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1. Safety



Carefully read the Safety Instructions Document (**DBCH-0512-0000-V000**) before operating your equipment.

2. General

The Squarefolder SFM7714 is designed as a stand-alone squarefolding device also compatible with a range of Booklet Maker systems.

With the addition of the Squarefolder SFM7714, SDD has expanded her product range.

The main goal of the Squarefolder SFM7714, further referred to as SFM, is squarefolding booklets for long run production with minimum operator intervention.

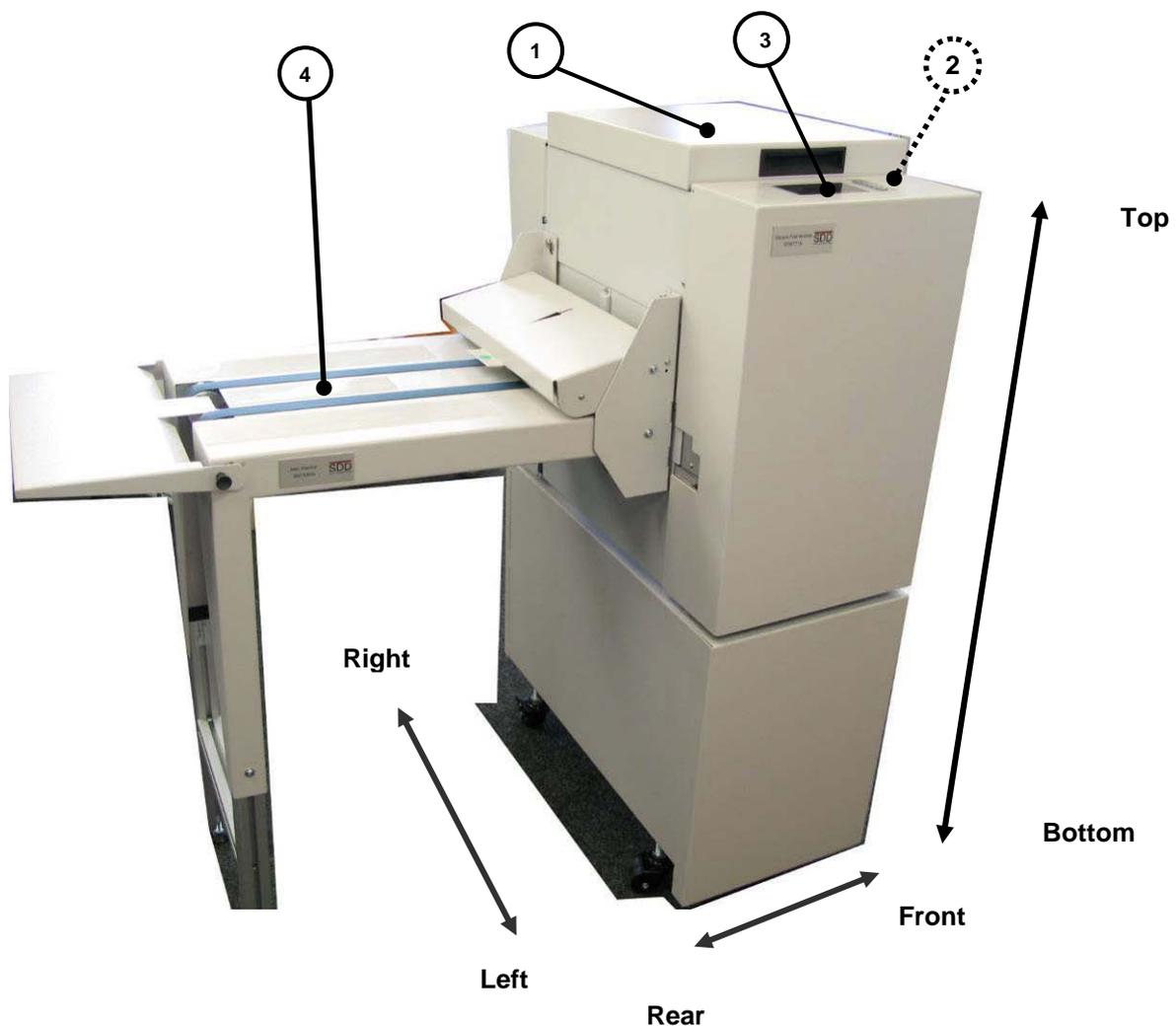
The Squarefolder SFM7714 is designed to fit to the Booklet Maker system as if they were one and is fully modular. This manual specifically includes operating instructions for the Squarefolder SFM7714 only.

3. Basic information

3.1 Exterior

See the picture below to get familiar with the components of the squarefolder.

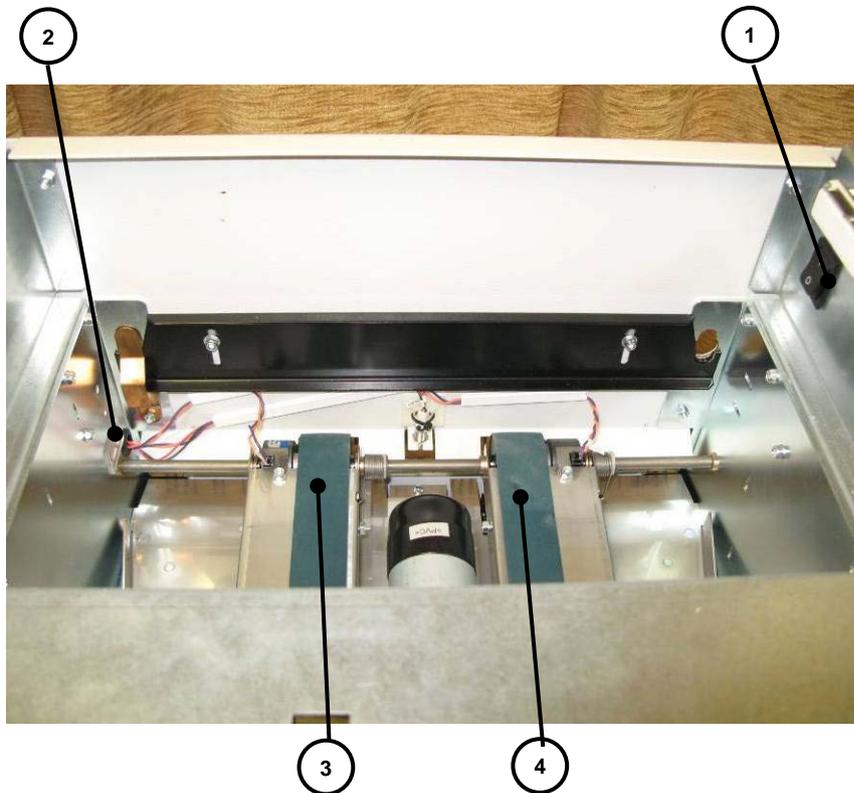
 All directions are seen from the paper flow direction.



No.	Description
1	Top Cover
2	Power Switch (inside)
3	User Interface (UI)
4	Beltstacker BST6900

3. Basic information (continued)

3.2 Interior



No.	Description
1	Power Switch
2	Counter
3	Upper Transport Belt Left
4	Upper Transport Belt Right

4. Operating the SFM

This section explains how to use the SFM during normal operation.

 The System Setup has to be set once.

4.1 System Setup

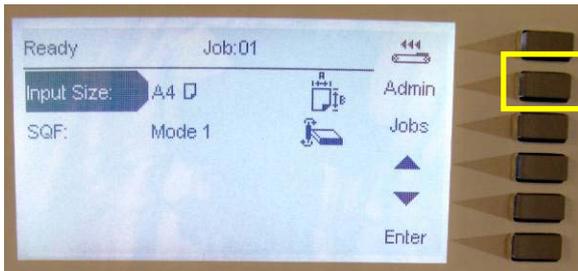


Fig. 1



Fig. 2

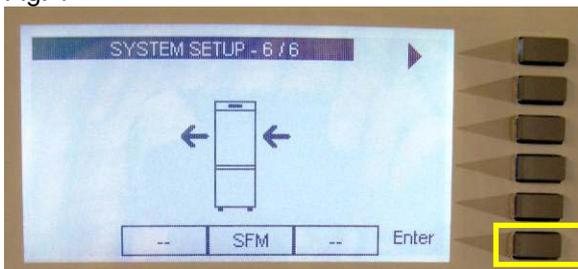


Fig. 3



Fig. 4

Step	Action	Remarks
1.	Open the Top cover of the SFM.	
2.	Turn on the SFM with the Power Switch	
3.	Close the Top cover of the SFM.	
4.	Enter 'Admin' menu	Press the 'Admin' button (Fig. 1)
5.	Enter 'System Setup' menu	Use the '▲ / ▼' buttons to select 'System Setup' and press the 'Enter' button. (Fig. 2)
6.	Select System Setup with or without SquareFold Module	Select the correct System Setup e.g. SFM (6 /6) (Fig. 3) Save and confirm with [Enter] ⚠ After saving the SFM will restart (Fig. 4).

4. Operating the SFM (continued)

4.2 Language

 The Language has to be set once.

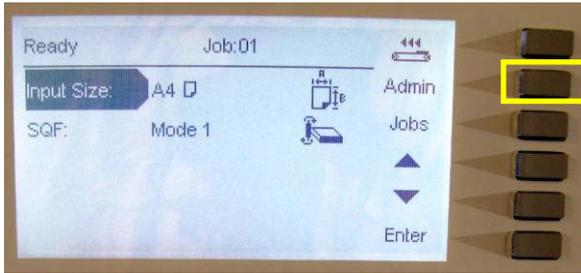


Fig. 1

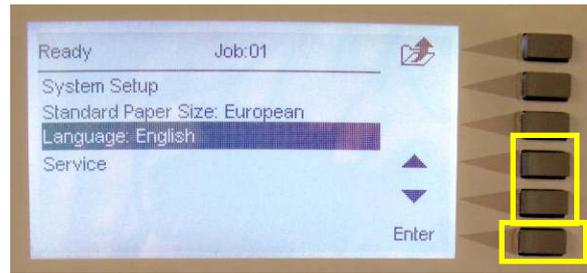


Fig. 2

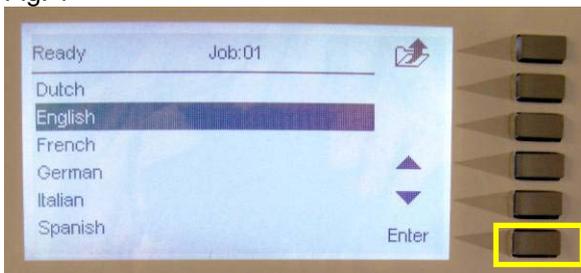


Fig. 3

Step	Action	Remarks
1.	Enter 'Admin' menu	Press the 'Admin' button (Fig. 1)
2.	Enter 'Language:' menu	Use the '▲ / ▼' buttons to select 'Language:' and press the 'Enter' button. (Fig. 2)
3.	Select Language	Use the '▲ / ▼' buttons to select the correct Language (Fig. 3). Save and confirm with [Enter]

4. Operating the SFM (continued)

4.3 Job Setup

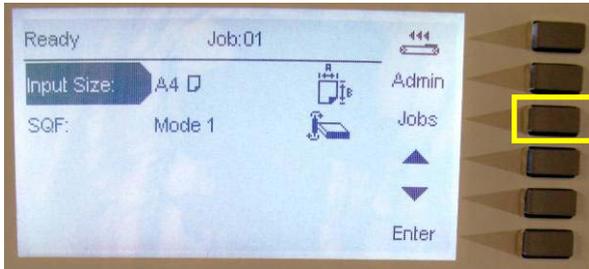


Fig. 1

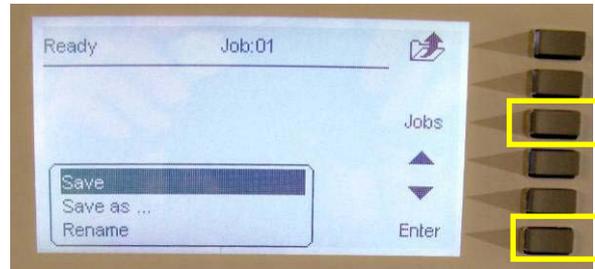


Fig. 2

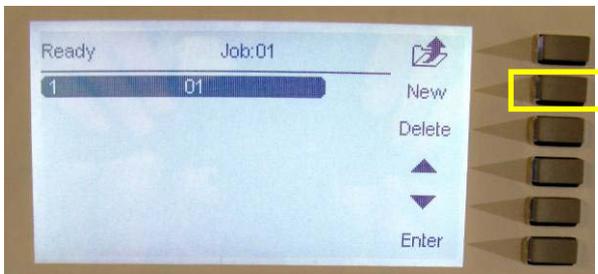


Fig. 3

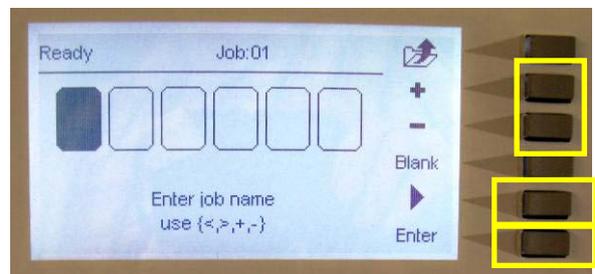


Fig. 4

Step	Action	Remarks
1.	Job Setup	Press the 'Jobs' button two times (Fig. 1 & 2).
2A.	Make a new Job	Press the 'New' button (Fig. 3).
2A.	Enter Job name	Use the '+ / -' and '▶' buttons (Fig. 4) to Enter the Job name and press the 'Enter' button. ⚠ A "Loading Job" signal appears for a few seconds.
2B.	Adjust a Job	Use the '▲ / ▼' buttons to select a Job and press the 'Enter' button to load or confirm. ⚠ A "Loading Job" signal appears for a few seconds.
3.	Adjust Mode	Use the '▲ / ▼' and the '+ / -' buttons to set the desired SQF settings for Mode, See Chapter: 4.5 Squarefold Mode
4.	Save Job	After adjusting press 'Jobs' (Fig. 1) and save the current Job or 'Rename' the adjusted Job by pressing the 'Enter' button (Fig. 2). ⚠ A "Saving Job" signal appears for a few seconds. ⚠ After Rename a Job, repeat step 2A 'Enter Job name'.

4. Operating the SFM (continued)

4.4 Paper Input Size Setup

The SFM UI software is based on the generic Booklet maker software. The option adjust paper size is available. Operating the SFM does not require setting the paper size.

4. Operating the SFM (continued)

4.5 SquareFold Mode

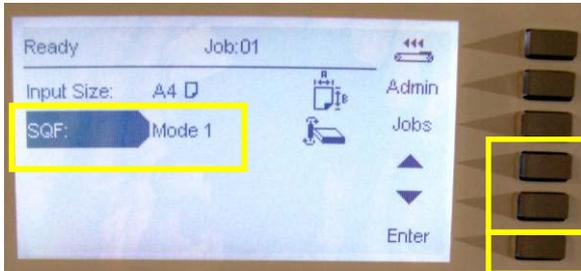


Fig. 1

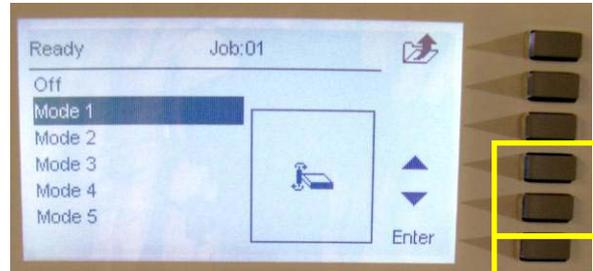


Fig. 2

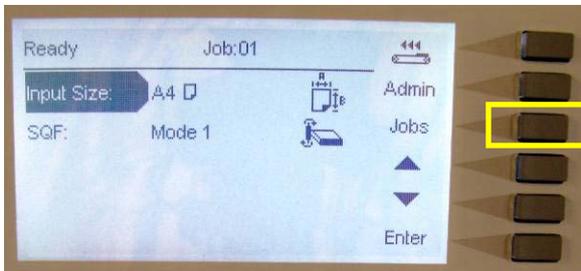


Fig. 3

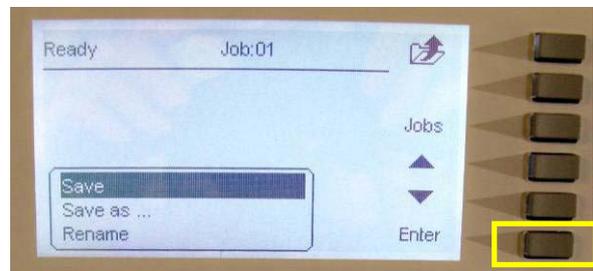


Fig. 4

Step	Action	Remarks
1.	Square Folding ON/OFF	Use the '▲ / ▼' buttons on the UI to select 'SQF' and press the 'Enter' button (Fig. 1).
2.	Adjust 'SFM Mode'	Use the '▲ / ▼' buttons (Fig. 2) to select 'Mode': Off for about 1 to 5 sheets (bypassing 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 Press 'Enter' to confirm the settings.
3.	Save settings.	After all desired settings are adjusted press 'Jobs' (Fig. 3) and press 'Enter' (Fig. 4) to save the settings. ⚠ A "Saving Job" signal appears for a few seconds.

4. Operating the SFM (continued)

4.6 Purge Button

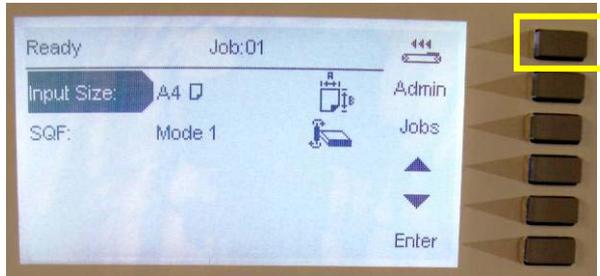


Fig.1

Step	Action	Remarks
1.	Press Purge Button.	Use the 'Purge buttons' to move booklets forward on Belt Stacker (Fig.1).

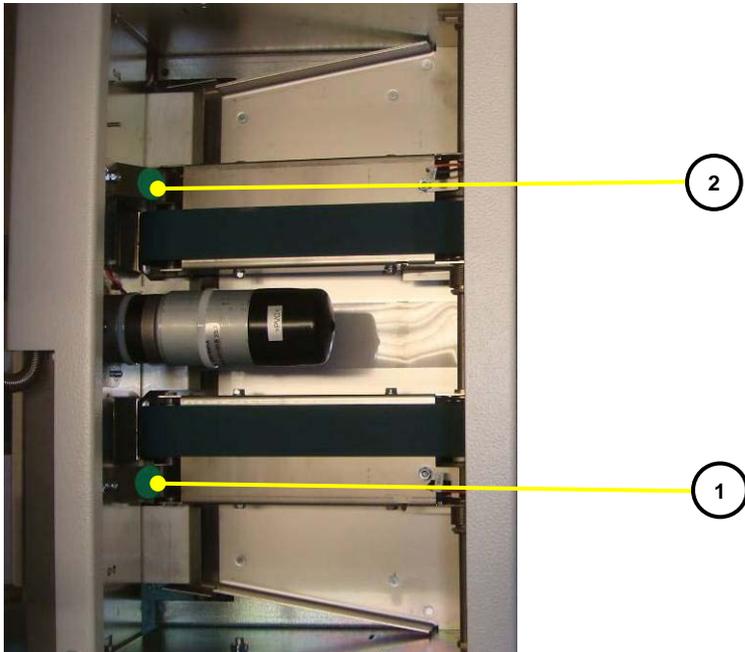
5. Troubleshooting

5.1 Improve Square Fold Quality

Booklet square fold quality

Fold quality	Action required
	The booklet is squared correctly
	The booklet is not fully squared. Increase the selected Mode 1 step, See Chapter: 4.5 Squarefold Mode .
	The booklet is squared too much. Decrease the selected Mode 1 step, See Chapter: 4.5 Squarefold Mode .
	Thin booklets can crease on the back. Decrease the selected Mode 1 step or select Off (bypassing the SFM), See Chapter: 4.5 Squarefold Mode .

5.2 Paper Jam



Step	Action	Remarks
1.	Lift the Upper Transport Belt Left.	Push the spring (green dot) to unlock the Belt.
2.	Lift the Upper Transport Belt Right.	Push the spring (green dot) to unlock the Belt.
3.	Remove Booklet	
4.	Close the Belts.	⚠ Push the belt down till the locking springs are engaged.

6. Cleaning / Maintenance

6.1 General



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



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



The exterior can be cleaned with a slightly moist cloth.



With exception of the belts, the interior of the SFM does not need cleaning.

6.2 Cleaning the belts

The belts of the SFM need to be cleaned regularly during normal conditions and if the SFM has not been used for a period of time. How often this should be done depends on the paper type and print quality.

An increasing number of jams are one indication of the need to clean the belts.



Clean the belts with water and a lint free cloth.

Step	Action	Remarks
1.	Open the Top Cover	
2.	Turn off the SFM	
3.	Lift the transport belts unit.	
4.	Clean the belts	
5.	Close the Belts.	

7. Technical Information

Capabilities:

<i>Compatibility:</i>	Standalone
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Physical:

	Operational	On Pallet in box
<i>Height</i>	1140 mm	720 mm
<i>Width</i>	700 mm	800 mm
<i>Depth</i>	360 mm	1200 mm
<i>Weight</i>	~70 Kg	~105 Kg

Booklet:

<i>booklet width (x):</i>	124 - 235 mm
<i>Booklet height (z):</i>	140 - 320 mm
<i>Paper Weight (min-max)</i>	60 - 300 g/m ²

Technical:

	A4	A3
<i>Speed</i>	1816 booklets/hour	1672 booklets/hour

Electrical:

<i>60Hz:</i>	220/230V, 0.3A
<i>50Hz:</i>	220/230V, 0.3A
<i>60Hz:</i>	100/110/120/127V, 0.6A (upon request)

Environmental:

<i>Temperature range</i>	+15 - 32 °C
<i>Humidity Range</i>	30 - 65 % RH
<i>Noise level (max.):</i>	70dB

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