



Booklet Maker BM 2000s

Addendum to Booklet Maker BM 2000 Operator Manual



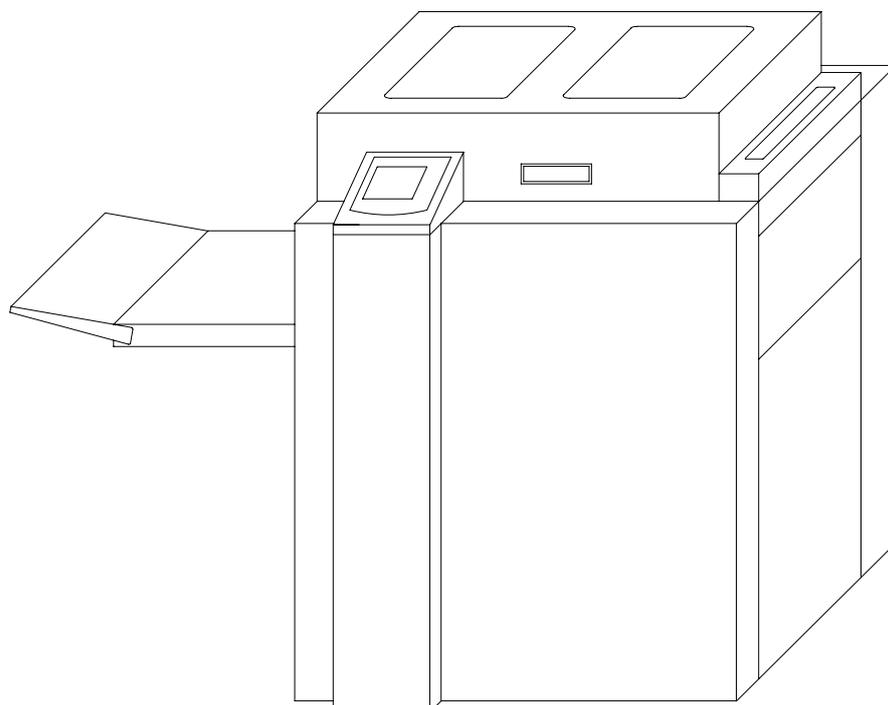
Operator Manual

Doc No. T10192

BOOKLET MAKER BM 2000s

Addendum to Booklet Maker BM 2000

Operator Manual



BM2000 Stitcher, addendum to BM 2000 operator manual

Operator instructions

Stitch positions, general

Caution!

The stitch head and the corresponding clincher box must always be correctly positioned together, even if one head is disengaged.

Caution!

Some combination of C-C distances and sheet sizes require removal of the side jogging extension rail.

As these characteristics vary depending on type of stitch head, please refer to the below listed specification, appropriate for the head your machine is equipped with.

Saddle stitching

The recommended standard C-C distance for saddle stapling is 120mm.

This C-C distance has matched cut-outs in the fold knife, to avoid that the stitches interfere with fold knife.

The 120 C-C distance is in most cases acceptable for both A4 and A3 booklets.

For narrow sheet sizes like CD (120mm), a C-C distance of 80mm is preferred.

Loop stitching

The standard European Loop stitch C-C distance is 80mm.

Because of the shape of the loop stitch, the ball racks transporting the stitched set to the fold area, has to be set to the widest position when loop stitching.

This limits the smallest sheet width possible to loop stitch to 160mm.

Edge stitching

For edge stitching (dual stitching) of A4, the recommended C-C distance is 120mm.

Corner stitching, portrait or landscape

For corner stitching of A4, the recommended position of the engaged stitch head is 273mm.

Caution! The stitch head setup is asymmetric. The engaged stitch head is positioned at 273mm according to the scale. The disengaged stitch head is positioned to 120mm according to the scale.

Positioning stitch head to a desired C-C

Positioning of clincher box

Loosen the set screw locking the clincher assy. with the Allen driver from the toolbox and slide the assy. to the desired position.

Lock the clincher assy in place, by tightening the set screw again.

Positioning of stitch head

Loosen the stitch heads clamping mechanism (Lever or screw, depending on head) Position the heads driver precisely centred over the clincher box.

Some stitch head have separate positioning guides provided.

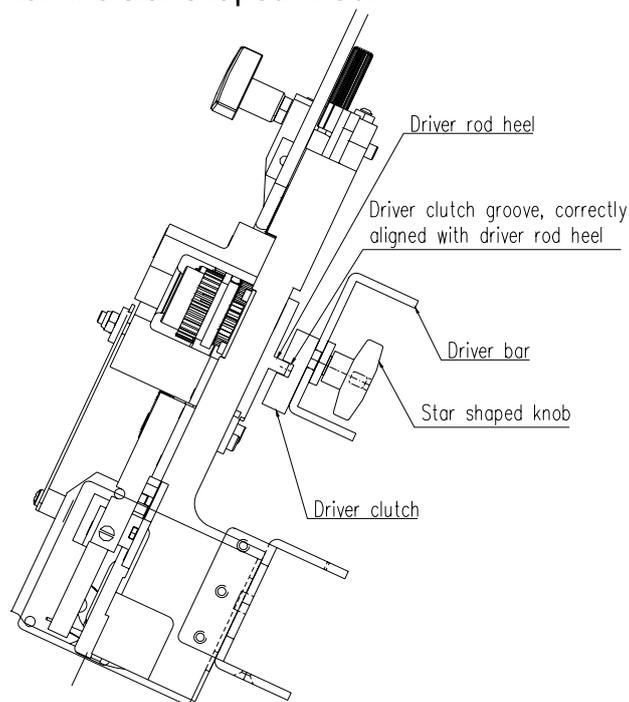
Please refer to the section for each type to find information about any provided guides.

Engage / disengage stitch head

The driver clutch is used to engage or disengage the stitch head for corner stitching (only one head engaged) or after positioning the stitch head to a new C-C.

The clutches are clamped into place by means of the star shaped knobs.

To alter the clutch position, loosen the star shaped knob and slide the clutch to the desired position. Tighten the star shaped knob.



Caution!

It is crucial that the star shaped knob is securely tightened during the stitching process, regardless if the stitch head is engaged or not. Negligence may cause severe damage to the machine.

To disengage the stitch head.

Position the clutch away from the driver rod heel so that the stitch head not actuates during the stitching process and ensure that the star shaped knob is securely tightened.

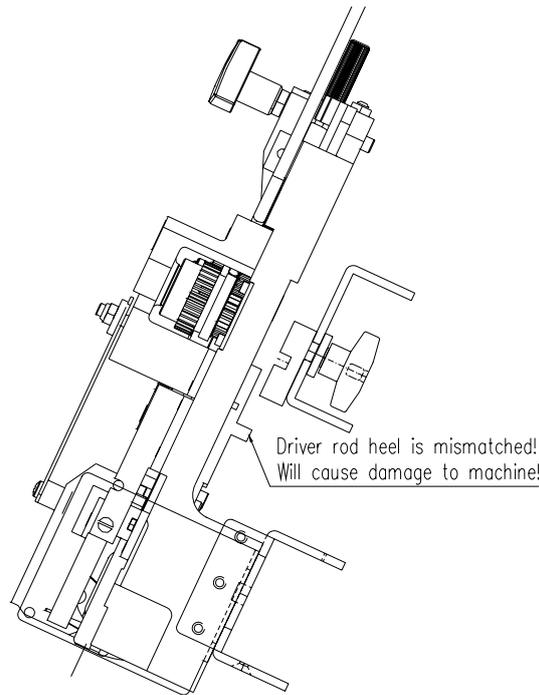
To engage the driver bar.

Position the clutch so that the groove is centred over the driver rod heel and ensure that the star shaped knob is securely tightened.

Caution!

Ensure that the groove in the clutch really mates with the driver rod heel and that the parts are fully centred.

Incorrect or misaligned positioning may cause severe damage to the machine.



Adjustment / maintenance of stitch head.

All stitch heads require regular cleaning, lubrication and adjustments.

For adjustment of stitch, preventive maintenance, repair and failure mode analysis please refer to the attached stitch head manufacturers manual.

Caution!

Stitch heads have individual tolerances, keep track of the heads original location so that they get back to the same location after maintenance.

Caution!

Excessive lubrication will end up on the surface of the booklet.

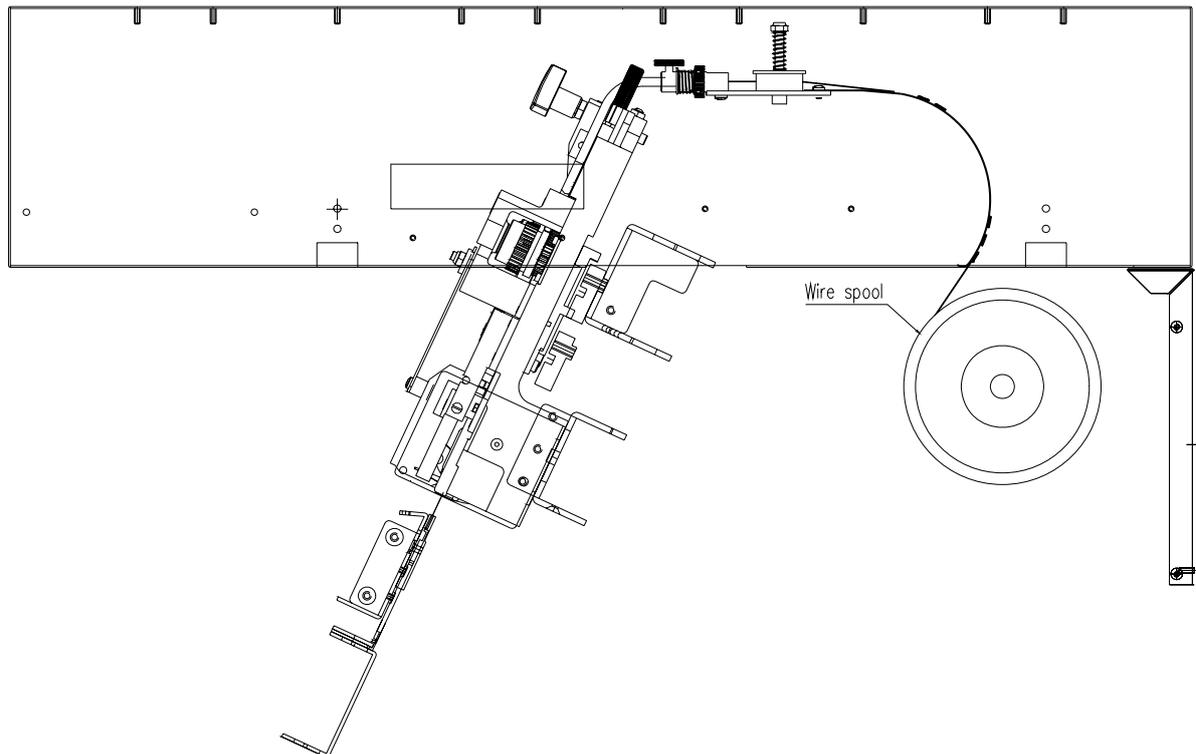
Reloading stitch wire

Caution!

Disconnect the power cord while reloading wire.

Direction of wire spool.

Ensure that a new wire spool is mounted with the correct direction of rotation. The correct direction of rotation is indicated in the picture below.



Wire

Factory settings are made with \varnothing 0.5mm wire.

Only use high quality book binder's wire, manufactured for this purpose.

Wire guide / bow direction

The tip of the wire guide must be directed towards the centre of the wire spool when free of tension.

Ensure that the tip of the wire guide moves freely during the wire feed sequence.

If the wire guide is allowed to interfere with other parts, the wire feed will be uneven and the feeder / gripper will suffer excessive wear resulting in need for premature replacement / cleaning.

Wire lubrication pad

Ensure that the felt pad is rotated so that the wire is routed through clean area of the felt.

Keep the felt pad saturated with quality oil of SAE 20 viscosity.

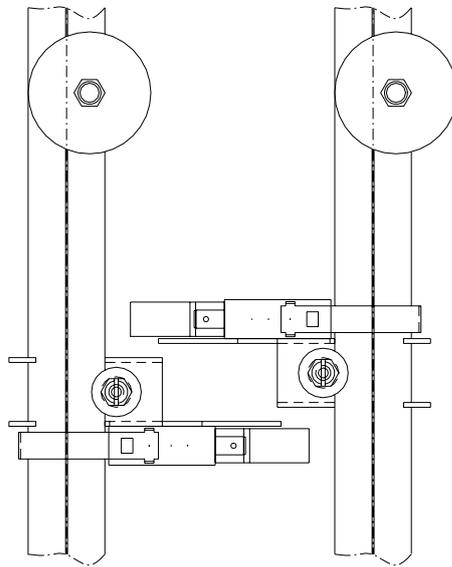
Wire spool brake spring

The brake spring should apply just enough braking torque to prevent the wire spool to unwind an excessive amount of wire during the wire pull phase, thus causing the wire coils to jam internally.

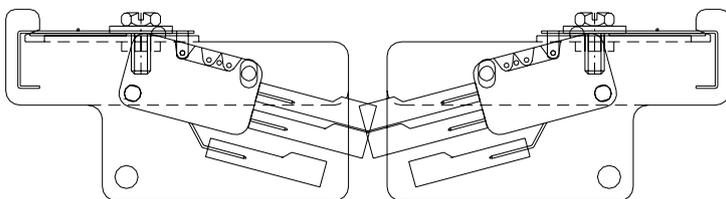
To achieve sufficient braking torque, the stop collar normally has to pre-load the brake spring approx. 1-3mm.

Wire low indicator microswitches

Ensure that mounting permits C-C 80mm distance without interference.



Terminals towards centre of machine on later models (with tilted switches)



Stitch position specifications Hohner 43/6

Saddle / Edge (Dual)

With the side jogger extension rails mounted, it is not possible to position the right stitch (centre) closer than 38mm from the edge.

With the side jogger extension rails mounted, it is not possible to position the left stitch (centre) closer than 41mm from the edge.

Loop

Set of parts to re-configure the head is required.

Requires also a loop enablement kit for the trimmer, if used.

Only Ø6mm loop available.

Max set thickness 3.0mm.

Corner, Portrait / Landscape

The side jogger extension rails must be removed.

4 Heads

Min. C-C distance in-between the heads is 48mm.

Same restrictions to centre and edge of sheet as for dual heads apply.

Alignment guide

To align the head with the clincher box the yellow alignment guide is used.

Remove the former block and replace it with the alignment guide to enable accurate alignment.

Stitch position specifications Hohner 52/8

Saddle / Edge (Dual)

With the side jogger extension rails mounted, it is not possible to position the right stitch (centre) closer than 51mm from the edge.

With the side jogger extension rails mounted, it is not possible to position the left stitch (centre) closer than 41mm from the edge.

Loop

Set of parts to re-configure the head is required.

Requires also a loop enablement kit for the trimmer, if used.

Ø6, Ø7 and Ø8mm loop configurations are available.

Max set thickness 4.0mm (with Ø6mm loop, 3.0mm with Ø7 and Ø8mm loop stitches).

Corner, Portrait / Landscape

The side jogger extension rails must be removed.

Landscape stitching is not possible.

4 Heads

Min. C-C distance in-between the heads is 55mm.

Same restrictions to centre and edge of sheet as for dual heads apply.

Stitch position specifications ISP M-2000

Saddle / Edge (Dual)

With the side jogger extension rails mounted, it is not possible to position the right stitch (centre) closer than 44mm from the edge.

With the side jogger extension rails mounted, it is not possible to position the left stitch (centre) closer than 42mm from the edge.

Loop

Loop stitch head is required.

Requires also a loop enablement kit for the trimmer, if used.

Only Ø6mm loop available.

Max set thickness 3.2mm.

Corner, Portrait / Landscape

The side jogger extension rails must be removed.

4 Heads

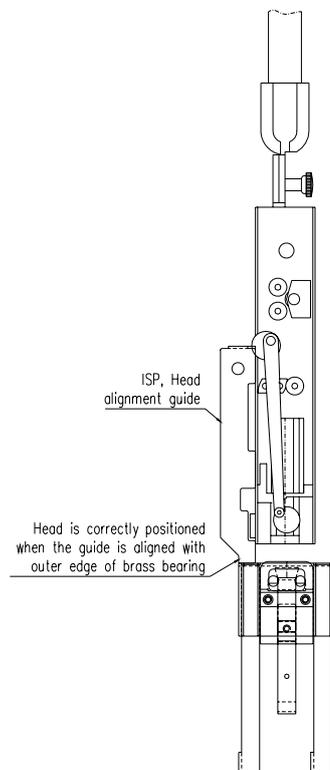
Min. C-C distance in-between the heads is 50mm.

Same restrictions to centre and edge of sheet as for dual heads apply.

Alignment guide

To align the head with the clincher box the sheet metal alignment guide is used.

The guide is held against the left side of the heads to enable alignment with the edge stop bearing block made of brass.



Stitch position specifications DeLuxe / Bostitch G5

Saddle / Edge (Dual)

With the side jogger extension rails mounted, it is not possible to position the right stitch (centre) closer than 37mm from the edge.

With the side jogger extension rails mounted, it is not possible to position the left stitch (centre) closer than 47mm from the edge.

Loop

Set of parts to re-configure the head is required.

Requires also a loop enablement kit for the trimmer, if used.

Only Ø6mm loop available.

Max set thickness 3.0mm.

Corner, Portrait / Landscape

The side jogger extension rails must be removed.

4 Heads

Min. C-C distance in-between the heads is 44mm.

Same restrictions to centre and edge of sheet as for dual heads apply.

Stitch position specifications DeLuxe / Bostitch 26/26D

Saddle / Edge (Dual)

With the side jogger extension rails mounted, it is not possible to position the right stitch (centre) closer than 46mm from the edge.

With the side jogger extension rails mounted, it is not possible to position the left stitch (centre) closer than 45mm from the edge.

Loop

Loop stitch head is required.

Requires also a loop enablement kit for the trimmer, if used.

Only Ø6mm loop available.

Max set thickness 3.2mm.

Corner, Portrait / Landscape

The side jogger extension rails must be removed.

4 Heads

Min. C-C distance in-between the heads is 52mm.

Same restrictions to centre and edge of sheet as for dual heads apply.

Stitcher head comparison table

Type	Max. book thickness @ standard stitch	Crown width	Wire Ø normal stitch	Loop stitch
Hohner 43/6	6.0 mm	12 mm	Ø 0.4-0.5 mm or Ø 0.5-0.6 mm	Ø6, 3 mm thickness Set of parts to re-configure head Wire Ø 0.5-0.6 mm
Hohner 52/8	8.0 mm	14 mm Optional 16 mm 8 mm 5 mm	Ø 0.4-0.6 mm Optional Ø 0.35-0.55 mm Flat 0.70x0.35 – 0.75x0.55 mm Ribbon 2.4 mm	Ø6, 4.0 mm book thickness Ø7, 3.0 mm book thickness Ø8, 3.0 mm book thickness Set of parts to re-configure head Wire Ø 0.5-0.6 mm
DeLuxe G5	5.0 mm	12.7 mm Optional 15.9	Ø 0.55 Optional 21x25 flat	Ø6, 3 mm thickness Set of parts to re-configure head Wire Ø 0.5-0.6 mm
DeLuxe 26/26D	3.2 mm	12.7 mm Optional 8 mm 9,5 mm 15.9 mm	Ø 0.55 Optional Ø0.4 – 0.7mm	No Loop head
ISP M-2000	3.2 mm	12.7 mm	Ø 0.35-0.55 mm	Separate Loop head