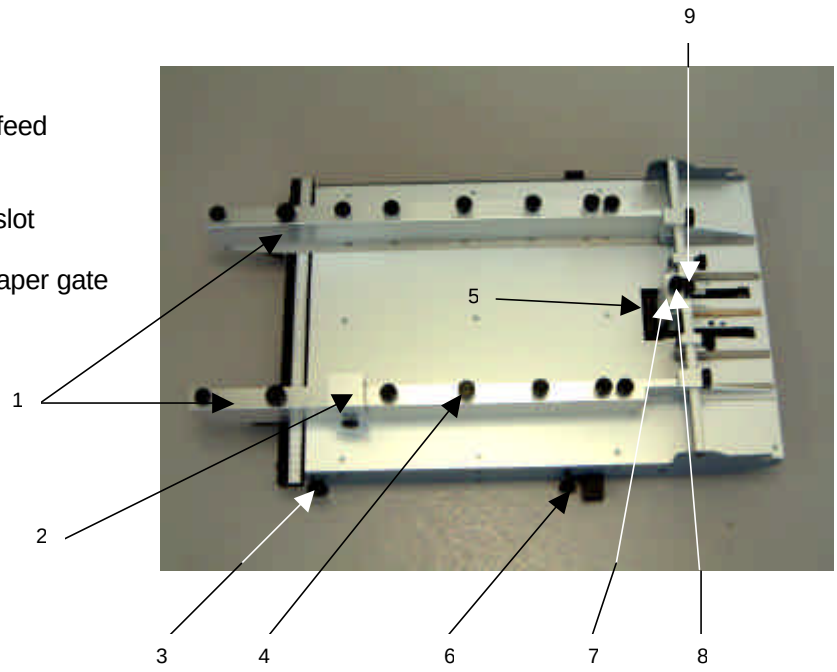
1. Contents

2. Safety instructions

For safety reasons, always first unplug the main plug before undertaking any repair or maintenance work. In addition to this we refer to the operating manual of the folding unit 235.122 which is supplied with every folding machine.

3. Description

1 Paper guides L and R
2 Back stop
3 Adjustment screw for paper infeed
4 Air jets
5 Vacuum drum
6 Adjustment screw for suction slot
7 Paper gate
8 Height adjustment screw for paper gate
9 Set screw for gate position



4. Connection to folding units 235.122

When the suction feeder is attached to the locking bolts of the folding unit, it is automatically connected to the driving shaft of the folding machine. Air hoses are to be connect to the folding unit as described on the separate installation instruction.

A vacuum pump with an output of 25 m^3 is required.

Order number:
210.110 Vacuum pump 25 m^3

For the exact installation instruction of the vacuum-feeder to the folding unit, we refer to the operating manual of the folding unit 235.122.

5. Operating instructions

5.1. Paper size adjustment

After the lateral paper guides (1) have been adjusted to the size of the paper being folded, the back stop (2) has to be placed to the end of the paper pile. This avoids that the paper moves backwards because of the air blow. The achieve a maximum sheet separation, all air jets (4) outside the paper stack have to be closed (thus ensuring optimal air pressure under the stack).

5.2. Infeed angle

The paper infeed angle to the folding rollers can be adjusted by the adjustment screw (3).

5.3. Suction roll and sheet separator

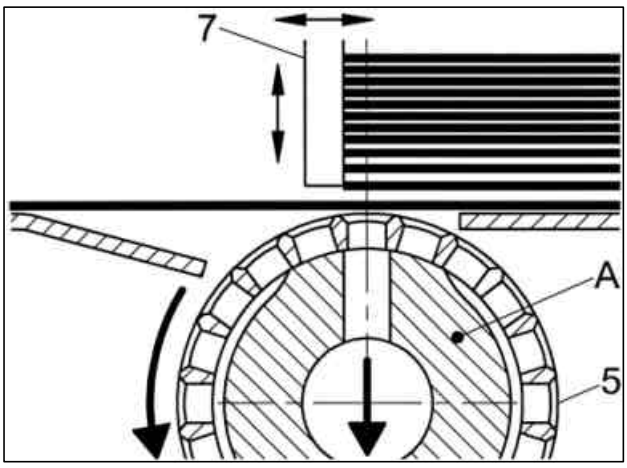
Gate (7) must be positioned as shown in illustrations 1 and 2, depending upon the thickness of the paper being processed. The ideal position can be determined by trial and error:

- Picture 1 for thicker papers
- Picture 2 for thinner papers

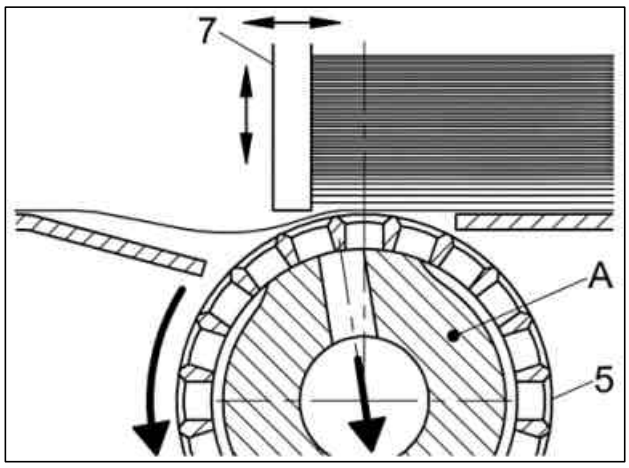
This procedure might require 2-3 trials until the best gate (7) position is found. There is no basic rule because every paper is being fed differently.

The suction slot (A) must always be adjusted to the position of the gate (7) by adjustment screw (6). After positioning, the gate has to be set to leave a gap of approx. 2 sheets to the suction roll with the adjustment screw (8).

The position of the suction slot (A) can be adjusted on the run.



Picture 1



Picture 2

5.4. Compressed air and vacuum

On most vacuum pumps the volume of air can be adjusted by means of valves provided for this purpose. If less vacuum is required for very light papers, a reduction can be achieved by adjusting the air supply on the pump directly.

Normally the air supply on the vacuum pump is set to the maximum.

5.5. Speed of feeder

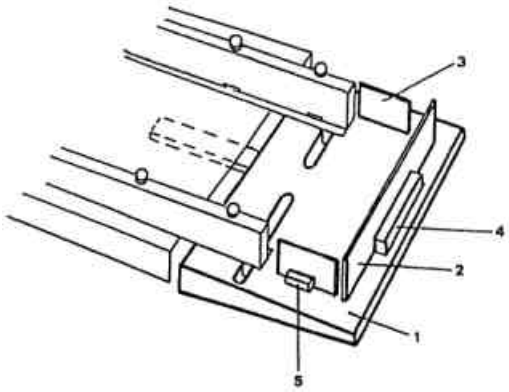
Depending upon paper size and type of fold, a different feed rates may be required to avoid paper jams. Three different speeds can be selected on the belt drive of all EUROFOLD folding machines. Place the driving belt into the desired position.

For exact instructions please refer to the operating manual of the folding unit 235.122.

6. Accessories

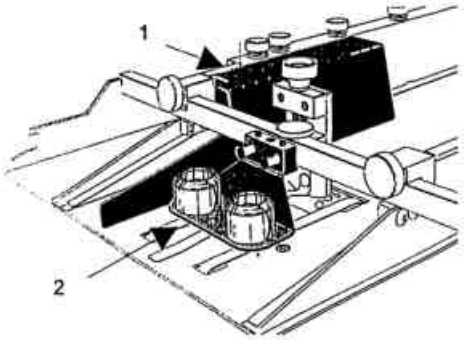
6.1. Table extension

An additional table extension (Part No. 235.000.882) is necessary for more convenient handling of formats up to a length of 650 mm:



6.2. Down holder for small paper sizes

In order to process also paper sizes down to 90 x 80 mm on the suction feeder, the following parts are available:



Item	Part No.	Description
1	235.000.318	Inset for narrow sizes
2	235.100.824	Down holder for short sizes

7. Troubleshooting

Problem	Cause	Remedy
Paper is not being fed.	o Not enough air supply under the paper pile. o Position of vacuum drum (5) and paper gate (7) has not been adjusted precisely to the paper. o Paper pile is too heavy.	o Air jets (4) are not open or outside of the paper pile not closed. o Search for the position of the vacuum drum (5) to the paper gate (7) (refer to point 5.3., page 3). o Reduce the paper pile, put less paper into the feeder.
Paper piles up after the paper gate, before entering the folding rollers.	o Side guides (1) have been adjusted too narrow or are not parallel.	o Readjust the side guides (1).
Double sheets	o Paper gate (7) has not been adjusted correctly.	o Adjust the paper gate (7) to 2 sheets of paper (refer to point 5.3., page 3).
Front edge of sheets are being marked by the paper gate	o Paper gate (7) is in wrong position for this particu-lar paper.	o Readjust the position of the paper gate (7) in moving it for- or backwards). Use set screw (9).