

SQUARE FOLD MODULE SFM7804

OPERATOR MANUAL



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About this manual



IMPORTANT:

This machine must be installed by a qualified technician.



IMPORTANT:

The pictures of the machine in this manual can have minor differences compared to the actual machine.

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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.

2. General

With the addition of the Square Fold Module SFM7804 to the SDD product range, a cost effective Booklet Spine Squaring solution is available which has a small footprint and is easily 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 Square Fold Module SFM7804, further referred to as SFM, is for online use behind the 2 Side Trimmer 2ST7210. The SFM is a compact unit with a small footprint requiring minimal floor space. The unit is finished in Canon Look & Feel.

The SFM is used for squaring the spine off a booklet. The folded and stapled center of booklets with a maximum thickness of 6 mm can be squared resulting in a professional finish. The output lays flat for easy packing and you are also able to print on the spine of the book for easy retrieval in bookshelves. Operating the SFM and adjusting the settings is achieved via the User Interface (UI) of the 2ST7210 2 Side Trimmer.

This manual describes the operation of the SFM7804 only.

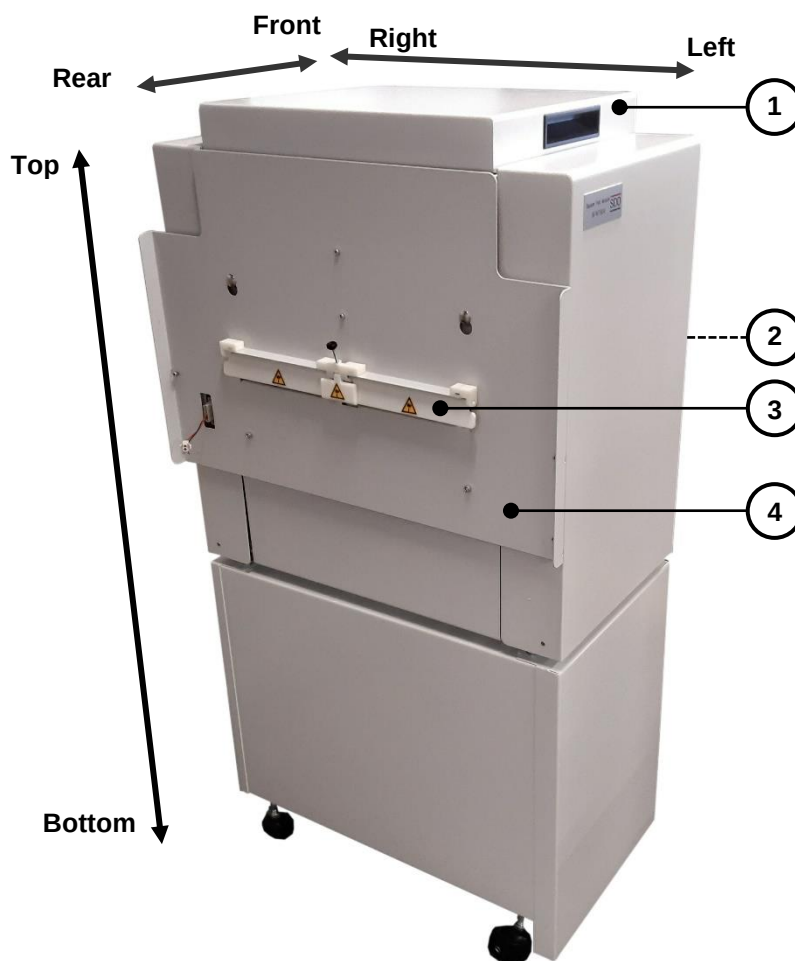
3. Basic Information

3.1 Exterior Overview



NOTE:
Orientation is based on the paper flow direction.

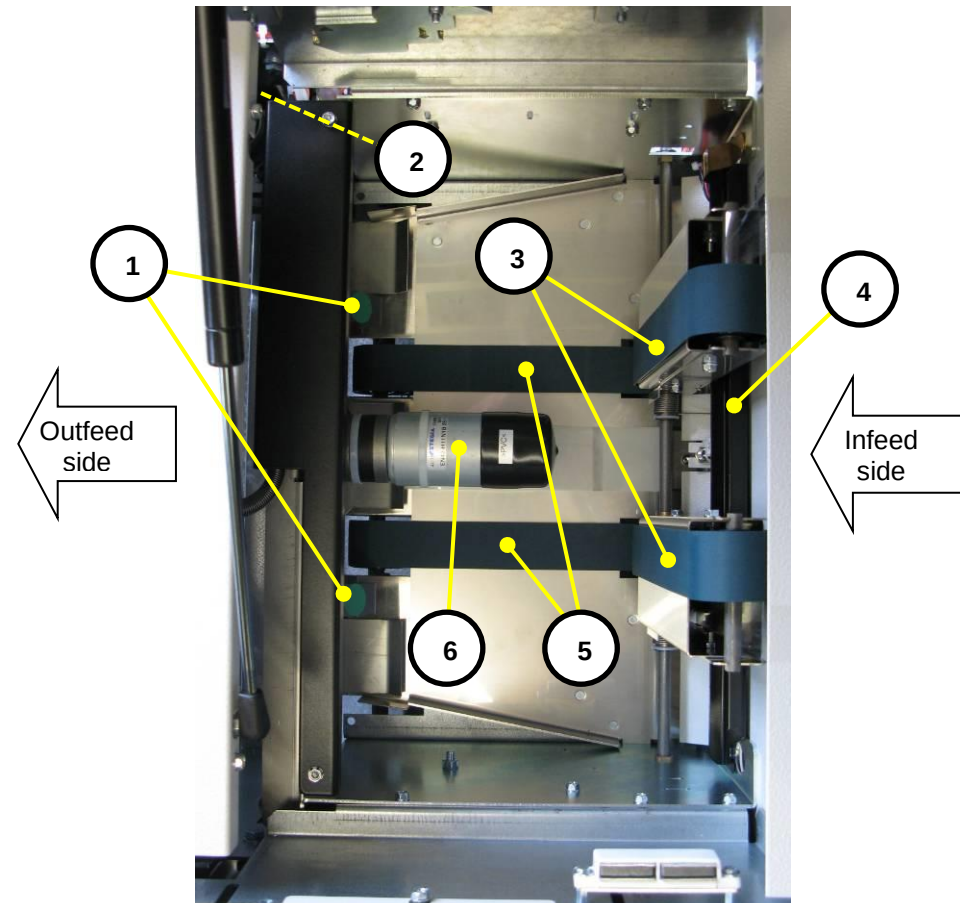
Study the picture below to become familiar with the main components.



No.	Description
1.	Top Cover
2.	Infeed
3.	Outfeed
4.	Belt Stacker Adaptor

3. Basic Information (continued)

3.2 Interior Overview



No.	Description
1.	Upper Feed Belt Latches
2.	Roller Motor (not visible in picture)
3.	Upper Feed Belts (lifted position)
4.	Docking Bracket (not visible in picture)
5.	Lower Feed Belts
6.	Booklet Clamp Motor

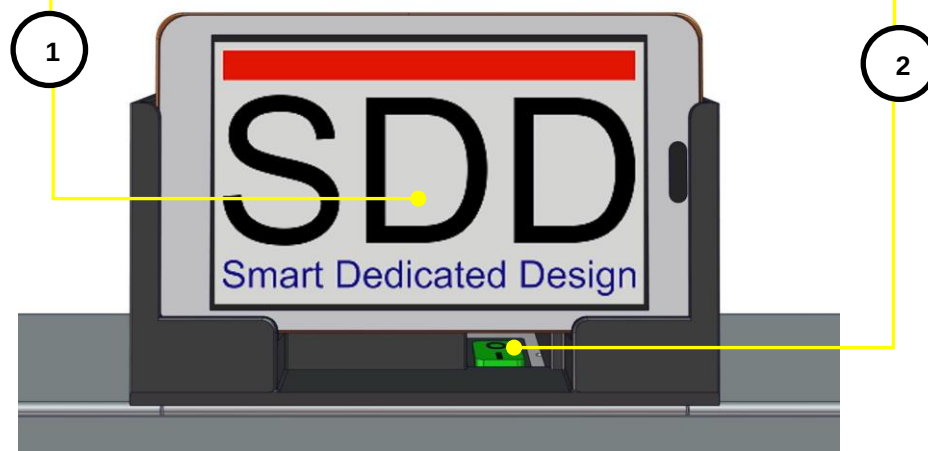
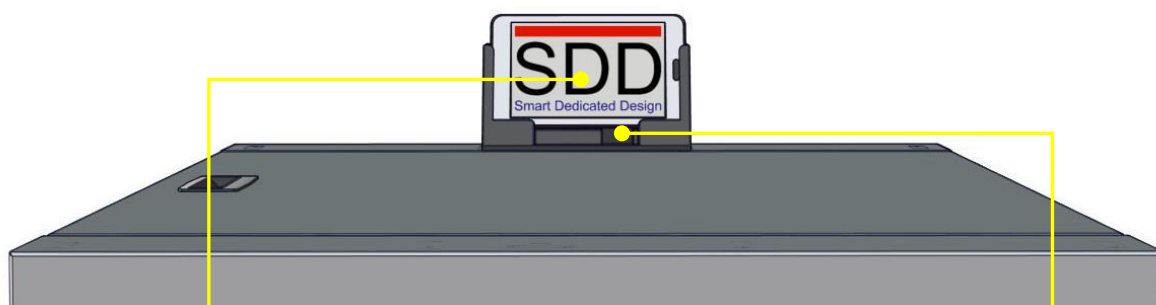
3. Basic Information (continued)

3.3 Controls

NOTE:



1. SFM7804 power and operation is controlled via the 2ST7210.
2. User Interface screens shown in this manual may appear different on your tablet, smartphone or laptop due to browser and display settings.
3. For Tablet operation refer to the Manufacturers User Manual.



No.	Description	Symbol	Remarks
1.	User Interface		On 2ST7210.
2.	Power switch		On 2ST7210. 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.



IMPORTANT:

Refer to the 2ST7210 Operator Manual DBCB-0512-0105-0000 for additional information on the User Interface.

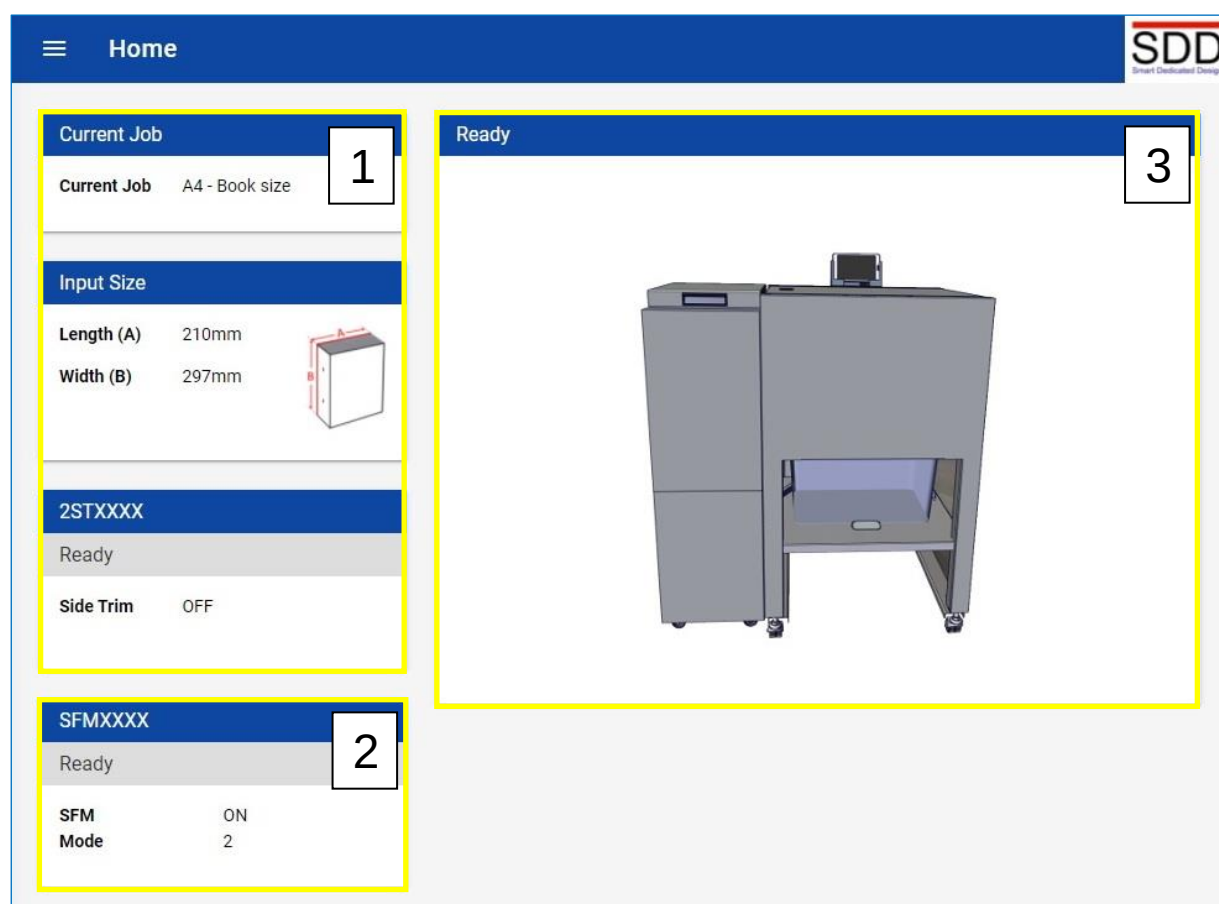


Fig. 3.4.1

No.	Description	Remarks
1.	2ST7210 Control Fields	
2.	SFM7804 Control Field	See Chapter 4
3.	Info/Settings field	Ready status shown

3. Basic Information (continued)

3.5 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 fitted in four ways as per Operator preference.

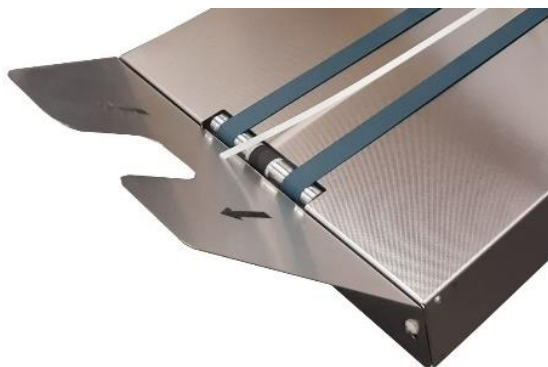


Fig. 3.5.1

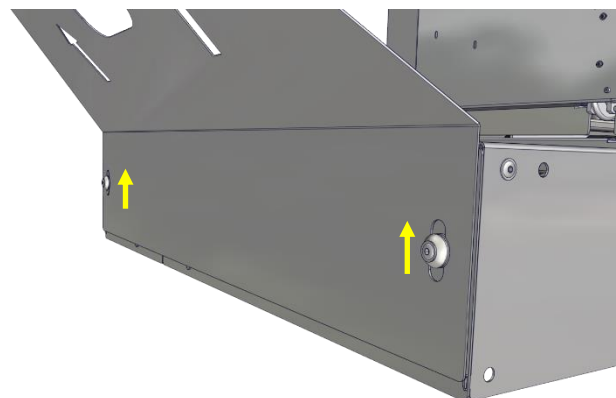


Fig. 3.5.2

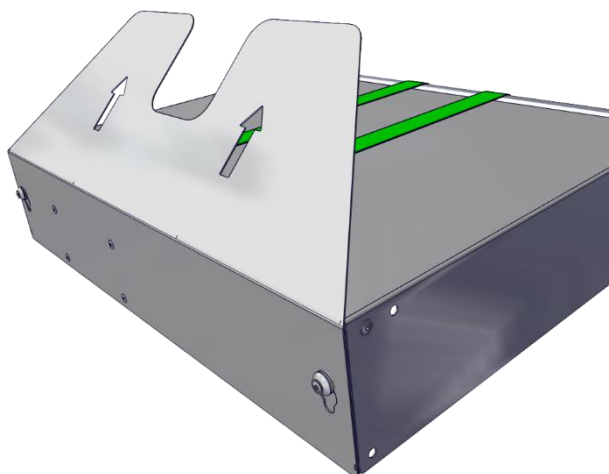


Fig. 3.5.3



Fig. 3.5.4

Step	Action	Remarks
1.	End Plate in standard position	Fig. 3.5.1
2.	Slide up till retainers are free in keyhole.	Fig. 3.5.2
3.	Turn End Plate 180°.	Fig. 3.5.3
4.	Fit End Plate on retainers and slide downward.	Fig. 3.5.4

3. Basic Information (continued)

3.5 Belt Stacker (continued)



Fig. 3.5.5

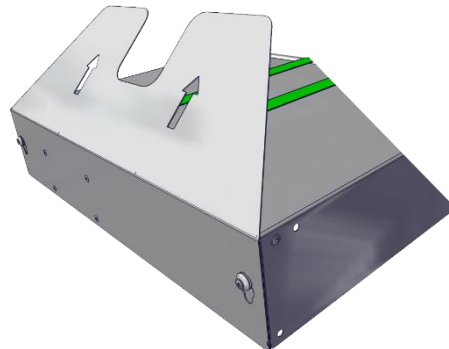


Fig. 3.5.6

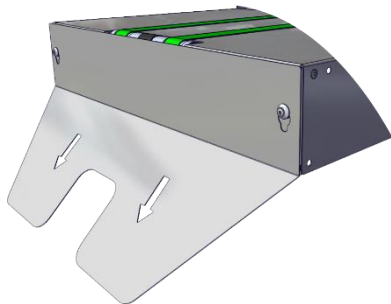


Fig. 3.5.7



Fig. 3.5.8

No.	Action	Remarks
1.	End Plate fitted in standard position.	Fig. 3.5.5
2.	End Plate fitted in reversed position.	Fig. 3.5.6
3.	End Plate fitted up-side down as slide.	Fig. 3.5.7
4.	End Plate fitted in reversed up-side down position.	Fig. 3.5.8

3. Basic Information (continued)

3.5 Belt Stacker (continued)

3.5.1 Outfeed pressure strip adjustment



NOTE:

This chapter only applies to CBS6060 or CBS6150.

If CBS6061, CBS6151 or CBS6060/CBS6150 with Upper Guiding Kit is installed, no adjustment is needed.

The Belt Stacker comes with an adjustable pressure strip to control correct stacking of the booklets.

Adjusting the setting

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

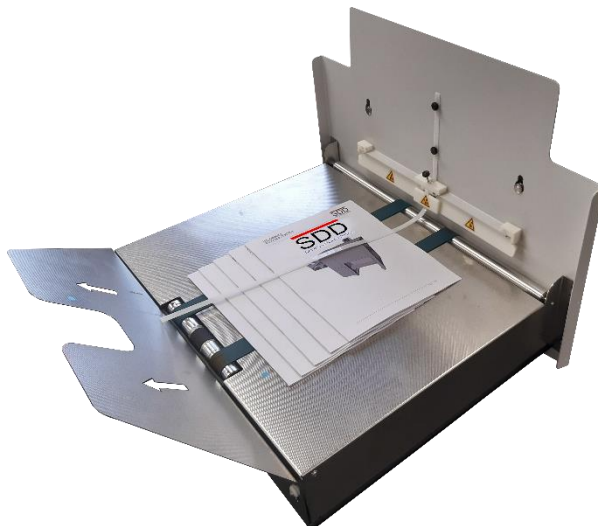


Fig. 3.5.1.1



Fig. 3.5.1.2

Step	Action	Remarks
1.	Adjust the pressure by turning the knob.	Fig. 3.5.1.2

3. Basic Information (continued)

3.5 Belt Stacker (continued)

3.5.1 Outfeed pressure strip adjustment (continued)

Standard setting

The standard setting for the pressure strip is to have no additional pressure on the strip.

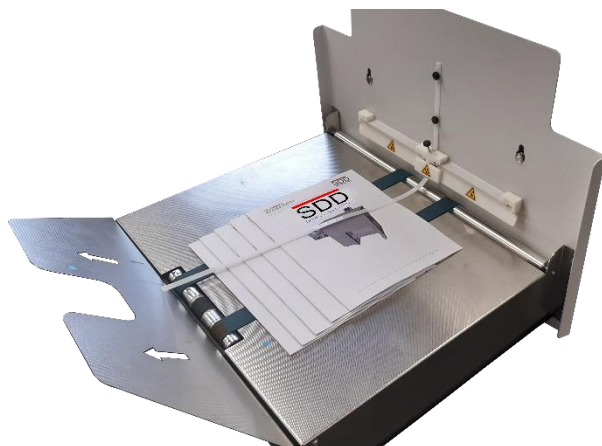


Fig. 3.5.1.3

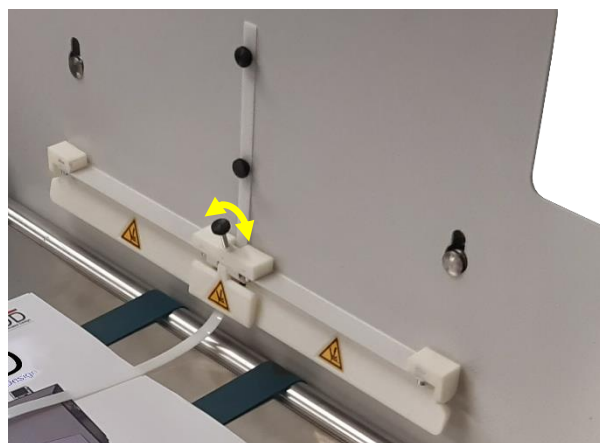


Fig. 3.5.1.4

Step	Action	Remarks
2.	Adjust the knob so that there is no additional pressure on the strip.	Fig. 3.5.1.4

Regulating pressure for overshooting books

For some specific applications, it may occur that the books coming out of the machine overshoot the previous book(s).

In this case, the pressure on the strip can be increased to a level where the books get stacked normally again.



Fig. 3.5.1.5



Fig. 3.5.1.6



Fig. 3.5.1.7

Step	Action	Remarks
3.	Turn the knob clockwise to increase the pressure on the strip.	Fig. 3.5.1.6
4.	Check the results and adjust accordingly.	Fig. 3.5.1.7

4. Operation

4.1 Square Fold Mode On/Off

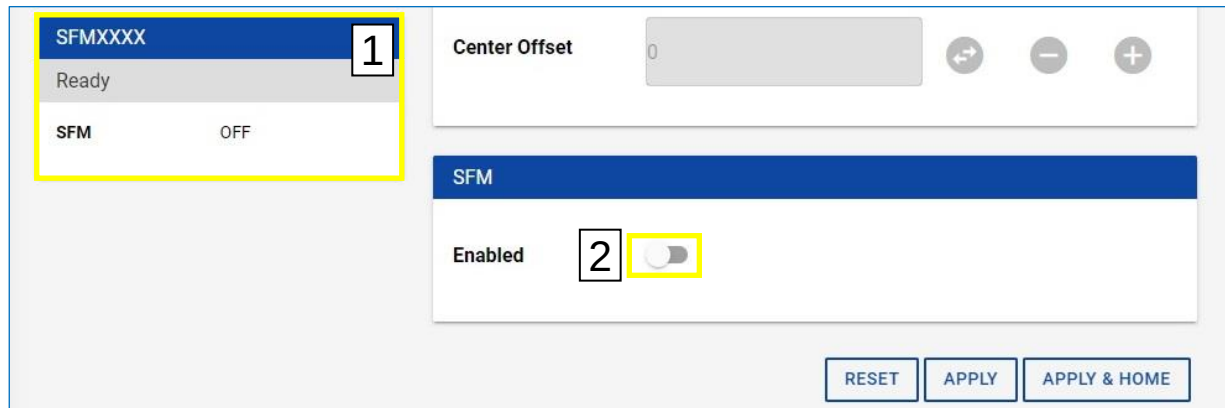


Fig. 4.1.1

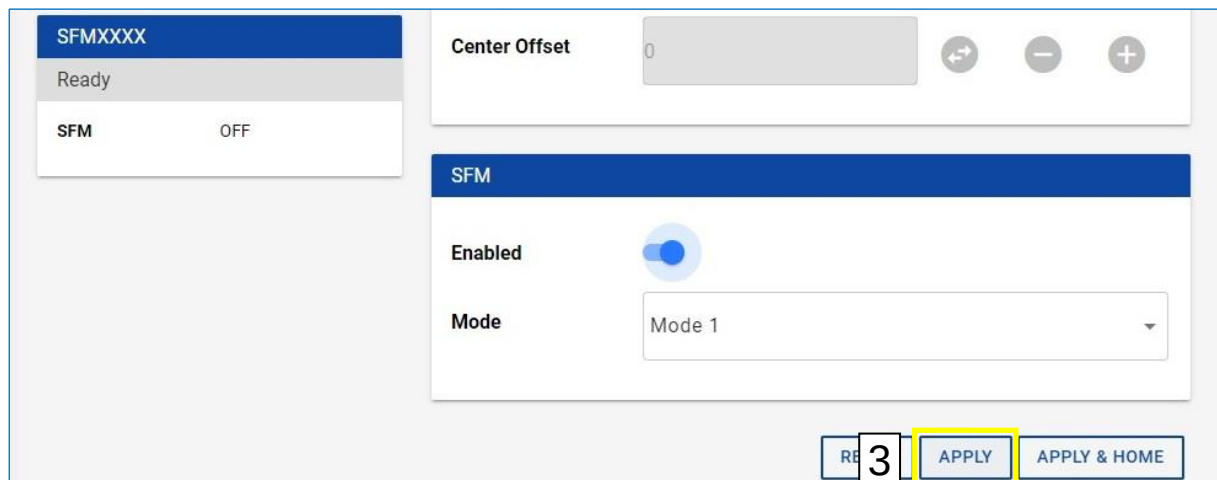


Fig. 4.1.2

Step	Action	Remarks
1.	Tap 'SFMXXXX' field to scroll down on the UI.	Fig. 4.1.1
2.	Tap  screen button to enable the Square Fold Mode.	Fig. 4.1.1
3.	Tap 'Apply' to change the Mode to 'On'.	Fig. 4.1.2

4. Operation (continued)

4.1 Square Fold Mode On/Off (continued)

The screenshot displays the SFM control interface. On the left, a status panel shows 'SFMXXXX' in a blue header, 'Ready' in a grey bar, and 'SFM Mode ON 1' in a white box with a yellow border. The main control area on the right has a 'Center Offset' field set to '0' with left, right, and reset buttons. Below this is the 'SFM' section with a blue header, an 'Enabled' toggle switch turned on, and a 'Mode' dropdown menu set to 'Mode 1'. At the bottom right are three buttons: 'RESET', 'APPLY', and 'APPLY & HOME'.

Fig. 4.1.3

Step	Action	Remarks
4.	Square Fold Mode set to 'On'.	Fig. 4.1.3

4. Operation (continued)

4.2 Square Fold Mode Setting

NOTE:

Use the following table to set the correct Square Fold Mode:

Off for about 1 to 5 sheets (bypasses the SFM)

Mode 1 for about 6 to 10 sheets

Mode 2 for about 11 to 15 sheets

Mode 3 for about 16 to 20 sheets

Mode 4 for about 21 to 25 sheets

Mode 5 for about 26 to 30 sheets



The screenshot shows the SFM control interface. On the left, a status box displays 'SFMXXXX', 'Ready', and 'SFM Mode ON 1'. On the right, the 'Center Offset' is set to 0. The 'SFM' section has an 'Enabled' toggle switch turned on. Below it, the 'Mode' dropdown menu is open, showing 'Mode 1' selected. At the bottom right, there are three buttons: 'RESET', 'APPLY', and 'APPLY & HOME'.

Fig. 4.2.1

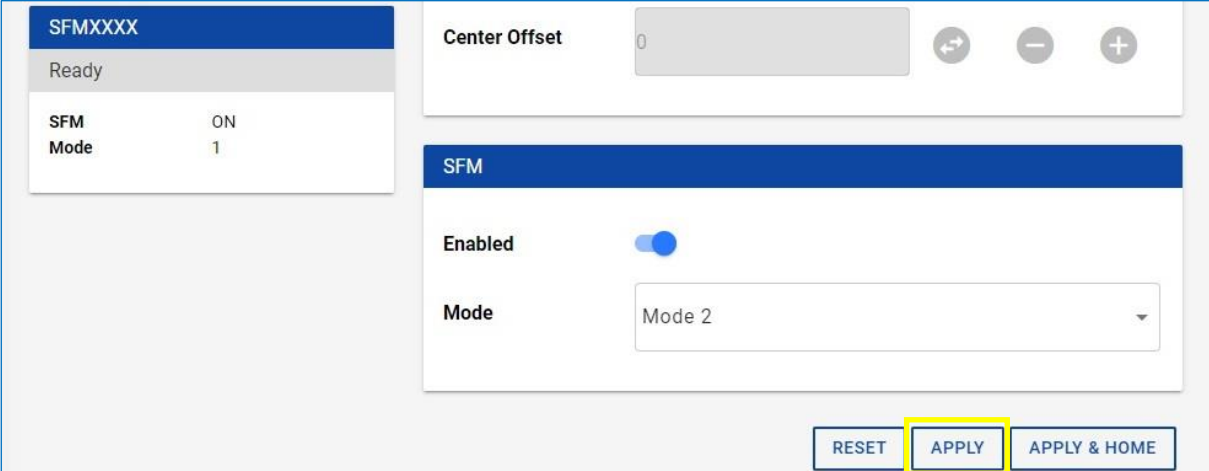
This screenshot is similar to Fig. 4.2.1, but the 'Mode' dropdown menu is expanded, showing a list of options: 'Mode 1', 'Mode 2', 'Mode 3', 'Mode 4', and 'Mode 5'. 'Mode 1' is currently selected. The rest of the interface, including the status box and 'Center Offset' field, remains the same.

Fig. 4.2.2

Step	Action	Remarks
1.	Tap 'Mode' field to drop down the Mode Settings menu.	Fig. 4.2.1
2.	Tap the required Mode based on the table above.	Fig. 4.2.2

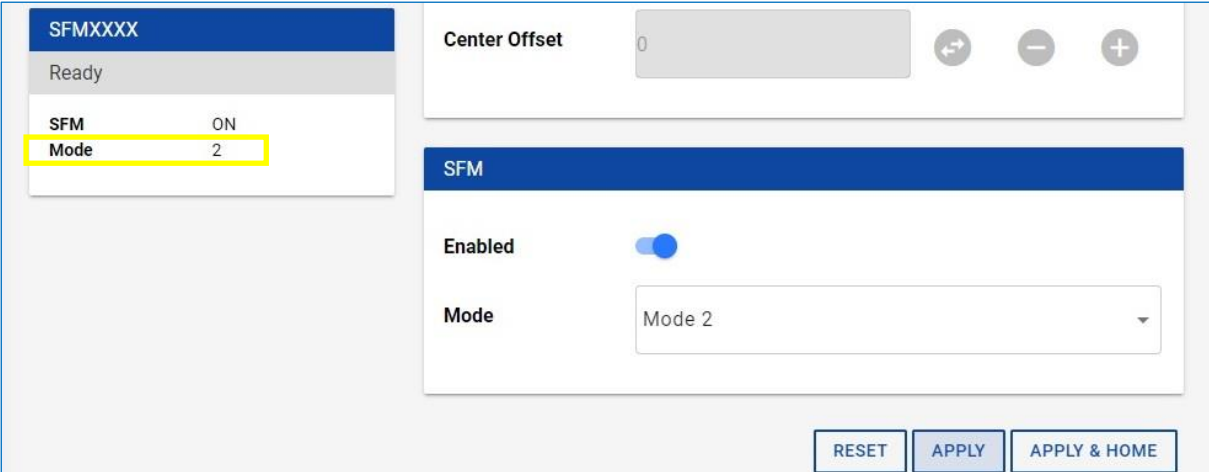
4. Operation (continued)

4.2 Square Fold Mode Setting (continued)



The screenshot shows the 'SFMXXXX' control interface. On the left, a status box indicates 'Ready' and 'SFM Mode' is 'ON 1'. The main area has a 'Center Offset' field set to '0' with navigation buttons. Below this is the 'SFM' settings section, which includes an 'Enabled' toggle switch and a 'Mode' dropdown menu currently set to 'Mode 2'. At the bottom right, there are three buttons: 'RESET', 'APPLY' (highlighted with a yellow box), and 'APPLY & HOME'.

Fig. 4.2.3



This screenshot shows the same 'SFMXXXX' control interface after the mode has been changed. The status box on the left now shows 'SFM Mode' as 'ON 2', with the '2' highlighted by a yellow box. The 'SFM' settings section remains the same, with 'Enabled' as a toggle switch and 'Mode' set to 'Mode 2'. The 'APPLY' button at the bottom right is now highlighted with a yellow box.

Fig. 4.2.4

Step	Action	Remarks
3.	Tap 'Apply' to activate the selected Mode.	Fig. 4.2.3
4.	Mode setting applied.	Fig. 4.2.4

4. Operation (continued)

4.3 Jobs



IMPORTANT:

All Square Fold settings (On/Off and Mode) can be used with the Jobs as set in the host 2ST7210. See Chapter 4.7 in the 2ST7210 Operator Manual (DBCB-0512-0105-0000) for information on Using-, Amending-, New- and Removing Jobs.

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 SFM booklet clamp.



NOTE:

An increasing number of Paper Jams is an indication of the need to clean the belts.

5.1 Error Messages

There are several SFM Error Message which will display on the 2ST UI. In all cases check the area indicated on the display. When a Paper Jam occurs, the affected area will be displayed on the 2ST UI. An Outfeed error is shown in Fig. 5.1.1.

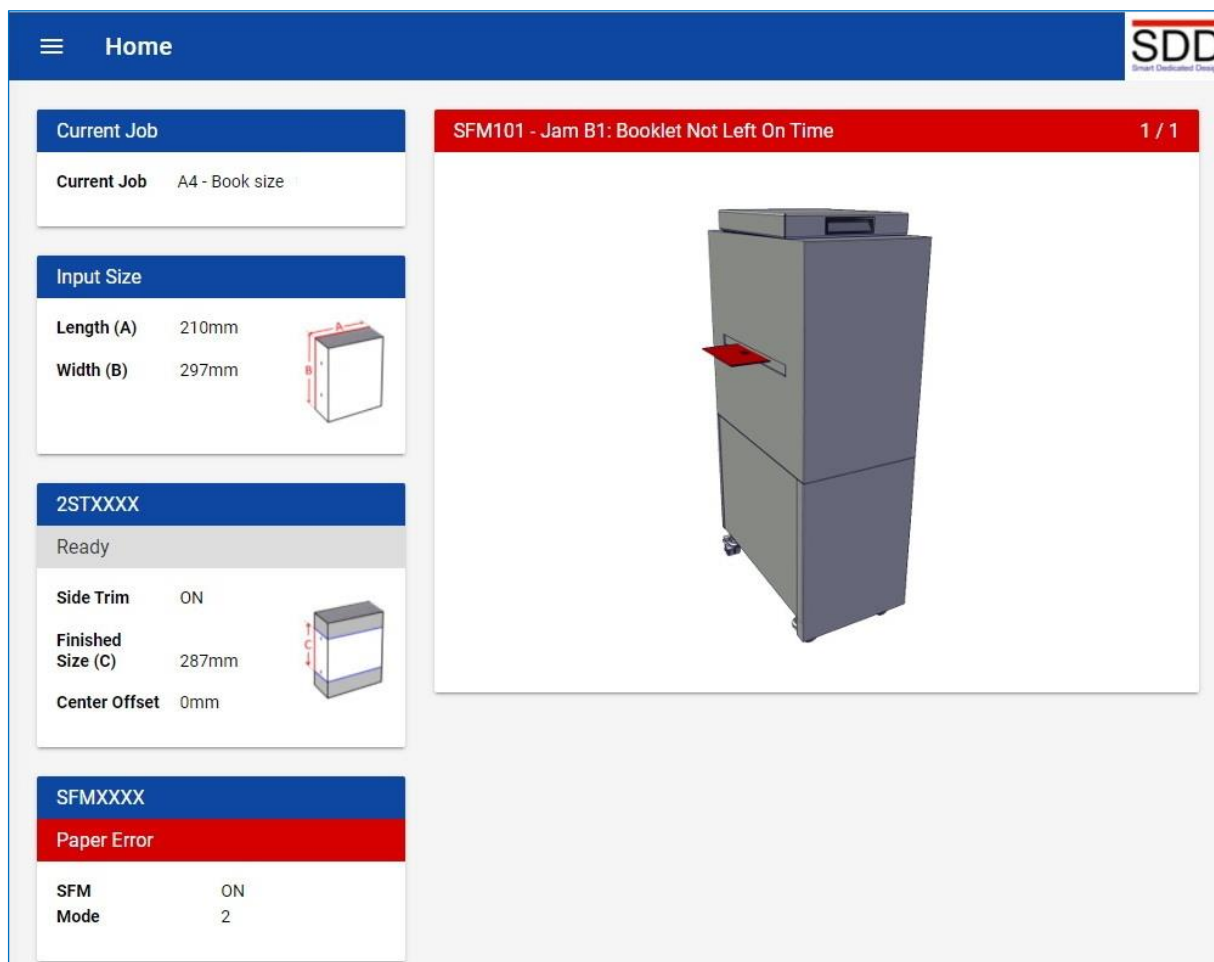


Fig. 5.1.1

5. Troubleshooting (continued)

5.2 Clearing a Paper Jam

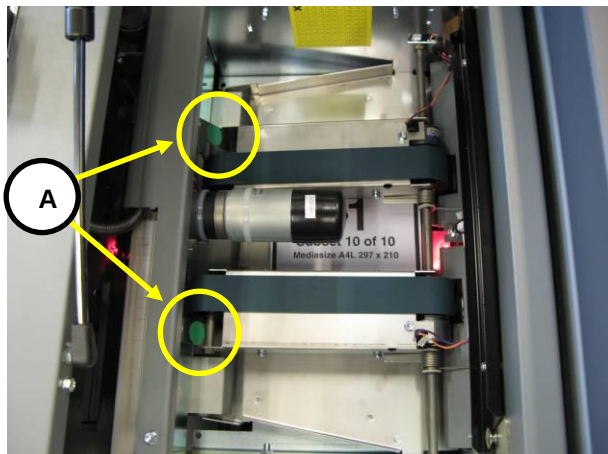


Fig. 5.2.1



Fig. 5.2.2

Step	Action	Remarks
1.	Open and close the Top Cover of the SFM. The SFM will now automatically try to empty the machine.	
2.	Manually clear a Paper Jam.	
3.	Open the SFM Top Cover.	
4.	Open Transport area by pushing the green-labeled latches [A] in the SFM to lift the Upper Feed Belts.	Fig. 5.2.1
5.	Remove the Paper Jam.	Fig. 5.2.2
6.	Close Transport area by lowering the Feed Belts till they click in place.	
7.	Close the SFM Top Cover.	

5. Troubleshooting (continued)

5.3 Feed Errors

NOTE:

If feed errors occur, the feed belts need to be cleaned or the pressure on the upper feed belts may be increased.



To clean the Belts, see [Chapter 6.3 Belts](#) for instructions.

To increase the pressure on the upper feed belts, follow below procedure.

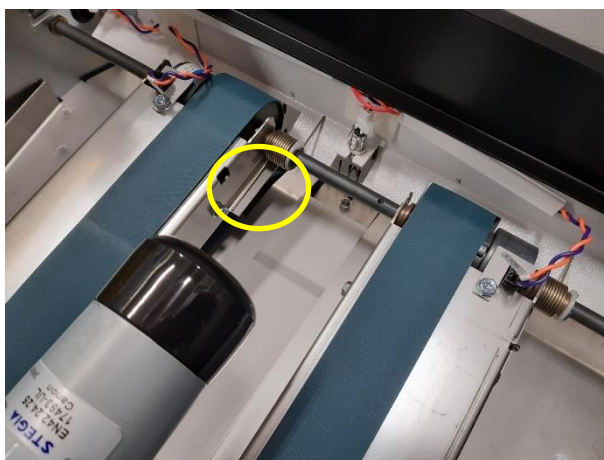


Fig. 5.3.1



Fig. 5.3.2

Step	Action	Remarks
1.	Open the Top Cover.	
2.	Place both springs in the Upper position.	Fig. 5.3.1 and Fig. 5.3.2
3.	Close Top Cover.	

5. Troubleshooting (continued)

5.4 Squared Booklet Quality

If necessary, correct the Booklet Square Fold quality as per the table below:

Fold quality	Action required
	The booklet is squared correctly.
	The booklet is not fully squared. Increase the selected Mode with one step. See Chapter 4.2 Square Fold Mode Setting .
	The booklet is squared to much. Decrease the selected Mode with one step. See Chapter 4.2 Square Fold Mode Setting .
	Thin booklets can wrinkle on the back. Decrease the selected Mode with one step or select Off (bypassing the SFM). See Chapter 4.2 Square Fold Mode Setting .

6. Cleaning / Maintenance

6.1 General



WARNING:

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

NOTE:

1. An increasing number of Paper Jams is an indication of the need to clean the belts.



2. The exterior of the SFM may be cleaned with a slightly moist cloth.

3. With the exception of the belts, the interior of the SFM requires minimal cleaning.

6.2 Sensors

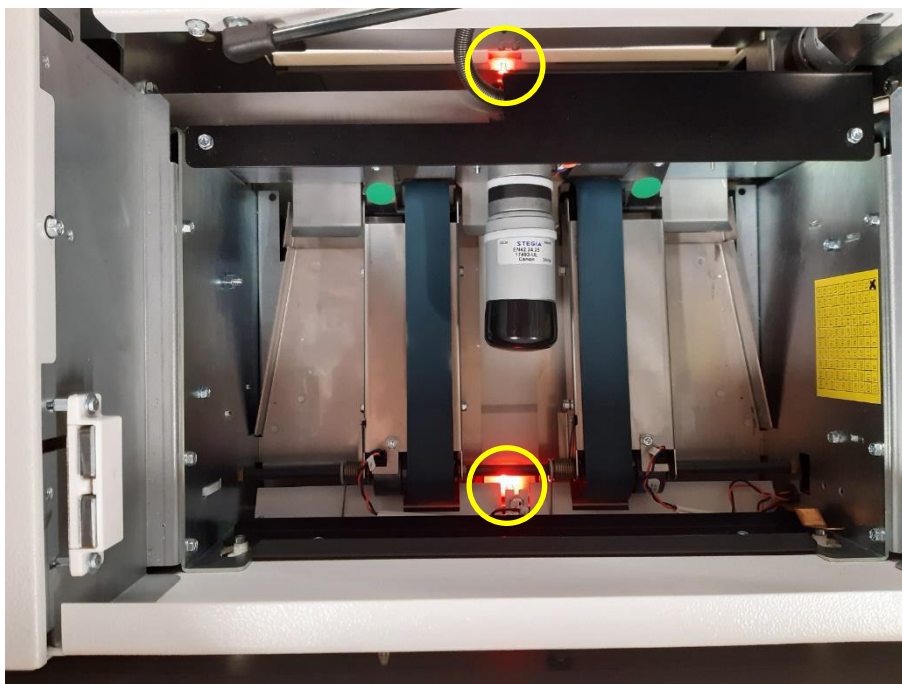


Fig. 6.2.1

Step	Action	Remarks
1.	Turn OFF the 2ST / SFM.	
2.	Open the SFM Top Cover.	
3.	Clean the sensor lenses with a dry cloth and/or soft brush.	Fig. 6.2.1
4.	Close the SFM Top Cover.	
5.	Turn ON the 2ST / SFM.	

6. Cleaning / Maintenance (continued)

6.3 Belts



NOTE:

The SFM belts need to be cleaned regularly during normal operation and if they have not been used for a period of time. The cleaning interval depends on paper type, print quality and for the lesser part on the environmental situation.

An increasing number of Paper Jams is an indication of the need to clean the belts.



NOTE:

Clean the belts with water and a lint free cloth.

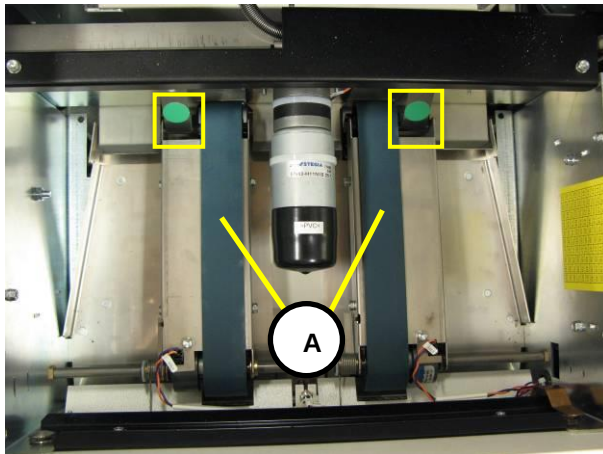


Fig. 6.3.1

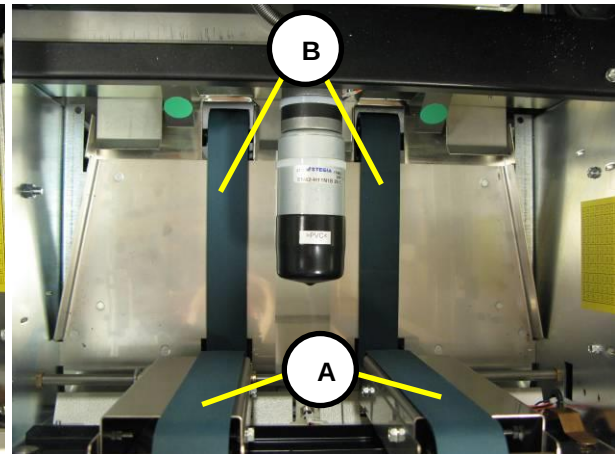


Fig. 6.3.2

Step	Action	Remarks
1.	Turn OFF the 2ST / SFM.	
2.	Open the SFM Top Cover.	
3.	Clean Upper Feed Belts. The Upper Feed Belts [A] can be rotated in either direction.	Fig. 6.3.1
4.	Press on the Green dot to release Upper Feed Belt and next lift them.	
5.	Clean Lower Feed Belts. The Lower Feed Belts [B] can be rotated in either direction.	Fig. 6.3.2
6.	Lower Upper Feed Belts Feed Belts till they click in place.	
7.	Close the SFM Top Cover.	
8.	Turn ON the 2ST / SFM.	

7. Technical Information

Capabilities:

Compatibility:

2ST7210 2-Side Trimmer
CBS6060 Conveyor Belt Stacker
CBS6061 Conveyor Belt Stacker
CBS6150 Conveyor Belt Stacker
CBS6151 Conveyor Belt Stacker

Physical:

Height:

Operational

Width:

Depth:

Weight:

1190 mm
600 mm
360 mm
~ 65 Kg

Booklet:

Min. – Max. paper size:

from 2-Side Trimmer

Paper Weight (min-max):

60 g/m² - 300 g/m²

Technical:

Speed:

1400 booklets/hour

Noise Level (max):

70 dB

Electrical:

Power Source:

From 2-Side Trimmer

Environmental:

Temperature Range:

+15 - 30 °C

Humidity Range:

30% - 60% RH

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