



BAUMFOLDER

Baum 2015/2018/2020 Floor Model Folders Job Setup

This sheet is only a guide to setup and operation of the Baum 2015/2018/2020 Pile feed folders. Jobs will vary and procedures will need to be modified.



1. **Hand fold a sample** as close as possible of the job to be run. Mark the sample so that it is not lost during setup. Measure the overall length and width of the sheet if you do not already know them, using the scale located on the holddown in the center of the register table.
2. **Start with the feeder** and move in progression to the exit end of the last fold section to complete the setup of the folder. There is no need to turn the power on until the setup is complete.
3. **Set the sideguide** on the pile feeder to half of the width of the sheet width using the scale on the frame. Remove the LH sideguide for easy access to load paper. See Fig. 1.
4. **Set the double front blow bar** to the proper air settings referring to the chart on the side of the control cabinet. See Figures 2 and 3.
5. **Set the double sheet detector** using (2) thicknesses of the stock being fed and insert into the lever and clip.
6. **Load paper** onto the pile feed platform. Be sure to fan the paper before loading to add air in between the sheets for easier feeding. Also note that the loading of the paper must be positioned to correspond to the folding imposition that you want to achieve in the folding unit(s). You must determine if you want the paper face up, or face down, or head first, or tail first. Refer to your hand folded sample to determine which foldplates you will be using and the loading of the paper.
7. **Install LH see-thru sideguide** and position register guide approximately 1/16 to 1/8" away from LH side of paper on pile feeder to insure that paper can slide freely during feeding. See figure 4.
8. **Install the small metal clip** that fastens to the end of the register guide to keep an up-curl from riding over the end of the register guide.
9. **Check register marble configuration** to make sure that it matches the job that you are running. At least (1) to (2) steel marbles are recommended at the end of the register closest to the pile feeder and (2) more at the end closest to the fold rollers. The marble configuration in between depends upon the weight of stock and whether the feeding is landscape or portrait. To



Fig 1



Fig 2

FRONT BLOW SETTINGS					
SHEET WIDTH			BLOW TUBE		
ENGLISH	METRIC		TOP	BOTTOM	
8" TO 8"	168 TO 168	1	1		
8" TO 8"	168 TO 200	1	2		
8" TO 12"	200 TO 250	2	2		
12" TO 18"	300 TO 450	2	4		
18" TO 24"	450 TO 600	4	4		
18" TO 24"	450 TO 600	4	4		

Fig 3



Fig 4

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many steel marbles can drive the sheet too hard and causing feeding problems.

10. **Place register holddowns in proper locations** for the sheet width being fed. Note that for 11x17 sheets being fed in the 11 inch width, place a register holddown between the LH see-thru guide and the vacuum wheel to keep air from cupping the sheet and causing stumbling. Note that the register holddown with the scale is always located in the center of the register in front of the vacuum. Be careful when placing the holddown on the right hand edge of the sheet to angle the holddown slightly to prevent the right hand edge from curling up inside and stumbling.
11. **Set the Baumsets** by inserting strips of paper of the job that is being run. Only insert the thickness that corresponds to the tailing or minimum thickness that the roller must drive without losing control of the paper. You need to refer to your hand-folded sample to follow the paper path See fig 5. Refer also to the example fold given in Fig. 6 that shows a cut-away section of the folder and notes the proper foldplate and Baumset settings for the imposition shown.



Fig. 5

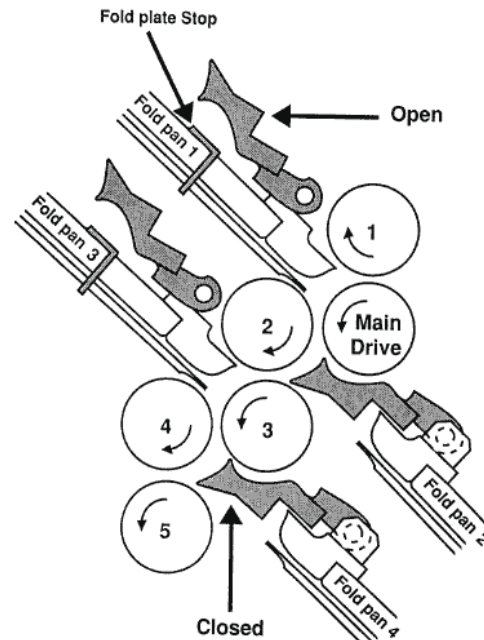
Letterfold: UP & UP

Foldplates

- #1 Open Set Paperstop to 1/3 unfolded sheet length
- #2 Closed
- #3 Open Set Paperstop to 1/3 unfolded sheet length
- #4 Closed

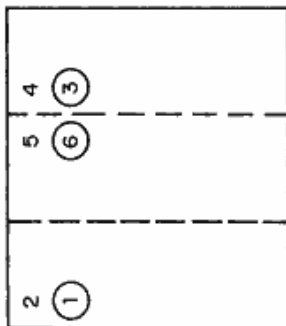
Baumset Paper Thickness Settings

- #1 = 1 Thickness
- #2 = 1 Thickness
- #3 = 1 Thickness
- #4 = 3 Thicknesses
- #5 = 3 Thicknesses



3 6-PAGE, STANDARD

Parallel: 1,3



May be folded two or more up and cut apart



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12. **Set the foldplates** to the proper open and closed positions by rotating the stop blocks and placing the correct symbol for either open or closed to the position closest to the fold rollers. Then set the desired fold depths using the scale on the belt and reading at the yellow mark on the indicator.
13. **Setup the slittershafts** using the proper perforating scoring or slitting accessories. If just a parallel folder is being used an perforating, scoring or slitting is not required, pullout tires must still remain on the slittershafts to properly eject the sheets. Note that a good setup procedure is to have all the setscrews facing outward at the same clock position. This eliminates a lot of handwheel turning to get to the setscrews during job changes. See Fig. 7
14. **Setup Delivery Stacker Wheels** to the expected position of the paper as it ejects the folder. The independent speed control will need to be set during the initial fold operation to insure proper shingling. Note that the exit holddown straps must also be installed to kick the sheet down onto the delivery stacker.



Fig. 7 Perforating on 1-1/8" slittershaft



Scoring with 1-1/8" slittershafts

Right angle Folding

When adding an 8-page or 16-page folder to a parallel unit it is highly recommended that the stock must be either perforated or scored as it exits the previous fold unit. The perforating or scoring is to be performed at the line of the fold that is to be folded in the next fold section. This weakens the grain of the stock so that a consistent, quality fold can be achieved. Perforating is also needed to relieve air that can become trapped in the folding process and create wrinkles in the paper. The size of the perforator tooth can make a difference in the amount of air that can escape and remove the wrinkle problem. Failure to score or perforate a sheet going into a right angle folder will result in inconsistent fold quality.

Refer to your operator's manual for scoring, perforating and slitting information.

Marbleholder Setup

Note that marble placement can be critical on some jobs and not on others. You may want to remove some marbles that are in the end that accepts the sheets at a right angle so that the sheets do not bounce back when trying to get under the marbles. At least (2) steel marbles are recommended at the end closest to the fold rollers to maintain sheet control against the guide.

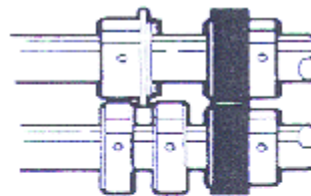


Figure 19

Scoring on a 7/8" slittershaft

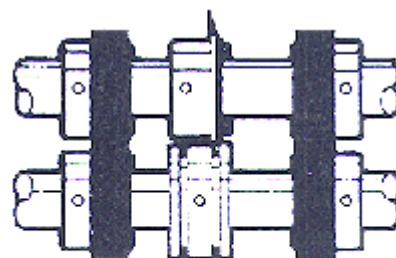


Figure 17

Perforating on a 7/8" Slittershaft

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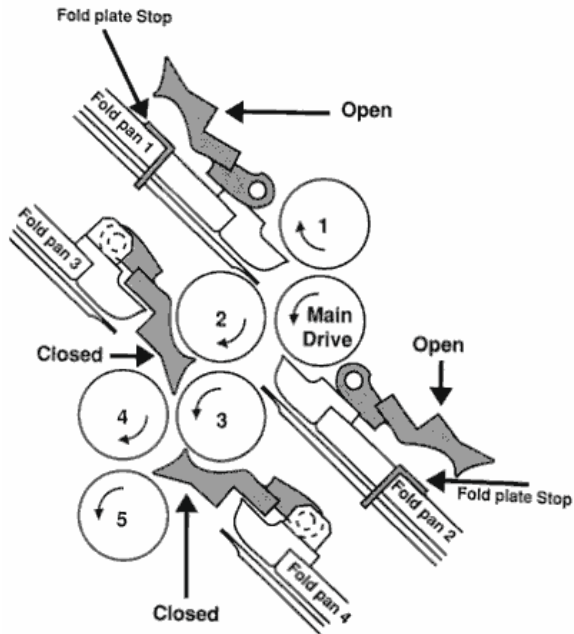
Letterfold: UP & DOWN

Foldplates

- #1 Open Set Paperstop to 2/3 unfolded sheet length
- #2 Open Set Paperstop to 1/3 unfolded sheet length
- #3 Closed
- #4 Closed

Baumset Paper Thickness Settings

- #1 = 1 Thickness
- #2 = 1 Thickness
- #3 = 3 Thicknesses
- #4 = 3 Thicknesses
- #5 = 3 Thicknesses



Letterfold: DOWN & DOWN

Foldplates

- #1 Closed
- #2 Open Set Paperstop to 1/3 unfolded sheet length
- #3 Closed
- #4 Open Set Paperstop to 1/3 unfolded sheet length

Baumset Paper Thickness Settings

- #1 = 1 Thickness
- #2 = 1 Thickness
- #3 = 1 Thickness
- #4 = 1 Thickness
- #5 = 3 Thicknesses

