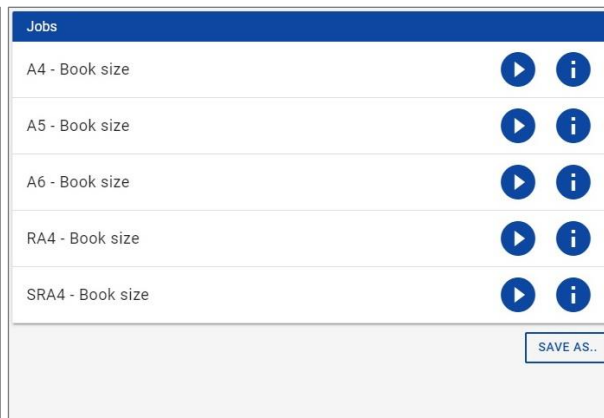


Fig. 4.7.4.6

Step	Action	Remarks
5.	Saved Job Removed.	Fig. 4.7.4.5 & 4.7.4.6

5. Troubleshooting



WARNING:

Before Troubleshooting, Cleaning or Maintenance, always make sure to disconnect the appropriate power cord.



CAUTION:

Never put fingers or other body parts between or near the knives of the 2ST.



NOTE:

An increasing number of Paper Jams indicates that the belts need to be cleaned.

5.1. Error Messages

There are several Error Message which will display on the 2ST UI and the top will flash red and yellow. In all cases check the area indicated on the display.

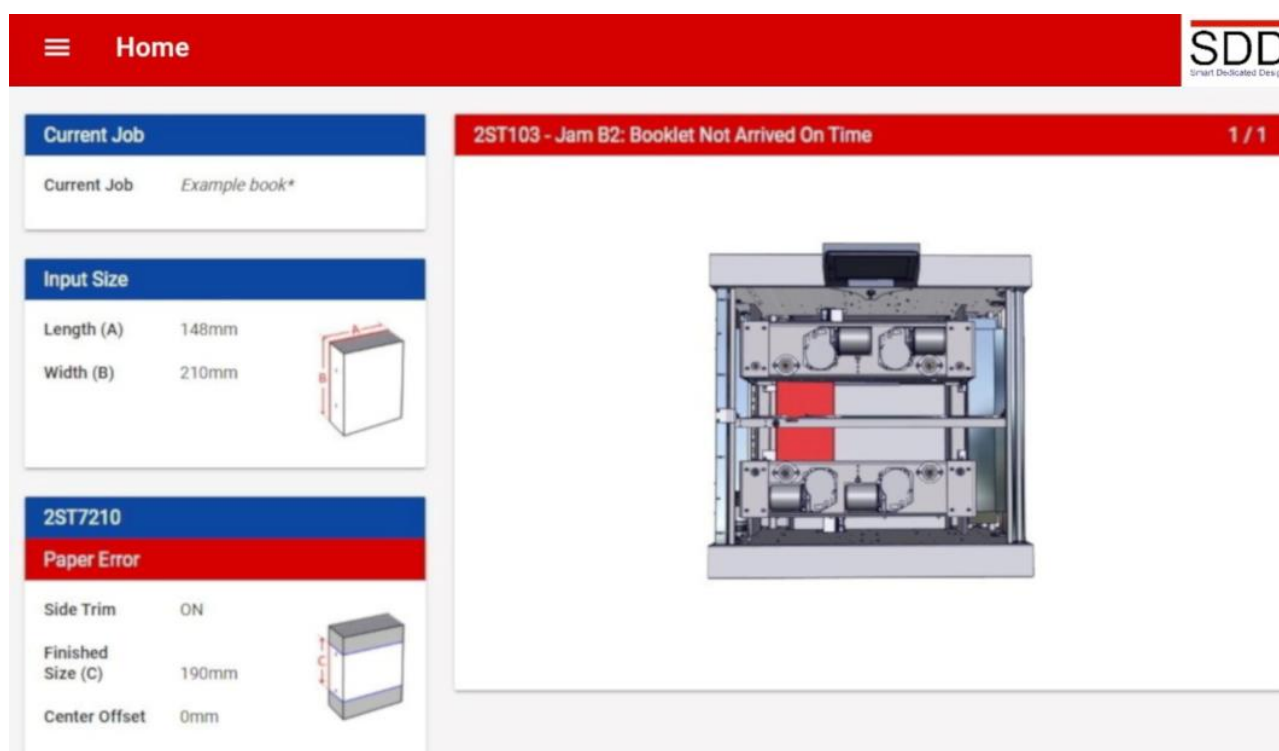


Fig. 5.1.1.

- When a Booklet doesn't arrive in time the message '2ST103 – Jam B2: Booklet Not Arrived On Time' will be displayed together with 'Paper Error'. Fig. 5.1.1.

5. Troubleshooting (continued)

5.2. Trim Waste Bin Full

- When the Trim Waste Bin is full or Trim Waste is prevented from falling down into the Waste Bin, the message 'Empty Trim Bin' will be displayed.
- The 2ST7210 will send a soft stop to the printer if F1/G1 trimming is on, this will result in a temporary stop. The printer will continue once the problem has been resolved.



Fig. 5.2.1.1



Fig. 5.2.1.2

Name: TL04

Fig. 5.2.1.3

Date: 24-3-2023

Step	Action	Remarks
1.	UI indicates Waste Bin Full (Paper Error).	Fig. 5.2.1.1
2.	Lift Trim Waste Bin [A] over retainer and pull forward.	Fig. 5.2.1.2 & Fig. 5.2.1.3
3.	Empty Trim Waste Bin.	
4.	Check for and remove any remaining Cutting Waste.  IMPORTANT Make sure all Trim Waste is removed from the 2ST.	
5.	Place the Trim Waste Bin back in the machine.	

5. Troubleshooting (continued)

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5.3. Clearing a Paper Jam

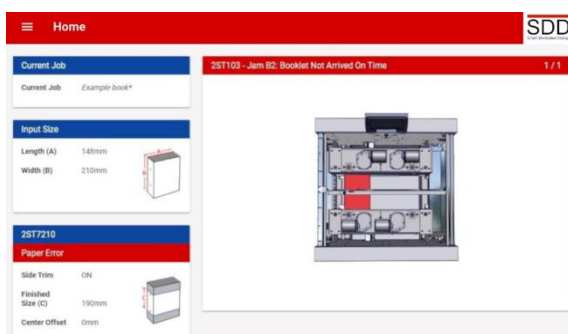


Fig. 5.3.1

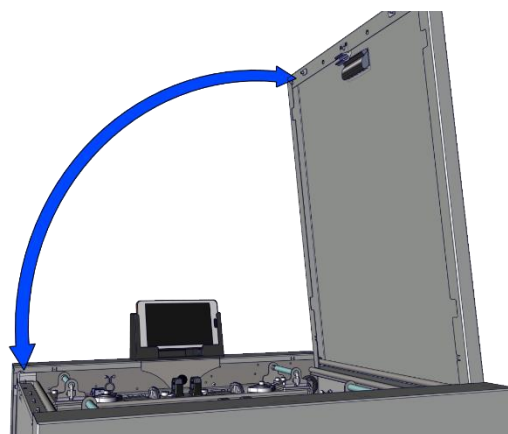


Fig. 5.3.2



Fig. 5.3.3



Fig. 5.3.4

Step	Action	Remarks
1.	UI indicates Paper Error.	Fig. 5.3.1

2.	Open and Close Top Cover. The 2ST will now automatically try to empty the machine.  NOTE If Stoppers were activated, the machine will not clear automatically.	Fig. 5.3.2
3.	Jam is cleared.	
4.	If jam is NOT cleared. Open Top Cover. The Knife Blocks will automatically move outward.	Fig. 5.3.3
5.	Turn the 2ST 'OFF'	
6.	Manually remove Booklet  CAUTION Take care when working near the Knives	Fig. 5.3.4

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5. Troubleshooting (continued)

5.3. Clearing a paper Jam (continued)

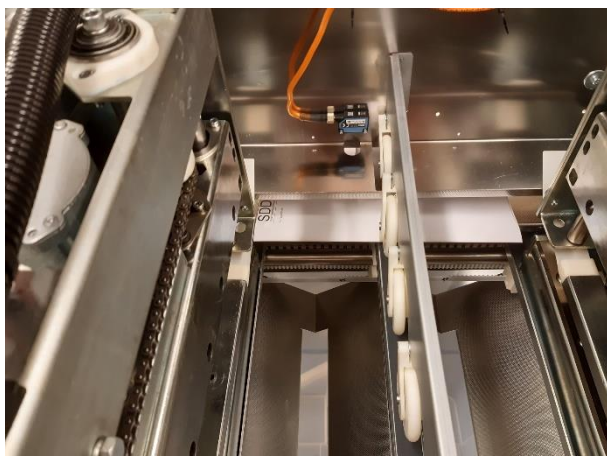


Fig. 5.3.5

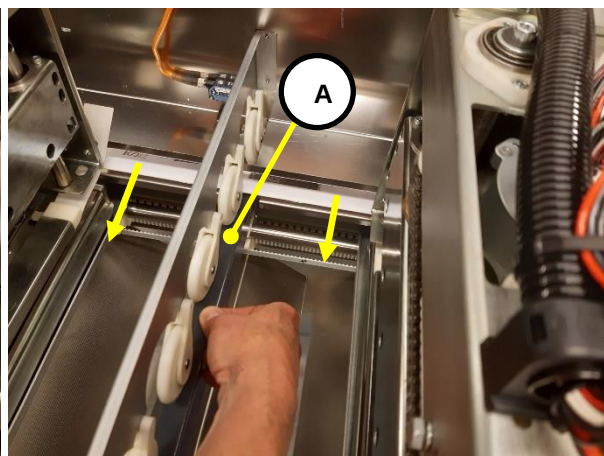


Fig. 5.3.6



Fig. 5.3.7



Fig. 5.3.8

Step	Action	Remarks
7.	Booklet in or near Infeed.	Fig. 5.3.5

8.	Pull the 2ST belt [A] to move the booklet into the 2ST. Or; Manually pull the booklet into the 2ST  CAUTION Take care when working near the Knives	Fig. 5.3.6 Fig. 5.3.7
9.	Remove the booklet from the 2ST.	Fig. 5.3.8
10.	Close the Top Cover.	
11.	Turn 'ON' the 2ST.	

6. Cleaning / Maintenance

6.1. General



WARNING:

Before Cleaning or Maintenance, always make sure to disconnect the appropriate power cord.



NOTES:

1. An increasing number of Paper Jams is an indication of the need to clean the belts.
2. The exterior of the 2ST may be cleaned with a slightly moist cloth.
3. With the exception of the belts and the 2ST Trim Waste Bin, the interior of the 2ST requires minimal cleaning.

When the 2ST7210 is in regular use it is advised to check the items in below table for cleaning and maintenance as per the interval mentioned. Check all Items when the machine has not been used for a month or more.

Cleaning / Maintenance Table

Item / area	Interval
<i>Sensors</i>	<i>Monthly</i>
<i>Belt</i>	<i>Monthly</i>
<i>Trim Waste</i>	<i>Once a week or on emptying bin, whichever comes first.</i>

6. Cleaning / Maintenance (continued)

6.2. Sensors



Fig. 6.2.1

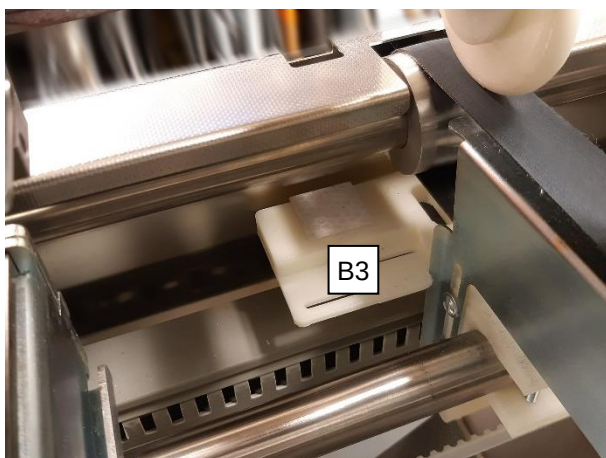


Fig. 6.2.2

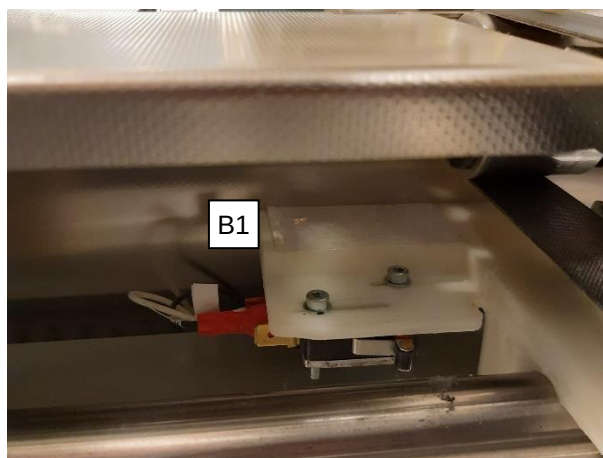


Fig. 6.2.3

Step	Action	Remarks
1.	Open Top Cover.	
2.	Clean Sensor lenses with a dry cloth and/or soft brush.	Fig. 6.2.1
3.	Clean Reflector tape for the outfeed- [B3] and infeed sensor [B1] with a dry cloth and/or soft brush.	Fig. 6.2.2 & Fig. 6.2.3
4.	Close Top Cover.	

6. Cleaning / Maintenance (continued)

6.2. Sensors (continued)



Fig. 6.2.2

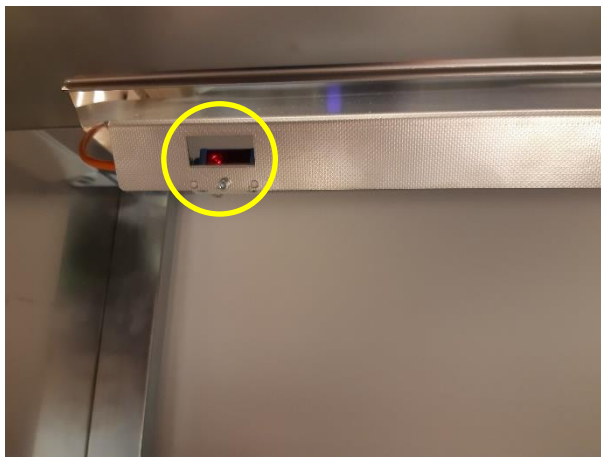


Fig. 6.2.3

Step	Action	Remarks
5.	Make sure 2ST is turned off.	
6.	Remove Trim Waste Bin.	Fig. 6.2.2
7.	Clean the sensor lens with a dry cloth and/or soft brush.	Fig. 6.2.3.
8.	Place Trim Waste Bin.	

6. Cleaning / Maintenance (continued)

6.3. Belts



WARNING

Make sure to disconnect the appropriate Power Cord before Cleaning or Maintenance.

The 2ST Belts need to be checked and if necessary cleaned based on the table in [Chapter 6.1](#) or if the 2ST7210 has not been used for a month or more.

An increasing number of jams is an indication of the need to clean the belt.



NOTE:

Clean the belt with water and a lint free cloth.

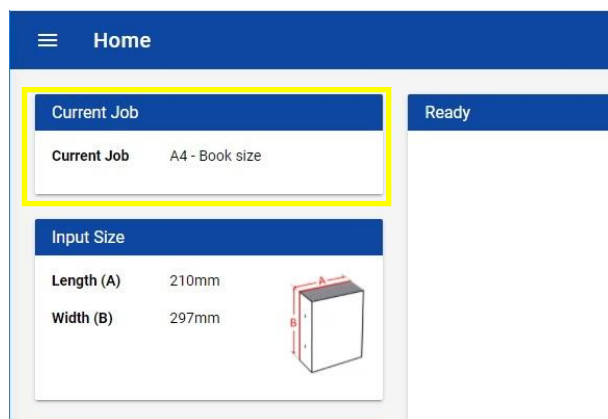


Fig. 6.3.1

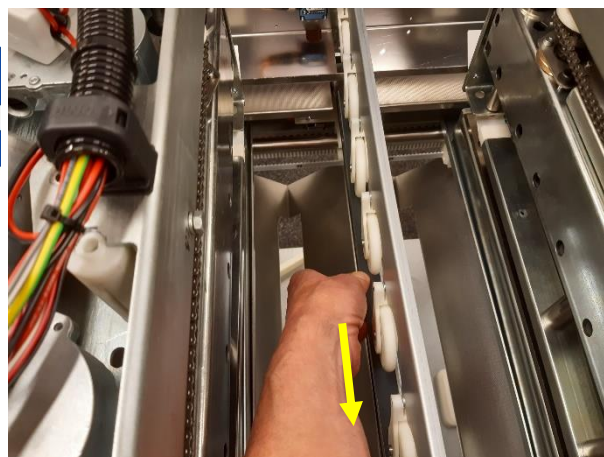


Fig. 6.3.2

Step	Action	Remarks
1.	Set the 2ST to an A4 - Book size job.	Fig. 6.3.1
2.	Switch off the 2ST.	
3.	Open the Top Cover.	
4.	Rotate the belt by pulling it manually and clean the belt.	Fig. 6.3.2
5.	Close the Top Cover.	
6.	Switch on the 2ST.	

6. Cleaning / Maintenance (continued)

6.4. Trim Waste Bin



Fig. 6.4.1



Fig. 6.4.2

Step	Action	Remarks
1.	Take the Trim Waste Bin [A] out of the machine.	Fig. 6.4.1 & Fig. 6.4.2
2.	Empty Trim Waste Bin.	
3.	Remove any remaining Cutting Waste in the Trim Waste Bin area.  IMPORTANT Make sure all Trim Waste is removed from the 2ST.	
4.	Place the Trim Waste Bin back in the machine.	

7. Technical Information

Capabilities:

<i>Compatibility:</i>	<i>Canon Booklet Trimmer F1</i> <i>Canon Booklet Trimmer G1</i> <i>Hand Infeed Module HIM5030</i> <i>Conveyor Belt Stacker CBS6060</i> <i>Conveyor Belt Stacker CBS6061</i> <i>Conveyor Belt Stacker CBS6150</i> <i>Conveyor Belt Stacker CBS6151</i> <i>Square Fold Module SFM7804</i>
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Physical:

	Operational
<i>Height</i>	1180 mm
<i>Width</i>	700 mm
<i>Depth</i>	700 mm
<i>Weight</i>	~ 170 Kg

Booklet

	<i>Infeed:</i>	<i>Outfeed:</i>
<i>Minimum booklet width (B):</i>		
<i>Bypass:</i>	120 mm	120 mm
<i>Trimmed:</i>	124 mm	120 mm
<i>Maximum booklet width (B):</i>		
<i>Bypass:</i>	450 mm	450 mm
<i>Trimmed:</i>	442 mm	340 mm
<i>Minimum booklet length (A):</i>	120 mm	
<i>Maximum booklet length (A):</i>	280 mm	
<i>Maximum Booklet Thickness:</i>	10 mm	
<i>Trimming size (min-max)</i>	2 mm – 51 mm each side	
<i>A-symmetrical trim (min-max)</i>	±1-24 mm (Depending of the booklet thickness)	
<i>Paper Weight (min-max)</i>	60 g/m ² - 300 g/m ²	
<i>Note 1:</i>	Minimum paper weight for 1 sheet only is 120 g/m ² .	
<i>Note 2:</i>	On booklets from about 15 sheets or more, always use coversheets from 120 g/m ² or higher to prevent possible deviations (like crinkles) on the booklet.	

7. Technical Information (continued)

Technical:

<i>Speed</i>	1400 booklets/hour
<i>Noise Level (max)</i>	64 dB

Electrical:

<i>Power Source;</i>	External
<i>50/60Hz:</i>	100 - 240VAC, 4.0A
<i>Note:</i>	The 2-Side Trimmer together with Square Fold Module only to be connected to an approved electrical system which is rated at a maximum of 16A and protected by circuit breakers.

Environmental:

<i>Temperature Range:</i>	+15 - 30 °C
<i>Humidity Range:</i>	30% - 60% RH
<i>Maximum Altitude:</i>	2000 meter

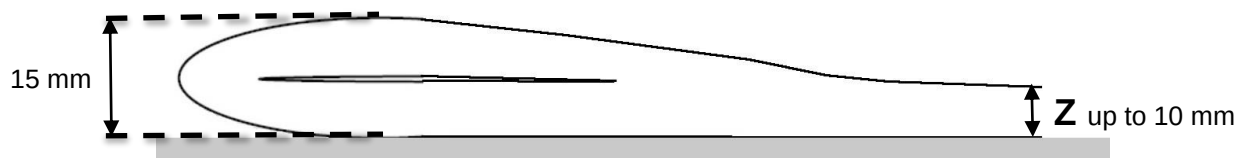
8. Booklet Information

Book(let) curvature and thickness:

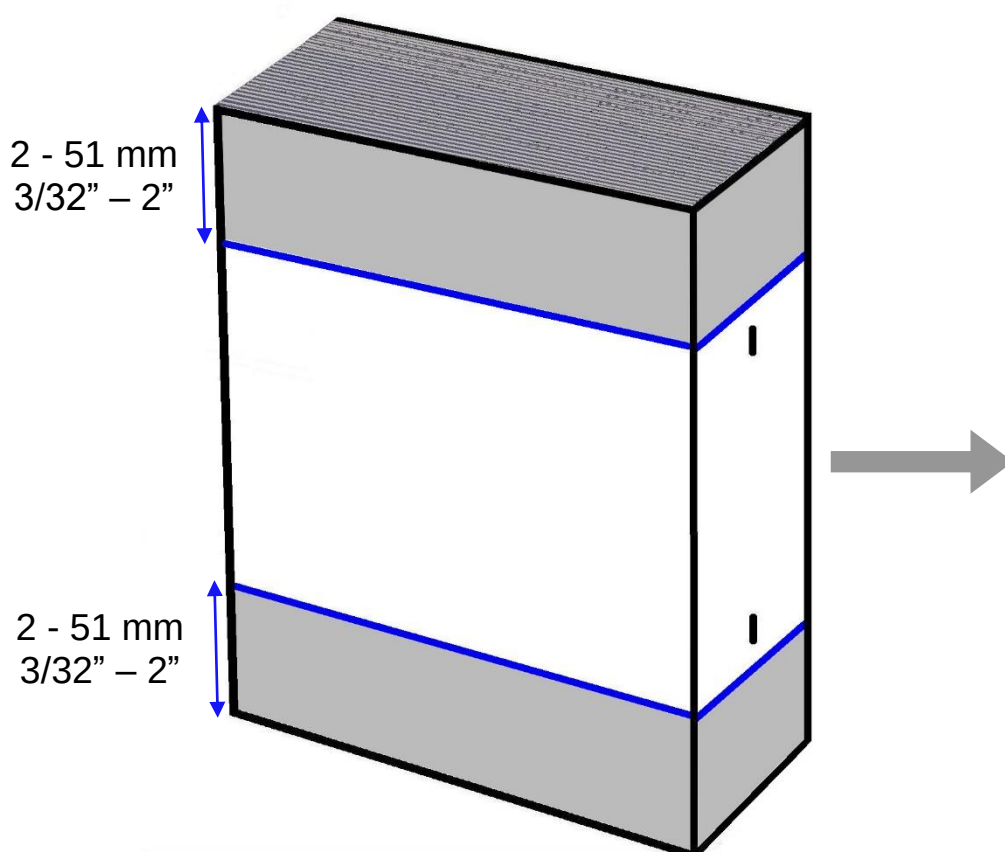
Maximum curvature off the book(let) during transport (after folding): 15 mm

To be measured without Trimming nor Squarefolding on the output belt and another book(let) on top so the book(let) to be measured will not fold open.

Booklet thickness to be measured at "Z" as shown in below diagram.

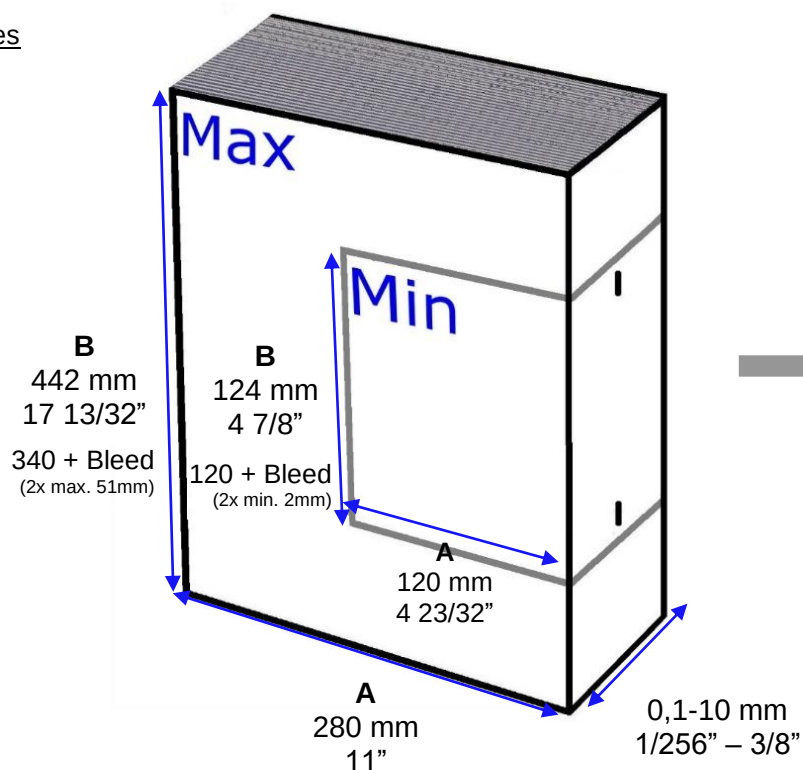


Book(let) Trimming

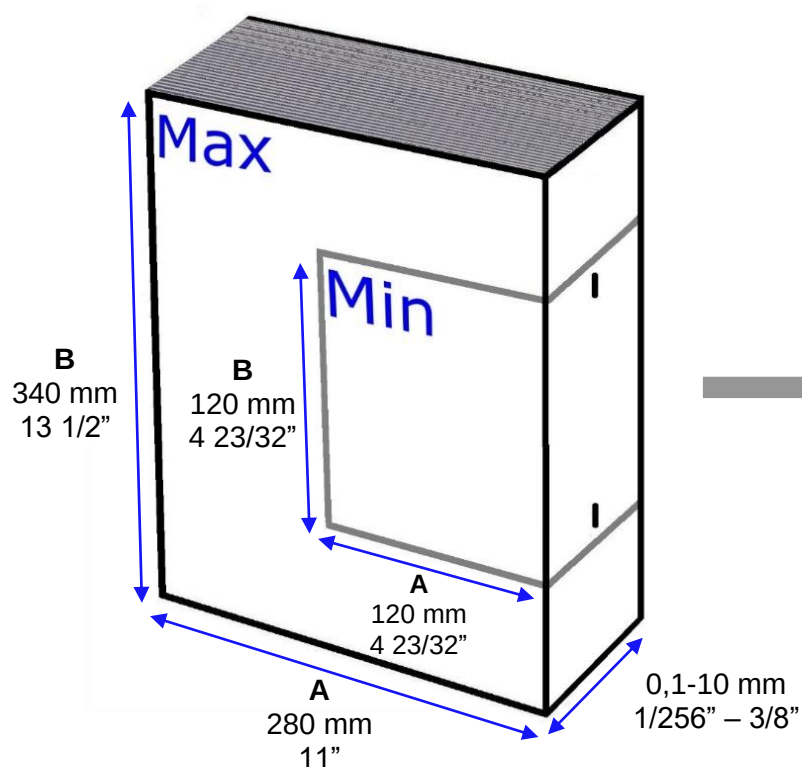


8. Booklet Information (continued)

Input Book(let) Sizes

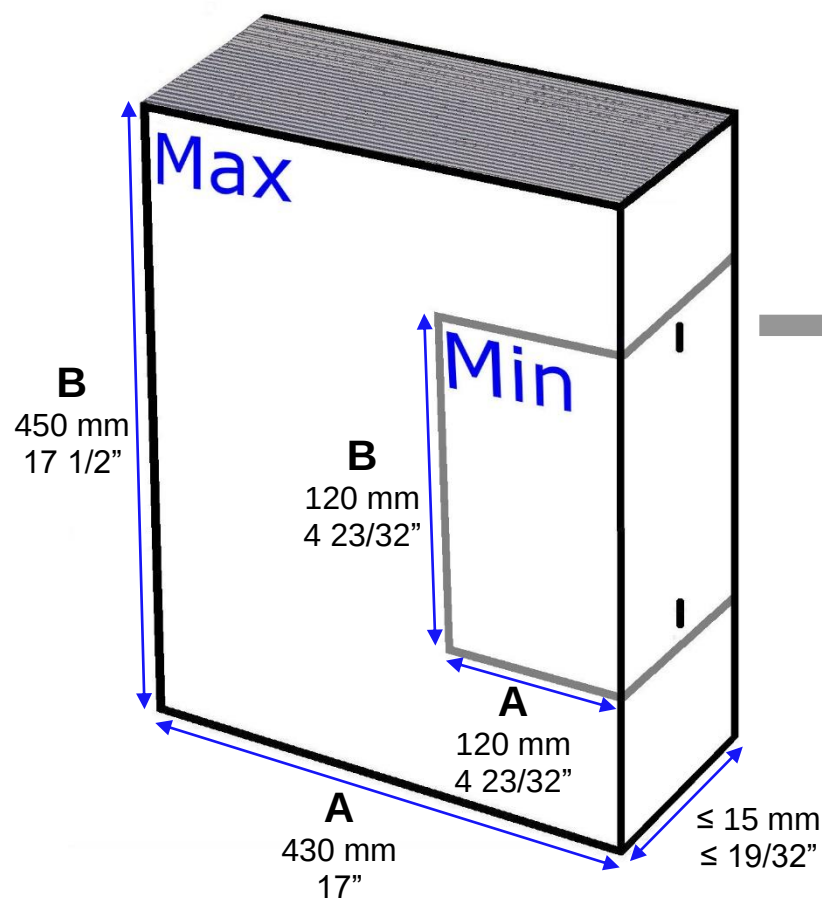


Output Book(let) Sizes



8. Booklet Information (continued)

Bypass sizes



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