

# FORMAX<sup>®</sup>

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FD 2056 AutoSeal<sup>®</sup>  
FE 2056 AutoSeal<sup>®</sup>  
Pressure Sealer

MAINTENANCE MANUAL  
FIRST EDITION

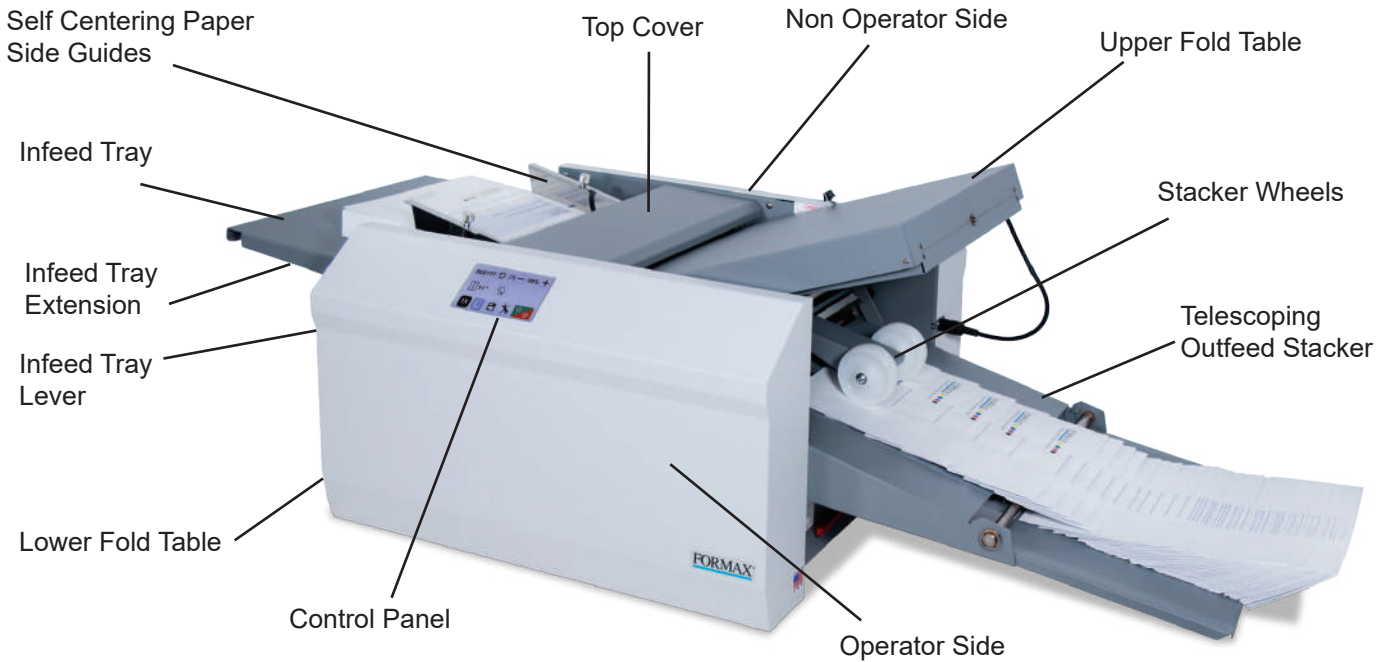


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## DESCRIPTION



The FD 2056 Pressure Sealer is designed to process a variety of form sizes and weights. The fold tables are automatically adjusted for standard folds and custom folds. Documents that are 8 ½" x 11"/14" and 11" x 17" (A5, A4, A3, B4, B5 & B6) are detected by sensors on the infeed tray. Batch counting, and self-centering side guides are added features. Three standard folds are pre-programmed for 11", 14" and 17" forms, uneven C and Z folds for 14" forms, and up to 36 custom folds can be programmed. The sealer will stop automatically after the last document has been processed.

## SPECIFICATIONS

Speed:	Up to 16,450 forms per hour – based on 11" (279mm) Z-Fold
Hopper Capacity:	Up to 500 forms 20# (75gsm)
Pre-Set Folds:	Pre-programmed for C, V, Z in 11 - 17" forms, uneven C, Z in 14" forms
Pre-Set Paper Sizes:	FD Model: 11", 14", 17" FE Model: A5, A4, A3, B6, B5, B4
Custom Folds:	Stores up to 36 custom folds into memory
Paper Size:	Min: 3.5" W x 5" L (88.9 W x 127 L mm) Max: 12.25" W x 17" L (311 W x 432 L mm)
Dimensions:	Closed: 43" L x 21.28" W x 16" H (109 L x 54 W x 41 H cm) Fully Extended: 55" L x 21.28" W x 16" H (140 L x 54 W x 41 H cm)
Weight:	127 lbs (57kg)
Power:	110-240VAC 50/60 Hz
Safety Certifications:	UL & CE applied for

# UNPACKING & SETUP

1. Check package for shipping damage. If there is shipping damage, do not discard the box.
2. Remove the machine and packed components from the box. The fold tables, telescoping stacker, and power cord are wrapped separately in the box.

**NOTE:** Two people must lift the machine from the box.

3. Place the folder on a solid stand.

## Install upper and lower fold tables, telescoping conveyor and power cord

1. Be sure the tables are set firmly on the locating pins (Fig 1a & 1b). Slide each fold table in until it meets the first locating pin then push down to set in place.

Upper Fold Table Pins



Fig. 1a

Locating Pins

Lower Fold Table Pins

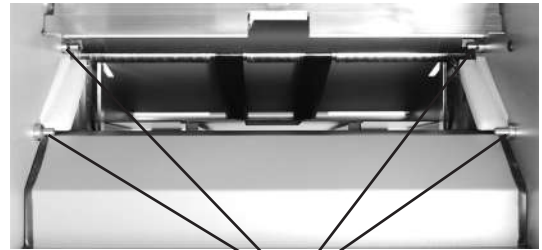


Fig. 1b

Locating Pins

2. Lock the fold table into position (Fig. 2)
3. Repeat the same steps for the lower fold table.



Fig. 2

Fold Table Lock

4. Plug the fold table cables into the receptacles on the side frame (Fig. 3 & 4).

Upper Fold Table Receptacle Location



Fig. 3

Plug in Receptacle

Lower Fold Table Receptacle Location



Fig. 4

Plug in Receptacle

5. Insert the telescoping extension tray into the end of the outfeed conveyor (Fig. 5).

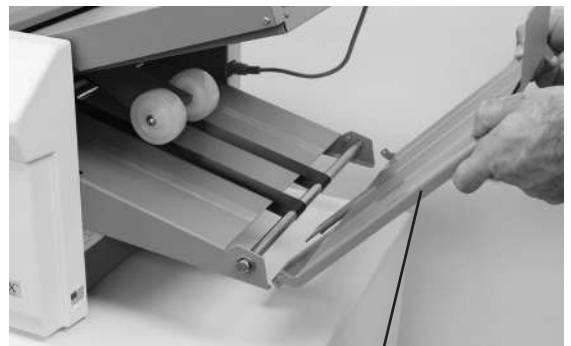
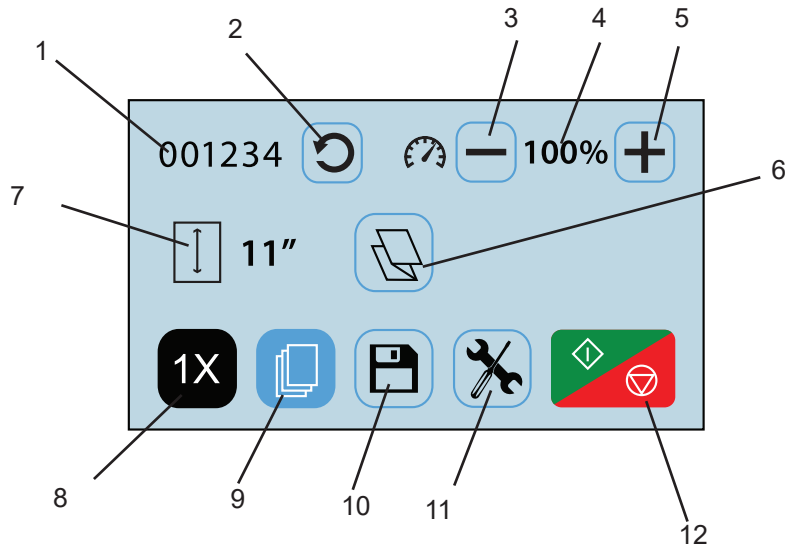


Fig. 5

Telescoping extension tray

6. Make sure the power switch is in the "OFF" position. Plug the power cord into the power inlet and the wall outlet.

# CONTROL PANEL - Home Screen Interface




No.	NAME	FUNCTION
1	Resettable Counter	Displays the number of the forms processed, can be reset between each job
2	Counter Reset Icon	Resets the counter to "0"
3	Speed Decrease Icon	Press to decrease the processing speed
4	Speed Level Display	Speed percentage
5	Speed Increase Icon	Press to increase the speed
6	Fold Selection Icon	Press to advance to fold selection screen
7	Paper Size Display	Shows the size of the paper in the pressure sealer
8	1X Fold Test Icon	Press to test the fold selected
9	AutoBatch Mode	Press to enter AutoBatch mode
10	Custom Fold Access	Press to select or edit previously saved custom folds
11	Operator Settings Icon	Press to enter to the operator settings screen
12	Start / Stop Icon	Press to start the pressure sealer. Press to stop the pressure sealer.

Any icon with a blue frame around it (i.e. #2 above) can be adjusted by pressing the icon.

Icons without a blue frame (i.e. #4 above) provide status, and cannot be pressed.

In any other screens, use the  icon after choosing a setting or entering information.

To return to the home screen from any other screen, press the  home icon.



## OPERATION

1. Place power switch in the ON / "I" position.
2. Extend the catch tray as required.
3. Set the self-centring paper side guides for the width of the forms and lock in position using thumbscrews. (Fig. 6)

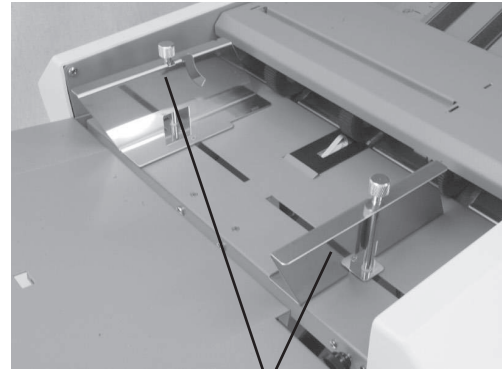


Fig. 6 Self centering side guides

4. Adjust infeed tray tension lever (Fig. 7) for different paper weights. Move the lever up towards the "-" symbol for lighter paper and down toward the "+" symbol for heavier paper. The middle position is for standard paper weights.

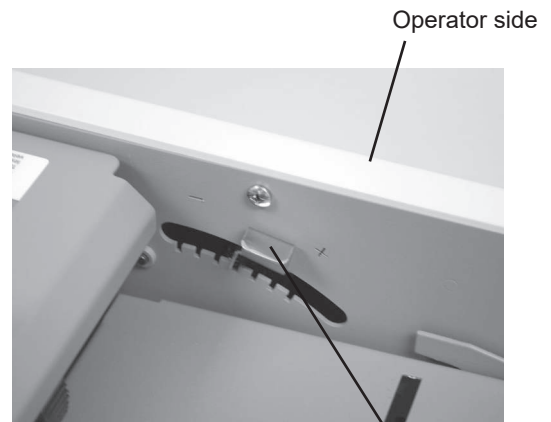




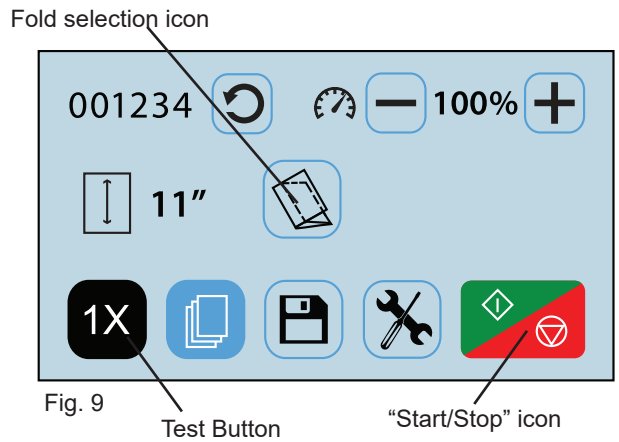
Fig. 7 Tension Lever



5. Raise the infeed tray lever to lower the infeed tray. (Fig. 8)
6. Neatly stack forms on the infeed tray.
7. Lower the infeed tray lever to raise the infeed tray.

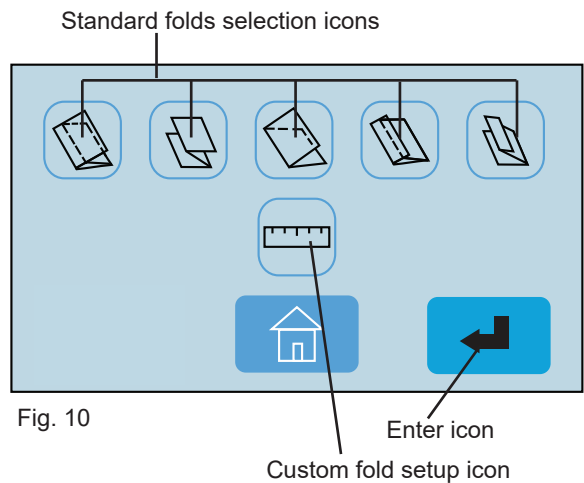


Fig. 8

- Select the type of fold desired by pressing the fold selection icon  (Fig. 9). Note: *If the fold selection icon shows the desired fold press the “Start/Stop” icon  to begin processing forms.*




- Select the standard fold type (Fig. 10) needed and press the “Enter” icon  to set the fold stop positions. When the fold stops are set, the control panel will return to the home screen. The selected fold icon should now be displayed. Press the “Start/Stop” icon  to begin processing forms.



Press the test icon  to check the fold.


- If the fold is skewed, remove forms, lower the infeed tray extension and turn the skew adjustment knob left or right to make corrections (Fig. 11).












- When satisfied with the test fold, press the “Start/Stop” icon  to begin processing forms. Press the same icon to stop.

- Press the “-” or “+” icons to adjust machine speed to desired level.

# AUTOBATCH COUNTING MODE

The AutoBatch feature can be set to count down the number of sets in a batch, the number of sheets in each set, and the delay between each set. To enter the AutoBatch Mode press the  icon on the main screen (Fig. 12a).

1. To enter the number of sets press the  icon (fig. 12b). Enter the number of sets on the keypad that appears. Next press the  icon to select the number of sheets, and then press the  icon to enter the delay between sets. Press the  to exit the keypad (Fig. 12c).
2. Press the  icon to begin folding. The folder will stop when the number of sets counts down to zero (0).
3. To exit the AutoBatch Mode press the  icon.

Note: Press the  icon on the keypad to exit back to the Auto Batch screen. Press the  icon to edit the number entered. Press the  icon on the keypad to reset the entered number to zero (0).

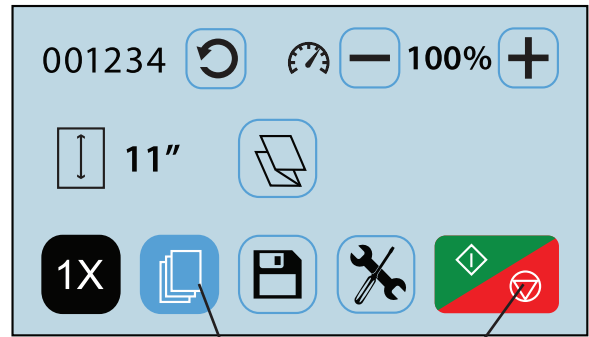


Fig. 12a

AutoBatch Mode

"Start/Stop" icon

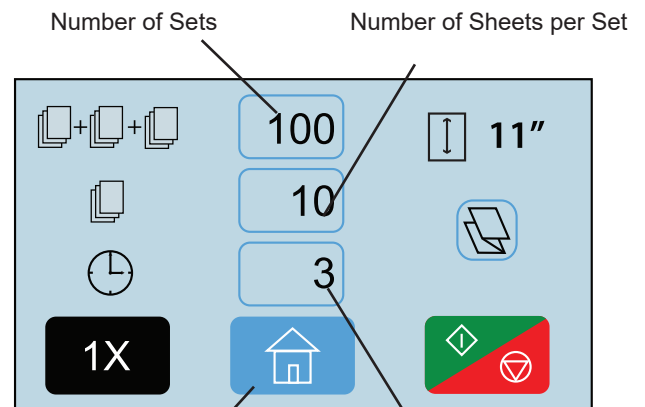


Fig. 12b

Delay between sets (seconds)

Return to Home Screen

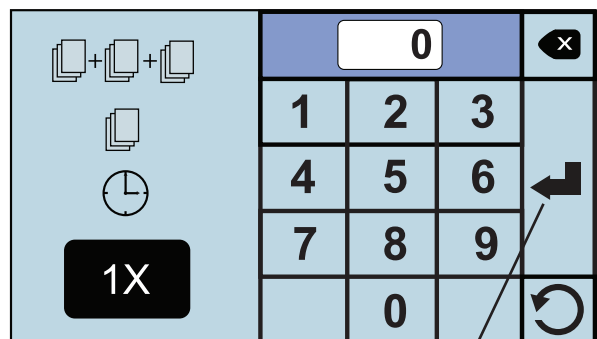




Fig. 12c

Exit icon

# FD 2056 CUSTOM FOLDS SETUP

The FD 2056 has 36 custom fold settings that can be stored into memory for recurring jobs with fold settings that vary from the standard fold settings. To create a custom fold, from the Home Screen press the fold selection icon  to access the fold selection screen (Fig. 9). From the fold selection screen press the Custom Fold icon .

See page 11 to help determine the new fold measurements.

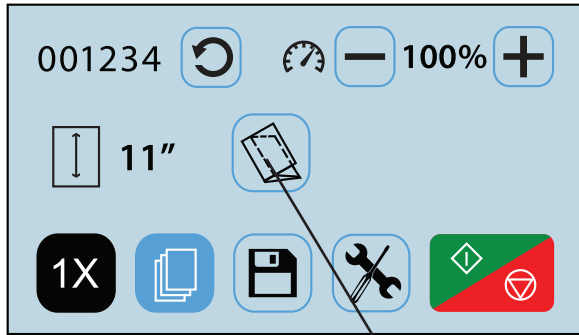


Fig. 13

Fold Selection icon

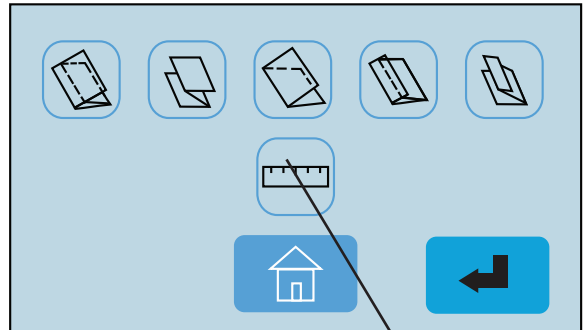




Fig. 14

Custom Fold icon

1. Select the top fold plate icon  (Fig. 15) to set the fold stop position for the first fold (the icon will flash dark gray when selected). Using the touch pad key, in the measurement for the first fold stop position, (**Note:** the minimum position is 1.62" and the max. position is 12.59".).

Press the enter key  to enter the measurement . The white box under the icon will show the measurement entered (Fig. 16).

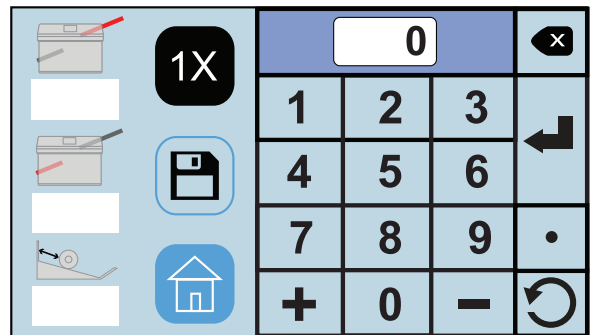




Fig. 15

2. Select the lower fold plate icon  (Fig. 16) to set the fold stop position for the second fold (the icon will flash dark gray when selected). Using the touch pad, key in the measurement for the second fold stop position, (**Note:** the minimum position is 1.49" and the max. position is 8.40".).

Press the enter key  to enter the measurement . The white box under the icon will show the measurement entered.

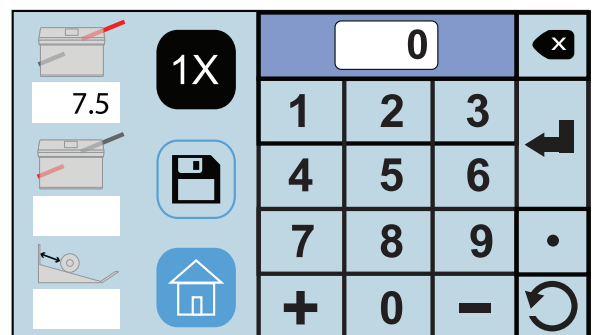



Fig. 16


Leave the fold stop position at Zero for Half Fold.


## FD 2056 CUSTOM FOLDS SETUP, cont.


5. Next set the automatic outfeed stackers. There are 10 stacker positions available. Select the one that best matches the size of the folded document. Using the touch pad key in the stacker position (Fig. 17), key in 0 - 9 based on the chart below.

Press the enter key  to enter the position. The white box under the icon will show the position entered. (Fig. 18).

### Stacker Wheel Positions:

- |   |                                   |
|---|-----------------------------------|
| 0 | Folded size to: 3.75"             |
| 1 | Folded size to: 4.00"             |
| 2 | Folded size to: 4.43"             |
| 3 | Folded size to: 4.87"             |
| 4 | Folded size to: 5.30"             |
| 5 | Folded size to: 5.73"             |
| 6 | Folded size to: 6.16"             |
| 7 | Folded size to: 6.60"             |
| 8 | Folded size to: 7.03"             |
| 9 | Folded size to: 7.46" and greater |
4. With forms loaded in the feeder press the test icon  (Fig. 18) to check that the fold settings are correct. To adjust the settings repeat steps 1 - 3.

When the folds and stacker wheels are set correctly press the save icon  to name and save the custom fold.

5. Select the job number the fold will be saved as (Fig. 19). Press the letter icon  to bring up the keypad to name the custom fold.

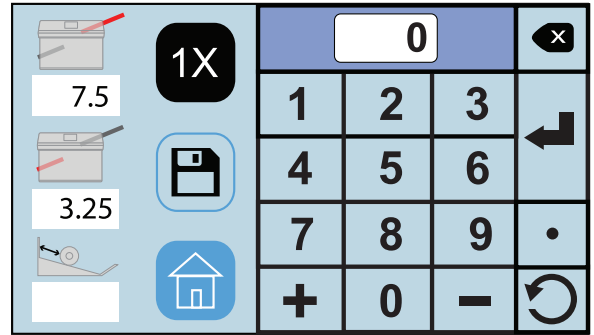


Fig. 17

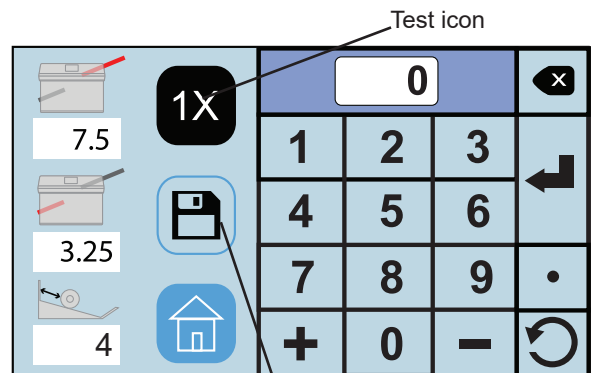


Fig. 18

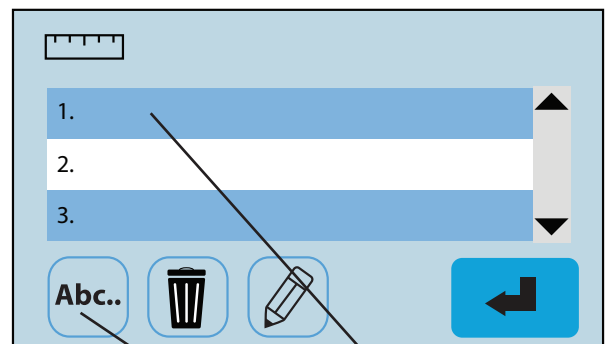


Fig. 19

Letter icon

Custom Job list

## FD 2056 CUSTOM FOLDS SETUP, cont.

5. Key in the name of the job (Fig. 20) and press the save icon in the bottom right corner.

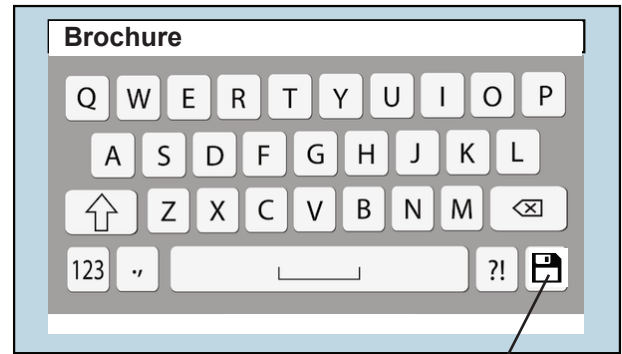



Fig. 20

Save icon

6. Select the custom job and press the blue enter icon  to set the fold stops (Fig. 21).

When the fold stops are set, the folder will return to the Home Screen with the custom job selected.

Press the start icon  to begin folding.

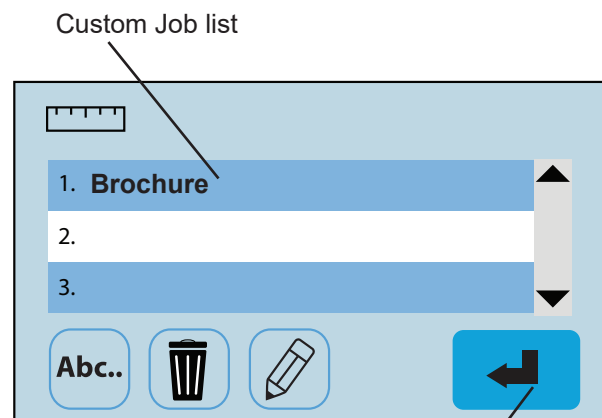


Fig. 21

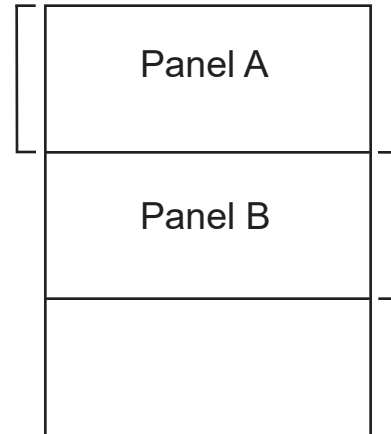
Enter Icon

## Measuring Fold Lengths

Use the examples below to help determine the fold lengths for custom fold settings.

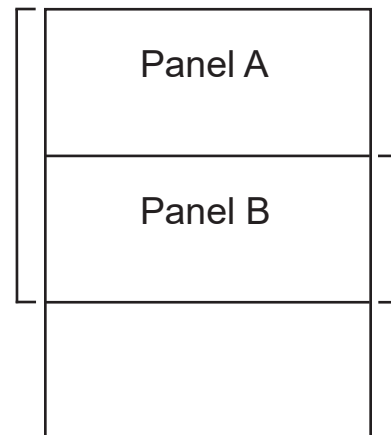
### Example 1: “Z” Fold

1. Measure the length of panel “A”, enter this number as the upper fold table measurement.
2. Measure the length of panel “B”, enter this number as the lower fold table measurement.




### Example 2: “C” Fold

1. Measure the length of panel “A” + “B”, enter this number as the upper fold table measurement.
2. Measure the length of panel “B”, enter this number as the lower fold table measurement.



# RECALLING, EDITING & DELETING SAVED CUSTOM FOLDS SETUP

1. To recall, edit, or delete a saved custom fold from the home screen press the saved job icon  (Fig. 22).

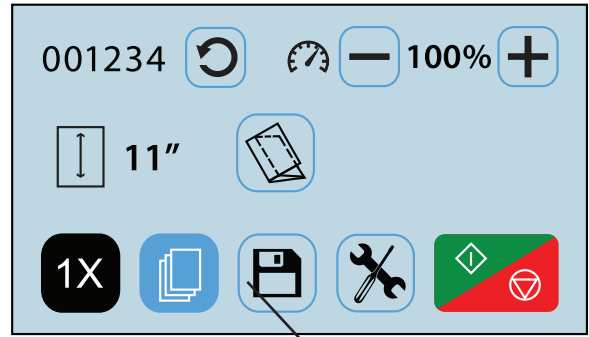



Fig. 22

Saved Job Icon

2. From the saved custom job screen you can recall a job, edit, rename, or delete a stored custom fold.

To recall select the job from the list and press the blue enter button  (Fig. 23). The fold will be set and then will return to the home screen to start processing the job.

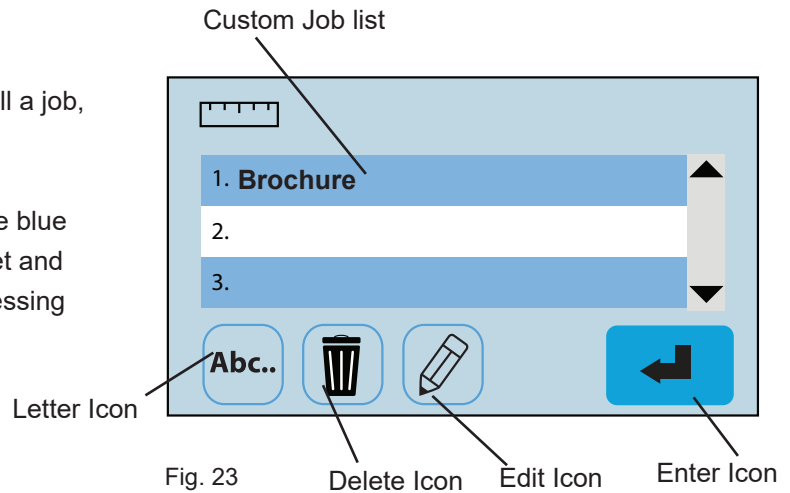



Fig. 23

Delete Icon

Edit Icon

Enter Icon

3. To rename a job, select the job from the list and press the letter icon  (Fig. 23). Use the keypad to change the name and press the save icon in the lower right corner (Fig. 24).

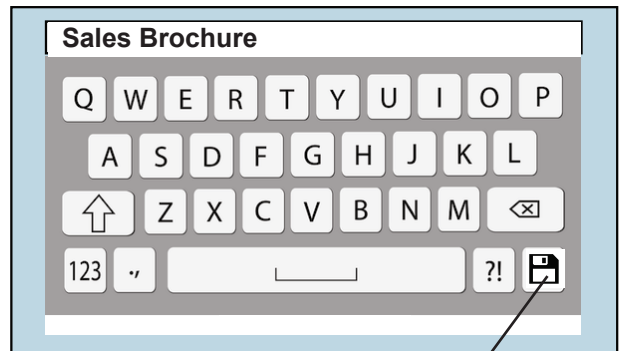



Fig. 24

Save icon

4. To delete a job, select the job from the list and press the delete icon  (Fig. 23). On the confirmation screen press the green box with the check to confirm the deletion or press the red box with the X to cancel the deletion (Fig. 25).

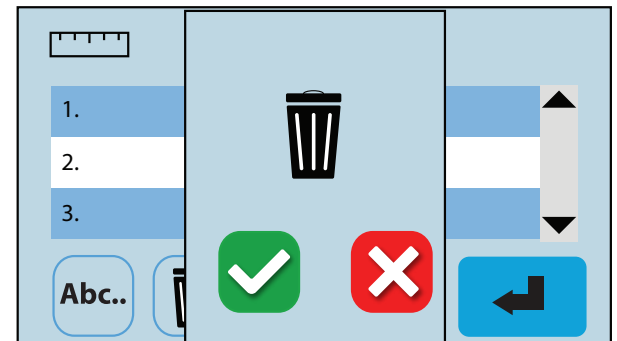



Fig. 25

Deletion confirmation screen



# RECALLING, EDITING & DELETING SAVED CUSTOM FOLDS SETUP

5. To edit a previously saved job, select the job from the list and press the edit icon  (Fig. 23). From the fold setup screen use the same process as setting a custom fold to edit the job settings (Fig. 26). See page 11 for measuring guidelines.

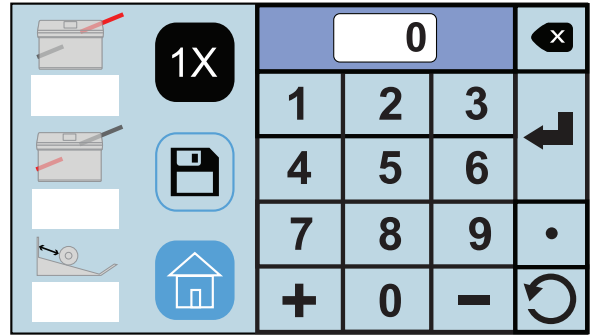



Fig. 26

# OPERATOR SETTINGS

A number of operator settings can be adjusted to personalize the FD 386 / FD 38Xi. This includes changing between standard and metric settings, number of test sheets, Fold and Stacker Override, and Standard Fold Override. This section will review each setting and how to adjust them. If needed, there is a Default Settings option that will reset to factory settings. To advance to the Operator Settings Screen press the Tool icon  on the Home screen.

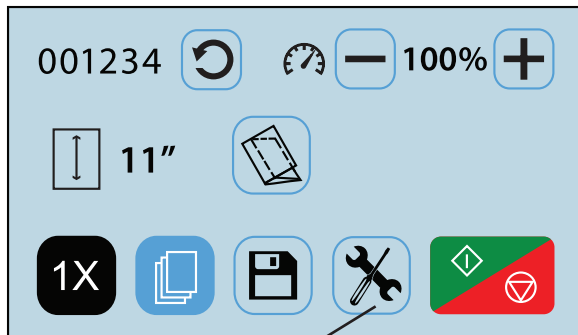


Fig. 27

Operator Settings Icon

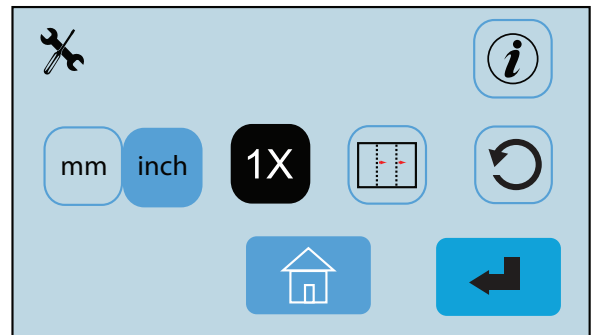



Fig. 28

Operator Settings Screen

## Standard / Metric Settings

1. From the Operator Settings screen (Fig. 28) press the measurement setting icon  (Fig. 29) to change between settings. The icon highlights in blue is the selected setting. By changing this setting the paper sizes will change from standard to metric or vice versa.

Press the home icon  to return to the Home Screen.

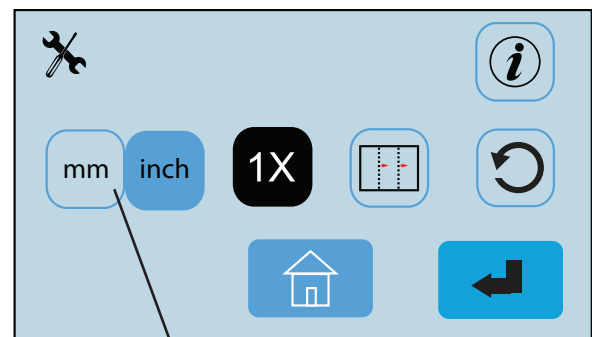




Fig. 29

Standard / Metric Icon

## Standard Fold Override

1. It may be necessary to adjust the factory set standard fold settings for a particular fold type and paper size. This can be done in the Standard Fold Override Mode. From the Operator Settings menu select the Standard Fold Override icon  (Fig. 30) and press the enter  icon to select.

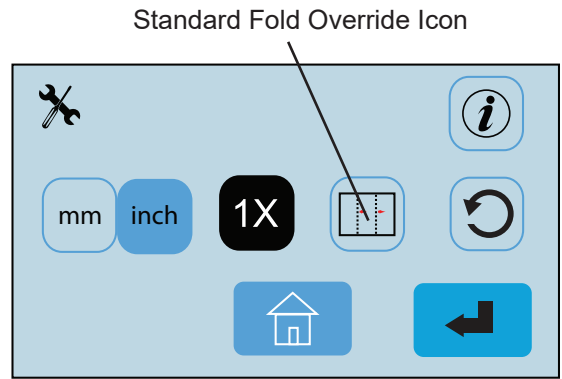


Fig. 30

2. "Standard folds will be modified from factory settings" warning will be displayed (Fig. 31). Press the green box with the check to continue or the red box with the X to exit and return to the operator screen.

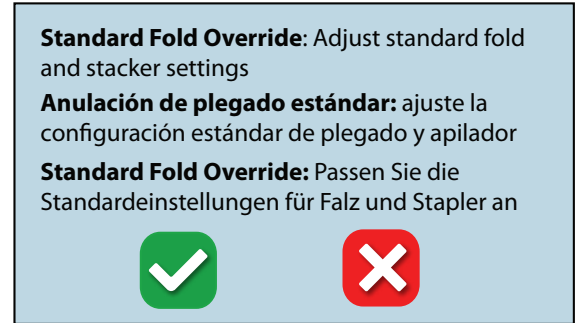



Fig. 31

3. From the Standard Fold Override Screen select the paper size and fold type that you would like to override (Fig. 32). Then press the enter  icon.

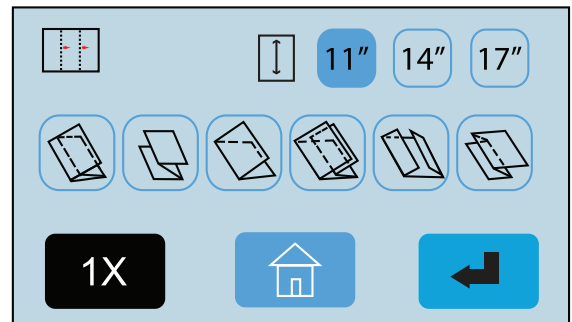




Fig. 32

4. Follow the same procedures as the custom fold settings to adjust the folds (Fig. 33). Press the Test icon  to confirm the change is correct. If the settings are good press the Save Icon  to save the new settings. A save confirmation will be displayed.

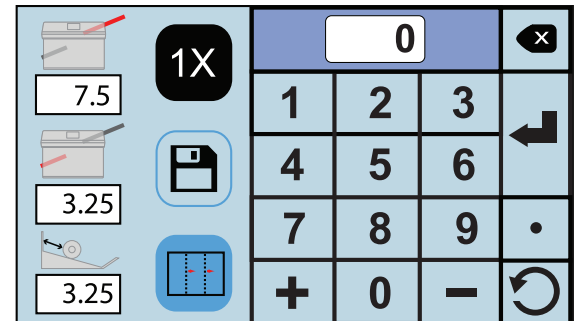


Fig. 33

Press the green box with the check to continue or the red box with the X to return to the fold setup screen (Fig. 34).

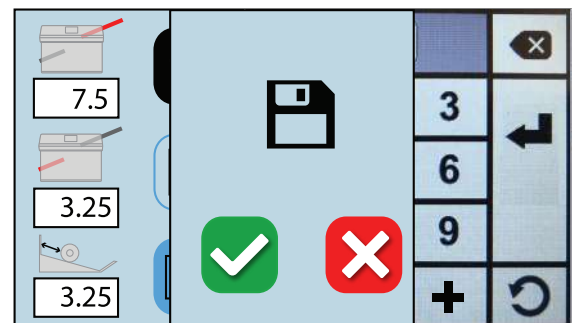



Fig. 34

## Test Sheet Setting

The number of test sheets can be changed between 1, 2 or 3.

1. From the Operator Settings Menu press the Test Icon  to access Test Sheet Setting (Fig. 35).

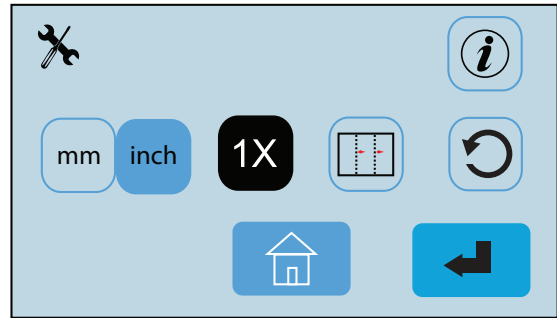



Fig. 35

2. The number of test sheets can be changed to 1, 2, or 3. Press the corresponding test button and then press the enter icon  to save the selection. The chosen icon will be highlighted in black (Fig. 36).

Press the Home button  to return to the Operator Settings screen.

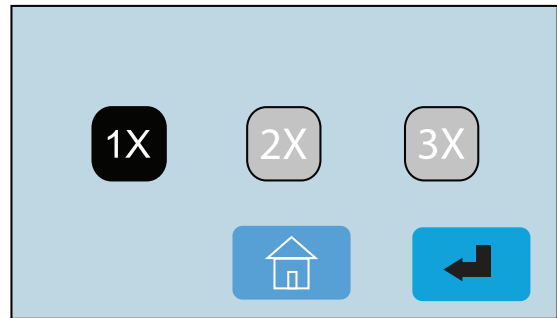



Fig. 36

## Default Settings - Return to Factory Settings

1. From the Operator Settings screen press the Default Settings icon  (Fig. 37). A confirmation screen will come up. Press the green box with the check to confirm or the red box with the X to cancel the setting (Fig. 38).

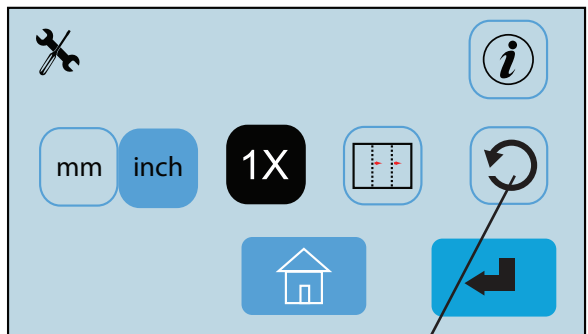


Fig. 37

Default setting Icon

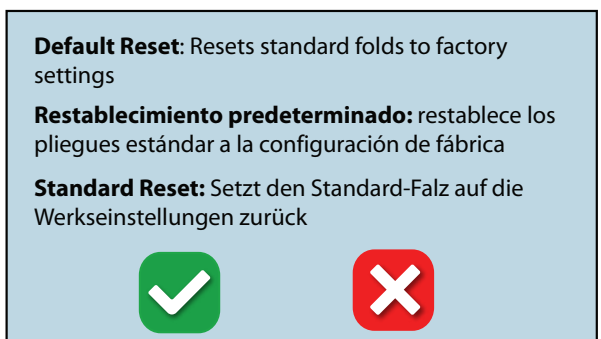


Fig. 38

Default setting confirmation screen

## REMOVING ROLLER COVER

The roller cover can be removed to access the sealing rollers. To remove, unscrew thumbscrews that hold the cover in place. (Fig. 39)

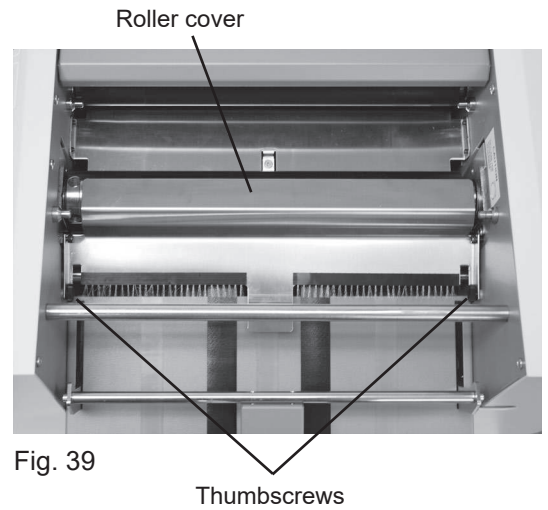


Fig. 39

## REMOVING INFEED TIRES

The infeed tires can easily be removed for cleaning and replacement. Remove the Allen screw located on the left side of the feed tire shaft (Fig. 40). Slide the shaft to the right to release from the side frame and remove (Fig. 41).

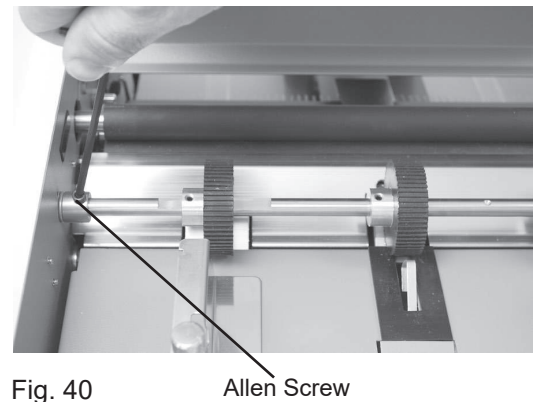


Fig. 40

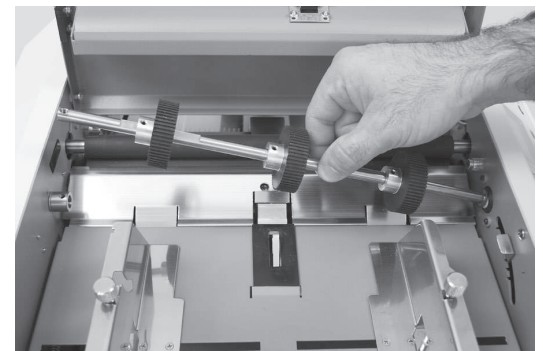


Fig. 41

## DAILY MAINTENANCE

1. It is recommended to let forms cool for one-half hour, from the laser printer, before processing. This allows toner to set on the forms and static electricity to discharge. The FD 402 Jogger is recommended for best results. The Jogger squares the forms and dissipates heat and static electricity created by laser printers.
2. Clean infeed tires and fold rollers with Formax recommended roller cleaner & rejuvenator to remove paper dust and toner. A Formax Cleaner Kit is available from your dealer. A damp cloth with water is the best alternative.

**CAUTION:** Do not use any chemicals other than the roller cleaner & rejuvenator or water.

## CLEANING PROCEDURES:

1. Make sure machine is turned off and unplugged. All folder/sealers have three infeed tires, four rubber fold rollers and two metal seal rollers (Fig. 42a).
2. Lift top covers and remove the upper and lower fold tables.
3. Using Formax roller cleaner, spray a new cotton cloth until the cloth is saturated. Wipe the wet cloth in a back and forth motion making sure to clean the entire surface of the infeed tires, fold and seal rollers. Next, use a dry cloth to wipe off excess toner. The cloth should be covered with black toner surplus from cleaning the rollers.
4. Run 10-15 sheets of blank copy paper to ensure all cleaner has been removed from the tires, fold and seal rollers. Running blank sheets will remove any excess residue of cleaner on the rollers.

**NOTE:** If the fold rollers are very dirty, you may use a green scrubbing sponge, i.e. ScotchBrite, with the roller cleaning solution.

**DO NOT** use a scrubbing sponge on the seal rollers. It will damage the surface. Use **ONLY** a new cotton cloth and roller cleaning solution on the seal rollers (Fig. 42b)

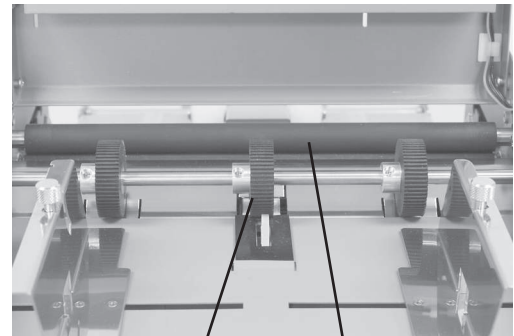


Fig. 42a

Infeed Tires

Fold Rollers




Fig. 42b

Seal rollers

# ERROR SCREENS

## Paper Misfeed / Paper Jam




A misfeed has occurred. Reset the stack of paper in the infeed and press the  icon to resume operation.

A Paper jam has occurred in one of the areas indicated. Turn the folder to the off position and unplug. Check the area indicated for paper and remove. Replace the fold plates and plug the folder in and the power on.

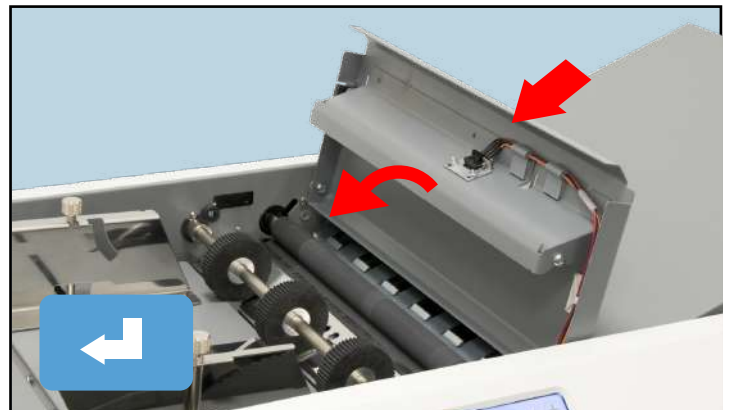
See page 31 for instructions on how to use the Jam Clearing Tool.


## Paper Out



There is no paper in the infeed. Reload paper and press the  icon to resume operation.

## Cover Open



The top cover is open. Close the top cover and press the  icon to resume operation.

## REPLACING SEALER ROLLERS

1. Turn power off and unplug power cord.
2. Remove side covers and upper fold plate.
3. Remove belts. (See belt replacement, below.)
4. Remove top plates by unscrewing four screws.
5. Loosen or remove the five lower screws on each side.
6. Remove first roller by lifting up and out of machine.
7. Remove the two springs.
8. To remove second roller tilt stainless steel center away from roller.
9. Remove second roller the same way as the first roller.
10. To reassemble, repeat above steps in reverse.
11. Adjust belt tension. (See belt replacement, below.)



Fig. 43a

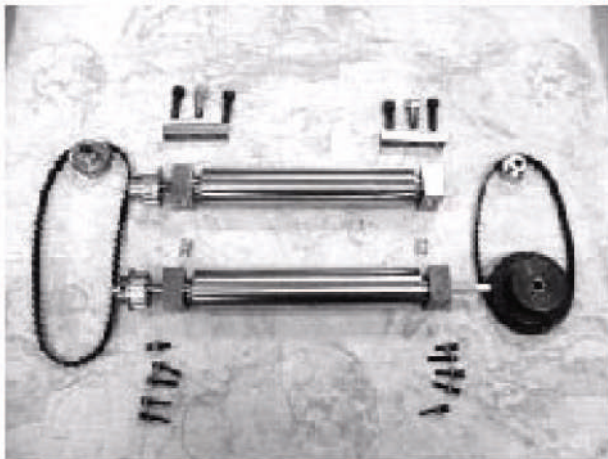


Fig. 43b Sealer Roller Components

## BELT ADJUSTMENT AND REPLACEMENT

**NOTE:** Roller clearance must be set before adjusting belt tension.

1. Make sure machine is turned off and unplugged.
2. Remove the operator side cover.
3. Loosen screw on the side of lever (Fig. 43a) until belt is loose enough to remove belt.
4. Install new belt.
5. To adjust belt first determine if belt is too tight, or too loose (belt should have no more than 5/16" play). Tighten or loosen the screw on the side of lever.
6. Reverse procedure to install.

**NOTE:** Be sure not to over tighten belt, it will affect roller clearance.

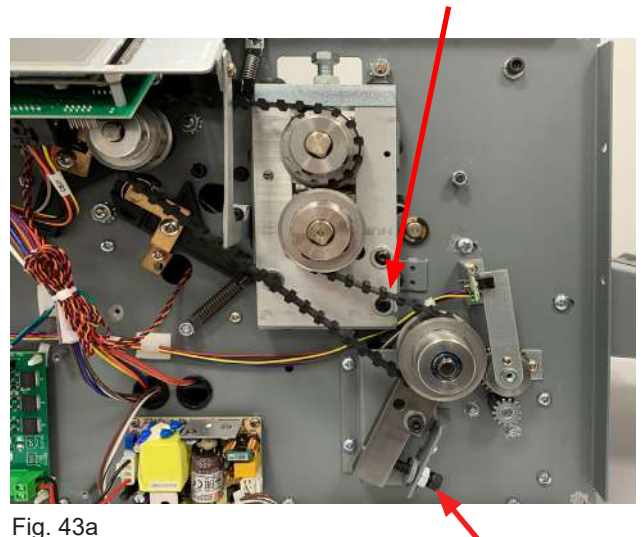


Fig. 43a



## REPLACING CONTROL PANEL BOARD

1. Make sure machine is turned off and unplugged.
2. Remove the operator side cover.
2. Remove the side bracket mounting screws from either side of the Control panel assembly.
3. Remove the two mounting screws holding the control panel assembly to the side frame (Fig. 44a/44b).
5. Remove the control panel from the control panel mount.
6. Unplug the electrical connectors. Note their location.
7. Remove the six ¼" nuts holding the board to the panel. Do not lose any of the eight white plastic spacers.
8. Reverse procedure to install.

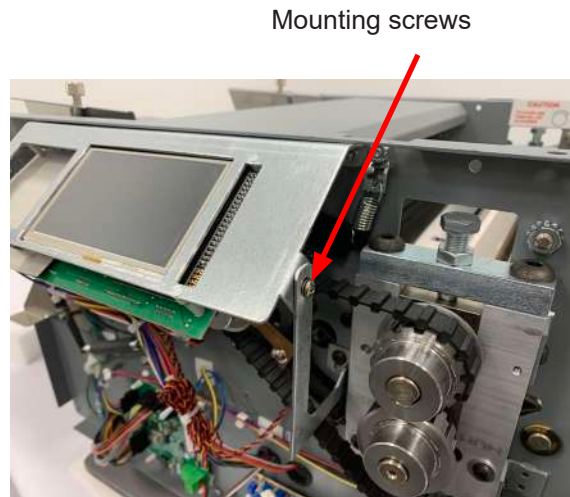


Fig. 44a

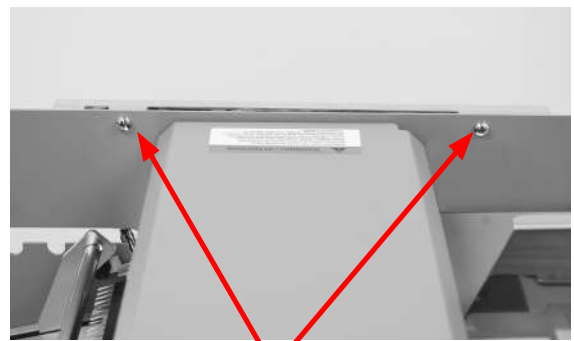


Fig. 44b

Mounting screws

## REPLACING SPEED CONTROL BOARD

1. Make sure machine is turned off and unplugged.
2. Remove the non-operator side cover.
3. Unplug the electrical connections from the board. Note the position of each connection (Fig. 45),
4. Remove two mounting nuts holding the board in position.
5. Remove the board.
6. Reverse procedure to install.

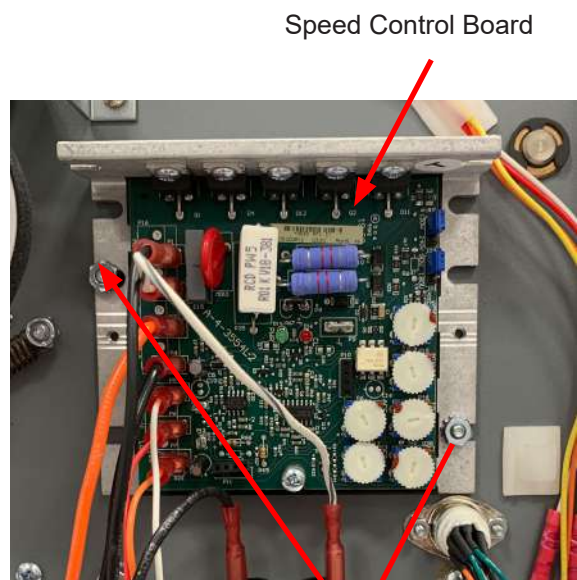


Fig. 45

Mounting Nuts

# REPLACING DRIVE MOTOR

1. Make sure machine is turned off and unplugged.
2. Remove non-operator side cover.
3. Disconnect the black and orange main wires from the speed control board. The black wire is in position one and the orange wire is in position three from the top of the board (Fig. 46)
4. Disconnect the black thermale overload protection wires. Disconnect one from the speed control board, position four and the second from the power filter top left position. (Fig. 46)
3. Remove lower fold table.
4. Remove three screws holding the component access panel in position (Fig. 47).
5. Remove component access panel.
8. Remove the four mounting nuts that hold the motor in position (Fig. 48).
9. Remove the drive belt from the drive pulley (Fig. 49).
10. Slide the motor out of the side frame.
11. Reverse procedure to install.

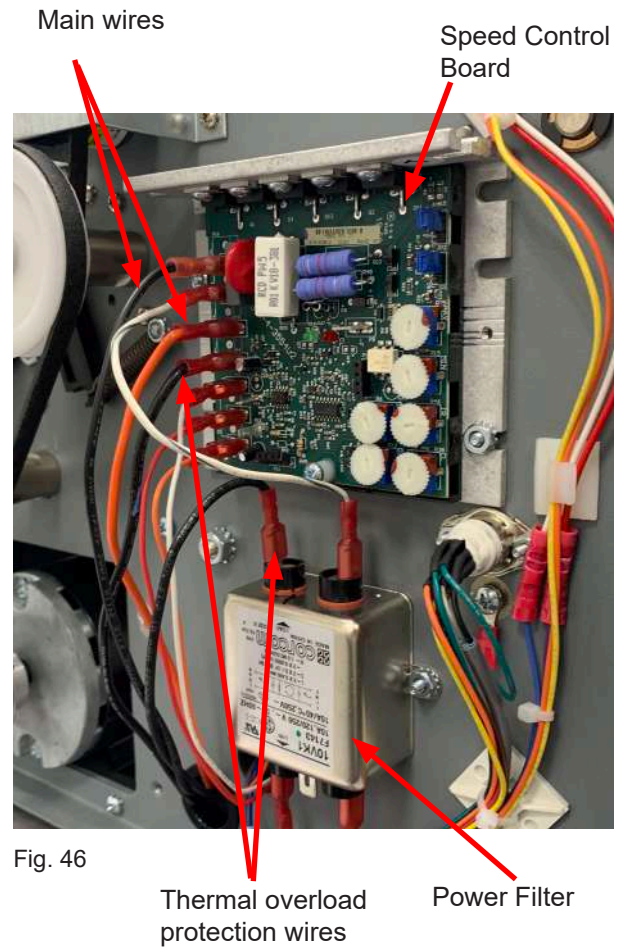


Fig. 46

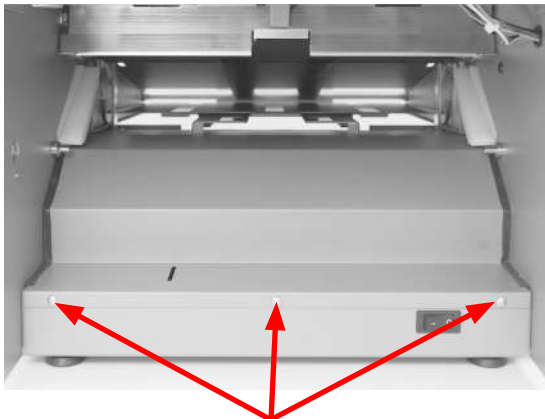


Fig. 47

Access Panel Screws

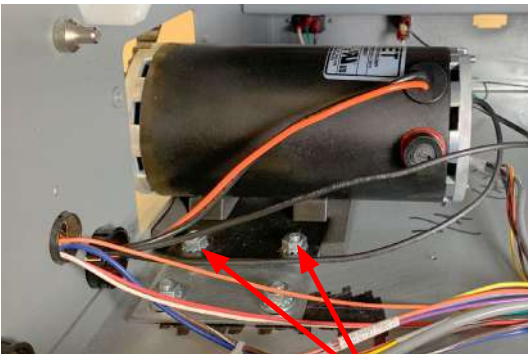


Fig. 48

Mounting Nuts

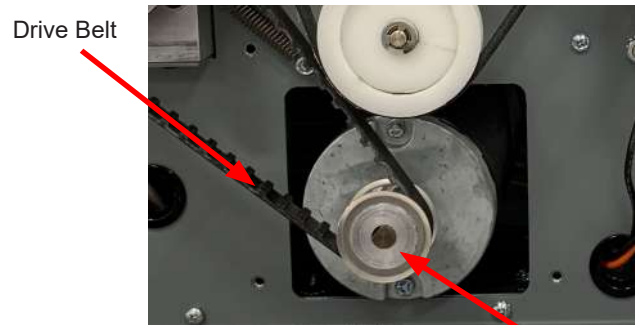


Fig. 49

Drive Pulley

## REPLACING STACKER BELTS

1. Make sure machine is turned off and unplugged.
2. Remove side covers.
3. Remove catch tray assembly.
4. Loosen stacker mounting screws to release tension on belts (Fig. 50a & 50b).
5. Remove one "E" clip from the lower stacker (Fig. 50c) shaft and slide the shaft out of the bushings.
6. Remove the drive belt.
7. Remove large white pulley and smaller white pulley above it from the studs (Fig. 50b).
8. Remove the upper conveyor shaft gear (Fig. 50b).
9. Remove the "E" clip on the operator side of the upper conveyor drive shaft (Fig. 50a).
10. Remove the "E" clip on the non-operator side of the upper conveyor drive shaft (Fig. 50c).
11. Slide the drive shaft toward the non-operator side and remove the brass bushing from non-operator side of the conveyor drive shaft (Fig. 50c).
12. Remove the drive shaft to allow enough clearance to remove the stacker belts. NOTE: removing the front shaft of the conveyor will help in removing belts.
13. Remove the four screws holding the stacker table in position and remove the stacker table (Fig. 50a & 50c)
14. Reverse procedure to install.

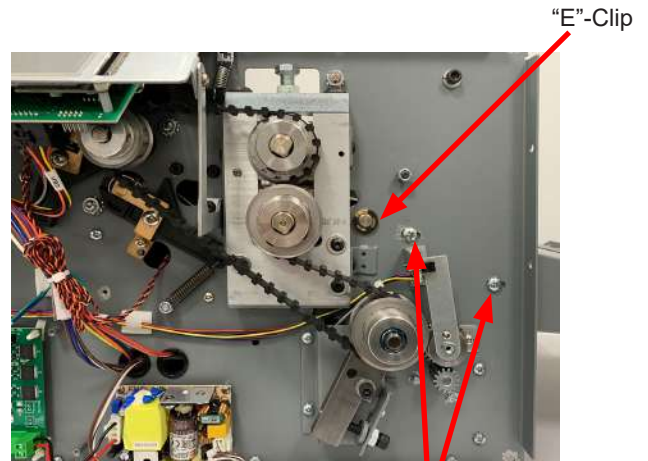


Fig. 50a

Mounting screws

White pulleys

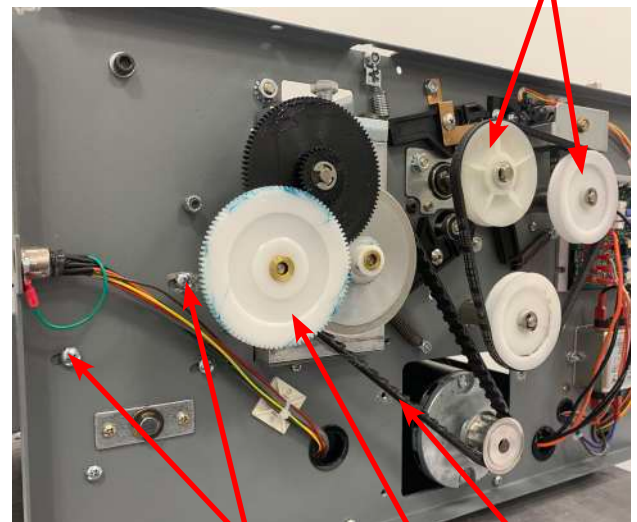


Fig. 50b

Mounting screws

Drive Belt

Shaft gear

"E" clip Brass Bushing

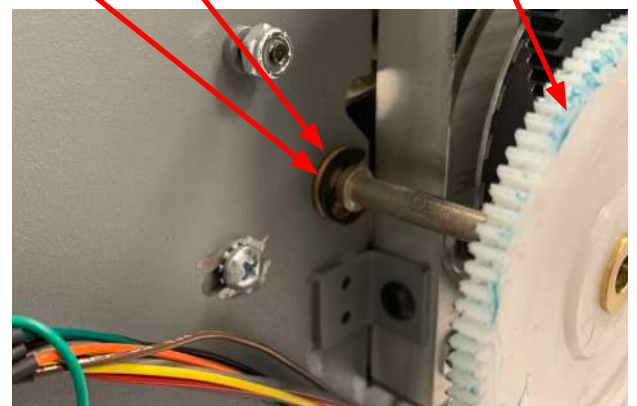


Fig. 50c

# REPLACING SENSOR HARNESS ASSEMBLIES

## Infeed Table Length Sensor

1. Make sure machine is turned off and unplugged.
2. Remove the operator side cover
3. Unplug the photo-eye harness from J4 on the control board.
4. The sensor is located under the in-feed extension tray. Remove the photo-eye mounting screws (Fig. 51).
5. Release the wires from the mounting clips and snip the necessary tie wraps. Gently pull wires through the hole on the control board side.
6. Reverse procedure to install.

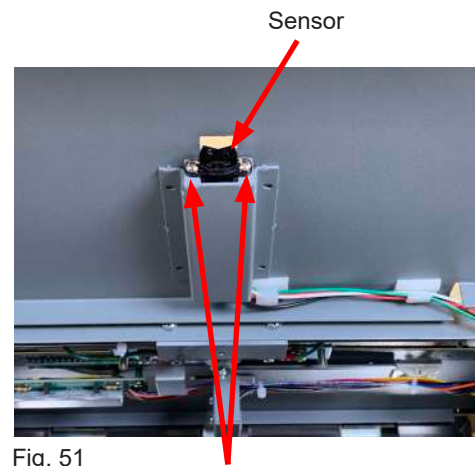


Fig. 51

Mounting Screws

## Infeed Table Width Sensor

1. Make sure machine is turned off and unplugged.
2. Remove the operator side cover
3. Unplug the photo-eye harness from J4 on the control board.
4. The sensor is located under the main in-feed tray. Remove the sensor mounting screws (Fig. 52).
5. Snip the necessary tie wraps. Gently pull wires through the hole on the control board side.
6. Reverse procedure to install.
5. Remove photo-eye assembly.

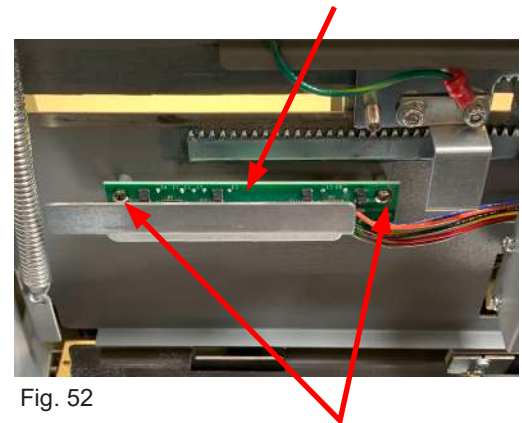


Fig. 52

Mounting Screws

## Exit Sensor

1. Make sure machine is turned off and unplugged.
2. Remove the operator side cover
3. Unplug J2 from the control board.
4. Remove the top fold table to access the sensor.
5. Remove the screw from the sensor mount (Fig. 53).
6. Snip the necessary tie wraps. Gently guide the wires through the hole on the control board side.
7. Reverse procedure to install.

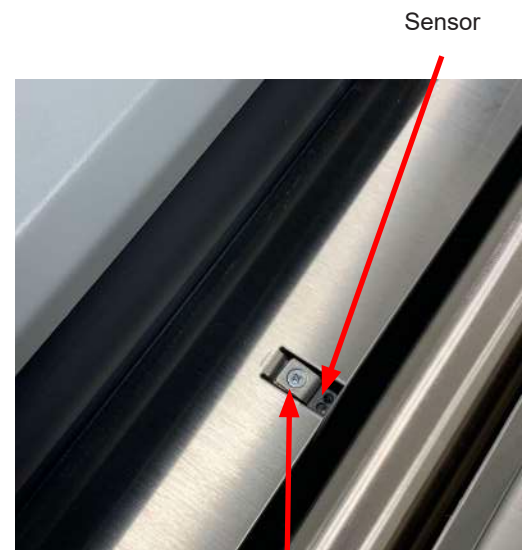


Fig. 53

Mounting Screw

## REPLACING FEED TABLE SELF-CENTERING SIDE GUIDES

1. Make sure machine is turned off and unplugged.
2. Remove lower fold table.
3. Loosen side guide locking screws and move guides to the center of the feed tray.
4. Remove the 11/32" nut (Fig. 54) holding the self-centering gear and remove the gear.
5. Unscrew and remove the locking screw.
6. Reverse procedure to install.

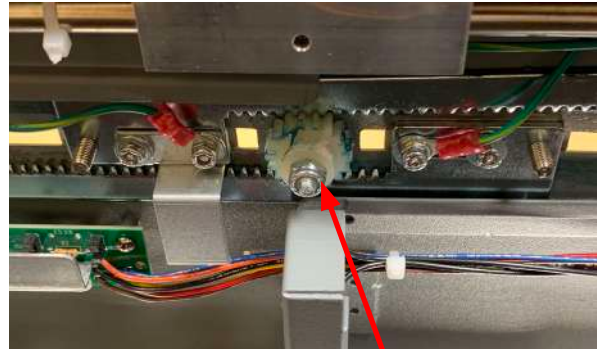


Fig. 54

11/32" Nut

## REPLACING SINGULATOR PAD

1. Make sure machine is turned off and unplugged.
2. Open top cover.
3. Loosen center feed tire setscrew with a 5/64" Allen wrench. Slide the tire to one side.
4. Peel off the pad (Fig. 55).
5. Clean the singulator mount. The mount should be removed in order to mount the pad and reinstall the mount and pad properly.
6. Glue a new pad on the mount using an instant glue.
7. Move the feed tire to its original position, tighten the setscrew and close the cover.

NOTES: When pad and mount are removed, you must also remove the tension spring.

When installing the pad on the mount, it should be cleaned and placed all the way forward.



Fig. 55

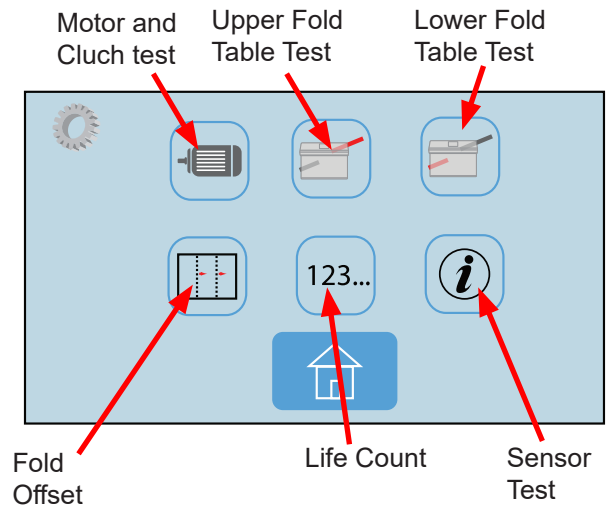
Singulator Pad

# SERVICE MODE - RUNNING DIAGNOSTIC TESTS

The Service Mode diagnostic software runs tests on the mechanical and electrical functions of the folder to make sure they are functioning properly. The diagnostic mode is also used to set and/or verify fold offsets.

To access the Service Mode Follow the steps below:

## Service Mode Home Screen



## Accessing the Service Mode


1. To access the service mode start by pressing the AutoBatch “” icon on the home screen (Fig. 56).



Fig. 56

AutoBatch Icon

2. In the AutoBatch mode insure all windows are set to “0”. (Fig. 57)  
NOTE: If a number is present press the window or the icon to left of the window and reset to zero.

All windows set to “0”

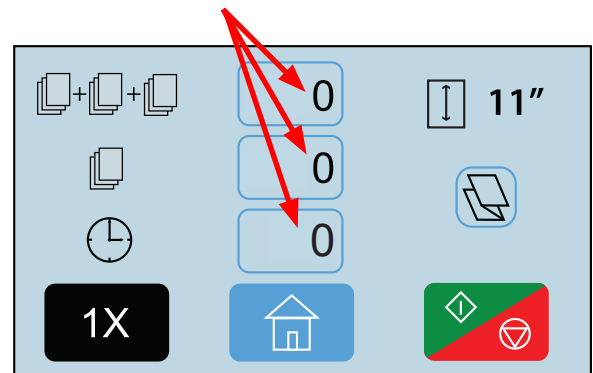



Fig. 57

- Press the number of sets “” icon, it will turn blue when selected (Fig. 58). Use the keypad to enter “9713” (Fig. 58).

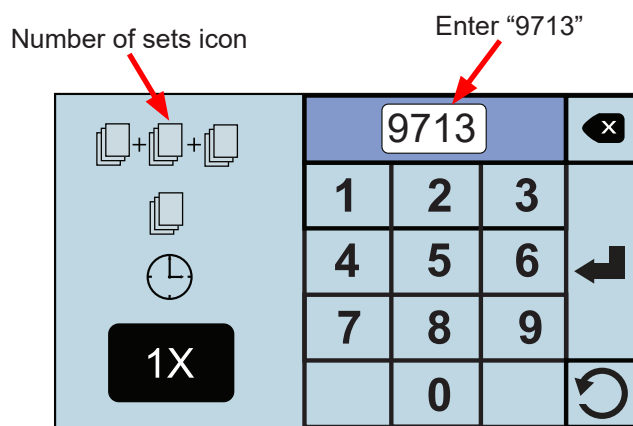






Fig. 58

### 1. Test Motor & Feed Clutch

This mode is used to verify that the motor and clutch are working.

- From the Service mode menu select the motor icon “”
- Press the Start/Stop icon “” to to the motor on and off. Use the “+” or “-” icons to adjust the speed
- To test paper clutch load paper onto the in-feed tray and press the paper feed icon “” in the lower left corner to feed a sheet of paper (Fig. 59).
- To Exit press the Service Mode Home icon “”

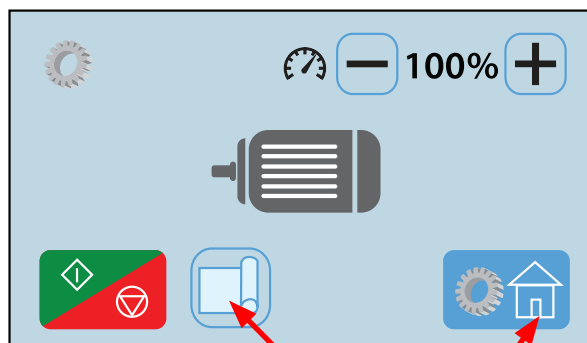





Fig. 59

Paper Feed Icon

Service Mode Home Icon

### 2. Upper Fold Table Test

This mode checks to see that the fold stop worm gear is operating smoothly and that the fold table sensors are working properly for the Upper Fold Table.

- From the Service mode menu select the Upper Fold Table Test icon “”.
- Press the Start/Stop icon “” the fold stop will move to the highest position and a number will appear in the white box (Fig. 60). Press the Start/Stop icon again to move the fold stop to the lowest position. A new number will appear in the white box for the lower position. Run the test a couple more times if the numbers remain with in 1 to 2 of the original numbers the fold table is working properly.
- To Exit press the Service Mode Home icon “”

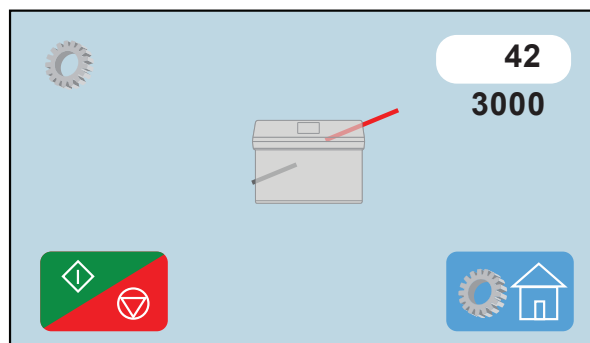





Fig. 60

### 3. Lower Fold Table Test

This mode checks to see that the fold stop worm gear is operating smoothly and that the fold table sensors are working properly for the Upper Fold Table.

1. From the Service mode menu select the Lower Fold Table icon .
2. Press the Start/Stop icon  the fold stop will move to the highest position and a number will appear in the white box (Fig. 61). Press the Start/Stop icon again to move the fold stop to the lowest position. A new number will appear in the white box for the lower position. Run the test a couple more times if the numbers remain within 1 to 2 of the original numbers the fold table is working properly.
3. To Exit press the Service Mode Home icon .

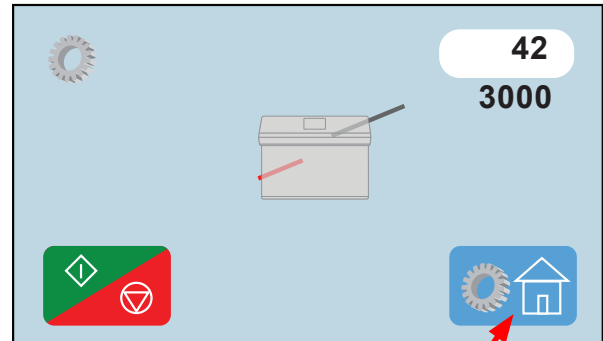








Fig. 61

Service Mode Home Icon

### 4. Fold Table Offset Adjustment

This function is used to make small adjustments to the standard fold settings on the fold tables. The adjustment made will effect all fold types and sizes.

1. From the Service mode menu select the Fold Offset” icon “”
2. Select the upper fold plate icon “” to adjust the fold stop position for the first fold (the icon will turn a dark gray when selected). Using the touch pad, key in the number or use the “=” and “-” keys to make the adjustment for the first fold stop position (Fig. 62). Press the enter key “” to enter the measurement. The white box under the icon will show the measurement entered.  
Select the bottom fold plate icon “” to adjust the second fold and repeat the same steps to adjust.
3. Press the save icon “” to save the adjustments. A confirmation screen will appear (Fig. 63). Press the green check box to accept the change or the red X box to cancel the change.
4. To Exit press the Service Mode Home icon at any time “”.

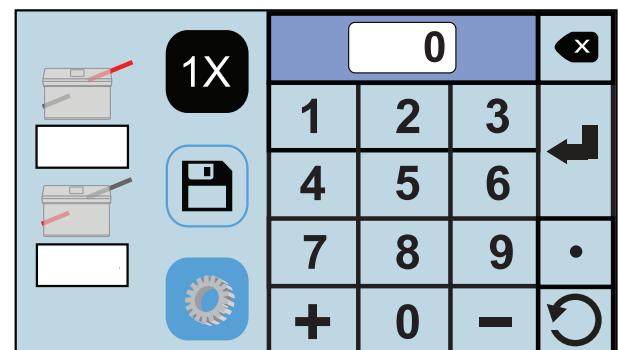


Fig. 62

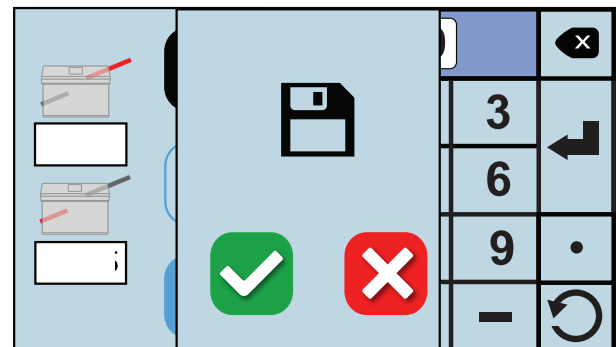



Fig. 63



## 5. Life Count

Shows the total number of sheets of paper run through the machine.

1. From the Service mode menu select the Life Count Icon “ 123...”.
2. The lifecount will be displayed (Fig. 64).
3. To Exit press the Service Mode Home icon “  ”.

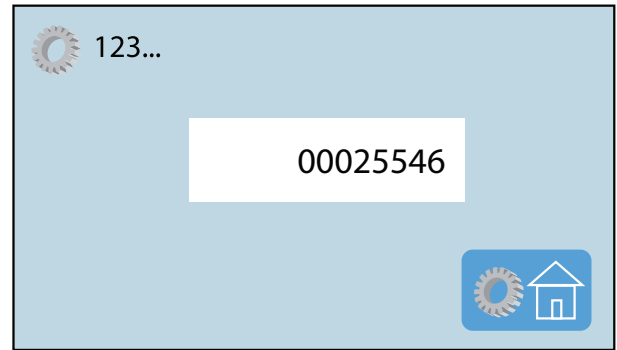




Fig. 64

## 6. Test Sensors

This mode is used to verify the inputs from various sensors on the machine including paper length, width and multi-feed sensors.

1. From the Service mode menu select the Sensor Test Icon “  ”. The Sensor Test Screen will be displayed (Fig. 65).
2.
  - To test the infeed tray paper width sensors move the side guides out.
  - To test the paper extension tray paper “Length Beam” run a piece of white paper over the photo-eye, if working properly the red box with “N” will turn to a green box with “Y” and the number next to it should increase. The “Paper size” “L” box will turn from red to green as well.
  - To test the exit sensor “Exit Beam” remove the top fold plate run a piece of white paper over the photo-eye, if working properly the red box with “N” will turn to a green box with “Y” and the number next to it should increase.
  - To test the paper out switch press the switch down, if working properly the red box with “N” will turn to a green box with “Y”.
  - To test the cover open sensor, lift the top cover, if working properly the red box with “N” will turn to a green box with “Y”. The “Paper size” “State” box will turn from red to green as well indicating the beam is working.
3. To Exit press the Enter icon “  ”.

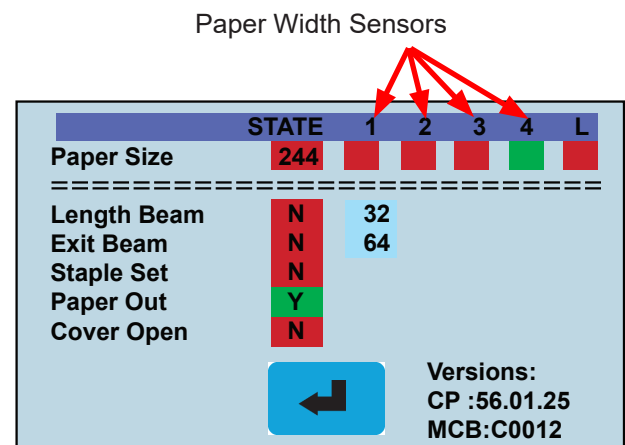


Fig. 65

## TROUBLE-SHOOTING

TROUBLE	POSSIBLE CAUSE	REMEDY
Control panel is not illuminated.	Power switch turned off. No power at the wall outlet. No power to the machine inlet. No power to the control panel. Internal electrical failure	Turn on power switch. Check wall outlet. Check power cord for frayed/broken wires. Press the button on the circuit breaker. Call for service.
Fold table stop not moving when “Test”/ “Start” is pressed.	Fold table is not plugged in. Electrical or mechanical failure	Plug in fold table. Call for service.
“Cover Open” image is displayed.	Cover open Magnetic switch is broken.	Close cover. Call for service.
“Paper out” image is displayed.	Infeed tray is empty.	Place documents on the infeed tray.
“Paper Jam / Misfeed” image is displayed.	Paper misfeed Paper jammed at exit of folder	Reload paper and press “Counter Reset” button. Remove paper and press “Counter Reset” button.
Black marks on the folded paper.	Infeed tires, separator, and/or fold rollers are dirty.	Clean the parts with approved roller cleaner and rejuvenator.
Fold is skewed.	Infeed tray is out of adjustment.	Turn skew adjuster knob to remove the skew.
Stacker belts do not turn.	Broken drive belt, worn drive gear.	Call for service.
Documents are wrinkled or crunched.	Fold tables are not inserted correctly. Piece of paper or other material is stuck in the fold table.	Remove and reinstall fold tables. Be sure they’re properly positioned. Remove object from the fold table.
Infeed tray lever does not work	Broken spring	Call for service.
Double feeding forms	Documents stuck together More tension is needed Feed tire or separator worn	Jog forms to remove static electricity. Adjust the infeed tension lever (page 5, Fig. 8) Call for service
Not feeding documents	Feed tires are dirty Feed tires or separator worn	Clean feed tires Call for Service
Power loss	Circuit Breaker tripped Under adverse conditions, power input level may drop below acceptable limits	Press black reset button next to power inlet. When power is restored, turn off machine, then turn on again to restore normal operations.

# TROUBLESHOOTING

## Clearing Paper Jams

**WARNING:** Turn off machine and unplug cord from its receptacle

If a jam occurs between the metal seal rollers, open the top cover, unplug and remove the upper fold table.

Remove the jam clearing tool (located under the upper fold table), apply the tool to the upper metal roller (see photo), and turn clockwise until the paper jam is clear. (Fig. 66)

**NOTE:** Do not turn counter-clockwise and force the forms to exit machine as rollers may be damaged. Remove the jammed form, return tool to holder and reinstall upper fold table. Reinstall cover and press reset button.

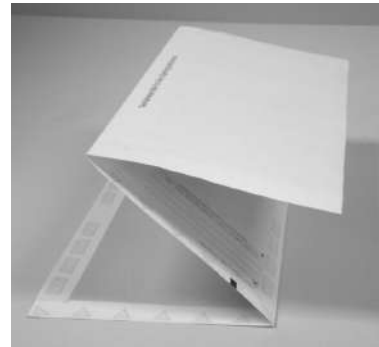
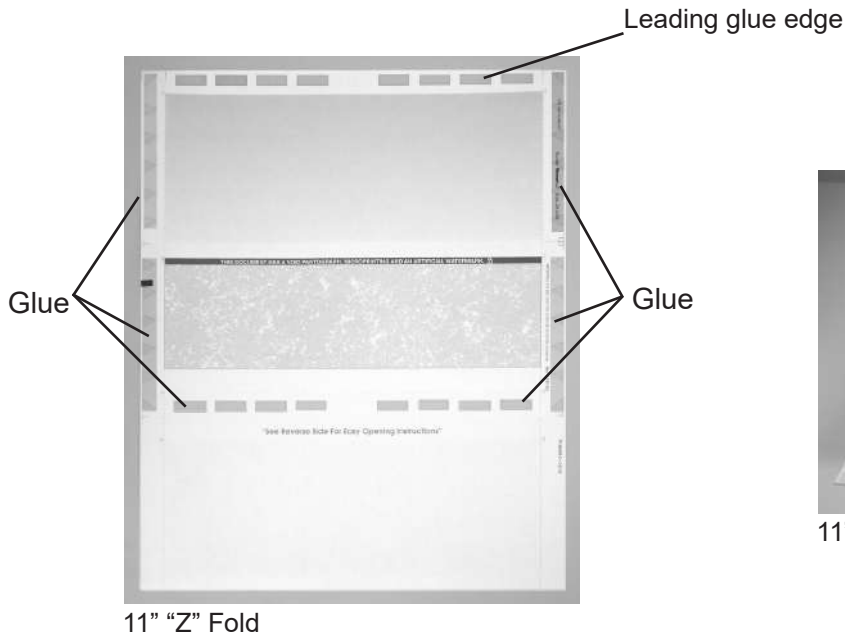
Using the Jam Clearing Tool



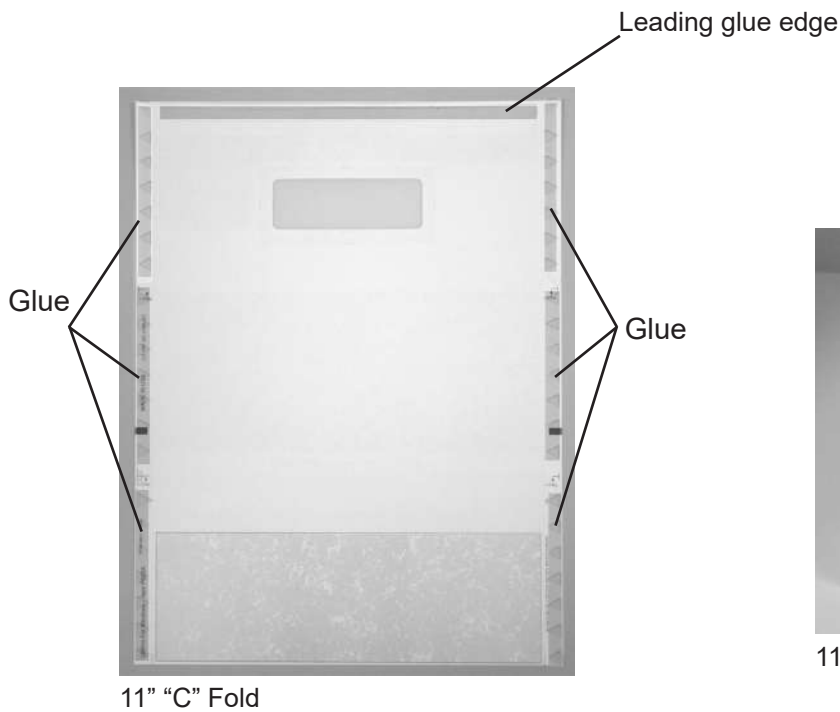
Fig. 66

# DETERMINING FOLD TYPE

Two Standard Folds 11" "Z" & 11" "C"  
Refer to Operator Manual for custom fold setup.



11" "Z" Fold



11" "C" Fold

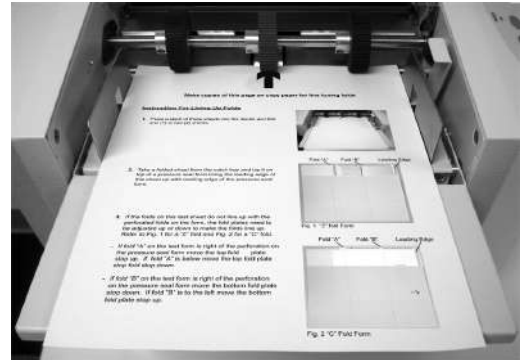
# Leading Edge



Make copies of this page on copy paper for fine tuning folds

## Instruction For Lining Up Folds

1. Place a stack of these sheets into the feeder and fold one (1) or two (2) sheets.



2. Take a folded sheet from the catch tray and lay it on top of a pressure seal form lining the leading edge of this sheet up with leading edge of the pressure seal form.

Fold "A"      Fold "B"      Leading Edge

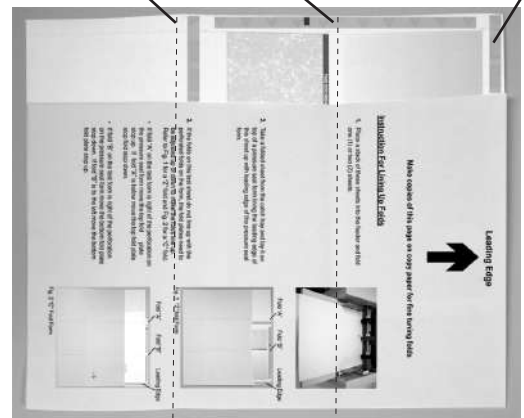


Fig. 67 "Z" fold Form

3. If the folds on this test sheet do not line up with the perforated folds on the form, the fold plates need to be adjusted up or down to make the folds line up. Refer to Fig. 67 for a "Z" fold and Fig. 68 for a "C" fold.

- If fold "A" on the test form is to the right of the perforation on the pressure seal form move the top fold plate stop position up. If fold "A" is to the left move the top fold plate stop position down.

- If fold "B" on the test form is to the right of the perforation on the pressure seal form move the bottom fold plate stop position down. If fold "B" is to the left move the bottom fold plate stop position up.

Fold "A"      Fold "B"      Leading Edge

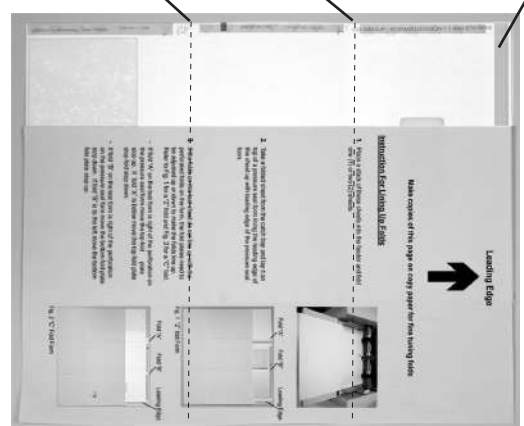


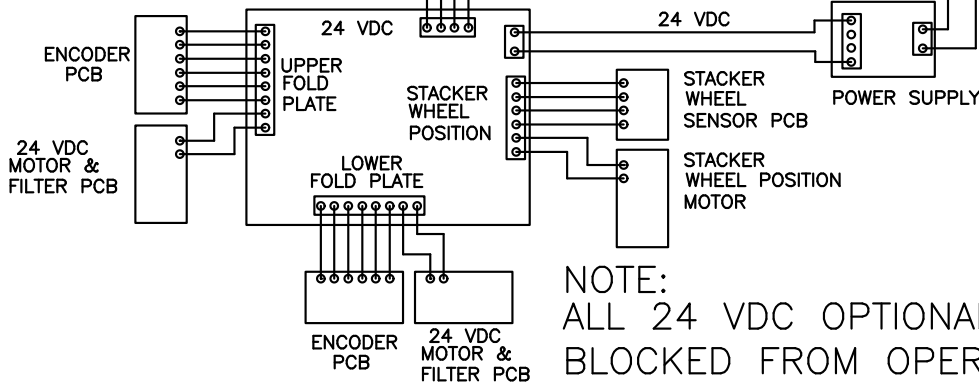
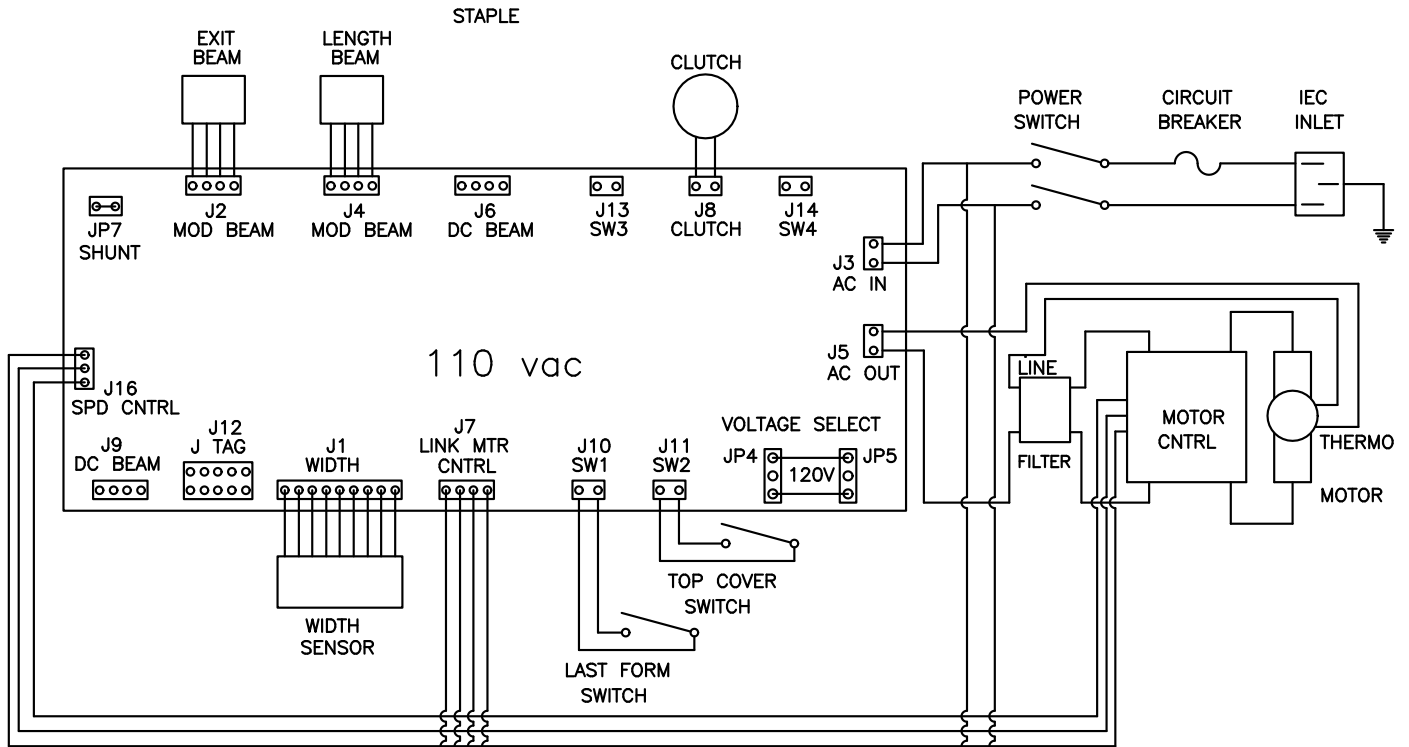
Fig. 68 "C" Fold Form

# PARTS

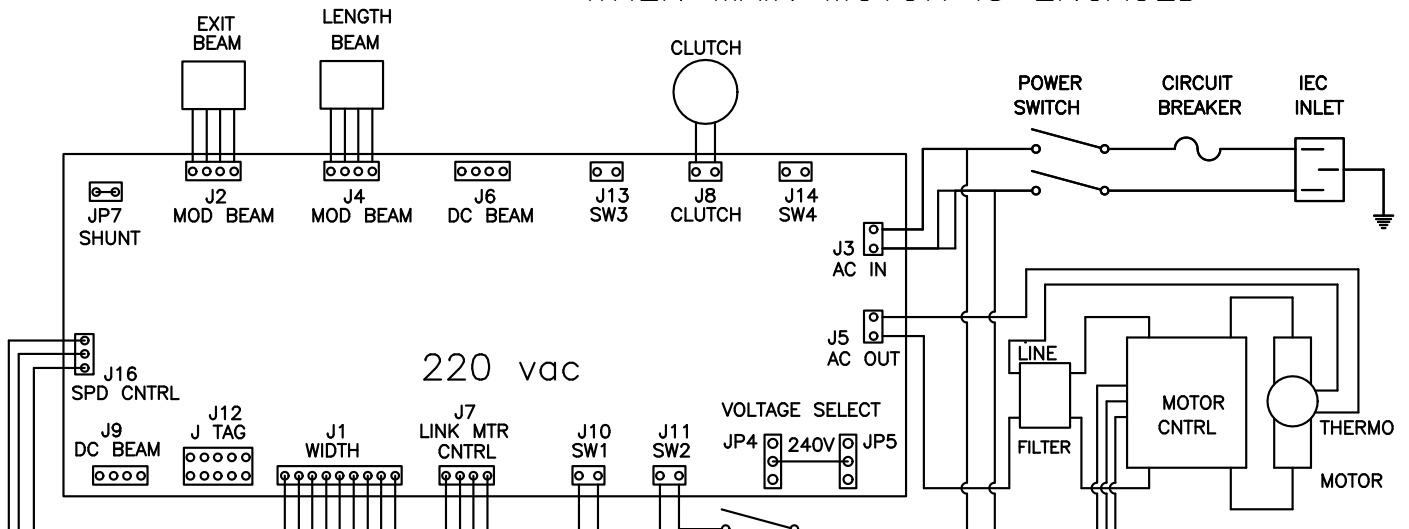


# ELECTRICAL SCHEMATIC

## 2056 SCHEMATIC

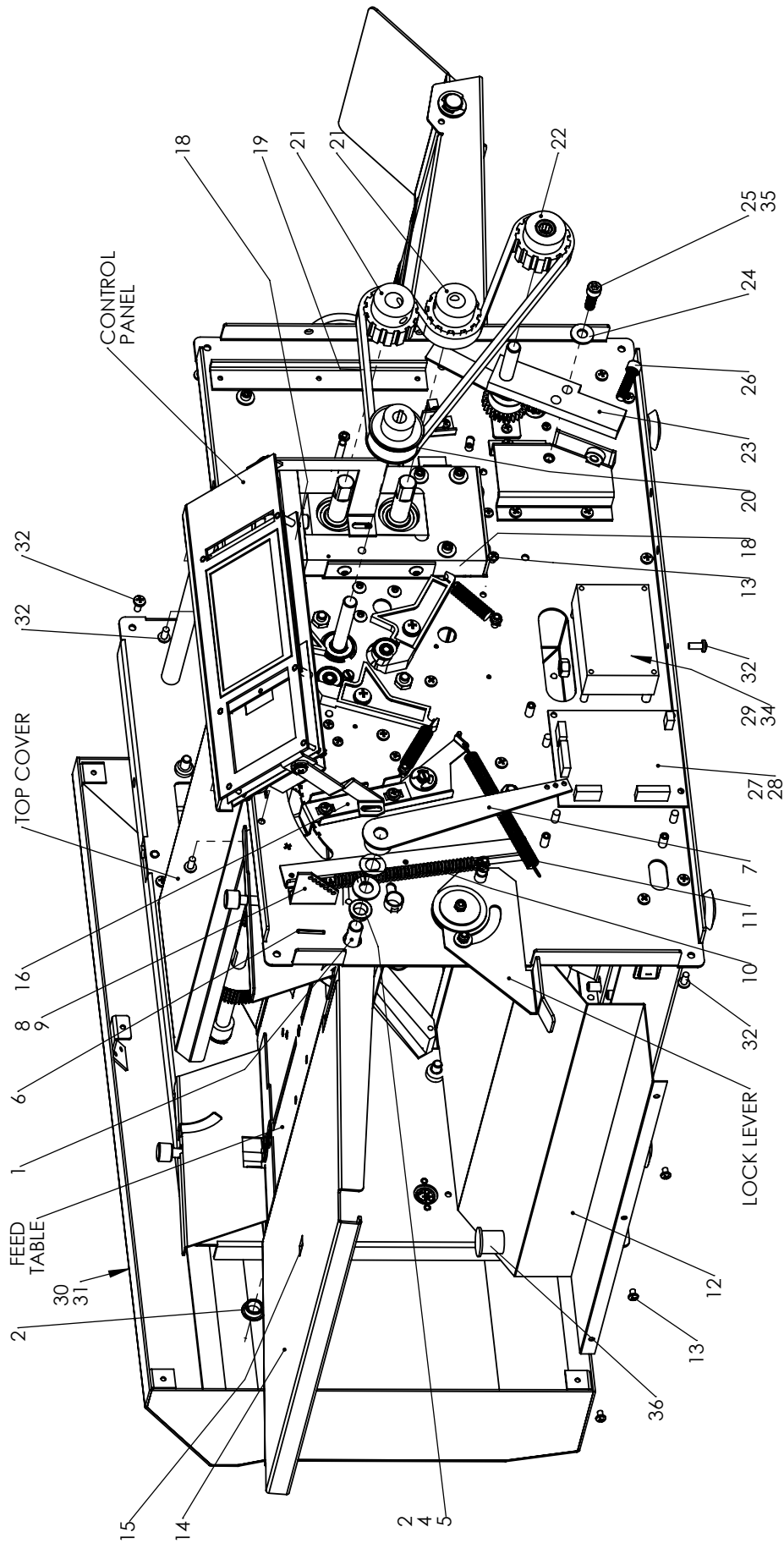


NOTE:  
ALL 24 VDC OPTIONAL COMPONENTS ARE  
BLOCKED FROM OPERATION  
WHEN MAIN MOTOR IS ENGAGED





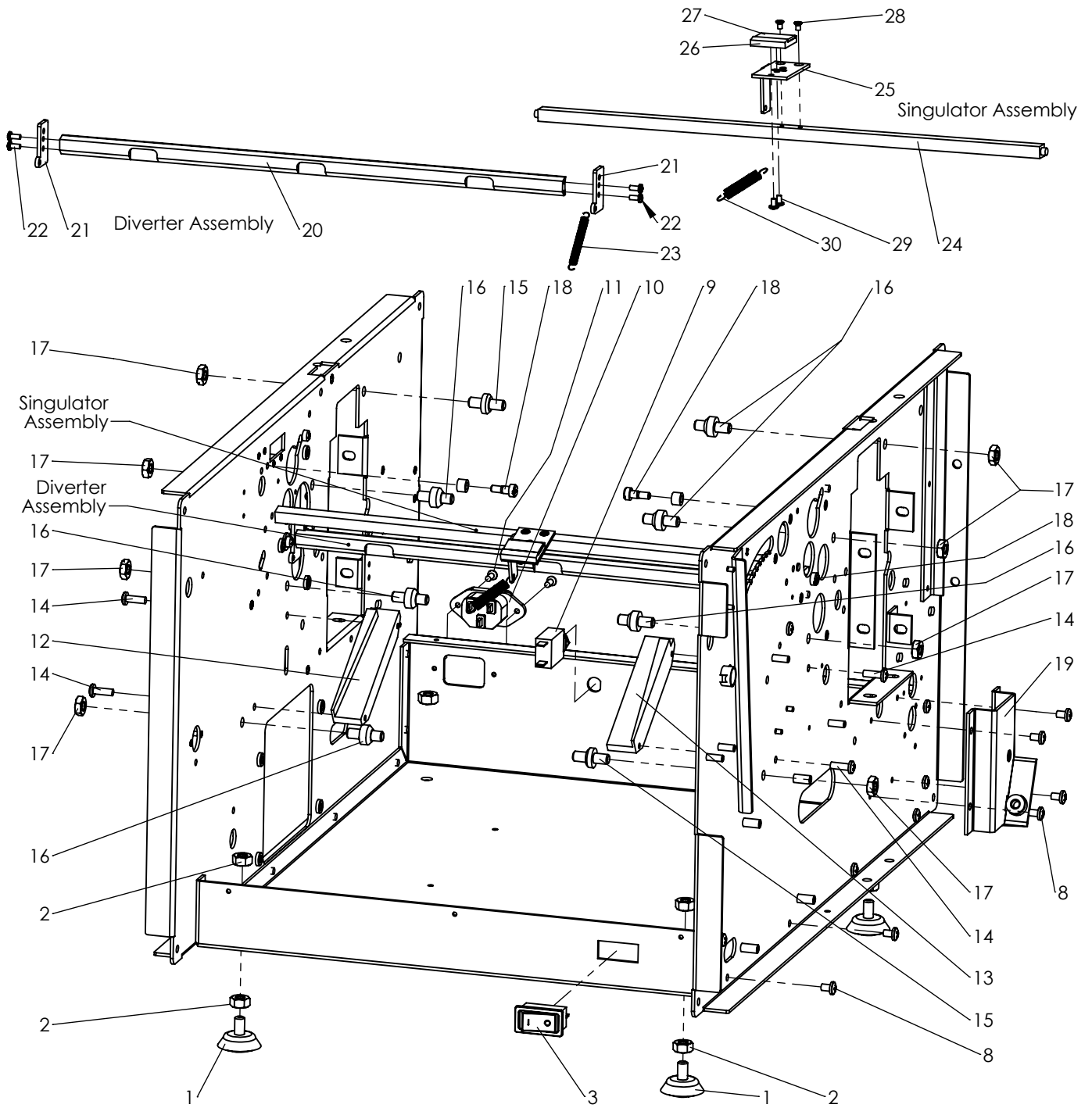
# OPERATOR SIDE COMPONENTS



## OPERATOR SIDE COMPONENTS

NO.	PART NO.	DESCRIPTION	QTY.
1	332-0144	PIVOT SHAFT, FEED TRAY	1
2	371-0013	OILITE 3/8 X 1/2 X 1/4 FLANGED	2
3	379-0014	E-RING, 3/8 SHAFT	1
4	377-0081	WASHER, NYLON 3/8 ID X 3/4 OD	1
5	377-5481	CURVED SPRING WASHER	1
6	381-0123	3/32 X 3/4" ROLL PIN	2
7	360-1939	PAPER TRAY LEVER	1
8	360-1951	SPRING MOUNT PAPER FEED	1
9	378-0001	HEX NUT, 4-40	2
10	342-0095	EXTENSION SPRING	1
11	342-0094	LOCK LEVER SPRING	1
12	395-1425	MOTOR & POWER SUPPLY COVER	1
13	373-0127	SCREW, PPH 6-32 X 3/16"	5
14	360-2648	FEED TRAY EXTENSION	1
15	310-0346	14" FORM BEAM HARNESS	1
16	395-1415	HOPPER TENSION ASSEMBLY	1
17	N/A		
18	373-5868	SCREW, PPH 6-32X1/4" EXT. WASHER	2
19	365-0179	TIMING BELT DOUBLE SIDED	1
20	365-0233	DRIVE PULLEY, 11T L 3/8 BORE	1
21	365-0232	TIMING PULLEY, 13T L .50 BORE	2
22	395-0764	IDLER TIMING PULLEY, 13T L	2
23	334-0371	BRACKET, IDLER ADJUST	1
24	377-0073	WASHER, 1/4"	1
25	374-5831	SCREW, SHC 1/4-20 X 3/4"	1
26	374-5832	SCREW, SHC 1/4-20 X 1.0"	1
27	395-1416	FOLD PLATE DRIVE PCB	1
28	381-0179	PCB SNAP IN MOUNT 3/16th HOLE	4
29	319-0309	POWER SUPPLY 24 VDC	1
30	395-1423	REAR COVER	1
31	395-1424	FRONT COVER (not shown)	1
32	373-0133	SCREW, PPH#8-32 x 3/8"	14
33	305-0068	ACOUSTICAL FOAM, 2054 COVER	2
34	381-0178	PCB SNAP IN MOUNT 3/16th HOLE	4
35	378-6549	1/4-20 KEP NUT	1
36	315-0048	.625 DIA. HOLE PLUG	1

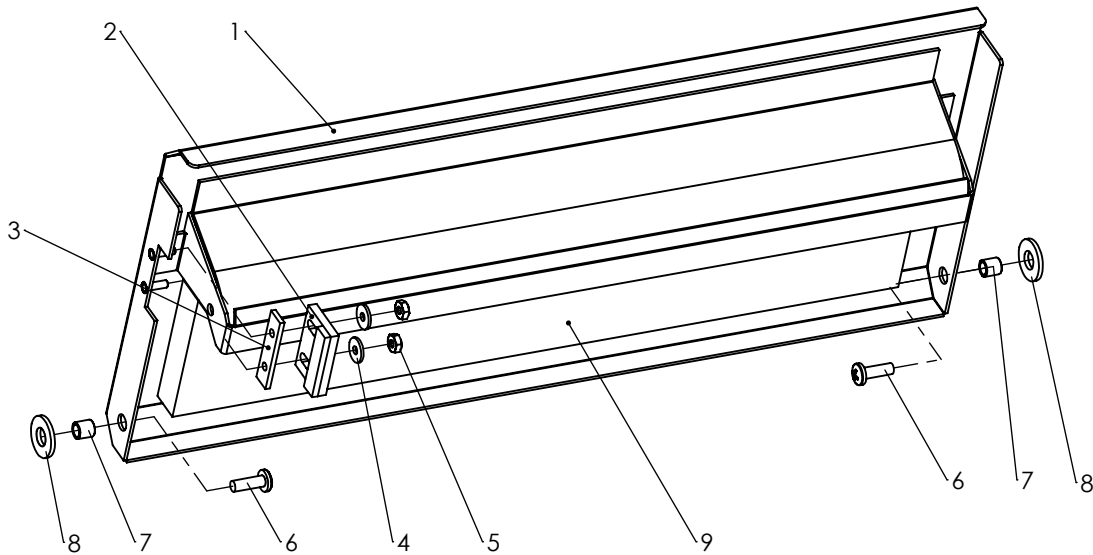
# BASE COMPONENTS



## BASE COMPONENTS

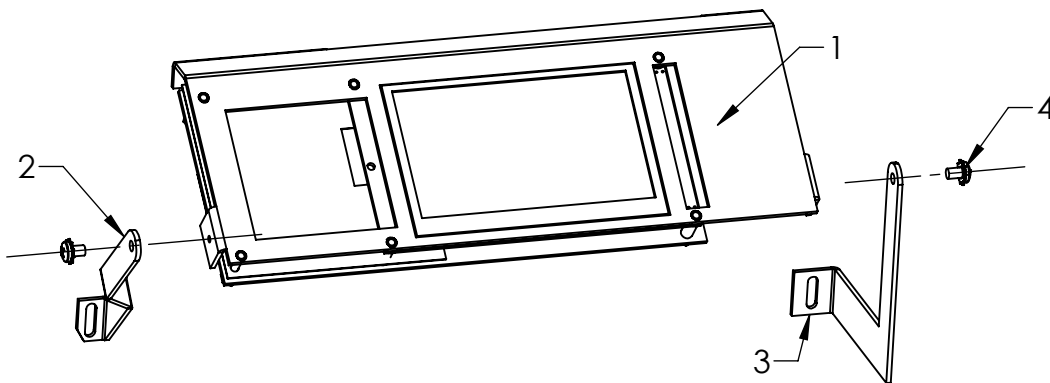
NO.	PART NO.	DESCRIPTION	QTY.
1	372-6544	NON-SWIVEL ADJ. GLIDE	4
2	378-6549	KEPNUT 1/4-20	8
3	311-0087	ROCKER SWITCH DPST	1
4	N/A		
5	N/A		
6	N/A		
7	N/A		
8	373-0088	SCREW, PPH 8-32 X .25, W/EXT STAR	18
9	317-0029	CIRCUIT BREAKER 3.5A	1
10	319-0096	RECEPTACLE, POWER	1
11	375-6625	SCREW PFH 6-32X1/2"	2
12	320-0069	BACK PLATE GUIDE	1
13	320-0070	FRONT PLATE GUIDE	1
14	373-0120	SCREW, PPH 8-32 X 1/2"	4
15	332-0169	LOCK PIN, FOLD PLATE	2
16	332-0150	PIN, FOLD PLATE SLOT	6
17	378-0132	KEPNUT 1/4-28	8
18	375-0044	SHOULDER SCREW	2
19	360-2733	IDLER TENSIONER BRACKET	1
20	334-0375	DIVERTER	1
21	360-1966	DIVERTER END PLATE	2
22	373-0131	SCREW, PPH #4-40X1/4"	4
23	342-0077	EXTENS.SPRING .188 O.D.	1
24	334-0376	SINGULATOR SHAFT	1
25	360-1930	SINGULATOR MOUNT	1
26	334-0377	SINGULATOR BLOCK	1
27	352-0008	SINGULATOR PAD	1
28	373-0119	SCREW, FLAT HD #4-40X3/16"	2
29	373-0126	SCREW, PPH #4-40X3/16"	2
30	342-0108	SINGULATOR SPRING	1

## TOP COVER ASSEMBLY



NO.	PART NO.	DESCRIPTION	QTY.
	395-1432	TOP COVER ASSY.	1
1	360-2752	TOP COVER	1
2	319-0159	MAGNET, ACTUATOR	1
3	360-1946	SPACER, MAGNET SWITCH	1
4	377-2811	#6 WASHER	2
5	378-0001	4-40 HEX NUT	2
6	373-0120	PH PHILLIPS 8-32 X 1/2"	2
7	371-0097	3/16X1/4X1/4 SLEEVE BUSHING	2
8	377-0074	.250 X .500 X .062 NYLON WSHR	2
9	305-0069	ACOUSTICAL FOAM	1

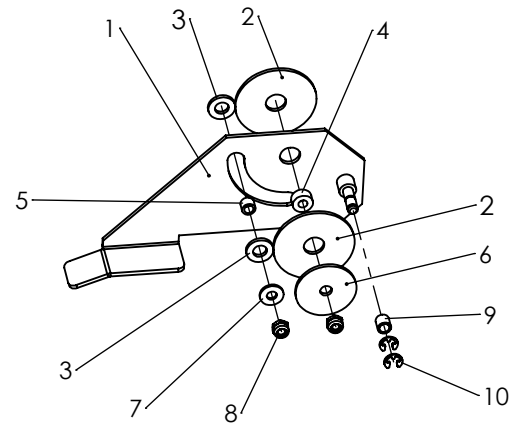
## TOUCHSCREEN COMPONENTS



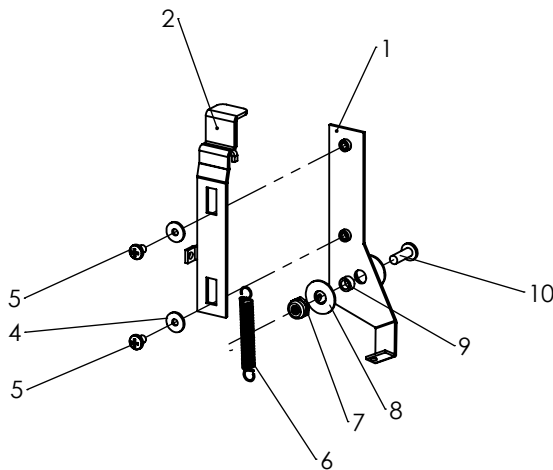
NO.	PART NO.	DESCRIPTION	QTY.
1	395-1417 (120 VAC)	TOUCH SCREEN ASSEMBLY	1
	395-1418 (240 VAC)		1
2	360-3152	LEFT BRACE	1
3	360-3151	RIGHT BRACE	1
4	373-5868	6-32 PPH SCREW	2

## LOCK LEVER COMPONENTS

NO.	PART NO.	DESCRIPTION	QTY.
1	360-1938	LOCK LEVER, FEED TRAY	1
2	377-0005	WASHER SPACER	2
3	377-0074	WASHER, NYLON 1/4 ID X 1/2 OD	2
4	381-0112	#8 BRASS SPACER 3/16"	1
5	381-0125	#8 X 3/16 NYLON SPACER	1
6	377-5290	FENDER WASHER	1
7	377-0001	WASHER, #8	1
8	378-0115	LOCK NUT, 8-32	2
9	371-0097	3/16X1/4X1/4 SLEEVE BUSHING	1
10	379-0009	RETAINING RING, 3/16 I.D.	2

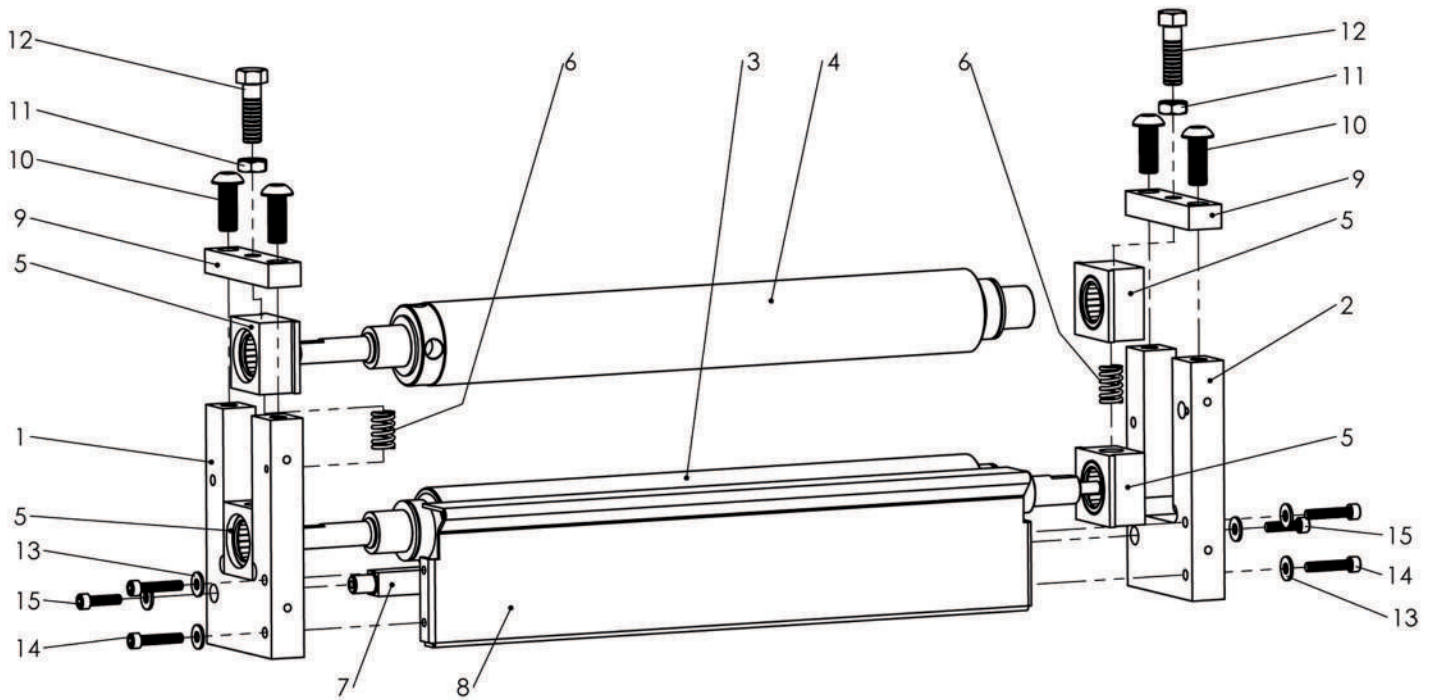


## HOPPER TENSION COMPONENTS



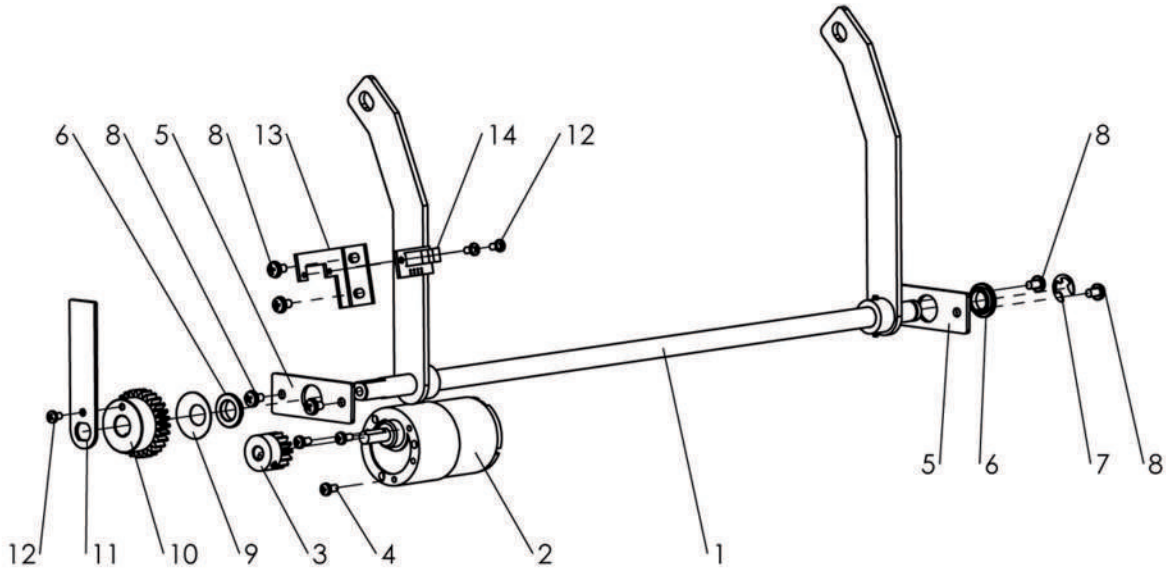
NO.	PART NO.	DESCRIPTION	QTY.
*	395-1415	HOPPER TENSION ASSEMBLY	1
1	360-3119	HOPPER TENSION ADJUST BAR	1
2	360-3118	HANDLE, HOPPER TENSION	1
3	N/A		
4	377-2811	WASHER, #6	2
5	373-0127	SCREW, PPH 6-32 X 3/16"	1
6	342-0108	EXT. SPRING .24 OD X 1.13 L	1
7	378-0115	LOCK NUT	1
8	377-6639	WASHER, NYLON	2
9	381-0117	SPACER	1
10	373-0120	SCREW, 8-32 X 1/2	1

# SEAL ROLLER COMPONENTS



NO.	PART NO.	DESCRIPTION	QTY.
1	334-0425	SIDE PLATE, SEALER FRONT	1
2	334-0426	SIDE PLATE, SEALER REAR	1
3	395-1244	LOWER SEALER ROLLER	1
4	395-1245	UPPER SEALER ROLLER	1
5	395-1246	BEARING BLOCK	4
6	342-0063	COMPRESSION SPRING,0.480 X .75	2
7	332-0180	CROSSBAR	1
8	360-2729	CROSS MEMBER, SEALER	1
9	334-0357	BRACKET SIDE, FRAME CAP	2
10	375-0148	SCREW, BHSC,3/8-24 X 1.0"	4
11	378-0118	3/8-40 HEX JAM NUT	2
12	375-0103	3/8-40 X 1.25" HEX HD BOLT	2
13	377-5298	WASHER, #10 FLAT	6
14	374-0096	SCREW, SHC 10-32 X 1.0"	4
15	375-0106	SCREW, SHC 10-32 X 3/4"	2

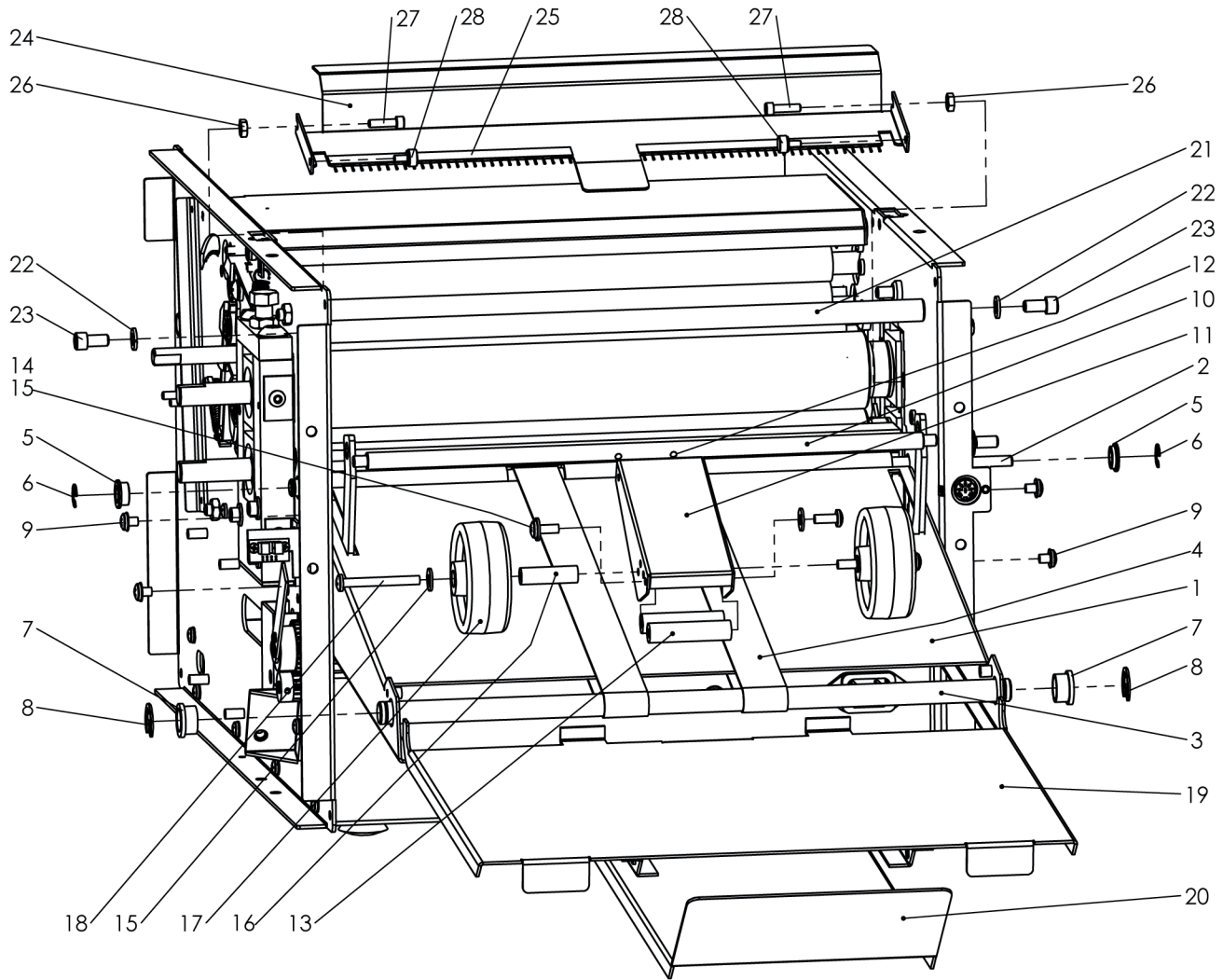
# AUTOSTACKER COMPONENTS



NO.	PART NO.	DESCRIPTION	QTY.
1	395-1188	AUTO STACKER ARM ASSY	1
2	395-1189	GEAR MOTOR w/ HARNESS, 24V DC	1
3	368-0078	SPUR GEAR, 14T 24P	1
4	373-0146	SCREW, M3 X 0.5 X 6mm	3
5	360-2480	BEARING RETAINER	2
6	371-0013	OILITE 3/8 X 1/2 X 1/4 FLANGED	2
7	379-0014	E-RING, 3/8 SHAFT	1
8	373-5868	SCREW, PPH 6-32X1/4" EXT. WASHER	6
9	342-0102	SPRING WASHER, .375 ID X .87 OD	1
10	368-0077	SPUR GEAR, 28T 24P	1
11	360-2481	SENSOR PADDLE	1
12	373-0126	SCREW, PPH 4-40 X 3/16"	3
13	360-2484	SENSOR BRACKET, STACKER ARM	1
14	390-1964	STACKER WHEEL BOARD HARNESS (1)	1
		(1) harness not shown	



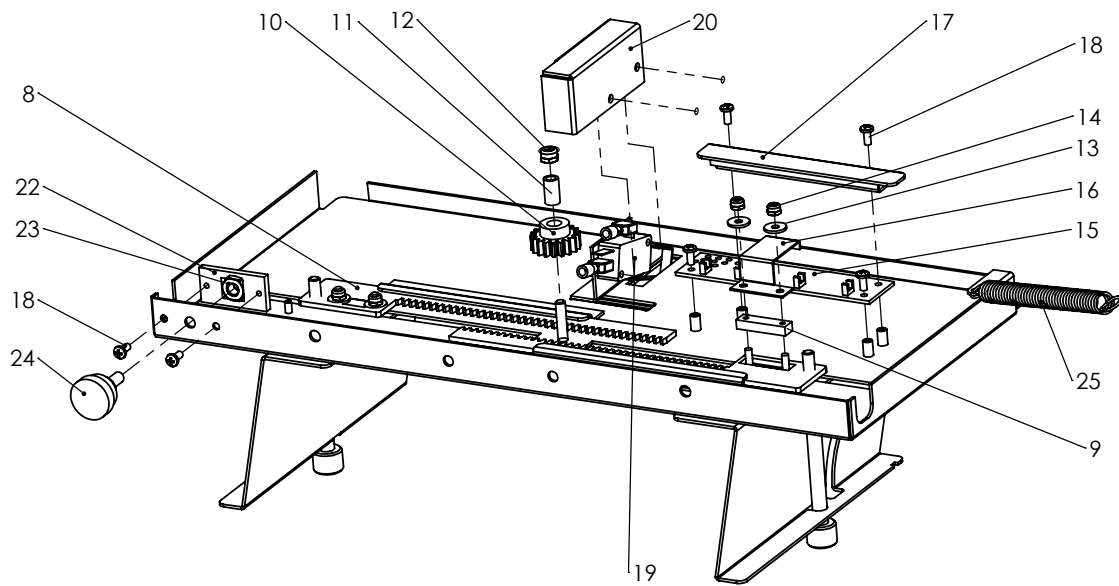
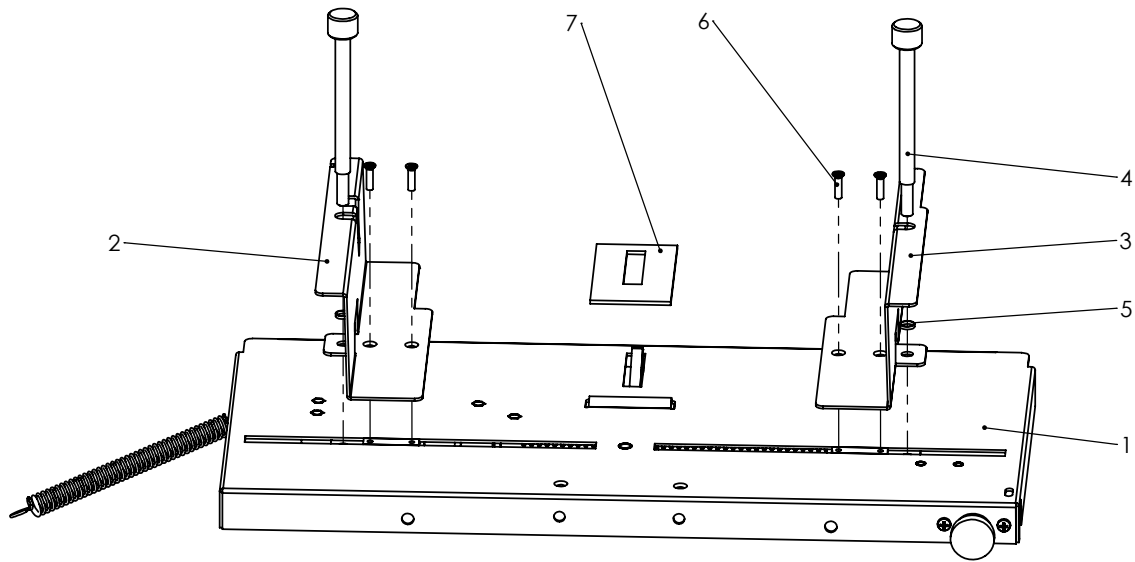
# CONVEYOR COMPONENTS



## CONVEYOR COMPONENTS

NO.	PART NO.	DESCRIPTION	QTY.
1	395-1295	CONVEYOR DECK ASSY	1
2	331-0218	CONVEYOR DRIVE SHAFT	1
3	331-0169	CONVEYOR SHAFT	1
4	369-0028	STACKER BELT	2
5	371-0013	OILITE 3/8 X 1/2 X 1/4 FLANGED	2
6	379-0014	E-RING, 3/8 SHAFT	2
7	371-0001	OILITE, FLANGE 1/2 X 5/8 X 3/8	2
8	379-0007	RETAINING RING, 1/2"	2
9	373-0124	SCREW, PPH #10-32X1/4" EXT.WASHER	4
10	332-0171	SHAFT, STACKER WHEEL	1
11	360-2642	STACKER WHEELS ARM	1
12	373-0129	SCREW, PPH 8-32 X 3/16"	2
13	332-0152	WEIGHT, STACKER ARM	2
14	373-0016	SCREW PPH 10-32 x 1/2"	2
15	377-5298	WASHER, #10 FLAT	4
16	381-0111	NYLON SPACER, #10 X 1.25"	2
17	320-0061	STACKER WHEEL	2
18	373-0130	SCREW, PPH 10-32 X 1 3/4"	2
19	395-1191	CONVEYOR TRAY	1
20	395-1192	CONVEYOR TRAY EXTENSION	1
21	332-0181	FRAME BRACE, .50" DIA.	1
22	377-2611	WASHER 1/4" SPLIT	2
23	374-0040	SCREW 1/4-20 X 1/2	2
24	360-2731	EXIT CHUTE	1
25	316-0014	STATIC BRUSH	2
26	378-0113	KEPNUT #8-32	2
27	374-0104	SCREW, SHC 8-32 X 5/8"	2
28	395-1177	THUMB SCREW, 8-32	2

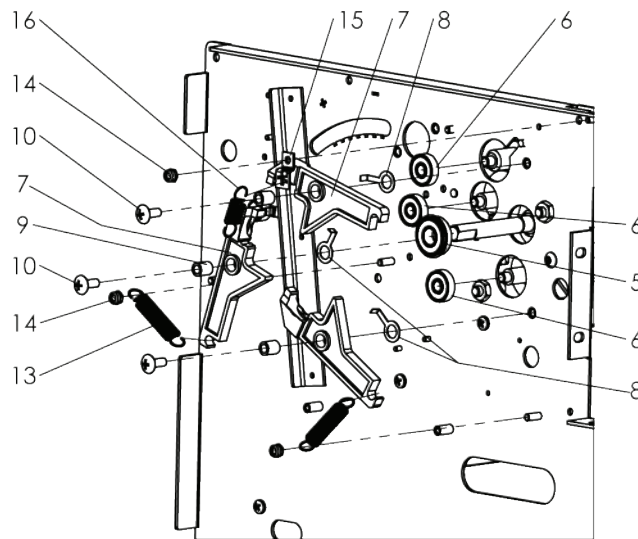
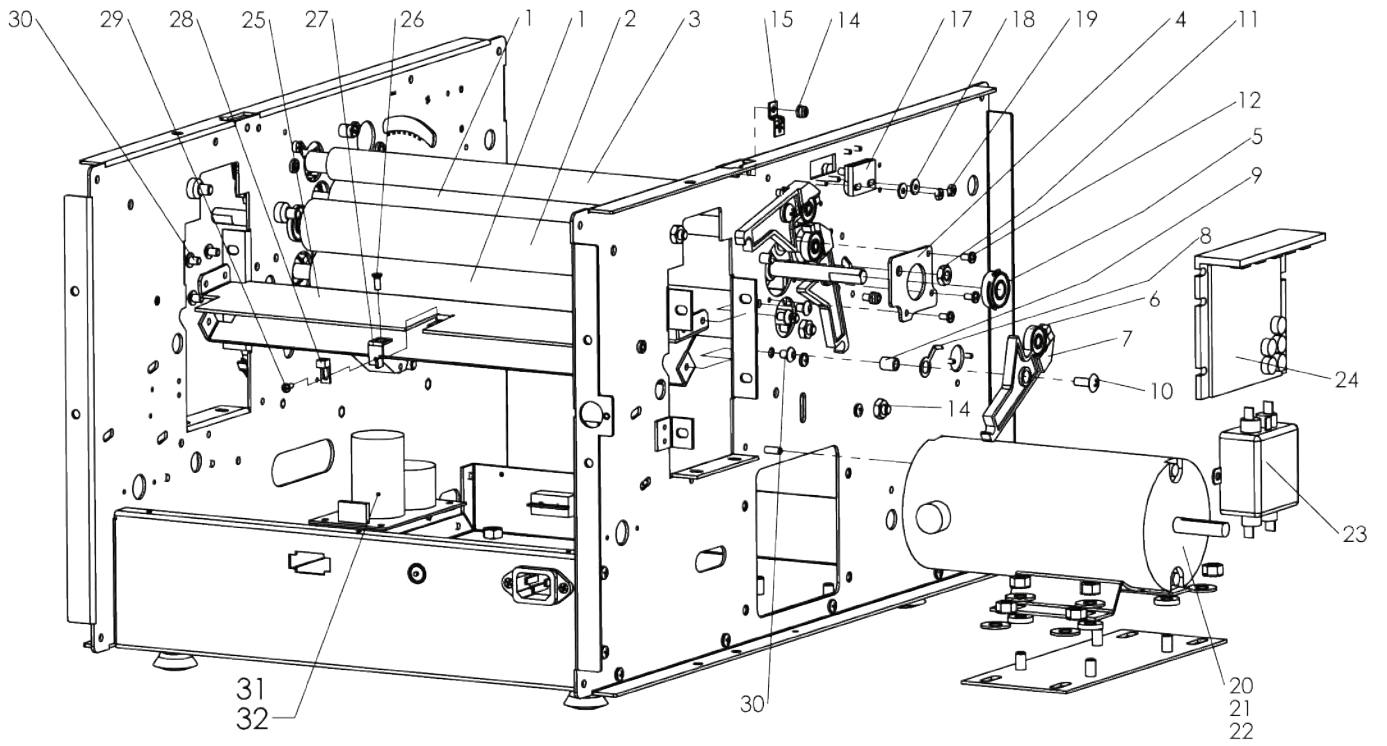
# FEED TABLE COMPONENTS



NO.	PART #	DESCRIPTION	QTY.
1	360-2649	FEED PLATE	1
2	395-1196	LEFT SIDE, ADJUSTMENT PLATE	1
3	395-1197	RIGHT SIDE, ADJUSTMENT PLATE	1
4	375-0128	CLAMP SCREW	2
5	381-0128	WASHER, 1/4 x #10 x 0.05" SPACER	2
6	373-0122	SCREW FL HD, 4-40 X 7/16"	4
7	352-0013	PAD FEED TRAY	1
8	360-1935	CLAMP PLATE	2
9	320-0064	SPACER BLOCK	2
10	368-0068	SIDE GUIDE GEAR	1
11	381-0109	#8 NYLON SPACER 1/2IN	1
12	378-0115	LOCK NUT, 8-32	1
13	377-2811	WASHER, #6	4

NO.	PART #	DESCRIPTION	QTY.
14	378-0122	LOCK NUT, 4-40	4
15	390-1813	PAPER WIDTH SENSOR ASSEMBLY	1
16	360-2172	FLAG, WIDTH SENSOR	1
17	360-2159	COVER, PAPER WIDTH SENSOR	1
18	373-0131	SCREW, PPH #4-40 X 1/4 "	6
19	311-0117	LAST FORM SWITCH	1
20	360-2485	SWITCH COVER, LAST FORM	1
21	373-0098	SCREW, PPH #4-40 X 5/8"	2
22	360-1936	NUT RETAINER	1
23	378-0124	LOCK NUT, 10-32	1
24	381-0119	THUMBSCREW, 10-32	1
25	342-0096	EXT. SPRING, SKEW ADJUST	1

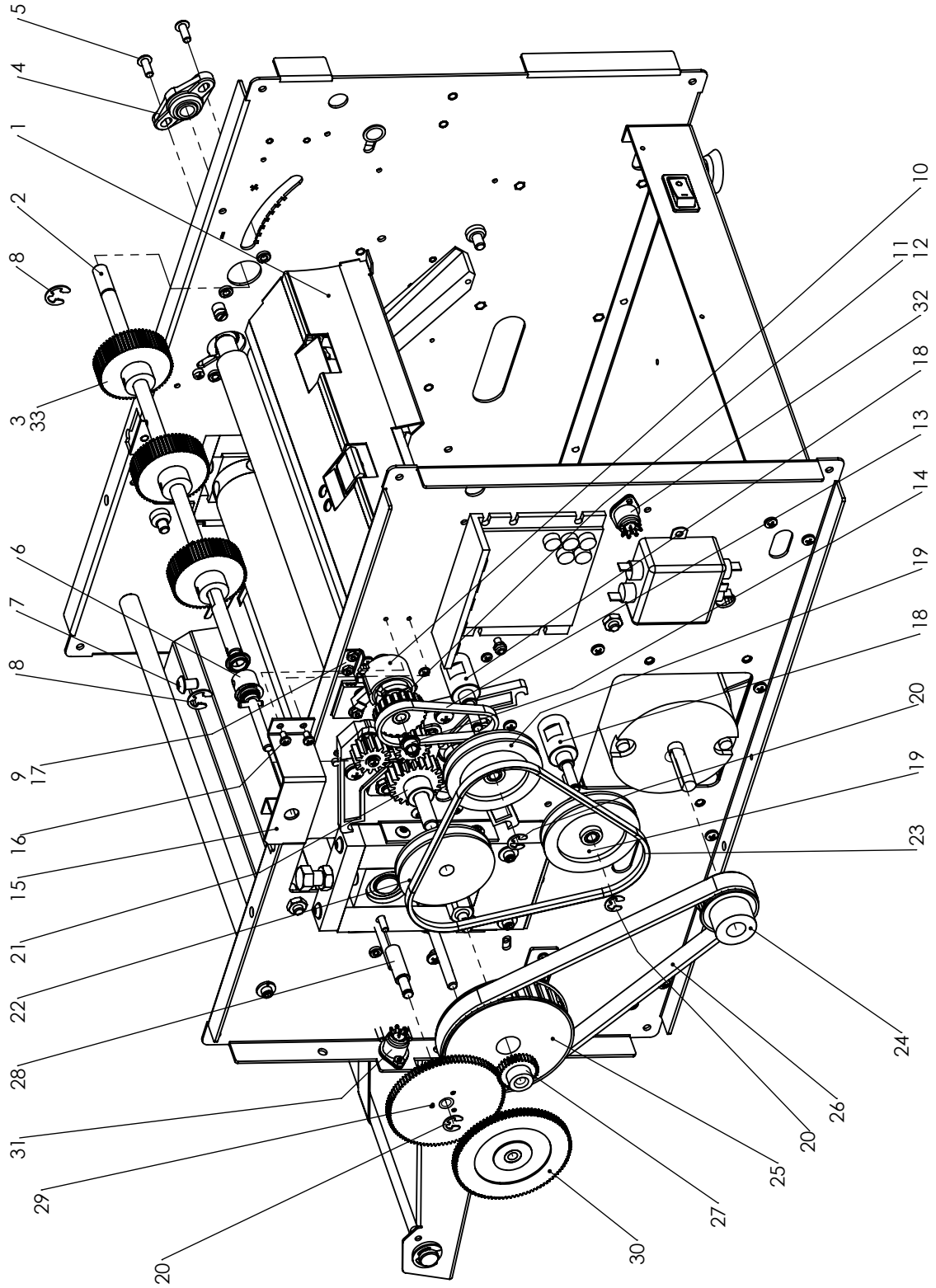
# FOLD ROLLERS & MOTOR COMPONENTS



## FOLD ROLLERS & MOTOR COMPONENTS

NO.	PART NO.	DESCRIPTION	QTY.
1	350-0096	COMMON ROLLER	2
2	350-0108	DRIVE ROLLER	1
3	350-0098	TOP ROLLER	1
4	360-2753	BEARING PLATE	1
5	370-0025	ROLLER BEARING	2
6	370-0030	FOLDER ROLLER BEARING	6
7	320-0063	LEVER, MOLDED PLASTIC	6
8	360-1988	LEVER CLIP	6
9	381-0118	SPACER, 10X3/8	6
10	373-0121	SCREW, 10-32X1/2", TRUSS HD	6
11	378-0132	KEPNUT 1/4-28	1
12	373-5868	SCREW, PPH 6-32 X 1/4", EXT STAR	3
13	342-0093	FOLDER ROLLER SPRING	4
14	378-0115	LOCK NUT, 8-32	6
15	360-2077	SPRING BRACKET	2
16	342-0098	TOP ROLLER SPRING	2
17	319-0213	PROXIMITY SENSOR	1
18	377-2811	WASHER, #6	2
19	378-0001	HEX NUT, 4-40	2
20	313-0072	MOTOR 90 VDC	1
21	360-3150	MOTOR PLATE	1
22	378-6549	1/4-20 KEP NUT	8
23	319-0078	LINE FILTER	1
24	395-1375	MOTOR CONTROL (120 VOLT)	1
25	395-1376	MOTOR CONTROL (240 VOLT)	1
26	360-2728	CROSS MEMBER, FOLDER	1
27	375-6625	SCREW, PFH 6-32X1/2"	1
28	360-1700	SENSOR BRACKET	1
29	310-0134	PHOTO EYE HARNESS	1
30	373-0131	SCREW, PPH 4-40X1/4"	1
31	375-5699	SCREW, SBH 10-32X3/8"	6
32	381-0180	SPACER .281x.625x.125 THK	4
33	332-0141	JAM CLEARING TOOL	1

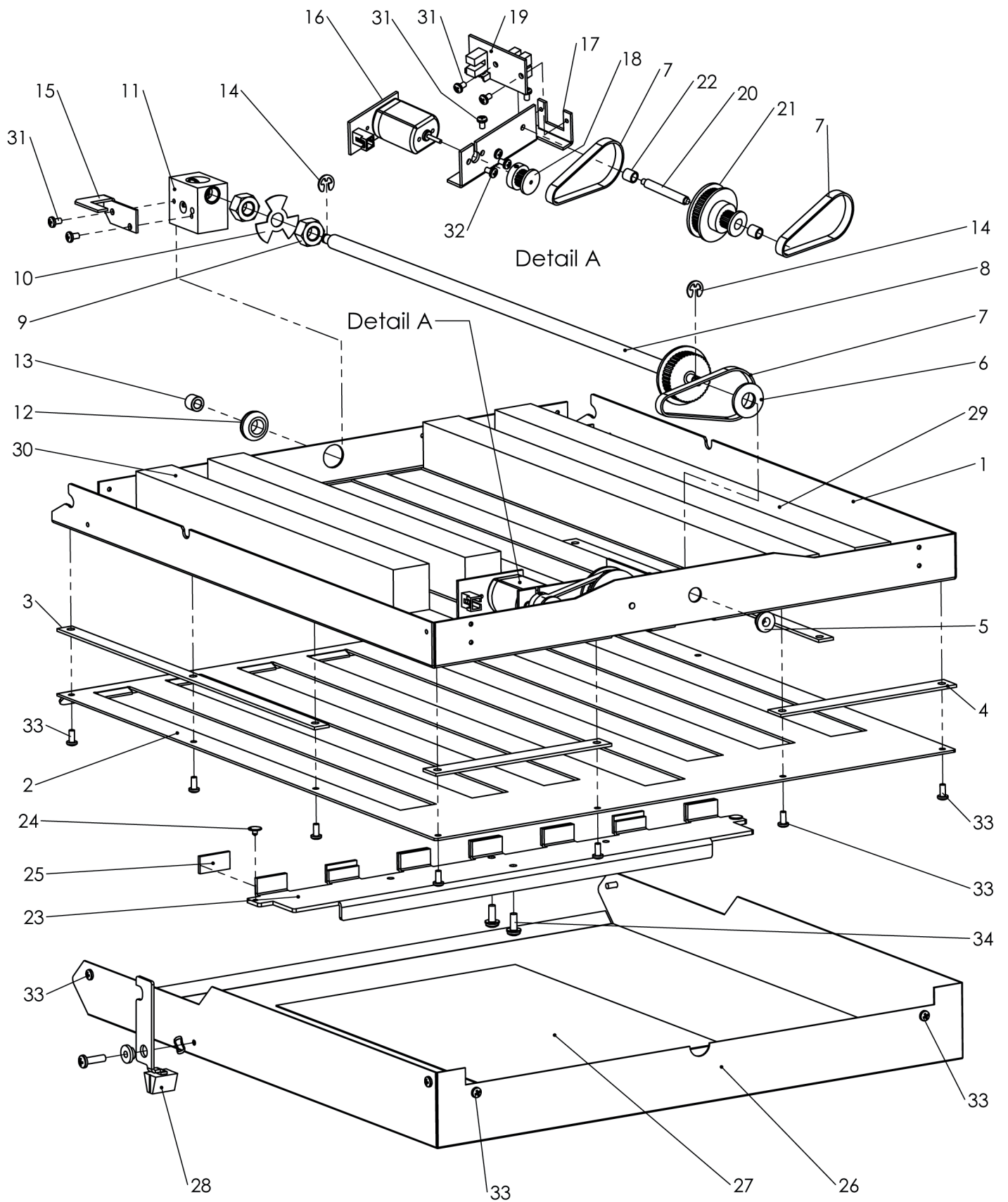
# DRIVE COMPONENTS



## DRIVE COMPONENTS

NO.	PART NO.	DESCRIPTION	QTY.
1	360-1959	FEED RAMP	1
2	331-0212	FEED SHAFT, REMOVABLE	1
3	350-0099	FOLDER FEED WHEEL	3
4	371-0101	FLANGE BEARING, 0.375 ID	1
5	375-6538	SCREW, BH 10-32 X1/2"	2
6	395-1193	CLUTCH STUB SHAFT ASSEMBLY	1
7	375-0014	SCREW, BH #8-32 X 3/8"	1
8	379-0014	E-RING, 3/8 SHAFT	2
9	360-1934	CLUTCH BRACKET	1
10	319-0244	FEED CLUTCH, 12 VDC	1
11	365-0202	CLUTCH 21 GRV. TIMING PULLEY	1
12	371-0098	SLEEVE BUSHING 1/4 X 7/16 X .300	1
13	365-0209	CLUTCH BELT	1
14	371-0014	OILITE 1/4 X 3/8 X 1/4 FLANGED	1
15	360-2656	CLUTCH BRACKET	1
16	373-5868	SCREW, PPH 6-32 x 1/4" EXT.	3
17	378-0001	NUT, #4-40 HEX	2
18	332-0146	REDUCER STUB SHAFT	2
19	395-1194	FEED REDUCER PULLEY ASSEMBLY	2
20	379-0033	E-RING, 1/4 SHAFT	3
21	330-5730	COLLAR 3/8	1
22	365-0205	DRIVE PULLEY	1
23	366-0006	V BELT 2L190	1
24	365-5416	TIMING PULLEY, 12T L .50 BORE	1
25	365-0259	TIMING PULLEY, 24LO50	1
26	365-0258	TIMING BELT, 203L050	1
27	368-0089	SPUR GEAR, 32T 32P .25 BORE	1
28	330-0097	IDLER, COMBO GEAR	1
29	395-1251	GEAR COMBO, 96T-32T	1
30	368-0069	CONVEYOR GEAR	1
31	310-0287	FOLD PLATE CABLE, UPPER (1)	1
32	310-0288	FOLD PLATE CABLE, LOWER (1)	1
33	376-2805	SETSCREW 8-32 x 3/16"	3
		(1) harness not shown	

# UPPER FOLD TABLE

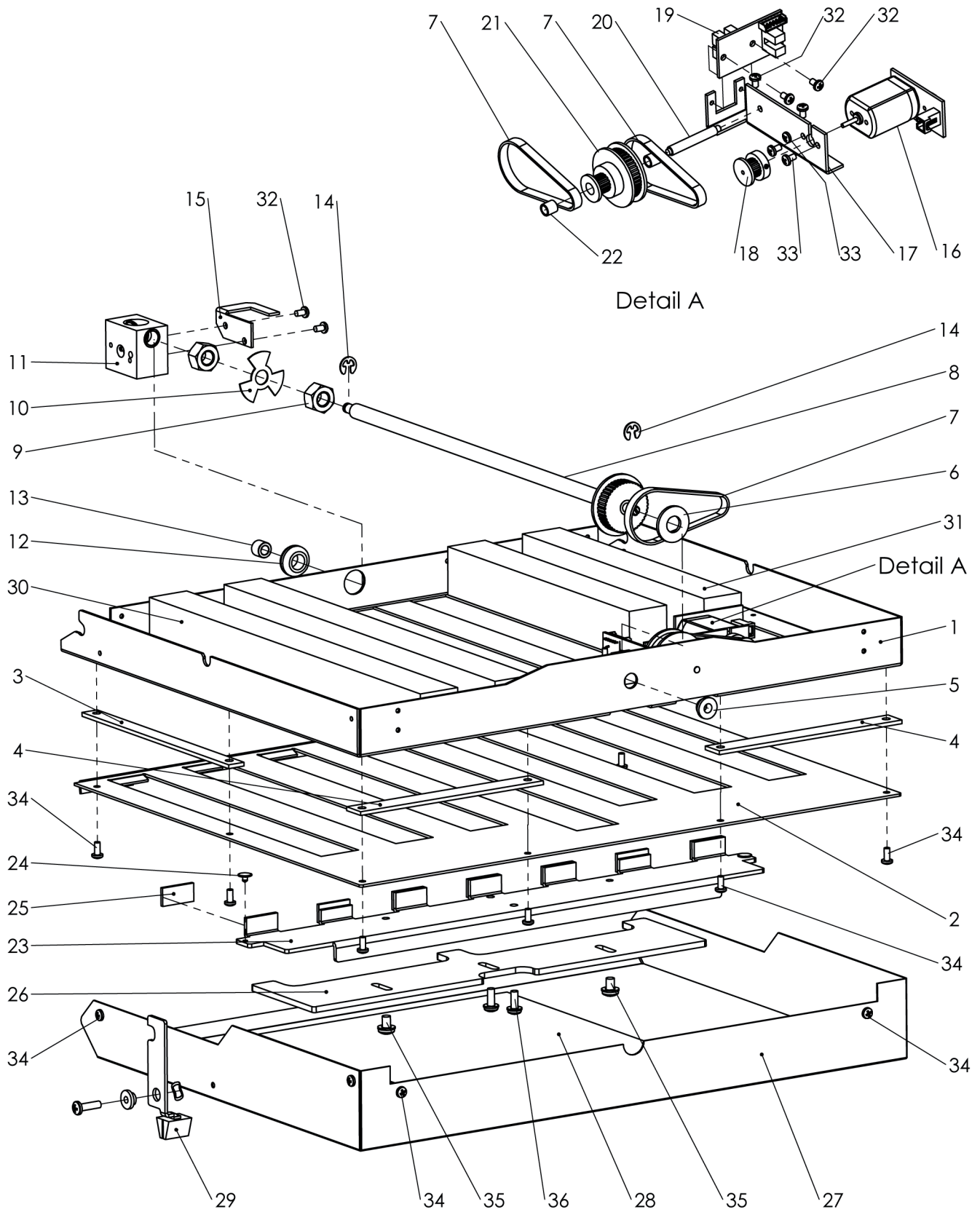




## UPPER FOLD TABLE

NO.	PART NO.	DESCRIPTION	QTY.
-	395-1210	UPPER FOLD TABLE ASSEMBLY	
1	360-2469	BASE, UPPER FOLD PLATE	1
2	360-2470	TOP SHEET, UPPER FOLD PLATE	1
3	360-1969	LONG SPACER, FOLD PLATE	2
4	360-1961	REAR SPACER, FOLD PLATE	2
5	371-0092	3/16X5/16X3/16 FLANGED BUSHING	1
6	377-0072	3/8 NYLON WASHER	1
7	365-0210	TIMING BELT, 70 GROOVE MXL	2
8	395-1204	UPPER LEAD SCREW ASSY	1
9	378-0133	M8 X 1.25MM HEX NUT	2
10	360-2473	3 FLAG, FOLD PLATE	1
11	395-1205	FOLLOWER BLOCK, FOLD PLATE	1
12	352-0014	GROMMET, FLANGED RUBBER	1
13	371-0093	3/16 X 5/16 X 1/4 SLEEVE BUSHING	1
14	379-0009	RETAINING RING, 3/16 I.D.	2
15	360-2475	HOME SENSOR ACTUATOR-UPPER	1
16	395-1206	MOTOR ASSY, 24VDC FOLD PLATE	1
17	360-2461	MOTOR BRACKET, UPP. FOLD PLATE	1
18	365-0208	PULLEY, 16 MXL	1
19	490-0035	ENCODER BOARD	1
20	332-0151	SHAFT, REDUCER, FOLD PLATE	1
21	365-0207	PULLEY, 42/16 MXL	1
22	371-0097	3/16X1/4X1/4 SLEEVE BUSHING	2
23	360-2464	PAPER STOP, FOLD PLATE	1
24	381-0114	NYLON RIVET	2
25	352-0016	PAD, PAPER STOP	7
26	360-2472	TOP COVER, UPPER FOLD PLATE	1
27	307-0041	SOUND FOIL, LOWER FOLD PLATE	2
28	390-1809	FOLD PLATE LOCK ASSY	1
29	305-0050	FOAM, 0.9" X 1" X 14"	2
30	305-0051	FOAM, 0.9" X 1" X 10"	2
31	373-0126	SCREW, PPH 4-40 X 3/16"	6
32	373-0116	SCREW, PPH 4 X 3/16" SELF TAPPING	3
33	373-0131	SCREW, PPH 4-40X1/4"	22
34	373-5893	SCREW, PPH 6-32 X 3/8"	2
NS	360-2471	PAN, UPPER FOLD PLATE	1
NS	390-1805	FD382 FOLD PLATE HARNESS	1
NS	315-0047	3/16" WIRE CLAMP	1
NS	377-5366	WASHER, #6 INT. STAR	1
NS	373-0014	SCREW, PPH 4-40 x 1/4 LG.	1

# LOWER FOLD TABLE



## LOWER FOLD TABLE

NO.	PART NO.	DESCRIPTION	QTY.
-	395-1211	LOWER FOLD TABLE ASSEMBLY	
1	360-2465	BASE, LOWER FOLD PLATE	1
2	360-2466	TOP SHEET, LOWER FOLD PLATE	1
3	360-1967	SHORT SPACER, LOWER PLATE	2
4	360-2429	REAR SPACER, FOLD PLATE (14 GA.)	2
5	371-0092	3/16X5/16X3/16 FLANGED BUSHING	1
6	377-0072	3/8 NYLON WASHER	1
7	365-0210	TIMING BELT, 70 GROOVE MXL	2
8	395-1207	LOWER LEAD SCREW ASSY 382	1
9	378-0133	M8 X 1.25MM HEX NUT	2
10	360-2473	3 FLAG, FOLD PLATE	1
11	395-1205	FOLLOWER BLOCK ASSY, FOLD PLATE	1
12	352-0014	GROMMET, FLANGED RUBBER	1
13	371-0093	3/16 X 5/16 X 1/4 SLEEVE BUSHING	1
14	379-0009	RETAINING RING, 3/16 I.D.	2
15	360-2635	HOME SENSOR ACTUATOR-LOWER	1
16	395-1206	MOTOR ASSY, 24VDC FOLD PLATE	1
17	360-2460	MOTOR BRACKET, 382 LOW. FOLD PLATE	1
18	365-0208	PULLEY, 16 MXL	1
19	490-0035	ENCODER BOARD	1
20	332-0151	SHAFT, REDUCER, FOLD PLATE	1
21	365-0207	PULLEY, 42/16 MXL	1
22	371-0097	3/16X1/4X1/4 SLEEVE BUSHING	2
23	360-2464	PAPER STOP, FOLD PLATE	1
24	381-0114	NYLON RIVET	2
25	352-0016	PAD, PAPER STOP	7
26	360-2463	DIVERTER ACTUATOR	1
27	360-2468	TOP COVER, LOWER FOLD PLATE	1
28	307-0041	SOUND FOIL, LOWER FOLD PLATE	2
29	390-1809	FOLD PLATE LOCK ASSY	1
30	305-0046	FOAM, 0.9" X 1" X 9.7"	2
31	305-0048	FOAM, 0.9" X 1" X 6.5"	2
32	373-0126	SCREW, PPH 4-40 X 3/16"	6
33	373-0116	SCREW, PPH 4 X 3/16" SELF TAPPING	3
34	373-0131	SCREW, PPH 4-40X1/4"	20
35	373-0088	SCREW, PPH 8-32X.25	2
36	373-5893	SCREW, PPH 6-32 X 3/8"	2
NS	390-1805	FD382 FOLD PLATE HARNESS	1
NS	360-2467	PAN, LOWER FOLD PLATE	1
NS	315-0047	3/16" WIRE CLAMP	1
NS	377-5366	WASHER, #6 INT. STAR	1
NS	373-0014	SCREW, PPH 4-40 x 1/4 LG.	1