

**bizhub PRESS**   
1250/1250P/1052

**bizhub PRESS**   
C1070/C1070P/C1060/C71hc

**bizhub PRESS**   
C1100/C1085

---

User's Guide Saddle Stitcher SD-513

---

# Table of contents

## 1 Introduction

1.1	Intended Use of this Machine .....	1-2
1.2	Users of this Machine .....	1-3
1.3	Objectives of this Manual .....	1-4

## 2 Preparation for Use

2.1	Machine Configuration .....	2-2
2.2	Warning Label and Caution Label .....	2-7
2.3	Optional Devices .....	2-11
2.4	Paper Information .....	2-12
2.4.1	Available Paper Weights .....	2-12
2.4.2	Exit Tray Capacity .....	2-13
2.4.3	Paper Size .....	2-17
2.5	Machine Screen .....	2-18
2.5.1	Screen with SD-513 installed .....	2-18
2.5.2	Setting Screen with SD-513 installed .....	2-19

## 3 Supplies and Disposals

3.1	Replenishing Staple Supply .....	3-2
3.1.1	Replenishing Staple Supply in Saddle Stitcher SD-513 .....	3-2
3.2	Disposing Trimmings .....	3-4
3.2.1	Emptying Trim Scrap Box of Saddle Stitcher SD-513 .....	3-4
3.2.2	Emptying Slit Scrap Box of Saddle Stitcher SD-513 .....	3-6

## 4 Using Saddle Stitcher SD-513

4.1	Basic Functions of Saddle Stitcher SD-513 .....	4-2
4.2	Additional Functions of Saddle Stitcher SD-513 .....	4-5
4.2.1	Creaser Unit CR-101 .....	4-5
4.2.2	Trimmer Unit TU-503 .....	4-10
4.2.3	Combination of Creaser Unit CR-101 and Trimmer Unit TU-503 .....	4-15
4.2.4	Folding Unit FD-504 .....	4-19
4.2.5	Combination of Basic Functions and Additional Functions .....	4-21
4.3	Making Folded Booklets: Fold & Staple/Multi Half-Fold .....	4-22
4.3.1	Functional Overview .....	4-22
4.3.2	Settings on the Copy Screen .....	4-23
4.3.3	Settings in Printer Driver .....	4-26
4.4	Folding Copies in Three: Multi Tri-Fold .....	4-27
4.4.1	Functional Overview .....	4-27
4.4.2	Settings on the Copy Screen .....	4-28
4.4.3	Settings in Printer Driver .....	4-29
4.5	Adding Fold Lines (Creases) on Paper .....	4-30
4.5.1	Functional Overview .....	4-30
4.5.2	Settings on the Copy Screen .....	4-32
4.5.3	Settings in Printer Driver .....	4-35
4.6	Adding Fold Lines (Creases) for Fold & Stapled/Multi Half-Folded Cover .....	4-36
4.6.1	Functional Overview .....	4-36
4.6.2	Settings on the Copy Screen .....	4-37
4.6.3	Settings in Printer Driver .....	4-41

<b>4.7</b>	<b>Adding Fold Lines (Creases) for Multi Tri-Folded Paper .....</b>	<b>4-42</b>
4.7.1	Functional Overview .....	4-42
4.7.2	Settings on the Copy Screen .....	4-43
4.7.3	Settings in Printer Driver .....	4-44
<b>4.8</b>	<b>Performing 2-Side Slitting .....</b>	<b>4-45</b>
4.8.1	Functional Overview .....	4-45
4.8.2	Settings on the Copy Screen .....	4-46
4.8.3	Settings in Printer Driver .....	4-47
<b>4.9</b>	<b>Performing 2-Side Slitting on Fold &amp; Stapled/Multi Half-Folded Paper .....</b>	<b>4-48</b>
4.9.1	Functional Overview .....	4-48
4.9.2	Settings on the Copy Screen .....	4-50
4.9.3	Settings in Printer Driver .....	4-55
<b>4.10</b>	<b>Performing 2-Side Slitting on Multi Tri-Folded Paper .....</b>	<b>4-56</b>
4.10.1	Functional Overview .....	4-56
4.10.2	Settings on the Copy Screen .....	4-57
4.10.3	Settings in Printer Driver .....	4-59
<b>4.11</b>	<b>Forming Spine Corners on Fold &amp; Stapled Sets .....</b>	<b>4-60</b>
4.11.1	Functional Overview .....	4-60
4.11.2	Settings on the Copy Screen .....	4-61
4.11.3	Settings in Printer Driver .....	4-64
<b>4.12</b>	<b>Manually Using Folding Unit FD-503 or Saddle Stitcher SD-513 .....</b>	<b>4-65</b>
<b>4.13</b>	<b>Combining Perfect Binder PB-503 .....</b>	<b>4-68</b>
4.13.1	Making Perfect-Bound Booklets .....	4-68
<b>4.14</b>	<b>Functions of Printer Driver .....</b>	<b>4-73</b>
4.14.1	PS Plug-in driver (Windows/Mac OS X) .....	4-73
4.14.2	PPD driver (Windows) .....	4-80
4.14.3	PPD Driver (Mac OS X) .....	4-82
4.14.4	PCL driver (Windows) .....	4-84
<b>4.15</b>	<b>Job Operations .....</b>	<b>4-91</b>
4.15.1	Operating Prior Print .....	4-91
4.15.2	Printing a Sample during Output and Checking it: Sample Print .....	4-91

## 5 Various Settings and Adjustment

<b>5.1</b>	<b>Tray Setting .....</b>	<b>5-2</b>
5.1.1	PI-PFU Tray Setting (bizhub PRESS 1250/1250P/1052) .....	5-2
5.1.2	Tray Setting for PI Trays: Post Inserter of Folding Unit FD-503 .....	5-9
<b>5.2</b>	<b>[Saddle Stitcher Adjustment] - [Staple Center Adjustment] .....</b>	<b>5-16</b>
5.2.1	Center Position of 2 Position Staples .....	5-16
5.2.2	Center Position of Front 2 Positions of 4 Position Staple .....	5-17
5.2.3	Center Position of Rear 2 Positions of 4 Position Staple .....	5-19
<b>5.3</b>	<b>[Saddle Stitcher Adjustment] - [Staple Paper Width Adj.] .....</b>	<b>5-21</b>
<b>5.4</b>	<b>[Saddle Stitcher Adjustment] - [Staple Pitch Adjustment] .....</b>	<b>5-23</b>
5.4.1	Staple Pitch of 2 Position Staple .....	5-23
5.4.2	Staple Pitch of Front 2 Positions of 4 Position Staple .....	5-24
5.4.3	Staple Pitch of Rear 2 Positions of 4 Position Staple .....	5-26
<b>5.5</b>	<b>[Saddle Stitcher Adjustment] - [Tri-Fold Position Adj.] .....</b>	<b>5-28</b>
<b>5.6</b>	<b>[Saddle Stitcher Adjustment] - [Fold Skew Adjustment] .....</b>	<b>5-30</b>
<b>5.7</b>	<b>[Saddle Stitcher Adjustment] - [Half-Fold Position Adjustment] .....</b>	<b>5-32</b>
<b>5.8</b>	<b>[Saddle Stitcher Adjustment] - [Fold Paper Width Adjustment] .....</b>	<b>5-34</b>
<b>5.9</b>	<b>[Saddle Stitcher Adjustment] - [Fore-edge Trimming Adjustment] .....</b>	<b>5-36</b>
<b>5.10</b>	<b>[Saddle Stitcher Adjustment] - [Parallel Trimming Adjustment] .....</b>	<b>5-38</b>
<b>5.11</b>	<b>[Saddle Stitcher Adjustment] - [2-Side Slitting Adjustment] .....</b>	<b>5-40</b>
<b>5.12</b>	<b>[Saddle Stitcher Adjustment] - [Crease Position Adjustment] .....</b>	<b>5-42</b>
5.12.1	Half-Fold Crease Position .....	5-42
5.12.2	Tri-Fold Crease Position .....	5-44



5.12.3	Perfect Bind Cover Crease Position .....	5-46
5.13	<b>[Saddle Stitcher Adjustment] - [Flattening a Fold (Strength)] .....</b>	<b>5-48</b>
5.14	<b>[Saddle Stitcher Adjustment] - [Flattening a Fold (Frequency)] .....</b>	<b>5-49</b>
5.15	<b>[Saddle Stitcher Adjustment] - [Staple Offset Adjustment] .....</b>	<b>5-50</b>
5.16	<b>[Saddle Stitcher Adjustment] - [Staple Tip Adjustment] .....</b>	<b>5-51</b>
5.17	<b>[Saddle Stitcher Adjustment] - [2-Side Slitting Finishing Adj.] .....</b>	<b>5-52</b>
5.18	<b>[Saddle Stitcher Adjustment] - [Trimmer Receiver Adjustment] .....</b>	<b>5-53</b>
5.18.1	Count Select for Move .....	5-53
5.18.2	Moving Pitch Select .....	5-54
5.18.3	Forcibly Move .....	5-55

## 6 Troubleshooting

6.1	<b>If [Mishandled paper] Message Is Displayed .....</b>	<b>6-2</b>
6.1.1	Precautions for Removing Mishandled Paper from Saddle Stitcher SD-513 .....	6-2
6.2	<b>Troubleshooting Tips .....</b>	<b>6-3</b>

## 7 Cleaning

7.1	<b>Cleaning the conveyance belt of the bundle exit tray .....</b>	<b>7-2</b>
-----	---	------------

## 8 Appendix

8.1	<b>Typical Specifications .....</b>	<b>8-2</b>
8.1.1	Saddle Stitcher SD-513 .....	8-2
8.1.2	Creaser Unit CR-101 (equipped in Saddle Stitcher SD-513) .....	8-4
8.1.3	Trimmer Unit TU-503 (equipped in Saddle Stitcher SD-513) .....	8-5
8.1.4	Folding Unit FD-504 (equipped in Saddle Stitcher SD-513 as option) .....	8-6





## Introduction

# 1 Introduction

## 1.1 Intended Use of this Machine

### Intended Use

**Saddle Stitcher SD-513** (this machine) is an optional saddle stitcher for the digital printing system. With this machine installed, you can use the half-fold and fold & staple functions and combine the half-fold/fold & staple function and the fore-edge trimming function.

Also, if this machine is equipped with optional devices, you can add fold lines (creases) and perform 2-side slitting or spine corner forming for cover paper.

This machine supports the following digital printing systems.

- **bizhub PRESS 1250/1052**
- **bizhub PRESS 1250P**
- **bizhub PRESS C1070/C1060**
- **bizhub PRESS C1070P/C71hc**
- **bizhub PRESS C1100/C1085**

To use this machine, comply with the following items.

- Use this machine in the range of the specifications for the main body and optional devices.
- Comply with all the precautions for safety information described in the user's guide.
- Comply with the prohibited items for copying or printing. (For details, refer to "Safety Information" in the booklet manual supplied with the digital printing system.)
- Faithfully observe inspection and maintenance instructions.
- Strictly observe the national and corporate safety regulations and general safety standards.

### Unacceptable operation conditions

This machine may not run when:

- an error or damage has been detected;
- the maintenance interval has expired; and
- mechanical functions or electrical functions do not run normally.

### Disclaimers

We assume no responsibility for damages that is caused when this machine is operated under unacceptable conditions.

## 1.2 Users of this Machine

This guide is intended for the following users of this machine.

- Operator: A person who receives training from Konica Minolta or an authorized partner, uses this machine in accordance with the intended use of this machine, and performs management, maintenance, and troubleshooting for the consumables described in the user's guide.
- Administrator: A person who receives training from Konica Minolta or authorized partner, makes consumables management and system settings, and builds up a network environment or security system.

All people who use this machine need to read the related user's guides and gain an understanding of their contents.

## 1.3 Objectives of this Manual

This guide only describes the available functions when **Saddle Stitcher SD-513** is installed on this machine. For details on other functions of the digital printing system, refer to the user's guide supplied with the digital printing system.

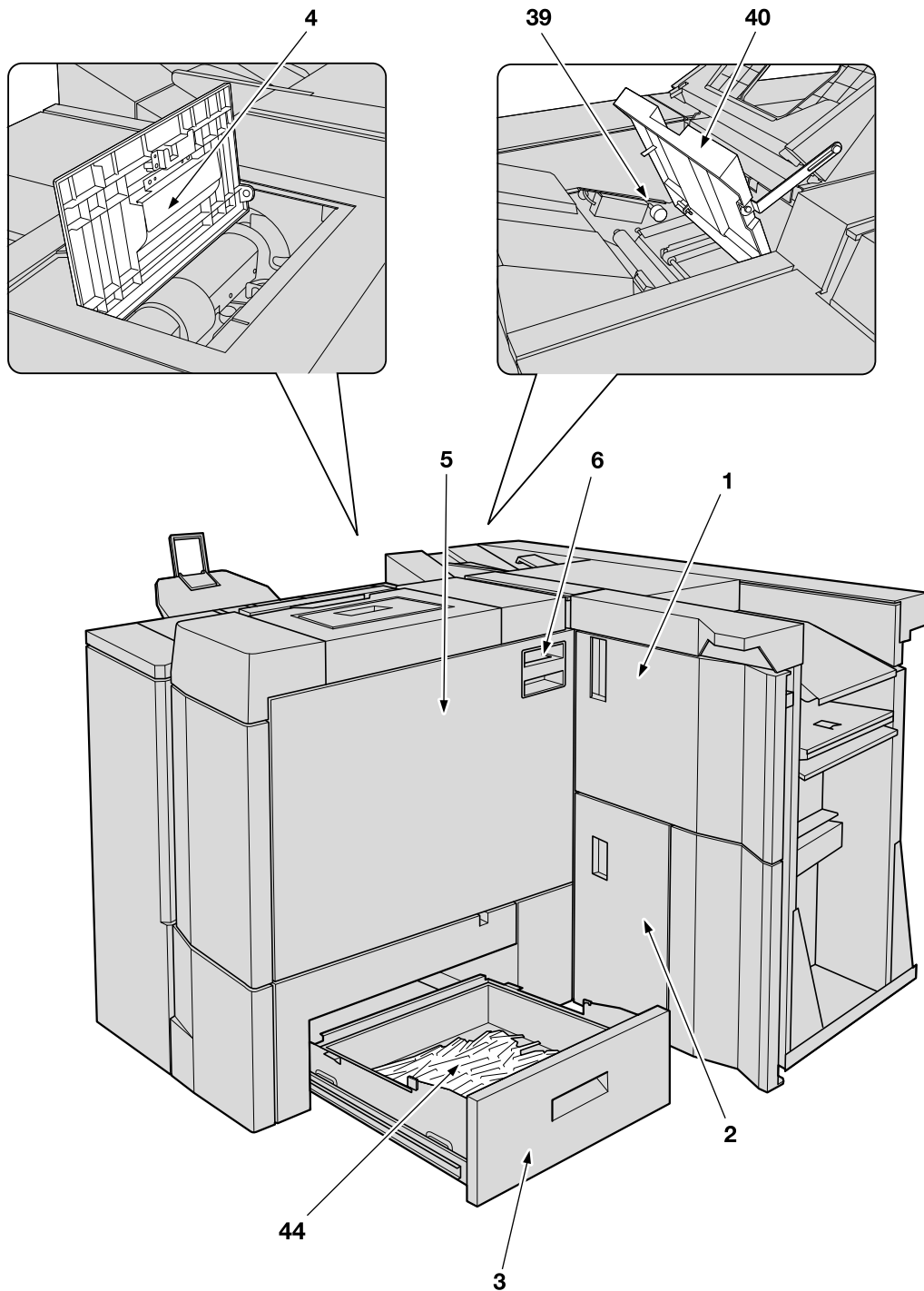
The screenshots shown in this guide mainly conform to the screens for **bizhub PRESS 1250/1052**. If they differ from model to model, differential information is described for each model.

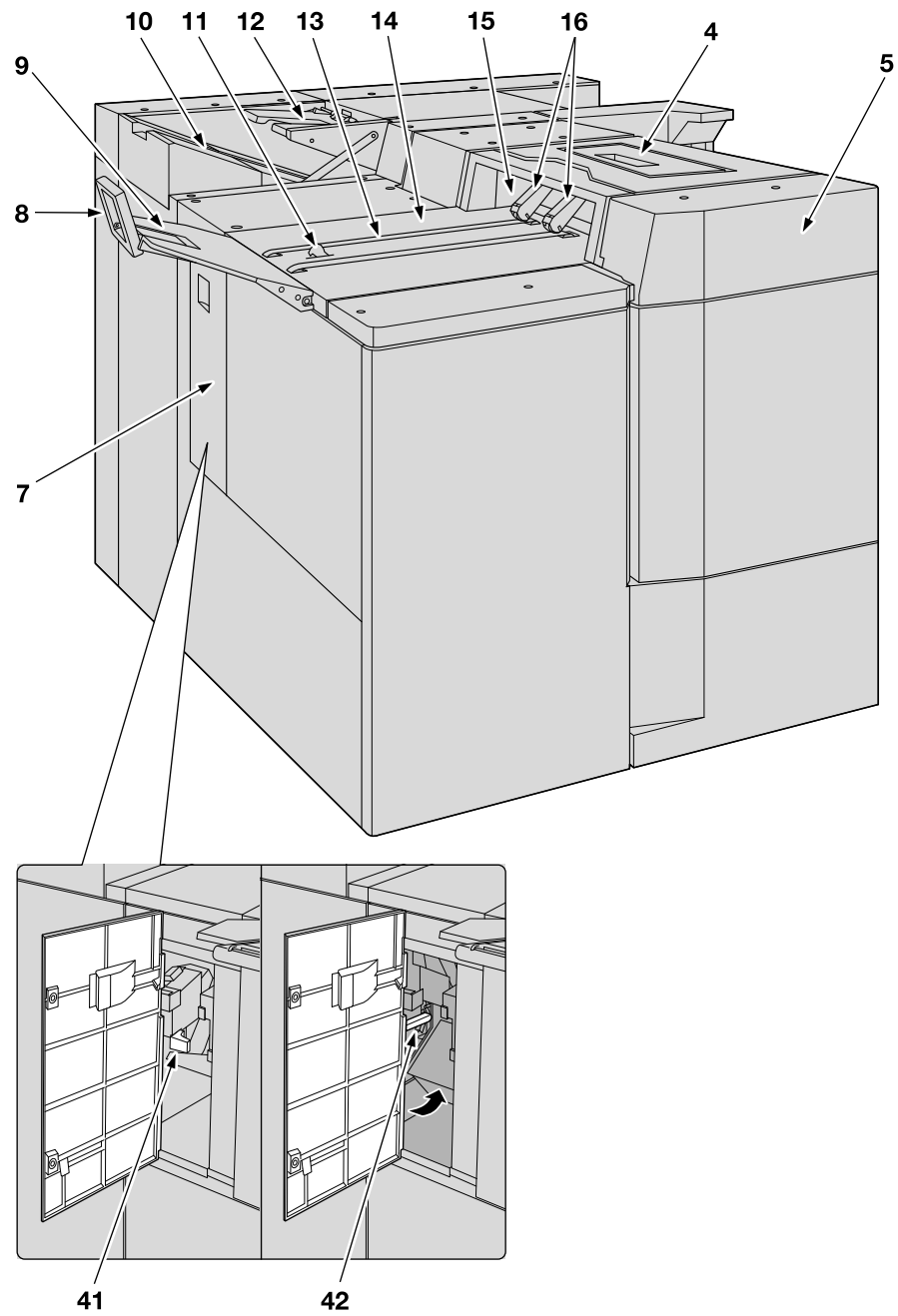


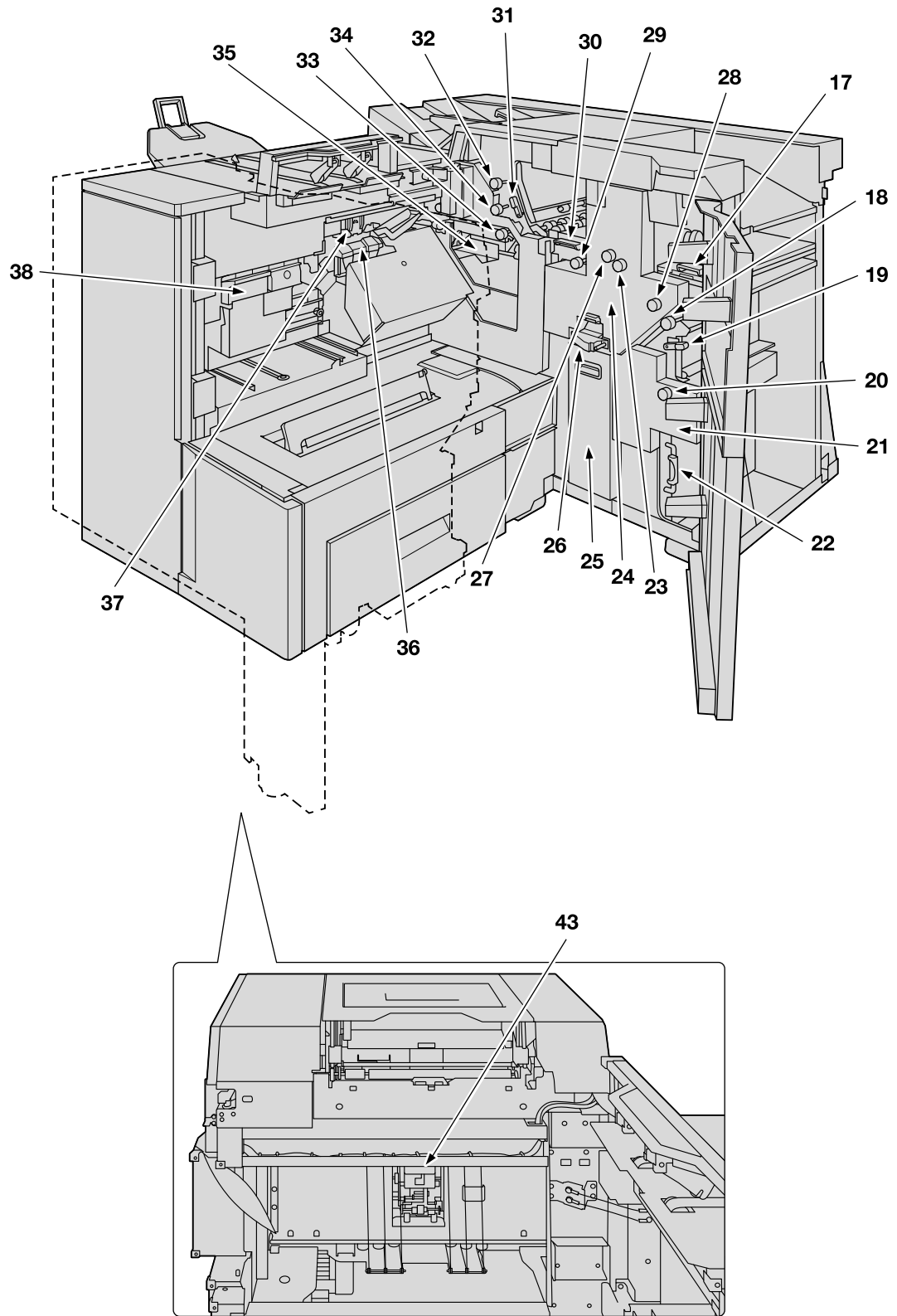
## Preparation for Use

## 2 Preparation for Use

### 2.1 Machine Configuration







External view of **Saddle Stitcher SD-513**

No.	Name	Description
1	<b>Saddle stitcher front door</b>	Opens to allow removal of mishandled paper.
2	<b>Slit scrap box door</b>	When the optional <b>Trimmer Unit TU-503</b> is mounted, opened for removal of slitting scraps in the <b>slit scrap box</b> .
3	<b>Trim scrap tray</b>	Withdrawn for removal of fore-edge trimmings in the <b>trim scrap box</b> .
4	<b>Clamp section upper door</b>	Opened for removal of mishandled paper inside the folding unit, and for cleaning the conveyance belts.
5	<b>Clamp section</b>	Opened for removal of mishandled paper inside the fold conveyance section, fold & staple section, or half-fold section. Open the saddle stitcher front door to access the clamp section.
6	<b>Clamp section handle</b>	Hold the lock release lever while opening the <b>clamp section</b> . Hold the lock release lever while closing the clamp section.
7	<b>Folding outlet door</b>	Opened for removal of mishandled paper inside the folding outlet.
8	<b>Stopper</b>	Prevents output sheets from falling off the <b>bundle exit tray</b> .
9	<b>Bundle exit tray extension</b>	Opened for delivery of output sheets onto the <b>bundle exit tray</b> .
10	<b>Secondary (sub) tray</b>	Holds output sheets that are delivered from the equipment attached to the right side of the machine without being processed in Fold & Staple, Multi Half-Fold, or Multi Tri-Fold mode. Also holds output delivered after performing creasing or 2-side slitting using <b>Trimmer Unit TU-503</b> or <b>Creaser Unit CR-101</b> .
11	<b>Paper detection sensor</b>	Detects output sheets delivered on the <b>conveyance belt</b> to prevent from falling off.
12	<b>Tri-fold tray</b>	Holds sets output in Tri-Fold mode.
13	<b>Conveyance belt</b>	Carries output sheets leftward.
14	<b>Bundle exit tray</b>	Holds fold & stapled or half-folded sets processed by the machine.
15	<b>Bundle exit tray outlet</b>	Delivers fold & stapled or half-folded sets processed by the machine.
16	<b>Output roller</b>	Straightens fold & stapled or half-folded sets processed by the machine.

Internal view of **Saddle Stitcher SD-513**

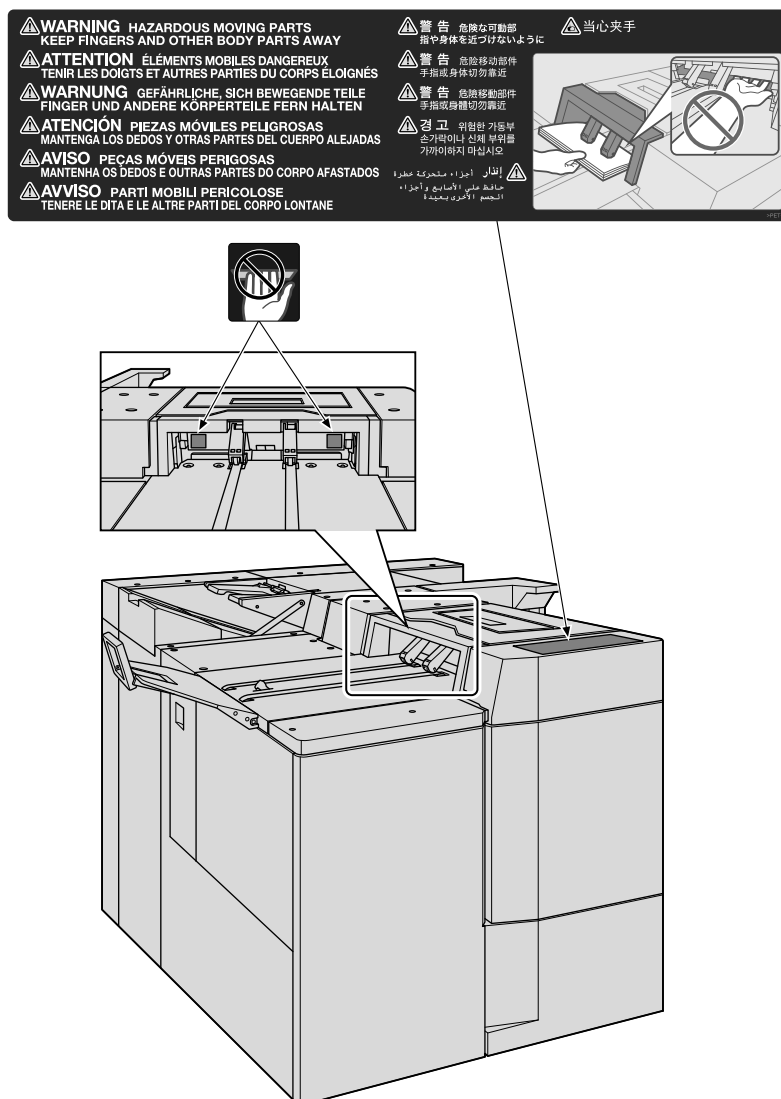
No.	Name	Description
17	<b>Lever</b> [SD1]	Opens upward for removal of mishandled paper.
18	<b>Knob</b> [SD2]	Turned to allow removal of mishandled paper from <b>Creaser Unit CR-101</b> or while being fed.
19	<b>Lever</b> [SD3]	Opens rightward to allow removal of mishandled paper from <b>Creaser Unit CR-101</b> or while being fed.
20	<b>Knob</b> [SD4]	Turned to allow removal of mishandled paper from <b>Creaser Unit CR-101</b> or while being fed.
21	<b>Creaser Unit CR-101</b> (option)	Adds fold lines on sheets.
22	<b>Lever</b> [SD5]	Opens rightward to allow removal of mishandled paper from <b>Creaser Unit CR-101</b> or while being fed.
23	<b>Knob</b> [SD15]	Turned clockwise to allow removal of mishandled paper from <b>Trimmer Unit TU-503</b> .
24	<b>Trimmer Unit TU-503</b> (option)	Trims both sides of sheets.
25	<b>Slit scrap box</b>	Withdrawn for removal of slit scraps.
26	<b>Scrap box lock release lever</b>	Pulled to release lock when withdrawing the <b>slit scrap box</b> for removal of slit scraps.
27	<b>Knob</b> [SD16]	Turned counterclockwise to allow removal of mishandled paper from <b>Trimmer Unit TU-503</b> .
28	<b>Knob</b> [SD6]	Turned clockwise for removal of mishandled paper.
29	<b>Knob</b> [SD7]	Turned counterclockwise for removal of mishandled paper.
30	<b>Lever</b> [SD8]	Opens upward for removal of mishandled paper.
31	<b>Lever</b> [SD9]	Opens rightward for removal of mishandled paper.
32	<b>Knob</b> [SD10]	Turned clockwise for removal of mishandled paper.
33	<b>Knob</b> [SD11]	Turned counterclockwise for removal of mishandled paper.
34	<b>Knob</b> [SD13]	Turned to allow removal of mishandled paper.
35	<b>Lever</b> [SD12]	Opens downward for removal of mishandled paper.
36	<b>Fold &amp; staple section</b>	Used to staple the center line of paper.
37	<b>Stapler</b>	Staples on 2 or 4 positions when performing fold & staple.
38	<b>Booklet transfer section</b>	Conveys folded paper (booklets) to the <b>clamp section</b> .
39	<b>Knob</b> [SD14]	Turned to allow removal of mishandled paper.
40	<b>Secondary (sub) tray cover</b>	Opened to allow removal of mishandled paper inside the tri-fold conveyance section.
41	<b>Lever</b> [SD17]	Opens upward for removal of mishandled paper.
42	<b>Lever</b> [SD18]	Opens downward for removal of mishandled paper.
43	<b>Folding Unit FD-504</b> (option)	Forms spine corners on fold & stapled booklets.
44	<b>Trim scrap box</b>	Holds waste fore-edge trimmings.

## 2.2 Warning Label and Caution Label

### ⚠ WARNING

When taking out output sheets from the bundle exit tray, do not put your hand into the shutter of the outlet.

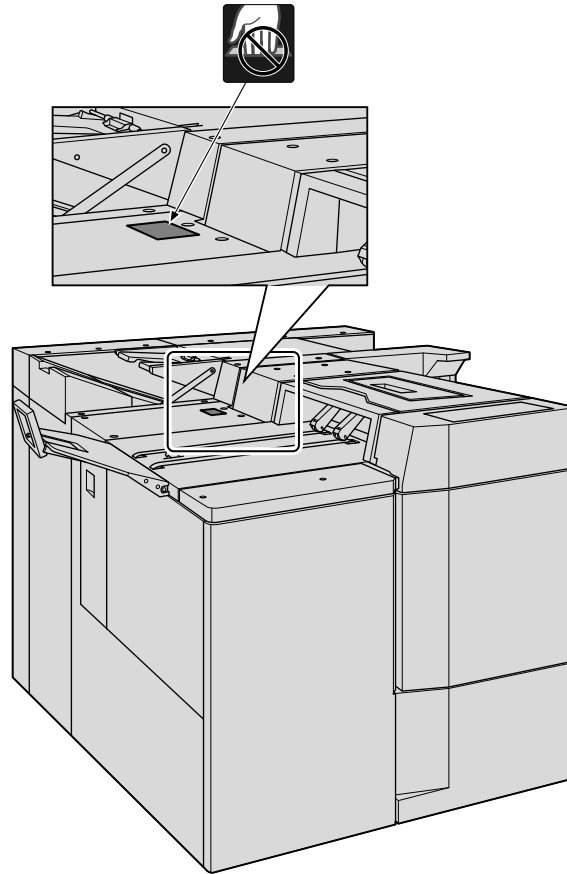
- If you put your hand into the shutter while sheets are being delivered onto the bundle exit tray, it may cause an unexpected accident.  
Before removing out output sheets, make sure that they have all been delivered onto the bundle exit tray.



**⚠ CAUTION**

When closing the clamp section, do not put your hand between the clamp section and the main body.

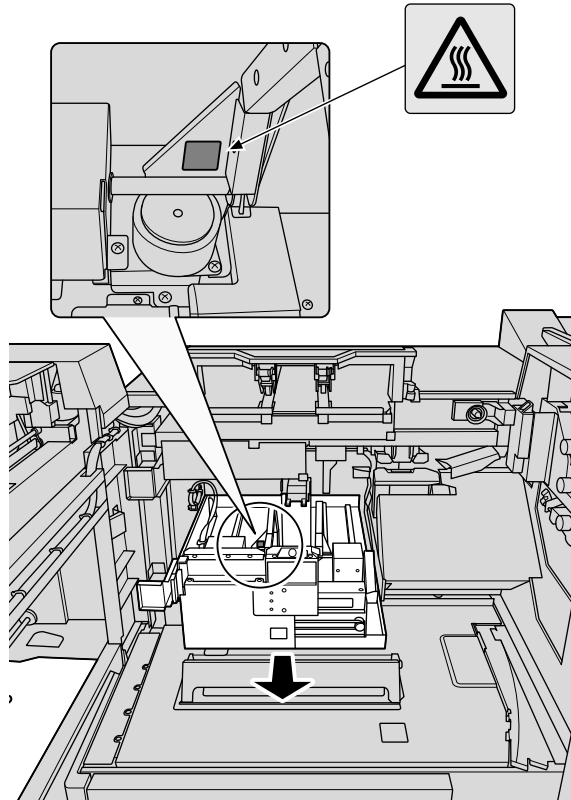
- Your hand is caught between them, it may cause an unexpected accident.  
Be careful to close the clamp section.



**⚠ CAUTION**

When the clamp section is opened, the internal unit inside the saddle stitcher may be located forward. Do not touch the motor section of the internal unit with your hand.

- The motor section of the internal unit may be hot. If you touch it with your hand, you may burn your hand.  
Pay special attention to clear jammed paper inside the main body of the saddle stitcher.



**⚠ WARNING**

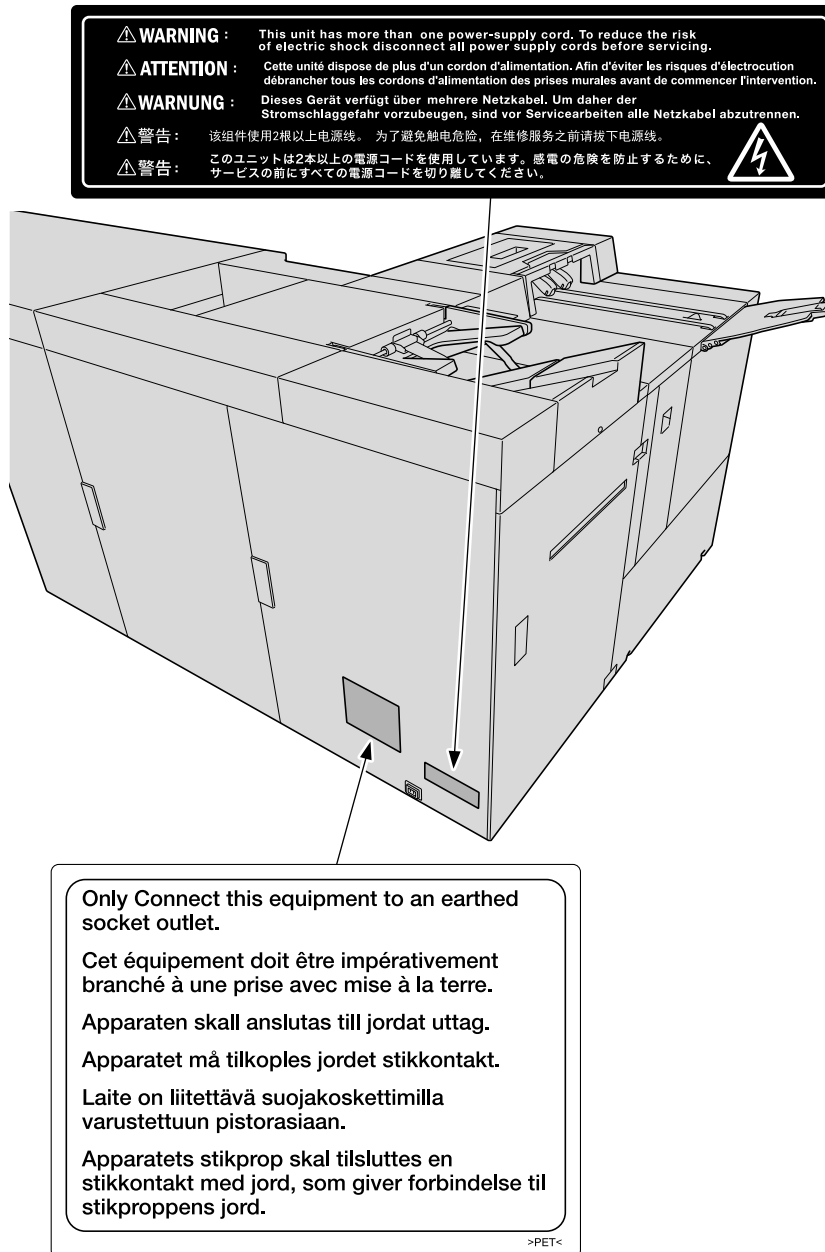
Before starting the service, disconnect the power cord.

- Otherwise, it may cause an electric shock.

**⚠ WARNING**

Be sure to connect this product to an earthed socket outlet only.

- Failure to do so and an unlikely event of leakage could result in a fire or electrical shock.



## 2.3 Optional Devices

This machine provides the following optional devices, enabling you to increase available functions if they are installed.

Name	Description
<b>Creaser Unit CR-101</b>	Adds up to four fold lines (creases) on output sheets. When combined with the Booklet function, this device adds fold lines only on the cover, and folds & staples or half-folds the cover and the body together.
<b>Trimmer Unit TU-503</b>	Trims both the head and the foot edges of output sheets. Also, when combined with the Booklet function, this device performs 2-side slitting on only the cover, or all sheets, including the body. 2-side slitting can be combined with the fold line (crease) function of <b>Creaser Unit CR-101</b> .
<b>Folding Unit FD-504</b>	Forms the spine of the folded & stapled booklet in combination with the Booklet function. Spine corner forming cannot be combined with the fold line (crease) function of <b>Creaser Unit CR-101</b> .

## 2.4 Paper Information

### 2.4.1 Available Paper Weights

Paper conveyance, processing, or output device		Weight
<b>Saddle Stitcher SD-513</b>	<b>Secondary (sub) tray</b>	11 <sup>*1</sup> to 93 <sup>*2</sup> lb Bond (40 <sup>*1</sup> g/m <sup>2</sup> to 350 <sup>*2</sup> g/m <sup>2</sup> )
	<b>Bundle exit tray</b>	Fold & Staple: 14 <sup>*1</sup> lb Bond to 80 lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 300 g/m <sup>2</sup> ) Fold & Staple + Fore-edge Trimming: 14 <sup>*1</sup> to 80 lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 300 g/m <sup>2</sup> ) 5 sheets folded in Multi Half-Fold: 14 to 22 lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 81 g/m <sup>2</sup> ) 3 sheets folded in Multi Half-Fold: 23 to 34 lb Bond (82 g/m <sup>2</sup> to 130 g/m <sup>2</sup> ) 2 sheets folded in Multi Half-Fold: 35 to 80 lb Bond (131 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )
	<b>Tri-fold tray</b>	5 sheets folded in Multi Tri-Fold: 14 <sup>*1</sup> to 22 lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 81 g/m <sup>2</sup> ) 3 sheets folded in Multi Tri-Fold: 23 to 24 lb Bond (82 g/m <sup>2</sup> to 91 g/m <sup>2</sup> ) Tri-Fold combined with Crease (with Multi Fold released): 29 lb Bond to 57 lb Bond (106 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )
<b>Creaser Unit CR-101</b>	<b>Secondary (sub) tray in Saddle Stitcher SD-513, Perfect Binder PB-503, or Finisher FS-532</b>	21 lb Bond to 93 <sup>*2</sup> lb Bond (80 g/m <sup>2</sup> to 350 <sup>*2</sup> g/m <sup>2</sup> ) (Crease) 11 <sup>*1</sup> lb Bond to 93 <sup>*2</sup> lb Bond (40 <sup>*1</sup> g/m <sup>2</sup> to 350 <sup>*2</sup> g/m <sup>2</sup> ) (Straight delivery / Output to secondary (sub) tray)
	<b>Bundle exit tray in Saddle Stitcher SD-513</b>	21 to 80 lb Bond (80 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )
	<b>Tri-fold tray in Saddle Stitcher SD-513</b>	29 to 57 lb Bond (106 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )
	<b>Perfect binder tray in Perfect Binder PB-503</b>	23 to 57 lb Bond (82 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )
	<b>Primary (main) tray in Finisher FS-532</b>	21 to 80 lb Bond (80 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )
<b>Trimmer Unit TU-503</b>	<b>Secondary (sub) tray in Saddle Stitcher SD-513, Perfect Binder PB-503, or Finisher FS-532</b>	11 <sup>*1</sup> to 93 <sup>*2</sup> lb Bond (40 <sup>*1</sup> g/m <sup>2</sup> to 350 <sup>*2</sup> g/m <sup>2</sup> )
	<b>Bundle exit tray in Saddle Stitcher SD-513</b>	2-Side Slitting on all sheets: 14 <sup>*1</sup> lb Bond to 80 lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 300 g/m <sup>2</sup> ) 2-Side Slitting on cover only: 14 <sup>*1</sup> lb Bond to 80 lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 300 g/m <sup>2</sup> ) 2-Side Slitting on cover only + Fore-edge Trimming: 14 lb Bond to 80 lb Bond (50 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )
	<b>Tri-fold tray in Saddle Stitcher SD-513</b>	21 to 57 lb Bond (80 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )
	<b>Perfect binder tray in Perfect Binder PB-503</b>	2-Side Slitting on cover only: 23 lb Bond to 57 lb Bond (82 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )
	<b>Primary (main) tray in Finisher FS-532</b>	2-Side Slitting on all sheets: 14 <sup>*1</sup> lb Bond to 93 <sup>*2</sup> lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 350 <sup>*2</sup> g/m <sup>2</sup> ) 2-Side Slitting on cover only: 14 <sup>*1</sup> lb Bond to 80 lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 300 g/m <sup>2</sup> )

Paper conveyance, processing, or output device		Weight
<b>Folding Unit FD-504</b>	<b>Bundle exit tray in Saddle Stitcher SD-513</b>	Fold & Staple + Spine Corner Forming: 14 <sup>*1</sup> to 57 lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 216 g/m <sup>2</sup> ) Fold & Staple + Spine Corner Forming + Fore Edge: 14 <sup>*1</sup> to 57 lb Bond (50 <sup>*1</sup> g/m <sup>2</sup> to 216 g/m <sup>2</sup> )

\*1: 17 lb Bond (62 g/m<sup>2</sup>) in **bizhub PRESS C1070/C1070P/C1060/C71hc**, and 15 lb Bond (55 g/m<sup>2</sup>) in **bizhub PRESS C1100/C1085**

\*2: 80 lb Bond (300 g/m<sup>2</sup>) in **bizhub PRESS C1070/C1070P/C1060/C71hc**

## 2.4.2 Exit Tray Capacity

Paper output device	Exit tray capacity
<b>Secondary (sub) tray</b>	Loading height (Full-load detected by sensor): 30 mm, approx. 200 sheets (22 lb Bond (80 g/m <sup>2</sup> )) Z-Fold: 20 sheets (22 lb Bond (80 g/m <sup>2</sup> )) Multi Half-Fold: 20 sheets (22 lb Bond (80 g/m <sup>2</sup> ))
<b>Bundle exit tray</b> (Fold & Staple)	<Fold & Staple> 2 to 10 sheets stapled: 30 sets or more 11 to 25 sheets stapled: 18 sets or more 26 to 50 sheets stapled: 10 sets or more (with full-load detection activated) <Fold & Staple + Spine Corner Forming> 5 to 10 sheets stapled: 30 sets or more 11 to 25 sheets stapled: 20 sets or more 26 to 50 sheets stapled: 10 sets or more (with full-load detection activated) For information on the number of sheets of each Fine type, contact your service representative. See the table on page 2-14 for the maximum number of folded & stapled sheets per set. See page 2-15 for the maximum number of sheets for coated or color paper. See page 2-16 for the maximum number of sheets for paper with width less than 7.15 inches (182 mm).
<b>Bundle exit tray</b> (Multi Half-Fold)	30 sets (with full-load detection activated) Number of sheets folded in Multi Half-Fold 5 sheets (14 to 22 lb Bond (50 g/m <sup>2</sup> to 81 g/m <sup>2</sup> )) 3 sheets (23 to 34 lb Bond (82 g/m <sup>2</sup> to 130 g/m <sup>2</sup> )) 2 sheets (35 to 80 lb Bond (131 g/m <sup>2</sup> to 300 g/m <sup>2</sup> ))
<b>Tri-fold tray</b> (Multi Tri-Fold)	Single-sheet fold: 40 sets 2-sheet fold: 20 sets 3-sheet fold: 13 sets 4-sheet fold: 10 sets 5-sheet fold: 8 sets (with full-load detection activated) Number of sheets folded in Multi Tri-Fold 5 sheets (14 to 22 lb Bond (50 g/m <sup>2</sup> to 81 g/m <sup>2</sup> )) 3 sheets (23 to 24 lb Bond (82 g/m <sup>2</sup> to 91 g/m <sup>2</sup> )) Number of folded sheets with Multi Tri-Fold and Crease combined 1 sheet (22 to 57 lb Bond (80 g/m <sup>2</sup> to 216 g/m <sup>2</sup> ))

## Maximum stapling capacity for plain or fine paper

### bizhub PRESS 1250/1250P/1052

Body		Cover sheet*1			
weight	Grain direction	No cover sheet*2	14 to 57 lb Bond (50 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )*2	58 to 65 lb Bond (217 g/m <sup>2</sup> to 244 g/m <sup>2</sup> )*2	66 to 80 lb Bond (245 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )*2
14 to 16 lb Bond (50 g/m <sup>2</sup> to 61 g/m <sup>2</sup> )	Short grain	50 (15~50)	45 (15~45)+1	40 (14~40)+1	40 (14~40)+1
	Long grain	30 (15~30)	29 (15~29)+1	-	-
17 to 21 lb Bond (62 g/m <sup>2</sup> to 81 g/m <sup>2</sup> )	Short grain	35 (12~35)	30 (12~30)+1	25 (11~25)+1	25 (11~25)+1
	Long grain	30 (12~30)	29 (12~29)+1	-	-
22 to 24 lb Bond (82 g/m <sup>2</sup> to 91 g/m <sup>2</sup> )	Short grain	30 (11~30)	29 (11~29)+1	24 (10~24)+1	24 (10~24)+1
	Long grain			-	-
25 to 36 lb Bond (92 g/m <sup>2</sup> to 135 g/m <sup>2</sup> )	Short grain	20 (9~20)	19 (9~19)+1	19 (8~19)+1	14 (8~14)+1
	Long grain	10 (9~10)	9 (9 only)+1	-	-
37 to 43 lb Bond (136 g/m <sup>2</sup> to 162 g/m <sup>2</sup> )	Short grain	15 (7~15)	14 (7~14)+1	14 (6~14)+1	9 (6~9)+1
	Long grain	5 (-)	4 (-)+1	-	-
44 to 57 lb Bond (163 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )	Short grain	10 (6~10)	9 (6~9)+1	9 (5~9)+1	4 (4 only)+1
	Long grain	-	-	-	-
58 to 65 lb Bond (217 g/m <sup>2</sup> to 244 g/m <sup>2</sup> )	Short grain	5 (4~5)	4 (4 only)+1	4 (3~4)+1	3 (3 only)+1
	Long grain	-	-	-	-
66 to 80 lb Bond (245 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )	Short grain	3 (3 only)	2 (2 only)+1	2 (2 only)+1	2 (2 only)+1
	Long grain	-	-	-	-

### bizhub PRESS C1070/C1070P/C1060/C71hc

### bizhub PRESS C1100/C1085

Body		Cover sheet*1			
Weight	Grain direction	No cover sheet*2	14 to 57 lb Bond (50 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )*2	58 to 65 lb Bond (217 g/m <sup>2</sup> to 244 g/m <sup>2</sup> )*2	66 to 80 lb Bond (245 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )*2
15 to 16 lb Bond (55 g/m <sup>2</sup> to 61 g/m <sup>2</sup> )*3	Short grain	50 (15~50)	45 (15~45)+1	40 (14~40)+1	40 (14~40)+1
	Long grain	30 (15~30)	29 (15~29)+1	-	-
17 to 21 lb Bond (62 g/m <sup>2</sup> to 80 g/m <sup>2</sup> )	Short grain	35 (12~35)	30 (12~30)+1	25 (11~25)+1	25 (11~25)+1
	Long grain	30 (12~30)	29 (12~29)+1	-	-
22 to 24 lb Bond (81 g/m <sup>2</sup> to 91 g/m <sup>2</sup> )	Short grain	30 (11~30)	29 (11~29)+1	24 (10~24)+1	24 (10~24)+1
	Long grain			-	-
25 to 36 lb Bond (92 g/m <sup>2</sup> to 135 g/m <sup>2</sup> )	Short grain	20 (9~20)	19 (9~19)+1	19 (8~19)+1	14 (8~14)+1
	Long grain	10 (9~10)	9 (9 only)+1	-	-
37 to 46 lb Bond (136 g/m <sup>2</sup> to 176 g/m <sup>2</sup> )	Short grain	15 (7~15)	14 (7~14)+1	14 (6~14)+1	9 (6~9)+1
	Long grain	5 (-)	4 (-)+1	-	-
47 to 57 lb Bond (177 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )	Short grain	10 (6~10)	9 (6~9)+1	9 (5~9)+1	4 (4 only)+1
	Long grain	-	-	-	-
58 to 68 lb Bond (217 g/m <sup>2</sup> to 256 g/m <sup>2</sup> )	Short grain	5 (4~5)	4 (4 only)+1	4 (3~4)+1	3 (3 only)+1
	Long grain	-	-	-	-
69 to 80 lb Bond (257 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )	Short grain	3 (3 only)	2 (2 only)+1	2 (2 only)+1	2 (2 only)+1
	Long grain	-	-	-	-

\*1: Applied when grain long paper is used as a cover sheet.

Paper type: grain long Kent paper must not be used. Any other paper type is acceptable.

Any grain long paper other than Kent paper can still result in paper wrinkling or cracked image.

\*2: For 4-position stapling, the quantity limits are indicated in parentheses.

\*3: **bizhub PRESS C1100/C1085** only

### Maximum stapling capacity for coated or color paper

#### bizhub PRESS 1250/1250P/1052

Body		Cover sheet*1			
weight	Grain direction	No cover sheet*2	14 to 57 lb Bond (50 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )*2	58 to 65 lb Bond (217 g/m <sup>2</sup> to 244 g/m <sup>2</sup> )*2	66 to 80 lb Bond (245 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )*2
14 to 16 lb Bond (50 g/m <sup>2</sup> to 61 g/m <sup>2</sup> )	Short grain	30 (15~30)	29 (15~29)+1	24 (14~24)+1	24 (14~24)+1
	Long grain			-	-
17 to 21 lb Bond (62 g/m <sup>2</sup> to 81 g/m <sup>2</sup> )	Short grain	30 (12~30)	29 (12~29)+1	24 (11~24)+1	24 (11~24)+1
	Long grain			-	-
22 to 24 lb Bond (82 g/m <sup>2</sup> to 91 g/m <sup>2</sup> )	Short grain	15 (11~15)	14 (11~14)+1	14 (10~14)+1	9 (8~9)+1
	Long grain			-	-
25 to 36 lb Bond (92 g/m <sup>2</sup> to 135 g/m <sup>2</sup> )	Short grain	10 (9~10)	9 (9 only)+1	9 (8~9)+1	4 (-)+1
	Long grain			-	-
37 to 43 lb Bond (136 g/m <sup>2</sup> to 162 g/m <sup>2</sup> )	Short grain	5 (-)	4 (-)+1	4 (-)+1	-
	Long grain			-	-
44 to 57 lb Bond (163 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )	Short grain	-	-	-	-
	Long grain	-	-	-	-
58 to 65 lb Bond (217 g/m <sup>2</sup> to 244 g/m <sup>2</sup> )	Short grain	-	-	-	-
	Long grain	-	-	-	-
66 to 80 lb Bond (245 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )	Short grain	-	-	-	-
	Long grain	-	-	-	-

#### bizhub PRESS C1070/C1070P/C1060/C71hc

#### bizhub PRESS C1100/C1085

Body		Cover sheet*1			
Weight	Grain direction	No cover sheet*2	14 to 57 lb Bond (50 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )*2	58 to 65 lb Bond (217 g/m <sup>2</sup> to 244 g/m <sup>2</sup> )*2	66 to 80 lb Bond (245 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )*2
15 to 16 lb Bond (55 g/m <sup>2</sup> to 61 g/m <sup>2</sup> ) *3	Short grain	30 (15~30)	29 (15~29)+1	24 (14~24)+1	24 (14~24)+1
	Long grain			-	-
17 to 21 lb Bond (62 g/m <sup>2</sup> to 80 g/m <sup>2</sup> )	Short grain	30 (12~30)	29 (12~29)+1	24 (11~24)+1	24 (11~24)+1
	Long grain			-	-
22 to 24 lb Bond (81 g/m <sup>2</sup> to 91 g/m <sup>2</sup> )	Short grain	15 (11~15)	14 (11~14)+1	14 (10~14)+1	9 (8~9)+1
	Long grain			-	-
25 to 36 lb Bond (92 g/m <sup>2</sup> to 135 g/m <sup>2</sup> )	Short grain	10 (9~10)	9 (9 only)+1	9 (8~9)+1	4 (-)+1
	Long grain			-	-
37 to 46 lb Bond (136 g/m <sup>2</sup> to 176 g/m <sup>2</sup> )	Short grain	5 (-)	4 (-)+1	4 (-)+1	-
	Long grain			-	-

47 to 57 lb Bond (177 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )	Short grain	-	-	-	-
	Long grain	-	-	-	-
58 to 68 lb Bond (217 g/m <sup>2</sup> to 256 g/m <sup>2</sup> )	Short grain	-	-	-	-
	Long grain	-	-	-	-
69 to 80 lb Bond (257 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )	Short grain	-	-	-	-
	Long grain	-	-	-	-

\*1: Applied when grain long paper is used as a cover sheet.

Paper type: grain long Kent paper must not be used. Any other paper type is acceptable.

Any grain long paper other than Kent paper can still result in paper wrinkling or cracked image.

\*2: For 4-position stapling, the quantity limits are indicated in parentheses.

\*3: bizhub PRESS C1100/C1085 only

### Maximum stapling capacity for paper with width less than 7.15 inches or 182 mm (smaller than B5 )

**bizhub PRESS 1250/1250P/1052**

Body weight	Cover sheet* <sup>1</sup>		
	No cover sheet	14 to 57 lb Bond (50 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )	58 to 80 lb Bond (217 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )
14 to 20 lb Bond (50 g/m <sup>2</sup> to 74 g/m <sup>2</sup> )	16	15+1	15+1
21 to 24 lb Bond (75 g/m <sup>2</sup> to 91 g/m <sup>2</sup> )			
25 to 36 lb Bond (92 g/m <sup>2</sup> to 135 g/m <sup>2</sup> )	8	7+1	3+1
37 to 43 lb Bond (136 g/m <sup>2</sup> to 162 g/m <sup>2</sup> )	4	3+1	

**bizhub PRESS C1070/C1070P/C1060/C71hc**  
**bizhub PRESS C1100/C1085**

Body weight	Cover sheet* <sup>1</sup>		
	No cover sheet	14 to 57 lb Bond (50 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )	58 to 80 lb Bond (217 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )
15 to 16 lb Bond (55 g/m <sup>2</sup> to 61 g/m <sup>2</sup> )* <sup>2</sup>	16	15+1	15+1
17 to 21 lb Bond (62 g/m <sup>2</sup> to 80 g/m <sup>2</sup> )			
22 to 24 lb Bond (81 g/m <sup>2</sup> to 91 g/m <sup>2</sup> )			
25 to 36 lb Bond (92 g/m <sup>2</sup> to 135 g/m <sup>2</sup> )	8	7+1	3+1
37 to 46 lb Bond (136 g/m <sup>2</sup> to 176 g/m <sup>2</sup> )	4	3+1	


































\*1: Applied when grain long paper is used as a cover sheet.

Paper type: grain long Kent paper must not be used. Any other paper type is acceptable.

Any grain long paper other than Kent paper can still result in paper wrinkling or cracked image.

\*2: bizhub PRESS C1100/C1085 only

## 2.4.3 Paper Size

Paper output device	Available sizes
<b>Secondary (sub) tray</b>	<p>Standard:  A3 , B4 , A4 , B5 , A5 , B6 , A6 , Foolscap,  Postcard , SRA3 , SRA4 , 13 × 19 , 12 × 18 , 11 × 17 ,  8.5 × 14 , 8.5 × 11 , 5.5 × 8.5 , 9 × 11 , 7.25 × 10.5 , 8K ,  16K </p> <p>Custom:  min. 3.74" × 5.24" to max. 13.03" × 19.21" (min. 95 mm × 133 mm to max.  331 mm × 488 mm)  Wide Paper  Tab Paper (Tab edge only at output)</p>
<b>Bundle exit tray (Fold &amp; Staple / Multi Half-Fold + Fore-edge Trimming)</b>	<p>Standard:  A3 , B4 , A4 , B5 , Foolscap, SRA3 , SRA4 , 12 × 18 ,  11 × 17 , 8.5 × 14 , 8.5 × 11 , 7.25 × 10.5 , 8K , 16K </p> <p>Custom:  min. 4.72" × 10.12" to max. 13.03" × 19.21" (min. 120 mm × 257 mm to  max. 331 mm × 488 mm)  Wide Paper  4-position stapling size in Fold &amp; Staple:  <ul style="list-style-type: none"> <li>Paper width: 10.98" to 11.69" (279 mm to 297 mm)</li> <li>Paper length: 9.45" to 19.21" (240 mm to 488 mm)</li> </ul> (10.12" to 19.21" (257 mm to 488 mm) for Fore-edge Trimming)  Guaranteed only for 297 mm × 420 mm (A3), and 279 mm × 431.8 mm  (11 × 17).</p>
<b>Tri-fold tray</b>	Standard: A4  , 8.5 × 11 

## 2.5 Machine Screen

### 2.5.1 Screen with SD-513 installed



No.	Name	Description
1	SD-513	Displayed when <b>Saddle Stitcher SD-513</b> is installed on this machine.
2	Tray information indicator (PI-PFU tray, Upper tray and lower tray of the post inserter, cover tray)	When the machine is equipped with <b>Large Capacity Post Inserters PI-PFU</b> , displays the paper size, orientation, paper name, weight specified, and remaining amount for the PI-PFU tray. Displays the paper size specified in "Cover Size Setting [Slit(Cover Only)]" for the paper tray, and the paper name and weight specified in "Common Setting" when <b>Trimmer Unit TU-503</b> is equipped in <b>Saddle Stitcher SD-513</b> .
3	Post Inserters tray setting display change button (Displayed only in <b>bizhub PRESS 1250/1250P/1052</b> .)	When the main body is equipped with a perfect binder, press this button to switch the display between "Normal Use Setting" and "Perfect Bind Cover Setting" specified in the Tray Setting for the PI-PFU tray or the post inserter tray of <b>Folding Unit FD-503</b> . When the main body is equipped with <b>Saddle Stitcher SD-513</b> with <b>Trimmer Unit TU-503</b> installed, press this button to switch the paper size display to that of "Cover Tray Setting [Slit(Cover Only)]" specified for PI-PFU trays, the paper tray of the post inserter of <b>Folding Unit FD-503</b> , or the paper tray of the post inserter attached to <b>Folding Unit FD-503</b> , in the Tray Setting.

## 2.5.2 Setting Screen with SD-513 installed

When **Saddle Sticher SD-513** is installed on this machine, functions can be adjusted using the [Adjustment] Screen at the bottom of the Machine Screen.



### [Adjustment]

Press [Adjustment] to display the Adjustment Screen. See "5 Various Settings and Adjustment" (page 5-2) for details on setting items.







## **Supplies and Disposals**

## 3 Supplies and Disposals

This section describes the indicators to be displayed when a specific process is required, and provides instructions on how to perform the process.

### 3.1 Replenishing Staple Supply

**Saddle Stitcher SD-513** is equipped with a **stapler**.

This section describes indications on the screen to inform you that the staple supply is due, and also instructions on how to replenish it.

#### 3.1.1 Replenishing Staple Supply in Saddle Stitcher SD-513

When the staple cartridge of **Saddle Stitcher SD-513** becomes empty, the following message will appear in the message area of the screen.

[Please add staples to the saddle stitcher stapler]

Also, the message [Staple Cartridge Supply] appears and its indicator lights in red in the Supply/Scrap Parts area of the Machine Screen.

Follow the procedure below to add staples to the specified **stapler**.



#### NOTICE

Hold both left and right sides of the staple cartridge, then draw it forward.

Check that the top side of the staple cartridge is up. With the top side down, the staple cartridge cannot be inserted.

- 1 Press [?] at the upper-right corner of the Machine Screen, or press [Help] on the **control panel**.  
A help message for the Machine Screen will be displayed at the top of the screen.

- 2 Press [Consumable/Scrap] at the lower-right corner of the help message area.



- 3 Press the [Add Staples] tab at the top of the help message area.  
If [▶] is displayed at the upper right of the screen, press it to display all the tabs.



- 4 Perform the process while pressing [▲] or [▼] to follow the steps.



## 3.2 Disposing Trimmings

Saddle Stitcher SD-513 is equipped with a trimmer.

This section describes indications on the screen to inform you that the disposal of trimmings is due, and also instructions on how to dispose it.

### 3.2.1 Emptying Trim Scrap Box of Saddle Stitcher SD-513

When the **trim scrap box** of **Saddle Stitcher SD-513** becomes full, the following message will appear in the message area of the screen.

[Fore-edge trimming scrap box is full / Please empty trimming scrap box]

Also, the message [SD trim scrap is full] appears and its indicator lights in red in the Supply/Scrap Parts area of the Machine Screen.

Follow the procedure below to dispose of trim scraps.



#### NOTICE

The trim scrap box is not disposable. Be sure to return it to the **trim scrap tray** after disposing of trim scraps.

- 1 Press [ ? ] at the upper-right corner of the Machine Screen, or press [Help] on the **control panel**.  
A help message for the Machine Screen will be displayed at the top of the screen.
- 2 Press [Consumable/Scrap] at the lower-right corner of the help message area.



- 3 Press the [Trim Scrap] tab at the top of the help message area.  
If [▶] is displayed at the upper right of the screen, press it to display all the tabs.



- 4 Perform the process while pressing [▲] or [▼] to follow the steps.



### 3.2.2 Emptying Slit Scrap Box of Saddle Stitcher SD-513

When the **slit scrap box** of **Saddle Stitcher SD-513** becomes full, the following message will appear in the message area of the screen.

[Saddle stitcher slit scrap box is full / Pull the lever to remove the scrap box]

Also, the message [SD slit scrap is full] appears and its indicator lights in red in the Supply/Scrap Parts area of the Machine Screen.

Follow the procedure below to dispose of slit scraps.



#### NOTICE

The **slit scrap box door** can be opened while machine operation is in progress, but the lock can only be released when pulling the **scrap box lock release lever**.

The trim scrap box is not disposable. Be sure to return the trim scrap box to its original position after emptying it.

- 1 Press [?] at the upper-right corner of the Machine Screen, or press [Help] on the **control panel**.  
A help message for the Machine Screen will be displayed at the top of the screen.
- 2 Press [Consumable/Scrap] at the lower-right corner of the help message area.



- 3 Press the [Slit Scrap] tab at the top of the help message area.  
If [▶] is displayed at the upper right of the screen, press it to display all the tabs.



- 4 Perform the process while pressing [▲] or [▼] to follow the steps.





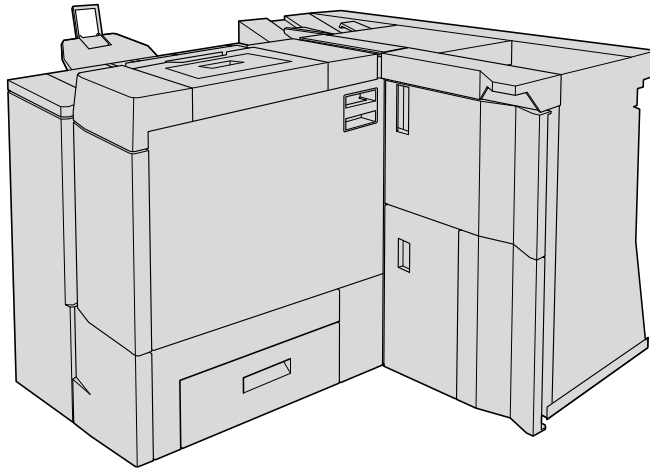


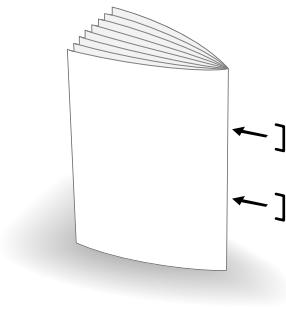
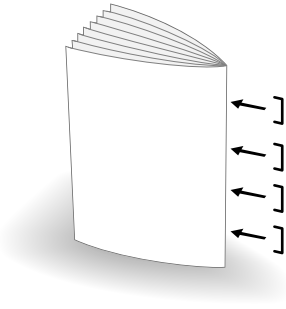
## **Using Saddle Stitcher SD-513**

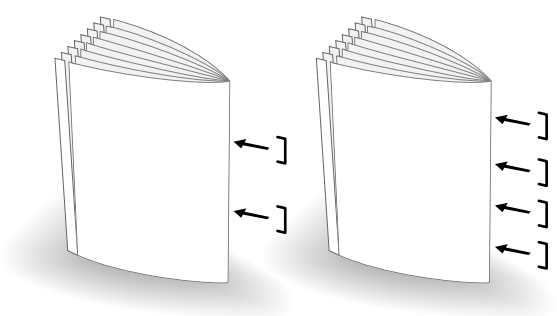
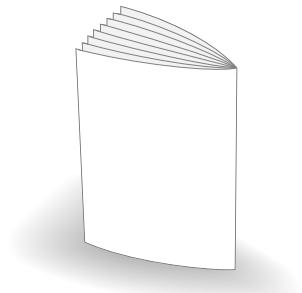
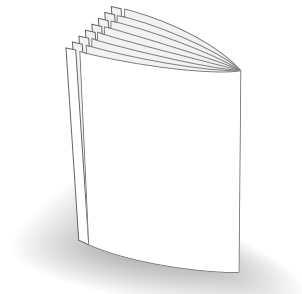
## 4 Using Saddle Stitcher SD-513

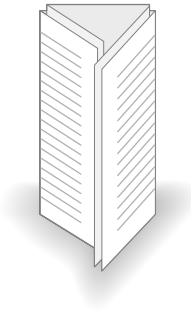
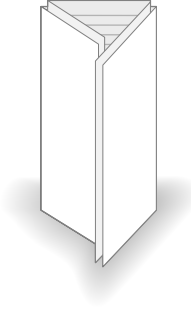
### 4.1 Basic Functions of Saddle Stitcher SD-513

The machine with **Saddle Stitcher SD-513** installed provides the following basic functions.



Operation	Function	Illustration
Fold & Staple (+ Fore-edge Trimming)	Using Booklet as an application function in combination, creates a multiple page signature booklet folded and stapled in the center. For Staple, select [2 Positions] or [4 Positions]. Using fore-edge trimming, trim the lead edge of sheets. Delivers output onto the <b>bundle exit tray</b> .	<p>[Fold&amp;Staple] + [2 Positions]</p>  <p>[Fold &amp; Staple] + [4 Positions]</p> 

Operation	Function	Illustration
		<div>[Fold&amp;Staple] + [Fore-edge Trimming]</div> 
Multi Half-Fold (+ Fore-edge Trimming)	Using Booklet as an application function in combination, doubles up to 5 sheets of printed set. Using fore-edge trimming, trim the lead edge of sheets. Delivers output onto the <b>bundle exit tray</b> .	<div>[Multi Half]</div>  <div>[Multi Half] + [Fore-edge Trimming]</div> 

Operation	Function	Illustration
Multi Tri-Fold	Fold sheets in three. Select [Outside Print] or [Inside Print] to have the printed image. Delivers output onto the <b>tri-fold tray</b> .	[Multi 3-Fold] + [Outside Print] 
		[Multi 3-Fold] + [Inside Print] 

Functions can be added to **Saddle Stitcher SD-513** by attaching the following 3 options as required.

- **Creaser Unit CR-101:** Crease
- **Trimmer Unit TU-503:** 2-Side Slitting
- **Folding Unit FD-504:** Spine Corner Forming

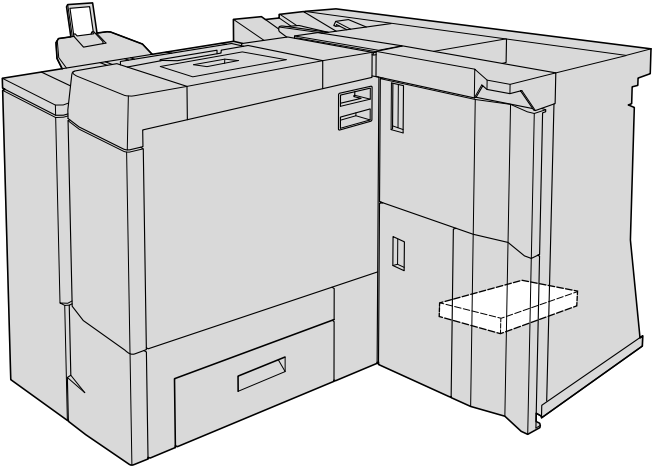
See page 4-5 for details.

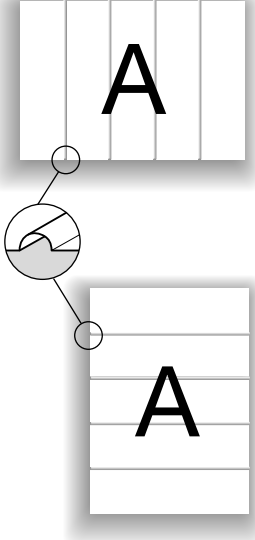
By using **Saddle Stitcher SD-513** and **Perfect Binder PB-503** in combination, spine corners can be formed before binding the cover, thus preventing toner flaking off the cover, which could occur while binding, or improving the presentability of bound sets. Page flip should also become smoother with added fold lines along the gutter. See page 4-68 for details.

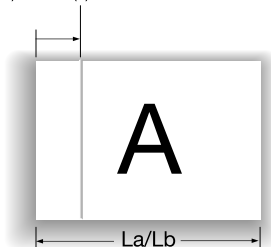
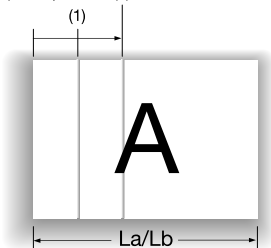
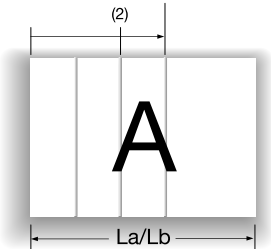
4.2 Additional Functions of Saddle Stitcher SD-513

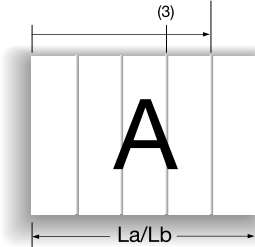
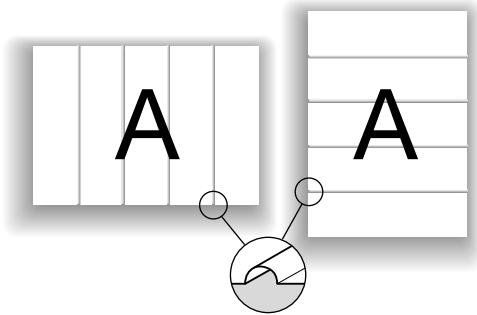
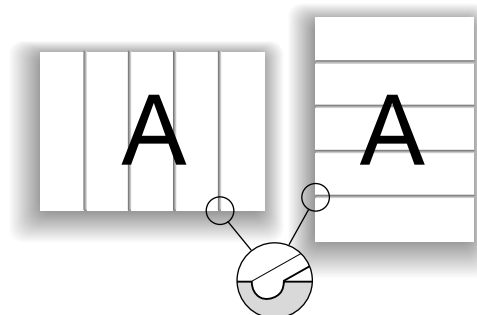
4.2.1 Creaser Unit CR-101

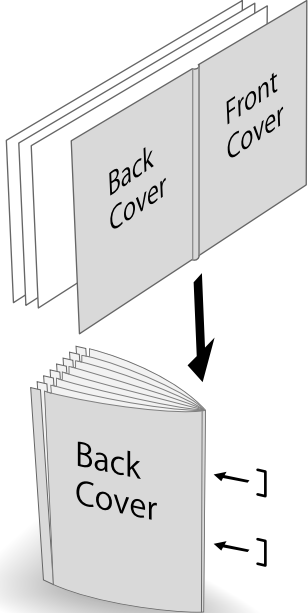
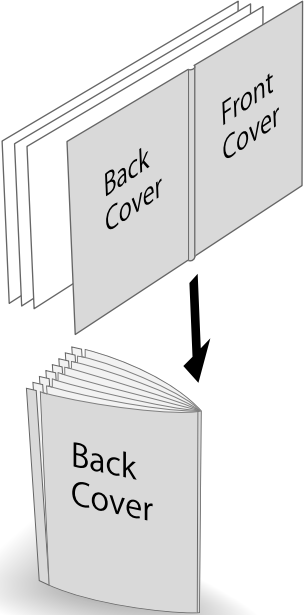
In addition to the basic functions provided by **Saddle Stitcher SD-513**, **Creaser Unit CR-101** can be used to add fold lines (crease) on output sheets.

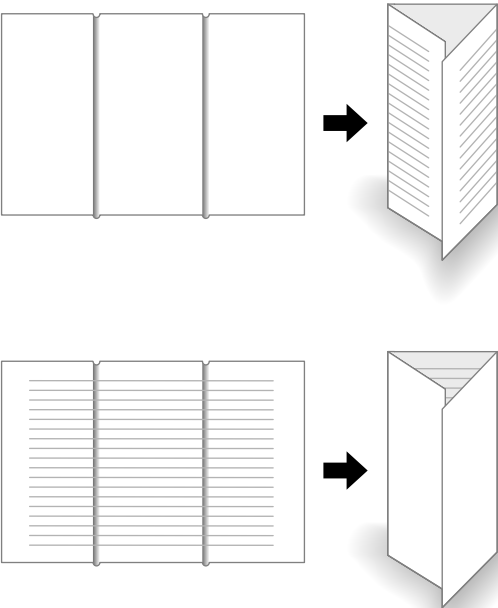


Option	Key Operation	Description and Illustration
Crease	[Crease]	<p>Adds fold lines on all sheets. Any other finishing operation, except for that with a perfect binder, is not available while using this option.</p> <p>For [The Number of Creases], select [1 Piece], [2 Pieces], [3 Pieces], or [4 Pieces]. When creating multiple creases, [Front] and [Back] cannot be mixed.</p> 

Option	Key Operation	Description and Illustration
		<p>The [Crease Position] options are as follows:  Crease Position shifts according to the paper length  (on the longer side).  Paper length La: 240 mm or more, 336 mm or less  Paper length Lb: 337 mm or more, 488 mm or less</p> <p>Crease Position (1):  Paper La: 7 mm to (La - 46) mm (in 0.1 mm increments)  Paper Lb: (Lb - 330) mm to 290 mm (in 0.1 mm increments)</p> <p>La: <math>7 \text{ mm} \leq (1) \leq (La - 46) \text{ mm}</math>  Lb: <math>(Lb - 330) \text{ mm} \leq (1) \leq 290 \text{ mm}</math></p>  <p>Crease Position (2):  Paper La: (position of (1) + 1.0) mm to (La - 46) mm  (in 0.1 mm increments)  Paper Lb: (position of (1) + 1.0) mm to 290 mm (in 0.1 mm increments)</p> <p>La: <math>((1) + 1.0) \text{ mm} \leq (2) \leq (La - 46) \text{ mm}</math>  Lb: <math>((1) + 1.0) \text{ mm} \leq (2) \leq 290 \text{ mm}</math></p>  <p>Crease Position (3):  Paper La: (position of (2) + 1.0) mm to (La - 46) mm  (in 0.1 mm increments)  Paper Lb: (position of (2) + 1.0) mm to 290 mm  (in 0.1 mm increments)</p> <p>La: <math>((2) + 1.0) \text{ mm} \leq (3) \leq (La - 46) \text{ mm}</math>  Lb: <math>((2) + 1.0) \text{ mm} \leq (3) \leq 290 \text{ mm}</math></p> 

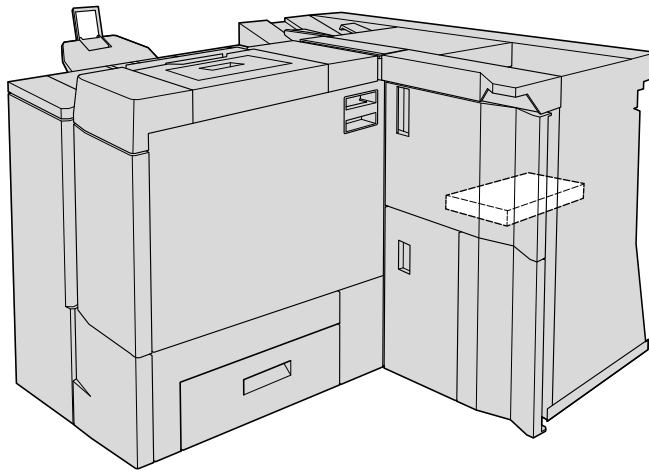
Option	Key Operation	Description and Illustration
		<p>Crease Position (4): Paper La: (position of (3) + 1.0) mm to (La - 46) mm (in 0.1 mm increments) Paper Lb: (position of (3) + 1.0) mm to 290 mm (in 0.1 mm increments)</p> <p><math display="block">La: ((3) + 1.0) \text{ mm} \leq (4) \leq (La - 46) \text{ mm}</math><math display="block">Lb: ((3) + 1.0) \text{ mm} \leq (4) \leq 290 \text{ mm}</math></p>  <p>For [Crease Side], select [Front] or [Back]. [Front]</p>  <p>[Back]</p>  <p>The following trays can be selected as output trays.</p> <ul style="list-style-type: none"><li>• <b>Secondary (sub) tray or bundle exit tray of Saddle Stitcher SD-513</b></li><li>• <b>Secondary (sub) tray of Perfect Binder PB-503</b></li><li>• <b>Primary (main) tray/secondary (sub) tray of Finisher FS-532</b></li></ul>

Option	Key Operation	Description and Illustration
Crease + Fold & Staple (+ Fore-edge Trimming)	[Fold&Staple] [Fold & Staple Setting] [Crease] to be set to [ON]	<p data-bbox="863 199 1426 333">Using Booklet as an application function in combination, when selecting [Cover With Copy Sheet], or [Cover With Blank Sheet], adds a single crease on cover only and fold &amp; staple with body. Fore-edge trimming can be combined.</p> 
Crease + Multi Half-Fold (+ Fore-edge Trimming)	[Multi Half] [Multi Half-Fold Setting] [Crease] to be set to [ON]	<p data-bbox="863 1055 1426 1189">Using Booklet as an application function in combination, when selecting [Cover With Copy Sheet], or [Cover With Blank Sheet], adds a single crease on cover only and multi half-fold with body. Fore-edge trimming can be combined.</p> 

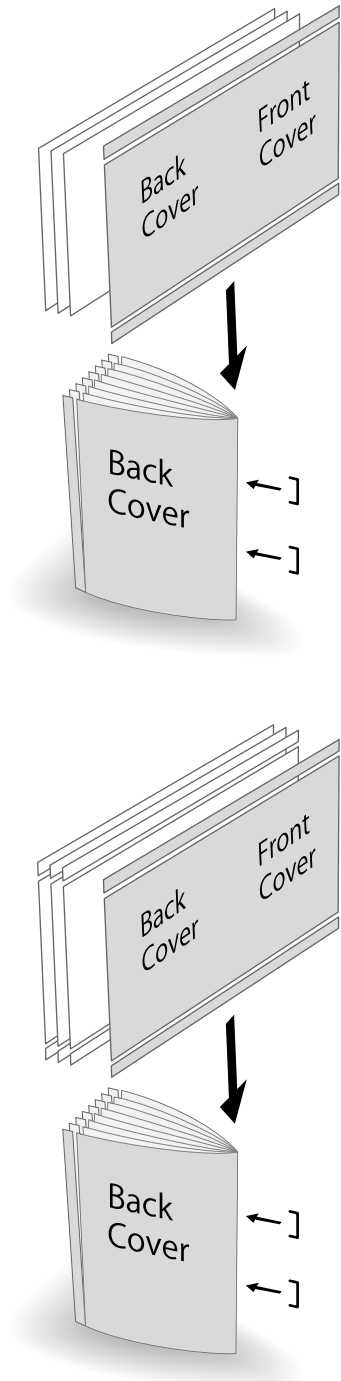
Option	Key Operation	Description and Illustration
Crease + Multi Tri-Fold	[Multi 3-Fold] [Fold Setting] [Crease] to be set to [ON]	<p>Adds 2 creases on all sheets, and fold them in three. In this case only one sheet is folded. Multi tri-fold is not performed.</p> 

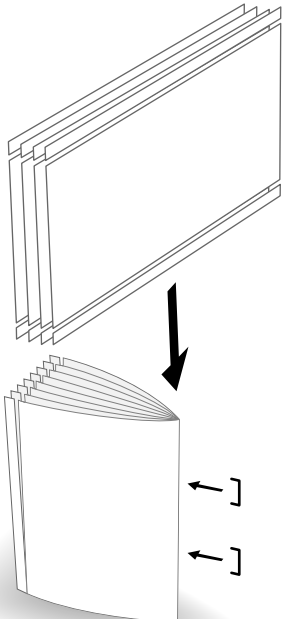
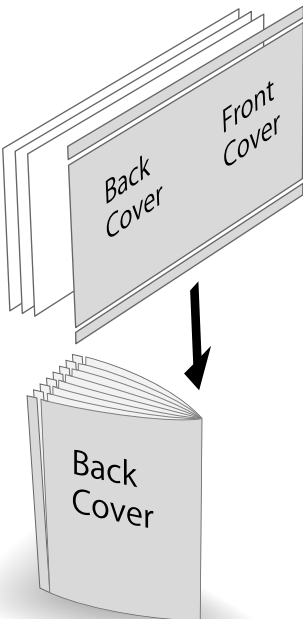
### 4.2.2 Trimmer Unit TU-503

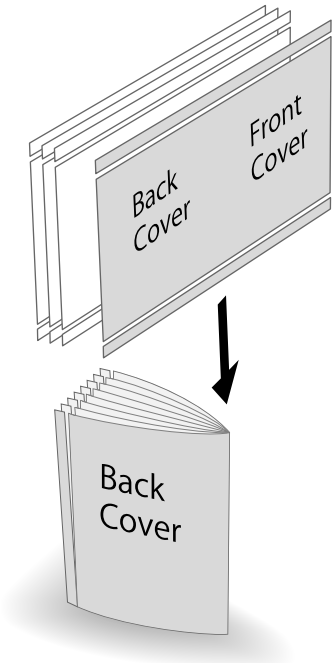
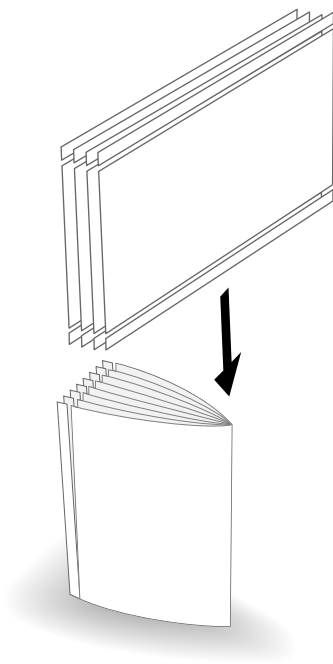
2-side slitting is available by using **Trimmer Unit TU-503**, in addition to the basic functions provided with **Saddle Stitcher SD-513**.

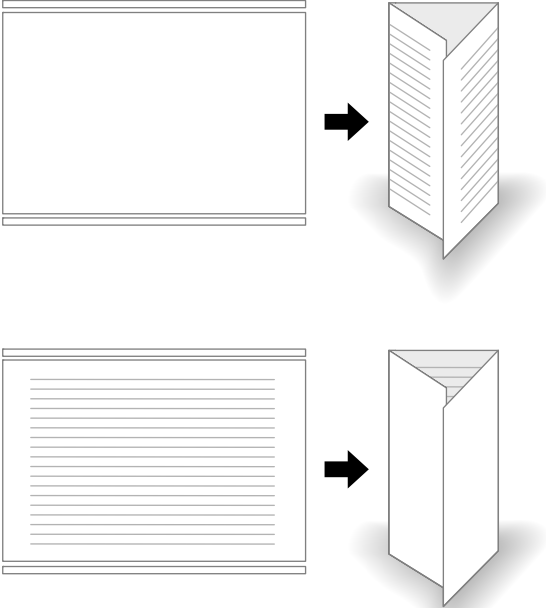


Option	Key Operation	Description and Illustration
2-Side Slitting	[2-Side Slit]	<p>Slit both the head and the foot of all sheets. The head and the foot are determined when sheets are positioned for conveyance.</p> <p>Trimming can be specified separately for the head and the foot.</p> <p>[Slitting] can be specified within the range from 8.0 mm to 26.0 mm in increments of 0.1 mm. The difference of specified slitting between the head and the foot must not exceed 10 mm.</p> <p>[Offset against Cover] will not function, even if specified.</p> <div style="text-align: center;"> </div> <p>The following trays can be selected as output trays.</p> <ul style="list-style-type: none"> <li>• <b>Secondary (sub) tray</b> or <b>bundle exit tray</b> of <b>Saddle Stitcher SD-513</b></li> <li>• <b>Secondary (sub) tray</b> of <b>Perfect Binder PB-503</b></li> <li>• <b>Primary (main) tray/secondary (sub) tray</b> of <b>Finisher FS-532</b></li> </ul>

Option	Key Operation	Description and Illustration
2-Side Slitting + Fold & Staple (+ Fore-edge Trimming)	[Fold&Staple] [Fold & Staple Setting] [(2)2-Side Slitting] to be set to [ON]	<p>Use Booklet as an application function in combination.</p> <p>When selecting [Cover With Copy Sheet], or [Cover With Blank Sheet], perform 2-side slitting on cover only, or on entire body. The slitting amount of body relative to cover can be specified within the range from -1.0 mm to +1.0 mm in increments of 0.1 mm. Fore-edge trimming can be combined.</p> 

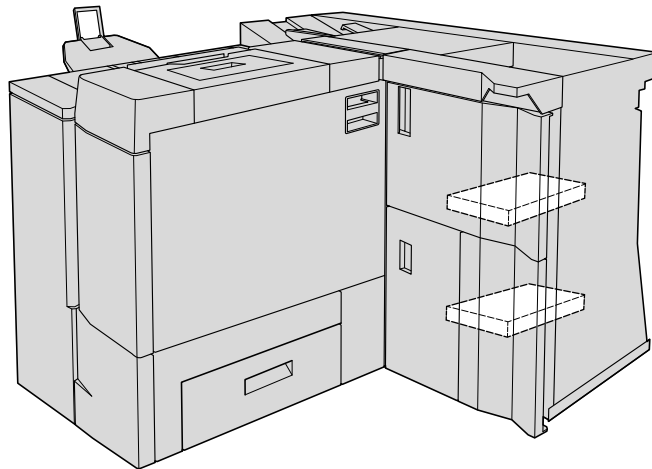
Option	Key Operation	Description and Illustration
		<p>Select [No Cover Sheet] to perform 2-side slitting on all body sheets. Fore-edge trimming can be combined.</p> 
2-Side Slitting + Multi Half-Fold (+ Fore-edge Trimming)	[Multi Half] [Multi Half-Fold Setting] [(2)2-Side Slitting] to be set to [ON]	<p>Use Booklet as an application function in combination. When selecting [Cover With Copy Sheet], or [Cover With Blank Sheet], perform 2-side slitting on cover only, or on entire body. Fore-edge trimming can be combined.</p> 

Option	Key Operation	Description and Illustration
		<div></div> <p>Select [No Cover Sheet] to perform 2-side slitting on all body sheets. Fore-edge trimming can be combined.</p> <div></div>

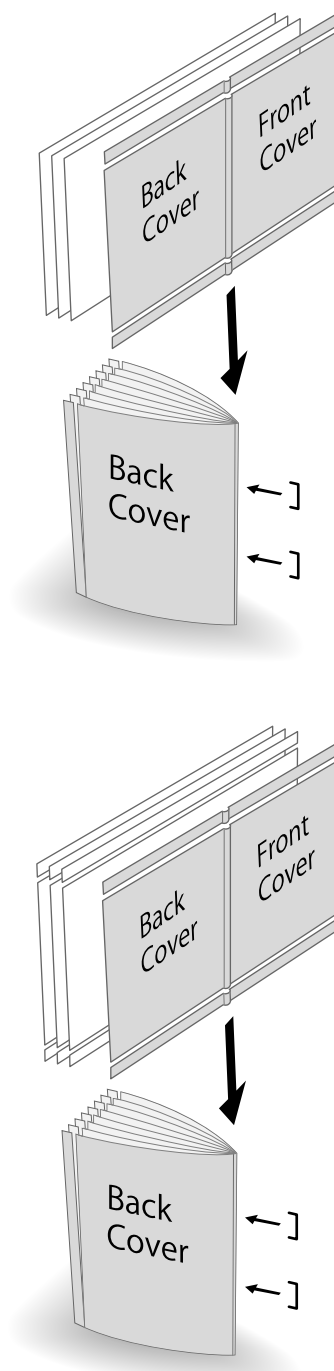
Option	Key Operation	Description and Illustration
2-Side Slitting + Multi Tri-Fold	[Multi 3-Fold] [Fold Setting] [2-Side Slitting] to be set to [ON]	<p>Perform 2-side slitting on all sheets. In this case only one sheet is folded. Multi fold is not performed.</p> 

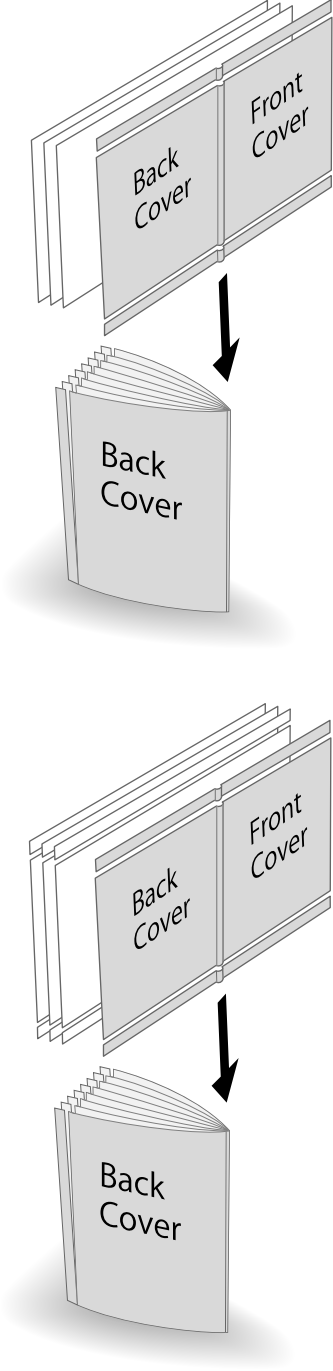
### 4.2.3 Combination of Creaser Unit CR-101 and Trimmer Unit TU-503

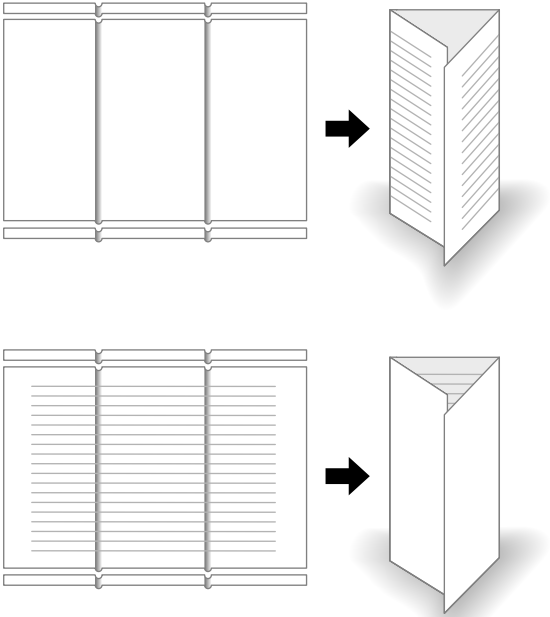
Fold line (crease) and 2-side slitting functions can be used in combination by using **Creaser Unit CR-101** and **Trimmer Unit TU-503**, in addition to the basic functions provided with **Saddle Stitcher SD-513**.



Option	Key Operation	Description and Illustration
Crease + 2-Side Slitting	[Crease] [2-Side Slit]	Adds fold lines and performs 2-side slitting on all sheets. For details on Crease and 2-Side Slitting, see "Crease" in the table in "Creaser Unit CR-101" (page 4-5) and "2-Side Slitting" in the table in "Trimmer Unit TU-503" (page 4-10).

Option	Key Operation	Description and Illustration
Crease + 2-Side Slitting + Fold & Staple (+ Fore- edge Trimming)	[Fold&Staple] [Fold & Staple Set- ting] [Crease] to be set to [ON] [Fold & Staple Set- ting] [(2)2-Side Slit- ting] to be set to [ON]	<p>Using Booklet as an application function in combina- tion, when selecting [Cover With Copy Sheet], or [Cover With Blank Sheet], adds a single crease on cover only and fold &amp; staple with body.</p> <p>Perform 2-side slitting on cover sheets only, or slit all body sheets. The slitting amount of body relative to cover can be specified within the range from -1.0 mm to +1.0 mm in increments of 0.1 mm. Fore-edge trimming can be combined.</p> 

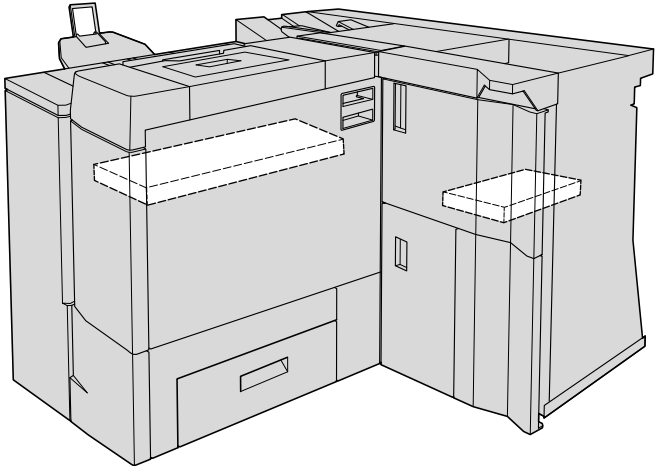
Option	Key Operation	Description and Illustration
Crease + 2-Side Slitting + Multi Half-Fold (+ Fore-edge Trimming)	[Multi Half] [Multi Half-Fold Setting] [Crease] to be set to [ON] [Multi Half-Fold Setting] [(2)2-Side Slitting] to be set to [ON]	<p>Using Booklet as an application function in combination, when selecting [Cover With Copy Sheet], or [Cover With Blank Sheet], adds a single crease on cover only and multi half-fold with body. Fore-edge trimming can be combined.</p> <p>Perform 2-side slitting on cover sheets only, or slit all body sheets. The slitting amount of body relative to cover can be specified within the range from -1.0 mm to +1.0 mm in increments of 0.1 mm. Fore-edge trimming can be combined.</p> 

Option	Key Operation	Description and Illustration
Crease + 2-Side Slitting + Multi Tri-Fold	[Multi 3-Fold] [Fold Setting] [Crease] to be set to [ON] [Fold Setting] [2-Side Slitting] to be set to [ON]	<p>Adds 2 creases on all sheets, and fold them in three. In this case only one sheet is folded. Multi tri-fold is not performed.</p> 

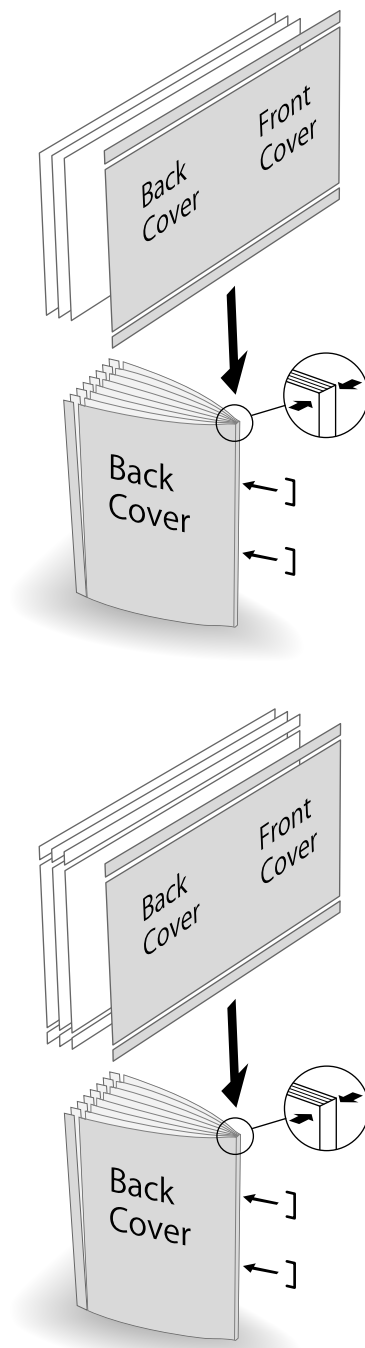
4.2.4 Folding Unit FD-504

Spine corner forming for fold & stapled sets is available by using **Folding Unit FD-504** with **Saddle Stitcher SD-513**. Also use **Trimmer Unit TU-503** as an application function in combination to form spine corners on fold & stapled sets that have come through 2-side slitting operation.

Spine corner forming is available only in combination with fold & staple.



Option	Key Operation	Description and Illustration
Spine Corner Forming + Fold & Staple (+ Fore-edge Trimming)	[Fold&Staple] [Fold & Staple Setting] [Spine Corner Forming] to be set to [ON]	Use Booklet as an application function in combination, and form spine corners on fold & stapled sets. For [Spine Corner Forming Strength], select [Strong+], [Strong], [Normal], [Weak], or [Weak+]. 

Option	Key Operation	Description and Illustration
Spine Corner Forming + 2-Side Slitting + Fold & Staple (+ Fore-edge Trimming)	[Fold&Staple] [Fold & Staple Setting] [Spine Corner Forming] to be set to [ON] [Fold & Staple Setting] [(2)2-Side Slitting] to be set to [ON]	<p>Use Booklet as an application function in combination, and form spine corners on fold &amp; stapled sets. For [Spine Corner Forming Strength], select [Strong+], [Strong], [Normal], [Weak], or [Weak+]. Perform 2-side slitting on cover only, or slit entire body. The slitting amount of body relative to cover can be specified within the range from -1.0 mm to +1.0 mm in increments of 0.1 mm. Fore-edge trimming can be combined.</p> 

### 4.2.5 Combination of Basic Functions and Additional Functions

The following table summarizes the combined use of basic functions and additional functions of the saddle stitcher.

Operation	Crease								2-Side Slit-ting		Spine Corner Forming
	Cover only				Body				Cover only	Body	
	1 line	2 lines	3 lines	4 lines	1 line	2 lines	3 lines	4 lines			
Fold & Staple (+ Fore-edge Trim-ming)	✓✓	-	-	-	-	-	-	-	✓	✓✓	-
	-	-	-	-	-	-	-	-	✓	✓✓	✓✓
Multi Half-Fold (+ Fore-edge Trim-ming)	✓✓	-	-	-	-	-	-	-	✓	✓✓	-
Multi Tri-Fold	-	-	-	-	-	✓✓	-	-	-	✓	-

✓✓: Adjustable for higher accuracy.

✓: Available and adjustable.

-: Not available.

The following table summarizes the combined use of other options and additional functions of the saddle stitcher.

Operation	Crease								2-Side Slit-ting		Spine Corner Forming
	Cover only				Body				Cover only	Body	
	1 line	2 lines	3 lines	4 lines	1 line	2 lines	3 lines	4 lines			
Output to secondary (sub) tray of <b>Saddle Stitcher SD-513</b> , <b>Perfect Binder PB-503</b> , or <b>Finisher FS-532</b>	-	-	-	-	✓✓	✓✓	✓	✓	✓	✓✓	-
Output to primary (main) tray of <b>Finisher FS-532</b>	-	-	-	-	✓✓	✓✓	✓	✓	✓	✓	-

✓✓: Adjustable for higher accuracy.

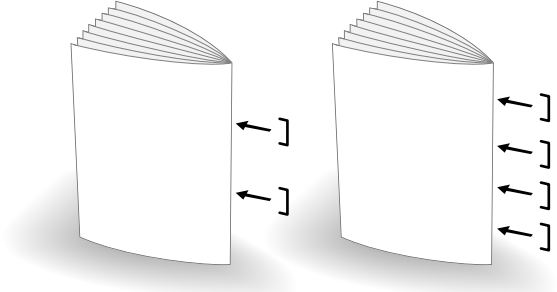
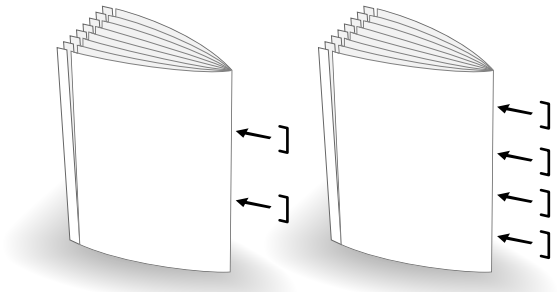
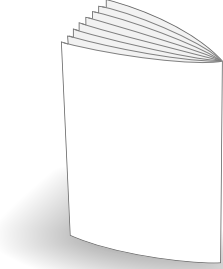
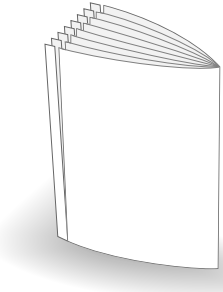
✓: Available and adjustable.

-: Not available.

## 4.3 Making Folded Booklets: Fold & Staple/Multi Half-Fold

### 4.3.1 Functional Overview

The machine with **Saddle Stitcher SD-513** installed provides the following functions.

Output mode	Details	Illustration
[Fold&Staple] + [(1)Fore-edge Trim- ming] set to [OFF]	Using Booklet as an ap- plication function in combination, creates a multiple page signature booklet folded and sta- pled at two or four posi- tions (saddle stitched) in the center.	
[Fold&Staple] + [(1)Fore-edge Trim- ming] set to [ON]	Trims the fore edge of booklets created using [Fold&Staple].	
[Multi Half] + [(1)Fore-edge Trim- ming] set to [OFF]	Using Booklet as an ap- plication function in combination, doubles up to 5 sheets of printed set.	
[Multi Half] + [(1)Fore-edge Trim- ming] set to [ON]	Trims the fore edge of doubled sheets created using [Multi Half].	



#### Reference

Please check paper information before use. See "Paper Information" (page 2-12) for details.

#### NOTICE

The multi half-folded and stapled sets will be delivered onto the **bundle exit tray**. Set up the **bundle exit tray extension**, and follow the preparation process before opening the **stopper**. Failing to carry out the preparation may lead to output sheets falling off the **bundle exit tray**. It could also cause the sensor to fail to detect the output full condition.

**NOTICE**

When creating a booklet in Fold & Staple or Multi Half-Fold, output sheets so that they are curled inside. Output only some sheets to the secondary (sub) tray before outputting a full booklet, then check the curl direction.

If output sheets are curled upward, when a booklet is created, sheets are curled inside.

**4.3.2 Settings on the Copy Screen**

- 1 Position the original.
  - The number of original sheets set will be the number of pages for fold & stapled or half-folded output, thus determining the number of folded sheets. For information on the number of folded sheets, see page 2-13.
- 2 Press [COPY] tab to display the Copy Screen.
- 3 Press [Output Setting].  
The Output Setting Screen will be displayed.
- 4 Press either [Fold&Staple] or [Multi Half].



The Fold & Staple Setting Screen or Multi Half-Fold Setting Screen will be displayed.

5 For [(1)Fore-edge Trimming], select [ON] or [OFF].

→ If [Fold&Staple] was selected in Step 4, select [2 Positions] or [4 Positions] for "Staple", then select whether to enable [(1)Fore-edge Trimming].



→ When [Multi Half] is selected in Step 4, select whether to enable [(1)Fore-edge Trimming].



→ If the saddle stitcher is equipped with **Creaser Unit CR-101**, [Crease] is available. See page 4-30 for details.

→ If the saddle stitcher is equipped with **Trimmer Unit TU-503**, [2-Side Slit] is available. See page 4-45 for details.

→ If the saddle stitcher is equipped with **Folding Unit FD-504**, [Spine Corner Forming] is available on the Fold & Staple Setting Screen. See page 4-60 for details.

6 Press [OK].

→ To restore the previous setting, press [Cancel].

→ To disable the function while keeping the current setting, press [Function OFF].

The Output Setting Screen will be restored.

7 Press [OK] on the Output Setting Screen to return to the Copy Screen.

An icon representing specified output mode will be displayed under [Output Setting] on the Copy Screen.

8 Press [Booklet] in Application, and display the Booklet Screen.

→ In **bizhub PRESS 1250/1250P/1052**, select [Binding Mode] ([No Cover Sheet], [Cover With Copy Sheet], or [Cover With Blank Sheet] from [Magazine Binding], or [Adhesive Binding]), [Binding Position] ([Left Bind] or [Right Bind]), and Cover Tray.



→ In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select [Cover Sheet] ([No Cover Sheet], [Cover With Copy Sheet], [Cover With Blank Sheet]), [Binding Position] ([Left Bind] or [Right Bind]), and Cover Tray.



→ Use the Setting Menu Screen to enable automatic selection of the Booklet mode in Application when [Fold&Staple] or [Multi Half] mode is selected.

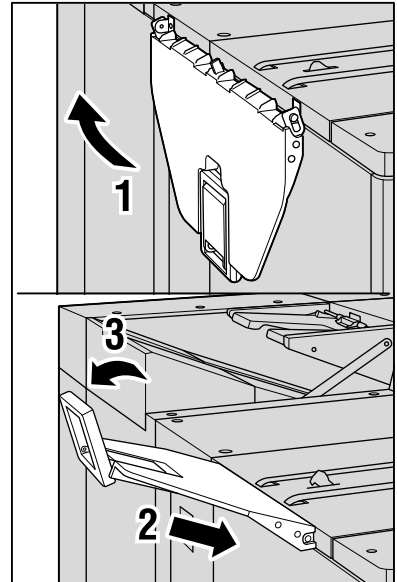
9 Select additional copy conditions, as desired.

→ In **bizhub PRESS 1250/1250P/1052**, you can load sheets onto a tray, and use [Paper Presetting] to change the paper setting temporarily. See the User's Guide supplied with this machine for details on [Paper Presetting].

10 Enter the desired print quantity from the control panel keypad.

→ The number of sets that can be output to a **bundle exit tray** varies depending on the type of paper. See page 2-13 for details.

- 11** Set up the **bundle exit tray extension**, and open the **stopper**.



- 12** Press **Start** on the **control panel**.

### 4.3.3 Settings in Printer Driver

When making folded booklets, select [Booklet] functions and [Fold and Staple] or [Multi Half-Fold].

The setting method varies depending on the type of the printer driver you are using.

Type of printer driver	Setting screen	Description
PS Plug-in driver (Windows/Mac OS X)	[Layout] tab	Set [Imposition] to [Booklet].
	[Fold] tab	Select [Multi Half-Fold] in [Fold], then set [Fold and Staple] or [Trim] in [Multi Half-Fold Details].
PCL driver (Windows)	[Layout] tab	Set [Print Type] to [Booklet].
	[Finish] tab	Select [Fold and Staple] or [Multi Half-Fold] in [Fold], then set [Trim].
PPD driver (Windows)	[Advanced Options] window	Set [Imposition] to [Booklet]. In [Fold], select [Fold and Staple] or [Fold and Staple + Trim], [Multi Half-Fold], [Multi Half-Fold + Trim].
PPD driver (Mac OS X)	[Image/Layout] window	Set [Imposition] to [Booklet].
	[Finishing] window	In [Fold], select [Fold and Staple] or [Fold and Staple + Trim], [Multi Half-Fold], [Multi Half-Fold + Trim].



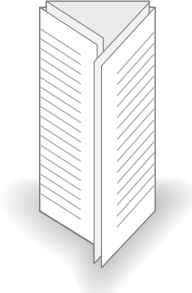
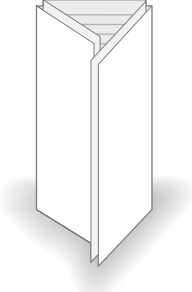
#### Reference

See page 4-73 for details on the printer driver functions that are available when this machine is equipped with **Saddle Stitcher SD-513**.

4.4 Folding Copies in Three: Multi Tri-Fold

4.4.1 Functional Overview

The machine with **Saddle Stitcher SD-513** installed can fold output sheets inside in three. When selecting Multi Tri-Fold, also select either inside or outside to have the printed image. The tri-folded sheets will be delivered onto the **tri-fold tray**.

Output mode	Details	Illustration
[Multi 3-Fold] + [Outside Print]	Fold sheets in three with the printed image out-side.	
[Multi 3-Fold] + [Inside Print]	Fold sheets in three with the printed image inside.	



Reference

Please check paper information before use. See "Paper Information" (page 2-12) for details.

### 4.4.2 Settings on the Copy Screen

- 1 Position the original.  
→ The number of original sheets set will be the number of multi tri-folded sheets. For information on the number of folded sheets, see page 2-13.
- 2 Press [COPY] tab to display the Copy Screen.
- 3 Press [Output Setting].  
The Output Setting Screen will be displayed.
- 4 Press [Multi 3-Fold].



The Multi Tri-Fold Setting Screen will be displayed.

- 5 Select either [Outside Print] or [Inside Print].



- If the saddle stitcher is equipped with **Creaser Unit CR-101**, [Crease] is available. See page 4-42 for details.
- If the saddle stitcher is equipped with **Trimmer Unit TU-503**, [2-Side Slitting] is available. See page 4-56 for details.

- 6 Press [OK].  
→ To restore the previous setting, press [Cancel].  
→ To disable the function while keeping the current setting, press [Function OFF].  
The Output Setting Screen will be restored.

- 7 Press [OK] on the Output Setting Screen to return to the Copy Screen.  
An icon representing specified output mode will be displayed under [Output Setting] on the Copy Screen.
- 8 Select additional copy conditions, as desired.
  - In **bizhub PRESS 1250/1250P/1052**, you can load sheets onto a tray, and use [Paper Presetting] to change the paper setting temporarily. See the User's Guide supplied with this machine for details on [Paper Presetting].
- 9 Enter the desired print quantity from the control panel keypad.
  - The number of sets that can be output to the **tri-fold tray** varies depending on the number of multi tri-folded sheets. See page 2-13 for details.
- 10 Press **Start** on the **control panel**.

### 4.4.3 Settings in Printer Driver

To fold copies in three, select [Multi Tri-Fold] and the folding direction.

The setting method varies depending on the type of the printer driver you are using.

Type of printer driver	Setting screen	Description
PS Plug-in driver (Windows/Mac OS X)	[Fold] tab	Select [Multi Tri-Fold] in [Fold], then set the print side to the inside or outside in [Folding Direction].
PCL driver (Windows)	[Finish] tab	In [Fold], select [Multi-Letter Fold In] or [Multi-Letter Fold Out].
PPD driver (Windows)	[Advanced Options] window	In [Fold], select [Multi Tri-Fold - Inside] or [Multi Tri-Fold - Outside].
PPD driver (Mac OS X)	[Finishing] window	In [Fold], select [Multi Tri-Fold - Inside] or [Multi Tri-Fold - Outside].



#### Reference

See page 4-73 for details on the printer driver functions that are available when this machine is equipped with **Saddle Sticher SD-513**.

## 4.5 Adding Fold Lines (Creases) on Paper

### 4.5.1 Functional Overview

Fold lines (creases) can be added on sheets when the machine uses **Creaser Unit CR-101** equipped in **Saddle Stitcher SD-513**.

Select The Number of Creases (1 piece, 2 pieces, 3 pieces, or 4 pieces), and set crease positions.

For the convex crease side, select front or back.

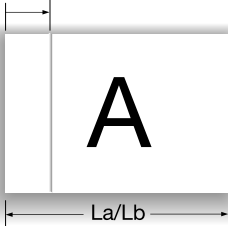
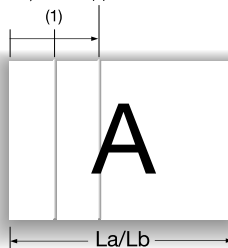
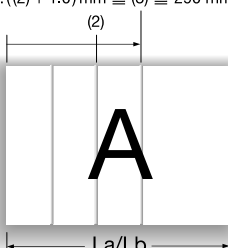
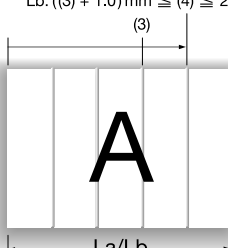
#### **NOTICE**

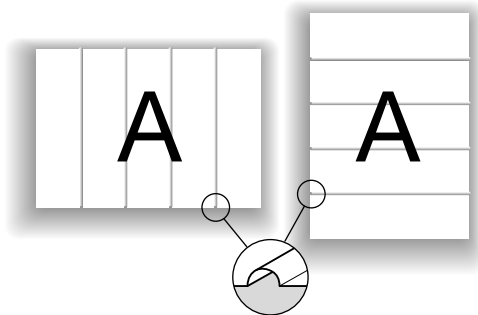
*The number of creases is affected by the copy settings used in combination.*

*When Fold & Staple or Multi Half Fold mode is selected, only a single crease can be specified for cover sheets. Creases cannot be added on body. See page 4-36 for details.*

*When Tri Fold mode is selected, only two creases can be specified for tri-folded sheets. See page 4-42 for details.*

*When Perfect Bind mode is selected, 2 creases or 4 creases can be specified for cover sheets. Creases cannot be added on body. See page 4-68 for details.*

Setting item	Details	Illustration
[The Number of Creases] Select [1 Piece], [2 Pieces], [3 Pieces], or [4 Pieces]. Crease Position shifts according to the paper length (on the longer side). Paper length La: 240 mm or more, 336 mm or less Paper length Lb: 337 mm or more, 488 mm or less	[1 Piece]: Add one piece of crease. Crease Position (1): Paper La: 7 mm to (La - 46) mm (in 0.1 mm increments) Paper Lb: (Lb - 330) mm to 290 mm (in 0.1 mm increments)	$\begin{aligned} \text{La: } & 7 \text{ mm} \leq (1) \leq (\text{La} - 46) \text{ mm} \\ \text{Lb: } & (\text{Lb} - 330) \text{ mm} \leq (1) \leq 290 \text{ mm} \end{aligned}$ 
	[2 Pieces]: Add 2 pieces of crease. Crease Position (2): Paper La: (position of (1) + 1.0) mm to (La - 46) mm (in 0.1 mm increments) Paper Lb: (position of (1) + 1.0) mm to 290 mm (in 0.1 mm increments)	$\begin{aligned} \text{La: } & ((1) + 1.0) \text{ mm} \leq (2) \leq (\text{La} - 46) \text{ mm} \\ \text{Lb: } & ((1) + 1.0) \text{ mm} \leq (2) \leq 290 \text{ mm} \end{aligned}$ 
	[3 Pieces]: Add 3 pieces of crease. Crease Position (3): Paper La: (position of (2) + 1.0) mm to (La - 46) mm (in 0.1 mm increments) Paper Lb: (position of (2) + 1.0) mm to 290 mm (in 0.1 mm increments)	$\begin{aligned} \text{La: } & ((2) + 1.0) \text{ mm} \leq (3) \leq (\text{La} - 46) \text{ mm} \\ \text{Lb: } & ((2) + 1.0) \text{ mm} \leq (3) \leq 290 \text{ mm} \end{aligned}$ 
	[4 Pieces]: Add 4 pieces of crease. Crease Position (4): Paper La: (position of (3) + 1.0) mm to (La - 46) mm (in 0.1 mm increments) Paper Lb: (position of (3) + 1.0) mm to 290 mm (in 0.1 mm increments)	$\begin{aligned} \text{La: } & ((3) + 1.0) \text{ mm} \leq (4) \leq (\text{La} - 46) \text{ mm} \\ \text{Lb: } & ((3) + 1.0) \text{ mm} \leq (4) \leq 290 \text{ mm} \end{aligned}$ 

Setting item	Details	Illustration
[Crease Side] Select [Front] or [Back].	[Front]: Add crease on the front side.	
	[Back]: Add crease on the back side.	

### 4.5.2 Settings on the Copy Screen

- 1 Position the original.
- 2 Press [COPY] tab to display the Copy Screen.
- 3 Press [Output Setting].  
The Output Setting Screen will be displayed.
- 4 Press [Crease].



The Crease Setting Screen will be displayed.

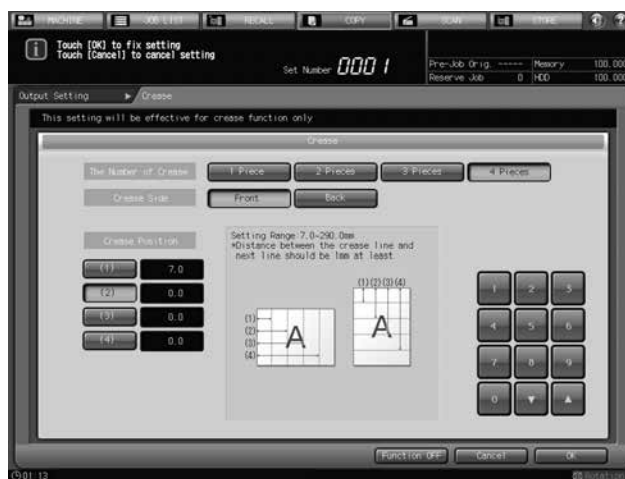
- 5 Specify the number of crease.  
Select from [1 Piece] to [4 Pieces].



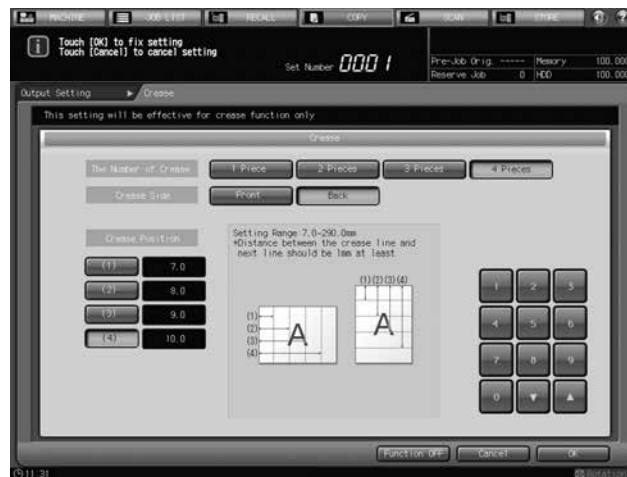
- 6 Specify the crease position.

Select [(1)] for "Crease Position", and press the keypad, [▼], or [▲] to enter the first crease position. Specify the remaining crease positions likewise.

- Crease Position that can be specified shifts according to the paper length (on the longer side).  
When Paper Length La is 240 mm or more and 336 mm or less, Crease Position (1) is 7 mm to (La - 46) mm (in 0.1 mm increments). When Paper Length Lb is 337 mm or more and 488 mm or less, Crease Position (1) is (Lb - 330) mm to 290 mm (in 0.1 mm increments).
- For the second and subsequent crease positions, when Paper Length La is 240 mm or more and 336 mm or less, enter a value greater than that of the preceding crease by 1.0 mm to (La - 46) mm. When Paper Length Lb is 337 mm or more and 488 mm or less, enter a value greater than that of the preceding crease by 1.0 mm to 290 mm.



- 7 Specify the crease side.  
Select [Front] or [Back] for "Crease Side".



- 8 Press [OK].  
 → To restore the previous setting, press [Cancel].  
 → To disable the function while keeping the current setting, press [Function OFF].  
 The Output Setting Screen will be restored.
- 9 Press [OK] on the Output Setting Screen to return to the Copy Screen.  
 An icon representing specified output mode will be displayed under [Output Setting] on the Copy Screen.
- 10 Select additional copy conditions, as desired.  
 → In **bizhub PRESS 1250/1250P/1052**, you can load sheets onto a tray, and use [Paper Presetting] to change the paper setting temporarily. See the User's Guide supplied with this machine for details on [Paper Presetting].
- 11 Enter the desired print quantity from the control panel keypad.
- 12 Press **Start** on the **control panel**.  
 → If output sheets are creased at an invalid position, respecify the crease position on the Crease Setting Screen in Step 6. For example, if you enter "210 mm", output sheets may be creased at the position 211 mm due to paper stretching. In such a case, set to "209 mm".

### 4.5.3 Settings in Printer Driver

To add fold lines (creases) to paper, specify the number of creases and the crease positions.

The setting method varies depending on the type of the printer driver you are using.

Type of printer driver	Setting screen	Description
PS Plug-in driver (Windows/Mac OS X)	[Fold] tab	Specify the number of creases in [Number of Crease], then select the crease side in [Crease Side]. In [Crease Position], specify crease positions.
PCL driver (Windows)	[Finish] tab	In [Crease], enable Crease, then select the crease side. In [Crease Settings], specify the number of creases and the crease positions.
PPD driver (Windows)	[Advanced Options] window	In [Crease], enable Crease.
PPD driver (Mac OS X)	[Finishing] window	In [Crease], enable Crease.



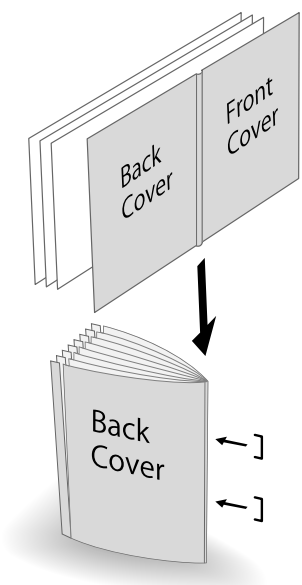
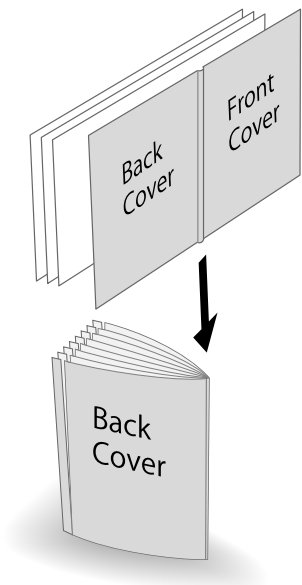
#### Reference

See page 4-73 for details on the printer driver functions that are available when this machine is equipped with **Saddle Stitcher SD-513**.

## 4.6 Adding Fold Lines (Creases) for Fold & Stapled/Multi Half-Folded Cover

### 4.6.1 Functional Overview

When the machine uses **Creaser Unit CR-101** equipped in **Saddle Stitcher SD-513**, and when creating cover with fold & staple or multi half-fold, one piece of crease can be added to cover as a fold line.

Setting item	Details	Illustration
[Fold&Staple] Fold & Staple Setting Screen, [Crease] to be set to [ON]	Using Booklet as an application function in combination, when selecting [Cover With Copy Sheet], or [Cover With Blank Sheet], adds a single crease on cover only and fold & staple with body. Fore-edge trimming can be combined.	
[Multi Half] Multi Half-Fold Setting Screen, [Crease] to be set to [ON]	Using Booklet as an application function in combination, when selecting [Cover With Copy Sheet], or [Cover With Blank Sheet], adds a single crease on cover only and multi half-fold with body. Fore-edge trimming can be combined.	

#### NOTICE

Crease cannot be added on body when Fold & Staple or Multi Half Fold mode is selected.

The crease position is fixed at the center.

The crease side selection is not available.

#### NOTICE

The multi half-folded and stapled sets will be delivered onto the **bundle exit tray**. Set up the **bundle exit tray extension**, and follow the preparation process before opening the **stopper**. Failing to carry out the preparation may lead to output sheets falling off the **bundle exit tray**. It could also cause the sensor to fail to detect the output full condition.

**NOTICE**

The fold and crease positions may be displaced depending on the paper weight. In this case, adjust the crease position to suit the fold position. See page 5-42 for details.

**Reference**

Please check paper information before use. See "Paper Information" (page 2-12) for details.

## 4.6.2 Settings on the Copy Screen

- 1 Position the original.
  - The number of original sheets set will be the number of pages for fold & stapled or half-folded output, thus determining the number of folded sheets. For information on the number of folded sheets, see page 2-13.
- 2 Load fold & stapled or multi half-folded cover sheet into a tray.
  - Load cover paper into [Tray1] to [Tray11]. The [PI-PFU Tray] or [PI Tray] is not available for covers.
  - In **bizhub PRESS 1250/1250P/1052**, use [Paper Presetting] to change the paper setting for paper loaded temporarily onto a tray. See the User's Guide supplied with this machine for details on [Paper Presetting].
- 3 Press [COPY] tab to display the Copy Screen.
- 4 Press [Output Setting].  
The Output Setting Screen will be displayed.
- 5 Select [Fold&Staple] or [Multi Half].



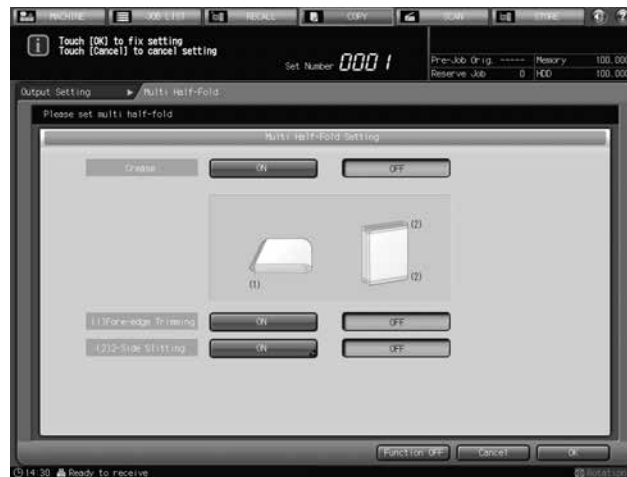
The Fold & Staple Setting Screen or Multi Half-Fold Setting Screen will be displayed.

6 For "(1) Fore-edge Trimming", select [ON] or [OFF].

→ If [Fold&Staple] was selected in Step 4, select [2 Positions] or [4 Positions] for "Staple", then select whether to enable [(1)Fore-edge Trimming].

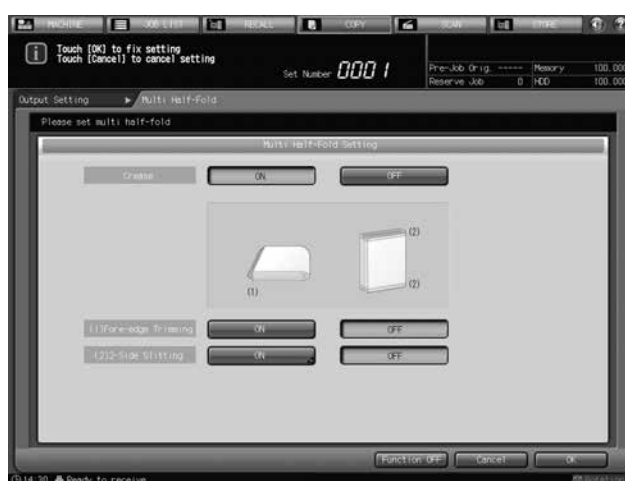
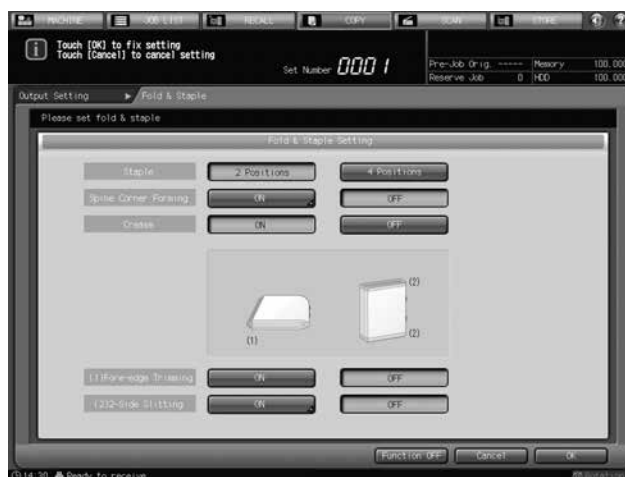


→ When [Multi Half] is selected in Step 4, select whether to enable [(1)Fore-edge Trimming].



→ If the saddle stitcher is equipped with **Trimmer Unit TU-503**, [2-Side Slitting] is available. See page 4-48 for details.

- 7 "Crease" to be set to [ON].



- 8 Press [OK].
- To restore the previous setting, press [Cancel].
  - To disable the function while keeping the current setting, press [Function OFF].
- The Output Setting Screen will be restored.
- [Fold&Staple] or [Multi Half] and [Crease] are highlighted. [Crease] has now become unavailable, and the crease settings cannot be changed.
- 9 Press [OK] on the Output Setting Screen to return to the Copy Screen.
- An icon representing specified output mode will be displayed under [Output Setting] on the Copy Screen.
- You will also find that Booklet in Application is selected automatically.

- 10 Press [Application], and then press [Booklet].



- 11 Select [Cover With Copy Sheet] or [Cover With Blank Sheet].

→ In bizhub PRESS 1250/1250P/1052, select in [Binding Mode] - [Magazine Binding].

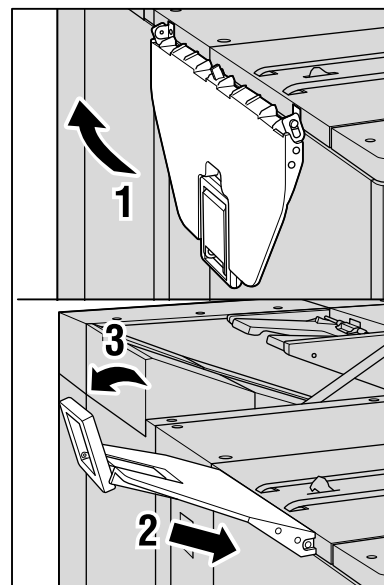


→ In bizhub PRESS C1070/C1070P/C1060/C71hc or bizhub PRESS C1100/C1085, select in [Cover Sheet].



- 12 For "Binding Position", select [Left Bind] or [Right Bind].

- 13** As the cover paper tray, select the tray to which the cover paper has been loaded in step 2.
- In **bizhub PRESS 1250/1250P/1052**, press [Cover Tray Change] to select a tray.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select a tray in [Cover Tray Setting].
- 14** Press [OK] to complete the setting and return to the Copy Screen.
- 15** Select additional copy conditions, as desired.
- 16** Enter the desired print quantity from the control panel keypad.
- The number of sets that can be output to a **bundle exit tray** varies depending on the type of paper. See page 2-13 for details.
- 17** Set up the **bundle exit tray extension**, and open the **stopper**.



- 18** Press **Start** on the **control panel**.

### 4.6.3 Settings in Printer Driver

For the printer driver, configure settings separately for the body and cover.

See page 4-22 for details on Fold & Staple and Multi Half-Fold.

See page 4-30 for details on Crease.



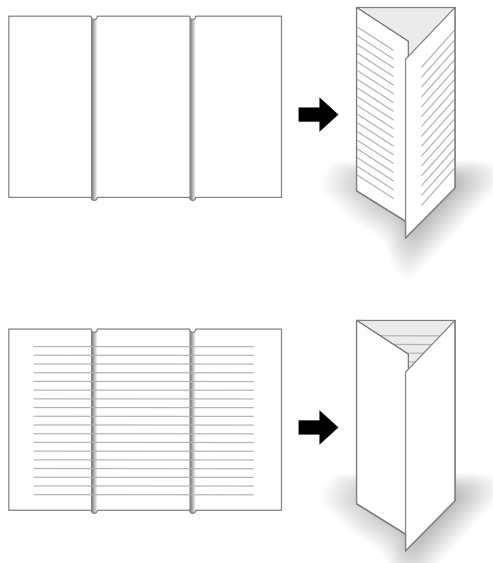
#### Reference

See page 4-73 for details on the printer driver functions that are available when this machine is equipped with **Saddle Stitcher SD-513**.

## 4.7 Adding Fold Lines (Creases) for Multi Tri-Folded Paper

### 4.7.1 Functional Overview

When the machine uses **Creaser Unit CR-101** equipped in **Saddle Stitcher SD-513**, 2 pieces of crease can be added on the folded section so that sheets can be tri-folded.

Setting item	Details	Illustration
[Multi 3-Fold] Multi Tri-Fold Setting Screen, [Crease] to be set to [ON]	Adds 2 creases on tri-fold sections, and fold sheets in three. In this case only one sheet is folded. Multi tri-fold is not performed.	

#### NOTICE

*The fold and crease positions may be displaced depending on the paper weight. In this case, adjust the crease position to suit the fold position. See page 5-42 for details.*

### 4.7.2 Settings on the Copy Screen

- 1 Position the original.
- 2 Press [COPY] tab to display the Copy Screen.
- 3 Press [Output Setting].  
The Output Setting Screen will be displayed.
- 4 Press [Multi 3-Fold].



The Multi Tri-Fold Setting Screen will be displayed.

- 5 Select either [Outside Print] or [Inside Print].



- 6 "Crease" to be set to [ON].
  - ➔ If the saddle sticher is equipped with **Trimmer Unit TU-503**, [2-Side Slitting] is available. See page 4-56 for details.
- 7 Press [OK].
  - ➔ To restore the previous setting, press [Cancel].
  - ➔ To disable the function while keeping the current setting, press [Function OFF].

The Output Setting Screen will be restored.

  - ➔ [Multi 3-Fold] and [Crease] are highlighted. [Crease] has now become unavailable, and the crease settings cannot be changed.

- 8 Press [OK] on the Output Setting Screen to return to the Copy Screen.  
An icon representing specified output mode will be displayed under [Output Setting] on the Copy Screen.
- 9 Select additional copy conditions, as desired.
  - In **bizhub PRESS 1250/1250P/1052**, you can load sheets onto a tray, and use [Paper Presetting] to change the paper setting temporarily. See the User's Guide supplied with this machine for details on [Paper Presetting].
- 10 Enter the desired print quantity from the control panel keypad.
  - Up to 40 sets of 1-sheet-tri-folded paper (for 22 lb Bond (80 g/m<sup>2</sup>) paper) can be load onto the **tri-fold tray**.
- 11 Press **Start** on the **control panel**.

### 4.7.3 Settings in Printer Driver

To add fold lines (creases) on tri-fold sections, configure [Multi Tri-Fold] and [Crease].

The setting method varies depending on the type of the printer driver you are using.

Type of printer driver	Setting screen	Description
PS Plug-in driver (Windows/Mac OS X)	[Fold] tab	Select [Multi Tri-Fold] in [Fold], then set the print side to the inside or outside in [Folding Direction]. Specify [3 Pieces] in [The Number of Creases], then select the crease side.
PCL driver (Windows)	[Finish] tab	In [Fold], select [Multi-Letter Fold In] or [Multi-Letter Fold Out]. Enable [Crease], then select the crease side.
PPD driver (Windows)	[Advanced Options] window	In [Fold], select [Multi Tri-Fold - Inside] or [Multi Tri-Fold - Outside], then enable [Crease].
PPD driver (Mac OS X)	[Finishing] window	In [Fold], select [Multi Tri-Fold - Inside] or [Multi Tri-Fold - Outside], then enable [Crease].



#### Reference

See page 4-73 for details on the printer driver functions that are available when this machine is equipped with **Saddle Stitcher SD-513**.

4.8 Performing 2-Side Slitting

4.8.1 Functional Overview

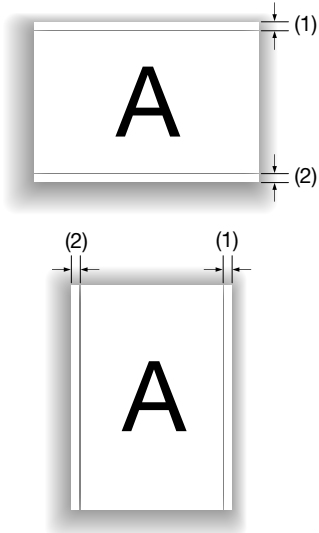
When **Trimmer Unit TU-503** is equipped in **Saddle Stitcher SD-513**, 2-side slitting can be performed on sheets.

**NOTICE**

*Slitting can be specified within the range from 8.0 mm to 26.0 mm in increments of 0.1 mm.*

*The difference of specified 2-side slitting between the two sides must be within 10.0 mm.*

*[Offset against Cover] can be used to specify [Cover With] for Booklet in Application. It will not function for other purposes, even if specified.*

Setting item	Details	Illustration
[2-Side Slit]	Slit both the head and the foot of all sheets (The head and the foot are determined when sheets are positioned for conveyance.). Trimming can be specified separately for the head and the foot.	

### 4.8.2 Settings on the Copy Screen

- 1 Position the original.
- 2 Press [COPY] tab to display the Copy Screen.
- 3 Press [Output Setting].  
The Output Setting Screen will be displayed.
- 4 Press [2-Side Slit].

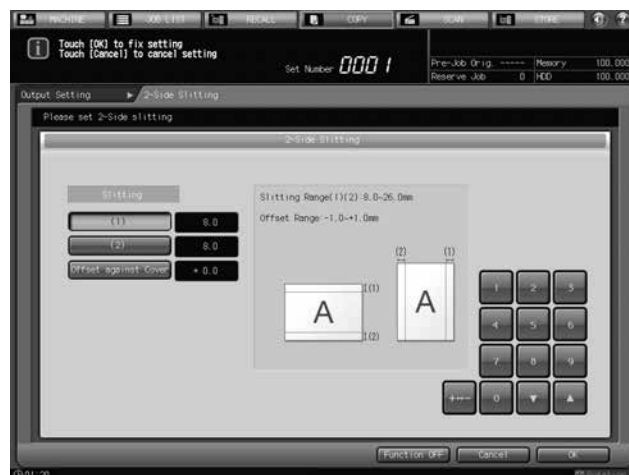


The 2-Side Slitting Adjustment Screen will be displayed.

- 5 Specify 2-side slitting width.

Select [(1)] for "Slitting", and press the keypad, [▼], or [▲] to enter the slitting amount for the head. Likewise, press [(2)] and enter the slitting amount for the foot.

- The difference of specified slitting between the head and the foot must not exceed 10.0 mm.
- [Offset against Cover] can be used to specify [Cover With] for Booklet in Application. It will not function for other purposes, even if specified.



- 6 Press [OK].
  - To restore the previous setting, press [Cancel].
  - To disable the function while keeping the current setting, press [Function OFF].
 The Output Setting Screen will be restored.

- 7 Press [OK] on the Output Setting Screen to return to the Copy Screen.  
An icon representing specified output mode will be displayed under [Output Setting] on the Copy Screen.
- 8 Select additional copy conditions, as desired.
- 9 Enter the desired print quantity from the control panel keypad.
- 10 Press **Start** on the **control panel**.

### 4.8.3 Settings in Printer Driver

To perform 2-side slitting on paper, select [2-Side Slitting].

The PS Plug-in driver and PCL driver are available as the available printer drivers.

The setting method varies depending on the type of the printer driver you are using.

Type of printer driver	Setting screen	Description
PS Plug-in driver (Windows/Mac OS X)	[Fold] tab	Select a target in [2-Side Slitting], then specify the slitting in [Top Slitting]/[Bottom Slitting].
PCL driver (Windows)	[Finish] tab	Enable [2-Side Slitting], then specify the target and slitting in [2-Side Slitting Settings].



#### Reference

See page 4-73 for details on the printer driver functions that are available when this machine is equipped with **Saddle Stitcher SD-513**.

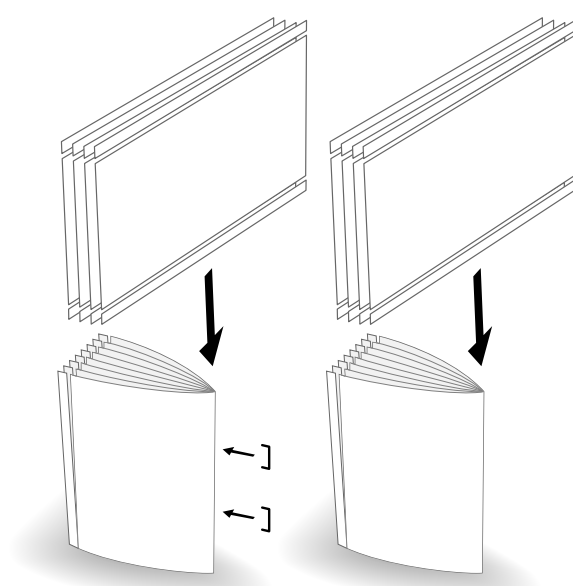
## 4.9 Performing 2-Side Slitting on Fold & Stapled/Multi Half-Folded Paper

### 4.9.1 Functional Overview

When **Trimmer Unit TU-503** is equipped in **Saddle Stitcher SD-513**, the following 2-side slitting functions can be performed in combination with fold & staple or multi half-fold.

When [Fold&Staple] or [Multi Half] is selected with 2-side slitting, and [No Cover Sheet] is selected for the Booklet mode in Application, 2-side slitting is performed on all sheets.

When [Fold&Staple] or [Multi Half] is selected with 2-side slitting, and [Cover With Copy Sheet] or [Cover With Blank Sheet] is selected for the Booklet mode in Application, 2-side slitting can be performed either on cover only, or on all sheets.

Setting item	Details	Illustration
[Fold&Staple] (+ [Fore-edge Trimming]) Fold & Staple Setting [2-Side Slitting] to be set to [ON] Using Booklet in Application, select [No Cover Sheet] or [Multi Half] (+ [Fore-edge Trimming]) Fold & Staple Setting [2-Side Slitting] to be set to [ON] Using Booklet in Application, select [No Cover Sheet]	Performing 2-side slitting on all fold & stapled or multi half-folded sheets.	

Setting item	Details	Illustration
[Fold&Staple] (+ [Fore-edge Trimming]) Fold & Staple Setting [2-Side Slitting] to be set to [ON] For Booklet in Application, select [Cover With Copy Sheet] or [Cover With Blank Sheet]. or [Multi Half] (+ [Fore-edge Trimming]) Fold & Staple Setting [2-Side Slitting] to be set to [ON] For Booklet in Application, select [Cover With Copy Sheet] or [Cover With Blank Sheet].	Select [All Sheets] for "2-Side Slitting" to perform 2-side slitting on cover and body. Select [Cover Only] for "2-Side Slitting" to perform 2-side slitting on cover only.	

**NOTICE**

Slitting can be specified within the range from 8.0 mm to 26.0 mm in increments of 0.1 mm.

The difference of specified 2-side slitting between the two sides must be within 10.0 mm.

[Offset against Cover] is enabled when [Cover With Copy Sheet] or [Cover With Blank Sheet] is selected for Booklet in Application. Slitting of body relative to cover can be specified within the range from -1.0 mm to +1.0 mm in increments of 0.1 mm.

**NOTICE**

The multi half-folded and stapled sets will be delivered onto the **bundle exit tray**. Set up the **bundle exit tray extension**, and follow the preparation process before opening the **stopper**. Failing to carry out the preparation may lead to output sheets falling off the **bundle exit tray**. It could also cause the sensor to fail to detect the output full condition.

**Reference**

Please check paper information before use. See "Paper Information" (page 2-12) for details.

### 4.9.2 Settings on the Copy Screen

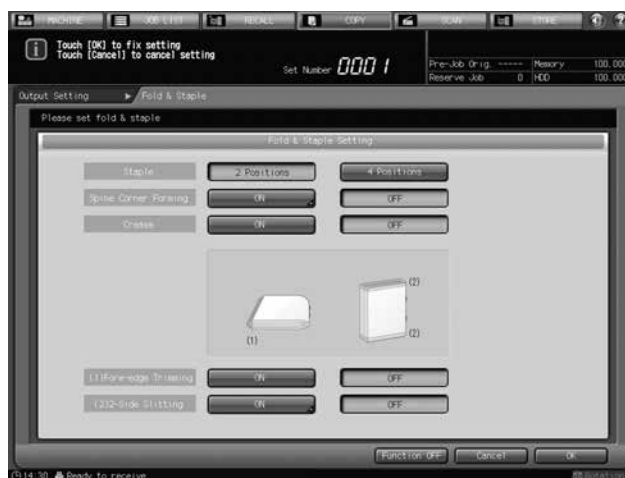
- 1 Position the original.
  - The number of original sheets set will be the number of pages for fold & stapled or half-folded output, thus determining the number of folded sheets. For information on the number of folded sheets, see page 2-13.
- 2 Load fold & stapled or multi half-folded cover sheet into a tray.
  - Load cover paper into [Tray1] to [Tray11]. The [PI-PFU Tray] or [PI Tray] is not available for covers.
  - In **bizhub PRESS 1250/1250P/1052**, use [Paper Presetting] to change the paper setting for paper loaded temporarily onto a tray. See the User's Guide supplied with this machine for details on [Paper Presetting].
- 3 Press [COPY] tab to display the Copy Screen.
- 4 Press [Output Setting].
 

The Output Setting Screen will be displayed.
- 5 Select [Fold&Staple] or [Multi Half].

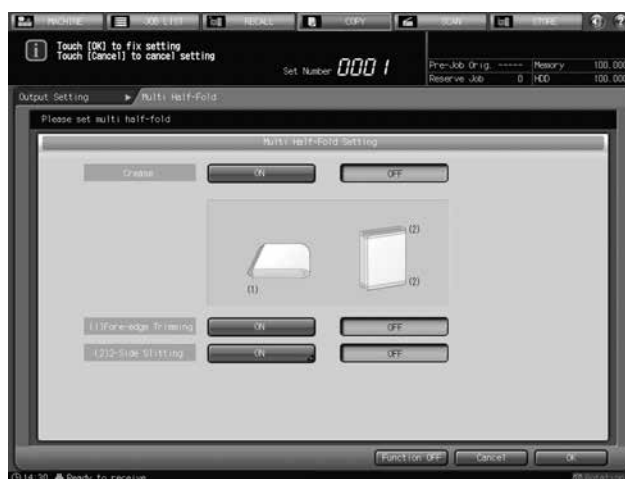


The Fold & Staple Setting Screen or Multi Half-Fold Setting Screen will be displayed.

- 6 For "(1) Fore-edge Trimming", select [ON] or [OFF].
- If [Fold&Staple] was selected in Step 4, select [2 Positions] or [4 Positions] for "Staple", select whether to enable [(1)Fore-edge Trimming].

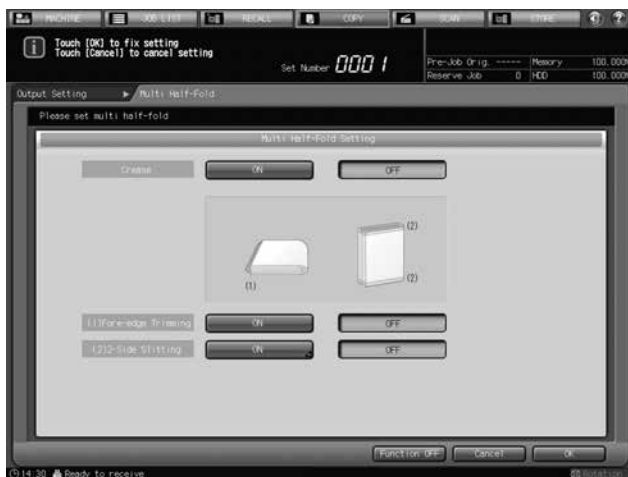


- When [Multi Half] is selected in Step 4, select whether to enable [(1)Fore-edge Trimming].



- If the saddle stitcher is equipped with **Creaser Unit CR-101**, [Crease] is available. See page 4-36 for details.
- If the saddle stitcher is equipped with **Folding Unit FD-504**, [Spine Corner Forming] is available on the Fold & Staple Setting Screen. See page 4-60 for details.

- 7 For "(2)2-Side Slitting", press [ON].



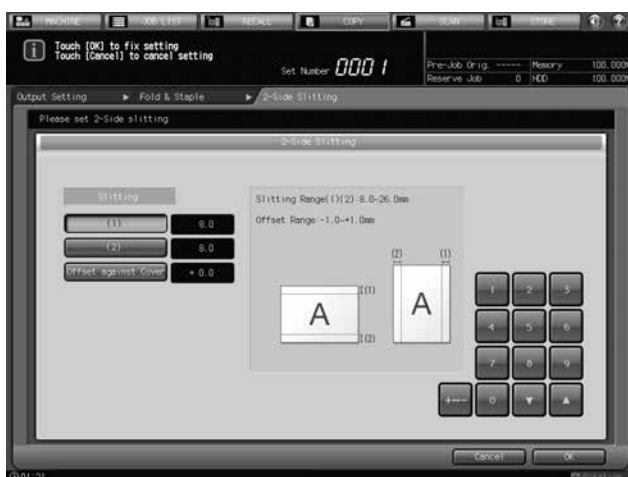
The 2-Side Slitting Setting Screen will be displayed.

- 8 Specify 2-side slitting width.

Select [(1)] for "Slitting", and press the keypad, [▼], or [▲] to enter the slitting amount for the head. Likewise, press [(2)] and enter the slitting amount for the foot.

Press [Offset against Cover], and press the keypad, [▼], or [▲] to enter the slitting amount of body relative to cover within the range from -1.0 mm to +1.0 mm in increments of 0.1 mm.

→ The difference of specified slitting between the head and the foot must not exceed 10.0 mm.



- 9 Press [OK].  
The Fold & Staple Setting Screen will be restored.
- 10 Press [OK].
  - To restore the previous setting, press [Cancel].
  - To disable the function while keeping the current setting, press [Function OFF].
 The Output Setting Screen will be restored.
  - [Fold&Staple] or [Multi Half] and [2-Side Slit] are highlighted. 2-side slitting settings can be changed by pressing [2-Side Slit].
- 11 Press [OK] on the Output Setting Screen to return to the Copy Screen.  
An icon representing specified output mode will be displayed under [Output Setting] on the Copy Screen.  
You will also find that Booklet in Application is selected automatically.
- 12 Press [Application], and then press [Booklet].



- 13** Select [No Cover Sheet], [Cover With Copy Sheet], or [Cover With Blank Sheet].

→ In **bizhub PRESS 1250/1250P/1052**, select in [Binding Mode] - [Magazine Binding].

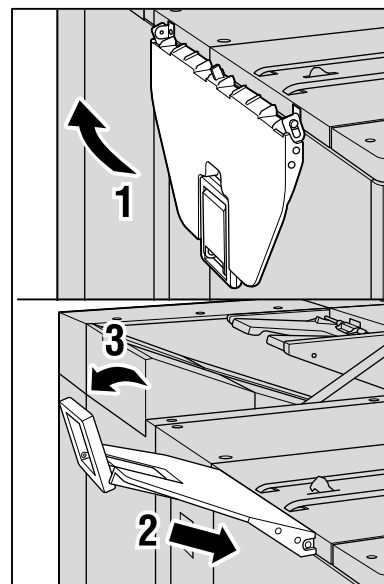


→ In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select in [Cover Sheet].



- 14** For "Binding Position", select [Left Bind] or [Right Bind].
- 15** As the cover paper tray, select the tray to which the cover paper has been loaded in step 2.
- In **bizhub PRESS 1250/1250P/1052**, press [Cover Tray Change] to select a tray.
- In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select a tray in [Cover Tray Setting].
- 16** Press [OK] to complete the setting and return to the Copy Screen.
- 17** Select additional copy conditions, as desired.
- 18** Enter the desired print quantity from the control panel keypad.
- The number of sets that can be output to a **bundle exit tray** varies depending on the type of paper. See page 2-13 for details.

- 19** Set up the **bundle exit tray extension**, and open the **stopper**.



- 20** Press **Start** on the **control panel**.

### 4.9.3 Settings in Printer Driver

To perform 2-side slitting in Fold & Staple or Multi Half-Fold, specify [Fold and Staple] or [Multi Half-Fold] and [2-Side Slitting].

The PS Plug-in driver and PCL driver are printer drivers for which [2-Side Slitting] is available.

The setting method varies depending on the type of the printer driver you are using.

Type of printer driver	Setting screen	Description
PS Plug-in driver (Windows/Mac OS X)	[Layout] tab	Set [Imposition] to [Booklet].
	[Fold] tab	Select [Multi Half-Fold] in [Fold], then set [Fold and Staple] or [Trim] in [Multi Half-Fold Details]. Select a target in [2-Side Slitting], then specify the slitting in [Top Slitting]/[Bottom Slitting].
PCL driver (Windows)	[Layout] tab	Set [Print Type] to [Booklet].
	[Finish] tab	Select [Fold and Staple] or [Multi Half-Fold] in [Fold], then set [Trim]. Enable [2-Side Slitting], then specify the target and slitting in [2-Side Slitting Settings].



#### Reference

See page 4-73 for details on the printer driver functions that are available when this machine is equipped with **Saddle Stitcher SD-513**.

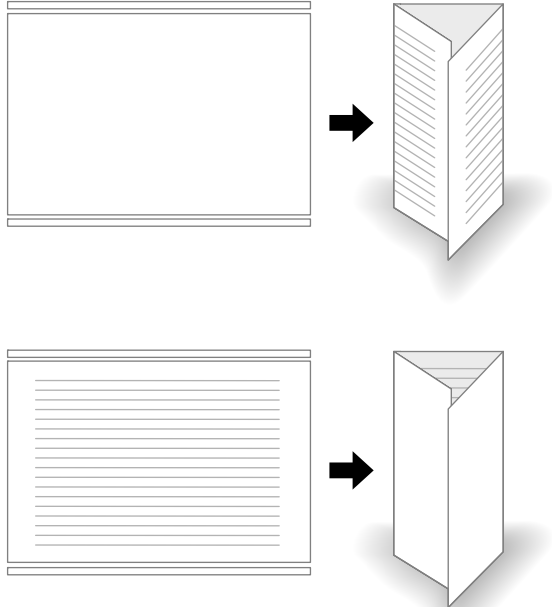
## 4.10 Performing 2-Side Slitting on Multi Tri-Folded Paper

### 4.10.1 Functional Overview

When **Trimmer Unit TU-503** is equipped in **Saddle Stitcher SD-513**, 2-side slitting can be performed on all sheets when tri-folding.

#### NOTICE

*If Tri-Fold and 2-Side Slitting are combined, sheets may be creased depending on their type. Furthermore, if Crease is combined with Tri-Fold and 2-Side Slitting, sheets may be broken near a crease. In any case, creases are easily caused when the slitting is 20 mm or more. If creases occur, reduce the slitting value.*

Setting item	Details	Illustration
[Multi 3-Fold] Multi Tri-Fold Setting Screen, [(2)2-Side Slitting] to be set to [ON]	Perform 2-side slitting on all sheets. In this case only one sheet is folded. Multi fold is not performed.	

### 4.10.2 Settings on the Copy Screen

- 1 Position the original.
- 2 Press [COPY] tab to display the Copy Screen.
- 3 Press [Output Setting].  
The Output Setting Screen will be displayed.
- 4 Press [Multi 3-Fold].



The Multi Tri-Fold Setting Screen will be displayed.

- 5 Select either [Outside Print] or [Inside Print].



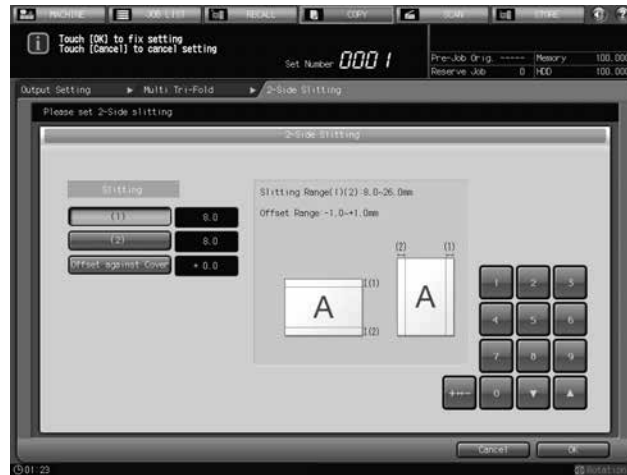
- 6 For "2-Side Slitting", press [ON].  
→ If the saddle stitcher is equipped with **Creaser Unit CR-101**, [Crease] is available. See page 4-36 for details.  
The 2-Side Slitting Setting Screen will be displayed.

## 7 Specify 2-side slitting width.

Select [(1)] for "Slitting", and press the keypad, [▼], or [▲] to enter the slitting amount for the head. Likewise, press [(2)] and enter the slitting amount for the foot.

[Offset against Cover] will not function, even if specified.

→ The difference of specified slitting between the head and the foot must not exceed 10.0 mm.



## 8 Press [OK].

The Multi Tri-Fold Setting Screen will be restored.

## 9 Press [OK].

→ To restore the previous setting, press [Cancel].

→ To disable the function while keeping the current setting, press [Function OFF].

The Output Setting Screen will be restored.

→ [Multi 3-Fold] and [2-Side Slit] are highlighted. 2-side slitting settings can be changed by pressing [2-Side Slit].

## 10 Press [OK].

→ To restore the previous setting, press [Cancel].

→ To disable the function while keeping the current setting, press [Function OFF].

The Output Setting Screen will be restored.

→ [Multi 3-Fold] and [Crease] are highlighted. [Crease] has now become unavailable, and the crease settings cannot be changed.

## 11 Press [OK] on the Output Setting Screen to return to the Copy Screen.

An icon representing specified output mode will be displayed under [Output Setting] on the Copy Screen.

## 12 Select additional copy conditions, as desired.

→ In **bizhub PRESS 1250/1250P/1052**, you can load sheets onto a tray, and use [Paper Presetting] to change the paper setting temporarily. See the User's Guide supplied with this machine for details on [Paper Presetting].

## 13 Enter the desired print quantity from the control panel keypad.

→ Up to 40 sets of 1-sheet-tri-folded paper (for 22 lb Bond (80 g/m<sup>2</sup>) paper) can be load onto the **tri-fold tray**.

## 14 Press **Start** on the **control panel**.

### 4.10.3 Settings in Printer Driver

To perform 2-side slitting in Tri-Fold, set [Multi Tri-Fold] and [2-Side Slitting].

The PS Plug-in driver and PCL driver are printer drivers for which [2-Side Slitting] is available.

The setting method varies depending on the type of the printer driver you are using.

Type of printer driver	Setting screen	Description
PS Plug-in driver (Windows/Mac OS X)	[Fold] tab	Select [Multi Tri-Fold] in [Fold], then set the print side to the inside or outside in [Folding Direction]. Select a target in [2-Side Slitting], then specify the slitting in [Top Slitting]/[Bottom Slitting].
PCL driver (Windows)	[Finish] tab	In [Fold], select [Multi-Letter Fold In] or [Multi-Letter Fold Out]. Enable [2-Side Slitting], then specify the target and slitting in [2-Side Slitting Settings].



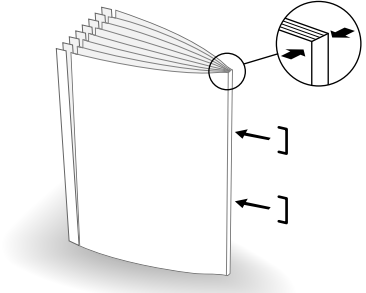
#### Reference

See page 4-73 for details on the printer driver functions that are available when this machine is equipped with **Saddle Stitcher SD-513**.

## 4.11 Forming Spine Corners on Fold & Stapled Sets

### 4.11.1 Functional Overview

Spine corner forming can be performed in combination with fold & staple when **Folding Unit FD-504** is mounted on **Saddle Stitcher SD-513**.

Setting item	Details	Illustration
[Fold&Staple] (+ [Fore-edge Trimming]) Fold & Staple Setting [Spine Corner Forming] to be set to [ON]	For "Spine Corner Forming Strength", select [Strong+], [Strong], [Normal], [Weak], or [Weak+].	

#### NOTICE

When Spine Corner Forming is specified, Crease is not available.



#### Reference

The number of sheets processed for spine corner forming equals the number of sheets processed for fold & staple. Please check paper information before use. See "Paper Information" (page 2-12) for details.

#### NOTICE

The multi half-folded and stapled sets will be delivered onto the **bundle exit tray**. Set up the **bundle exit tray extension**, and follow the preparation process before opening the **stopper**. Failing to carry out the preparation may lead to output sheets falling off the **bundle exit tray**. It could also cause the sensor to fail to detect the output full condition.

#### NOTICE

When increasing or further lowering the spine corner forming strength, you can adjust it to the appropriate setting. See page 5-48 for details.

### 4.11.2 Settings on the Copy Screen

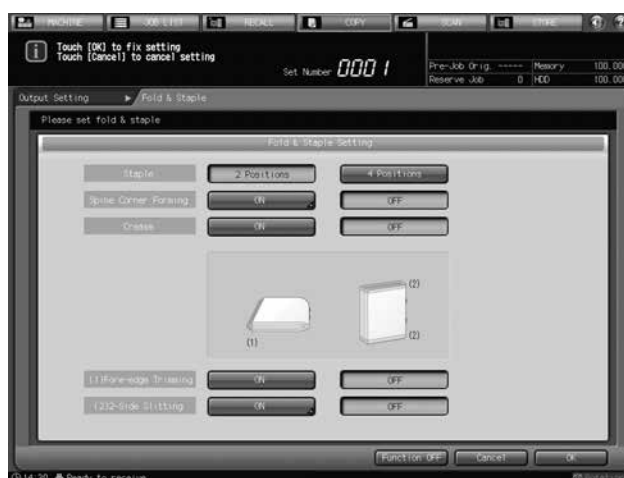
- 1 Position the original.
  - The number of original sheets will be the number of pages for fold & stapled output, thus determining the number of fold & stapled sheets. For information on the number of fold & stapled sheets, see page 2-13.
- 2 Load cover for fold & staple in the desired tray.
  - Load cover paper into [Tray1] to [Tray11]. The [PI-PFU Tray] or [PI Tray] is not available for covers.
  - In **bizhub PRESS 1250/1250P/1052**, use [Paper Presetting] to change the paper setting for paper loaded temporarily onto a tray. See the User's Guide supplied with this machine for details on [Paper Presetting].
- 3 Press [COPY] tab to display the Copy Screen.
- 4 Press [Output Setting].
 

The Output Setting Screen will be displayed.
- 5 Select [Fold&Staple].



The Fold & Staple Setting Screen will be displayed.

- 6 For "Staple", select [2 Positions] or [4 Positions].



- 7 For "(1) Fore-edge Trimming", select [ON] or [OFF].
  - If the saddle stitcher is equipped with **Trimmer Unit TU-503**, [(2)2-Side Slitting] is available on the Fold & Staple Setting Screen. See page 4-48 for details.

- 8 For "Spine Corner Forming", press [ON].  
The Spine Corner Forming Strength Setting Screen will be displayed.
- 9 Select [Strong+], [Strong], [Normal], [Weak], or [Weak+].



- 10 Press [Return].  
The Fold & Staple Setting Screen will be restored.
- 11 Press [OK].
  - To restore the previous setting, press [Cancel].
  - To disable the function while keeping the current setting, press [Function OFF].
 The Output Setting Screen will be restored.
- 12 Press [OK] on the Output Setting Screen to return to the Copy Screen.  
An icon representing specified output mode will be displayed under [Output Setting] on the Copy Screen.  
You will also find that Booklet in Application is selected automatically.
- 13 Press [Application], and then press [Booklet].



- 14 Select [No Cover Sheet], [Cover With Copy Sheet], or [Cover With Blank Sheet].  
 → In **bizhub PRESS 1250/1250P/1052**, select in [Binding Mode] - [Magazine Binding].

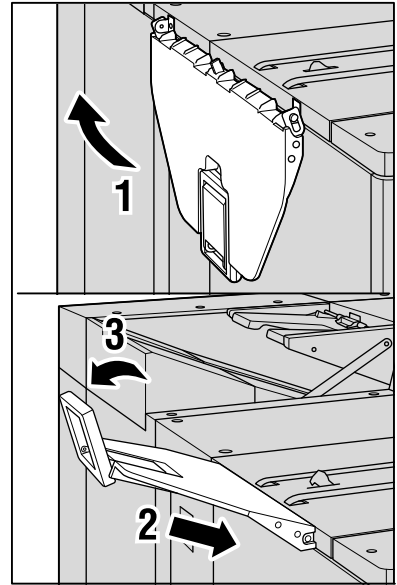


- In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select in [Cover Sheet].



- 15 For "Binding Position", select [Left Bind] or [Right Bind].  
 16 As the cover paper tray, select the tray to which the cover paper has been loaded in step 2.  
 → In **bizhub PRESS 1250/1250P/1052**, press [Cover Tray Change] to select a tray.  
 → In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select a tray in [Cover Tray Setting].  
 17 Press [OK] to complete the setting and return to the Copy Screen.  
 18 Select additional copy conditions, as desired.  
 19 Enter the desired print quantity from the control panel keypad.  
 → The number of sets that can be output to a **bundle exit tray** varies depending on the type of paper. The number of sets that can be output to a **bundle exit tray** for spine corner forming equals the number of sets that can be loaded for fold & staple. See page 2-13 for details.

**20** Set up the **bundle exit tray extension**, and open the **stopper**.



**21** Press **Start** on the **control panel**.

### 4.11.3 Settings in Printer Driver

To form spine corners on Fold & Stapled sets, set [Fold and Staple] and [2-Side Slitting].

The PS Plug-in driver and PCL driver are printer drivers for which [2-Side Slitting] is available.

The setting method varies depending on the type of the printer driver you are using.

Type of printer driver	Setting screen	Description
PS Plug-in driver (Windows/Mac OS X)	[Fold] tab	Select [Multi Half-Fold] in [Fold], then set [Fold and Staple] in [Multi Half-Fold Details]. Select a target in [2-Side Slitting], then specify the slitting in [Top Slitting]/[Bottom Slitting].
PCL driver (Windows)	[Finish] tab	Select [Fold and Staple]. Enable [2-Side Slitting], then specify the target and slitting in [2-Side Slitting Settings].










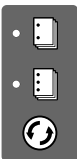
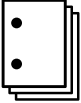
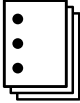
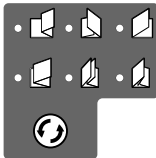

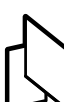
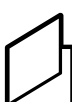


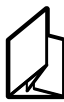
#### Reference

See page 4-73 for details on the printer driver functions that are available when this machine is equipped with **Saddle Stitcher SD-513**.

## 4.12 Manually Using Folding Unit FD-503 or Saddle Stitcher SD-513

The following finishing functions are manually available with a set of paper loaded in the upper tray of the post inserter of **Folding Unit FD-503**.

Standard/Optional Equipment	Output mode
<b>Folding Unit FD-503 + Saddle Stitcher SD-513</b>	Functions available with <b>Folding Unit FD-503</b> only, Fold & Staple
<b>Folding Unit FD-503 + Finisher FS-532 + Saddle Stitcher SD-513</b>	All the manual operations with the post inserter

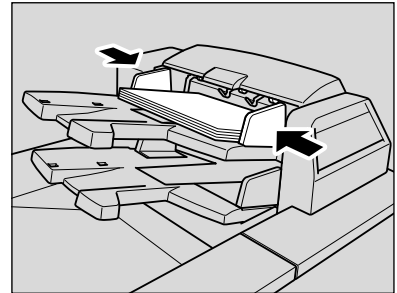
Button	Output		
<b>Multi-feed detection button</b>  	Multi-feed detection - ON	Multi-feed detection - OFF	
			
<b>Staple selection button</b>  	Corner Staple	2 Position Staple	Fold & Staple
			
<b>Punch selection button</b>  	2-Hole Punch	3-Hole Punch	
			
<b>Fold selection button</b>  	Z-Fold	Tri-Fold-in	Half-Fold
			
	Tri-Fold-out	Double Parallel	Gate
			

- ✓ When manually using the functions available with **Folding Unit FD-503/Finisher FS-532/Saddle Stitcher SD-513**, you can load paper only in the upper tray of the post inserter of **Folding Unit FD-503**.

- ✓ Multi-feed detection is a feature that automatically stops the machine if more than one sheet is fed at a time. The post inserter is designed to operate this function. Some paper type, such as smooth surface paper, may activate this function even if a single sheet is fed, and may stop the machine as a result. Should this case occur frequently, press the multi-feed detection button and light up the lower lamp, in order to turn the function OFF.

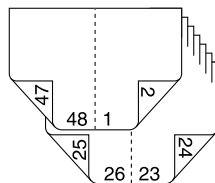
- 1 Place paper in the upper tray of the post inserter, then align the guides with paper.

Function	Positioning of paper
Corner Staple/2 Position Staple	Place paper face up.
Punch	Place paper face up.
Fold	Place the face to be inside the fold up.
Fold & Staple	Place the face to be inside the booklet up.

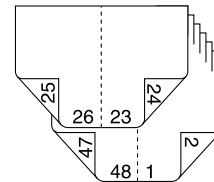


- To fold or fold & staple booklet-styled (magazine bound) prints manually, arrange the printed sheets as shown below before placing them into the post inserter.

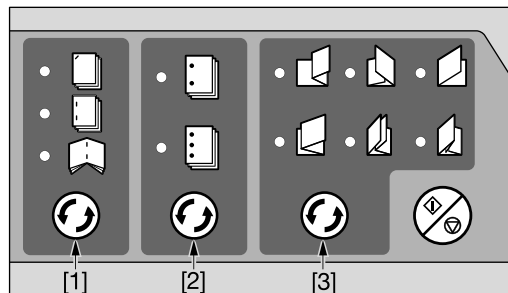
Magazine bound print



Arrange sheets in the reverse order



- 2 Select the desired function.

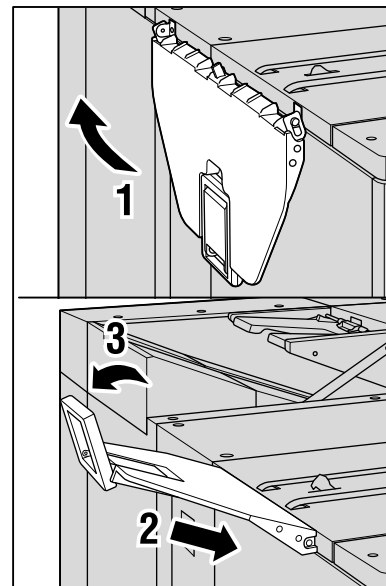


- [1]: Staple selection button  
[2]: Punch selection button  
[3]: Fold selection button

- Press **staple selection button**, **punch selection button** or **fold selection button**, and turn on the desired mode lamp.
- Punch and Corner Staple/2 Position Staple are compatible. To use them in combination, turn on the lamps of both functions.

**NOTICE**

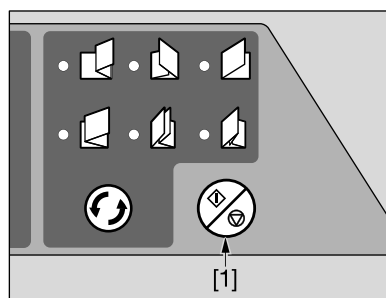
Set up the **bundle exit tray extension** of the saddle stitcher, and open the **stopper**.



**3** Press the **Start/Stop button**.

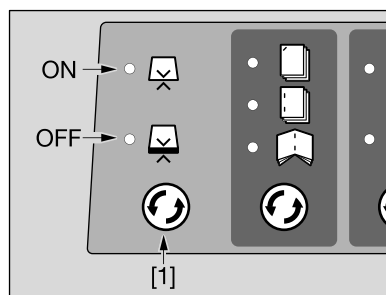
→ To interrupt the operation, press the **Start/Stop button** again.

[1]: Start/Stop button



→ If multi-feeding is detected and the machine stops even if a single sheet is fed, press the **multi-feed detection button** to turn on the lower lamp.

[1]: Multi-feed detection button

**NOTICE**

The **Finisher FS-532** trays have a limit in capacity. Be careful not to exceed the limit, otherwise unexpected trouble may be caused.

## 4.13 Combining Perfect Binder PB-503

The machine with **Perfect Binder PB-503** installed automatically attaches a printed set with a cover to make a perfect-bound book, applying a dab of glue to the spine.

If **Saddle Stitcher SD-513** is combined, the following functions are available.

- Cover Fore-edge Trim
  - If [ON] is selected, the machine trims the cover by the amount automatically estimated from the following formula, in the range from 5 mm to 40 mm in 0.1 mm increments.  
Trimming width = (Cover width) - (Body width × 2) - (Spine width)
  - If the estimated amount exceeds 10 mm, the machine will automatically trim the cover whether this function is activated or not.
- Cover 2-Side Slit
  - This function is available when using **Trimmer Unit TU-503** equipped in **Saddle Stitcher SD-513**.
  - Perform 2-side slitting on the head and the foot of cover loaded in a tray other than the cover tray of a perfect binder. 2-side slitting cannot be performed for body.
  - Slitting can be specified within the range from 8.0 mm to 26.0 mm in increments of 0.1 mm.
  - The difference of specified 2-side slitting between the head and the foot must be within 10.0 mm.
- Crease
  - This function is available when using **Creaser Unit CR-101** equipped in **Saddle Stitcher SD-513**.
  - Selecting [(3)Spine] will add 2 creases on the fold part of the spine.
  - Selecting [(4)Gutter] will add 2 creases on the gutter of the front cover and the back cover, making bound pages easier to flip. The crease side is fixed to [Back].
  - Selecting [(3) Spine + (4) Gutter] will add 2 creases each on the back cover and the gutter.

### 4.13.1 Making Perfect-Bound Booklets



#### Reference

See the *User's Guide* supplied with this machine for details on how to normally use perfect-bound booklets.

- 1 On the Copy screen, specify the tray with body paper loaded, then press [Output Setting] and [Perfect Bind] in sequence.



The Perfect Bind Screen will be displayed.

The heater of the perfect binder automatically starts warming up. The warmup takes approximately 20 minutes.

#### NOTICE

**Perfect Binder PB-503** will not stop warming up even if [Default Set] is pressed on the Output Setting Screen or **Reset** is pressed on the **Control panel**.

To stop using **Perfect Binder PB-503**, return to the Machine Screen, then press [OFF] of PB heater switch. When you stop using the perfect binder, be sure to turn off the heater so as to prevent the degradation of glue pellets.

- 2 Select the tray loaded with covers.
  - Press [Change Set] on the right of [Cover Tray], then select the tray to which the cover paper has been loaded.



- Selecting one from [Tray1] to [Tray11] enables the covers to be printed. Cover print cannot be performed if any other tray is selected. The number of displayed trays varies depending on which options are installed.
- When **Saddle Stitcher SD-513** is attached, and a tray other than the cover tray of a perfect binder is selected for cover, both the crease and 2-side slitting functions of a saddle stitcher are available for cover. For details, refer to page 4-30 and page 4-45.
- Press [Change Paper Setting], and modify the settings as required.

- 3 Press [OK] on the Cover Tray Screen.  
The Perfect Bind Screen will be restored.

- 4 Select the settings for cover print, cover print side, and bind direction.



- Cover Print can be set to [ON] when one of [Tray1] to [Tray11] is specified as the cover tray. By selecting [ON], Cover Print Side becomes selectable.
- The cover print operations will differ, depending on whether the number of original sheets is odd or even.
- When using **Creaser Unit CR-101** or **Trimmer Unit TU-503** equipped in **Saddle Stitcher SD-513**, [Previous] and [Next] display at the lower left corner of the screen. Cover trim can be specified in "(1)Cover Fore-edge Trim" and "(2)Cover 2-Side Slit" displayed when [Next] is pressed. See steps 7 to 10 for details.

- 5 Specify the spine width.

- Press [Change Set] on the right side of [Spine Width (1-30 mm)] to display the Spine Width Screen. Use the touch panel keypad, [▼], [▲], or the **control panel keypad** to enter the desired value.
- This setting is effective with Cover Print set to [ON].
- Press [OK] to restore the Perfect Bind Screen.

- 6 Make fine adjustments in the lead edge, trimming width, and image position of the cover.

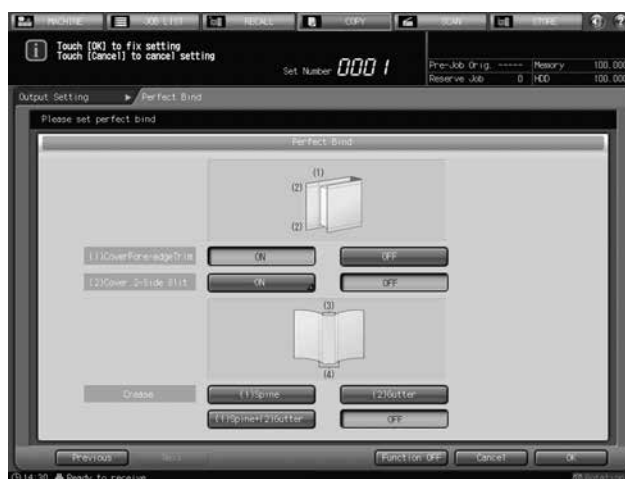
- In **bizhub PRESS 1250/1250P/1052**, press [Change Set] on the right of [Fine Adjustment] to display the Fine Adjustment window, then make adjustments.
- In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Change Set] on the right of [Cover Fine Adj.] to display the Fine Adjustment window, then make adjustments. Press [OK] to restore the Perfect Bind Screen.

- 7 Press [Next].

The Perfect Bind Screen will display for specifying a trimming mode (fore-edge trimming or 2-side slitting) or crease.

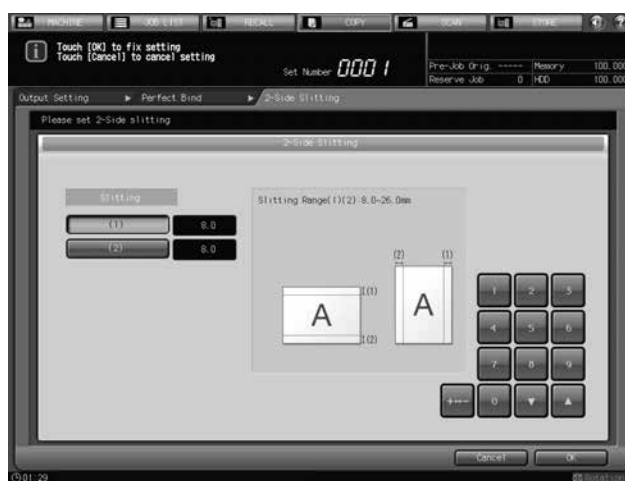


- 8 Specify fore-edge trimming for cover.  
Select [ON] for "(1)Cover Fore-edge Trim".



→ With "(1)Cover Fore-edge Trim" set to [ON], if the trimming width estimated by the machine does not fall within the range from 5 mm to 40 mm, a message will be displayed to inform you that the trimming mode is unavailable. If the trimming width exceeds 10 mm, the machine will automatically trim the cover whether this function is activated or not.

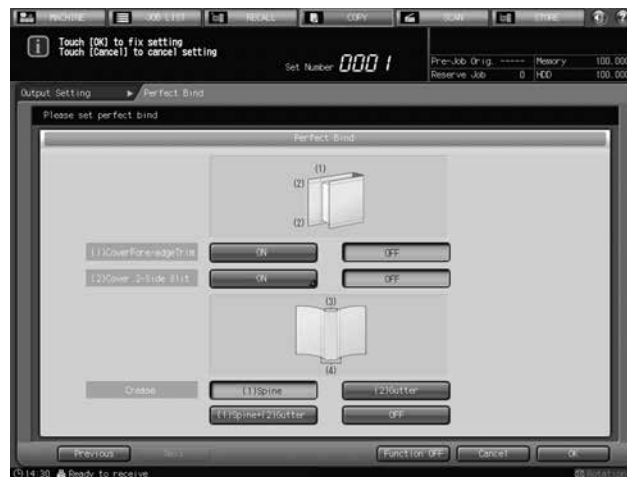
- 9 Specify 2-side slitting for cover.  
Press [ON] for "(2)Cover 2-Side Slit", and enter the slitting amount.



- This setting is not available when [PB Tray] is selected for "Cover Tray". Select a tray other than [PB Tray].
- Select [(1)] for "Slitting", and press the keypad, [▼], or [▲] to enter the slitting amount for the head. Likewise, press [(2)] and enter the slitting amount for the foot.
- The difference of specified slitting between the head and the foot must not exceed 10.0 mm.
- Press [OK] when completed.

**10** Specify crease for cover.

For "Crease", select [(3)Spine], [(4)Gutter], [(3) Spine + (4) Gutter], or [OFF].



- This setting is not available when [PB Tray] is selected for "Cover Tray". Select a tray other than [PB Tray].
- Selecting [(3)Spine] will add 2 creases on the fold part of the spine.
- Selecting [(4)Gutter] will add 2 creases on the gutter of the front cover and the back cover, making bound pages easier to flip.
- Selecting [(3) Spine + (4) Gutter] will add 2 creases each on the back cover and the gutter.
- Selecting [OFF] will result in no crease to be added.

**11** Press [Previous].

The Perfect Bind Screen will be restored.

The screen shows the details of perfect binding settings currently made. Check the settings.

**12** Press [OK] to confirm the settings.

→ To restore the previous setting, press [Cancel].

→ To disable the function while keeping the current setting, press [Function OFF].

The Output Setting Screen will be restored.

**13** Press [OK] on the Output Setting Screen to return to the Copy Screen.

The Perfect Bind icon will be displayed under [Output Setting] on the Copy Screen.

**14** Select additional copy conditions, as desired.

- When making double-sided copies, select [1->2] or [2->2].
- If the original count exceeds 100, use Separate Scan mode.

**15** Enter the desired print quantity from the control panel keypad.

- It is recommended to proof copy before making multiple sets.
- After proof copying, the actual thickness of body set will be displayed on the Perfect Bind Screen. Use this information to adjust the spine width if it differs from the value specified before.

**16** Press **Start** on the **control panel**.

**Perfect Binder PB-503** does not operate while the heater of perfect binder is warming up. When warm-up is completed, the machine operation starts automatically.

**NOTICE**

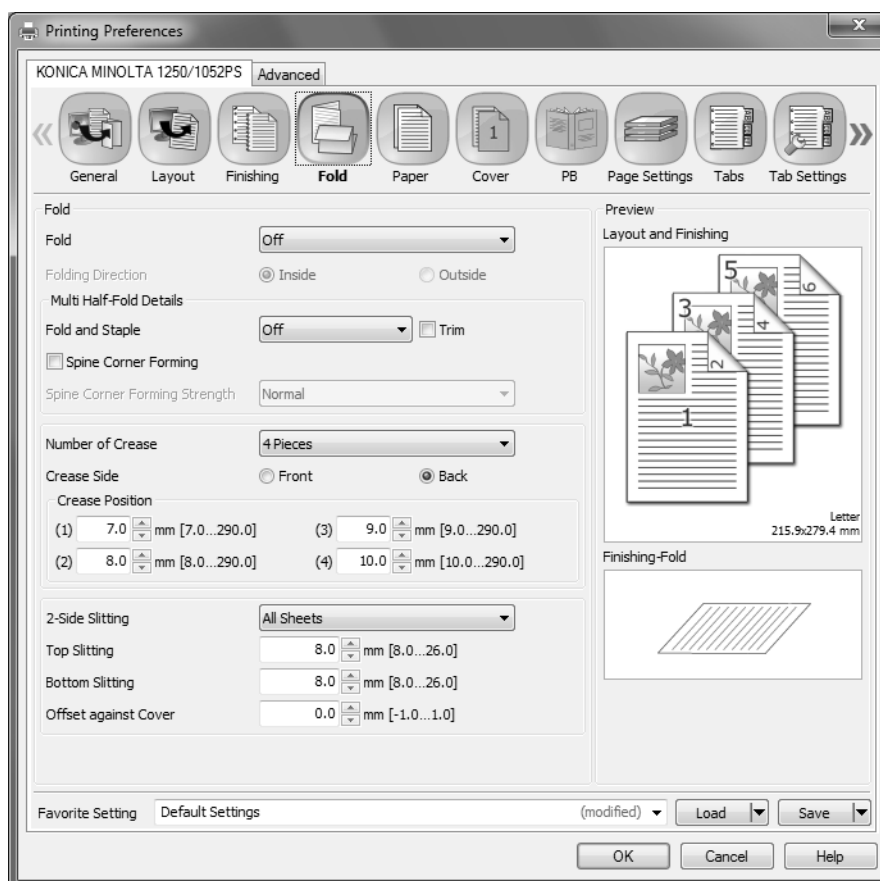
*Never open the front door of the **Perfect Binder PB-503** while the machine operation is in process. Otherwise the machine immediately stops the operation and paper jam may be caused.*

## 4.14 Functions of Printer Driver

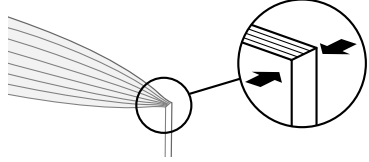
The available functions vary depending on the type of the printer driver of the model you are using.

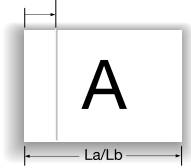
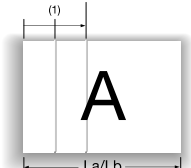
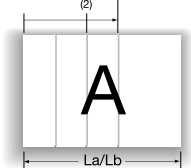
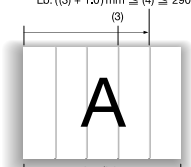
### 4.14.1 PS Plug-in driver (Windows/Mac OS X)

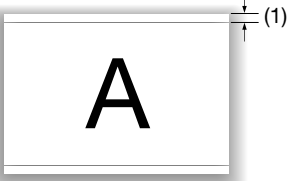
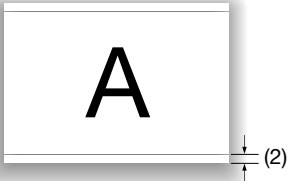
If this machine is equipped with **Saddle Stitcher SD-513** and **Creaser Unit CR-101**, **Trimmer Unit TU-503**, or **Folding Unit FD-504**, the [Fold] tab is displayed, enabling you to configure Fold & Staple functions.

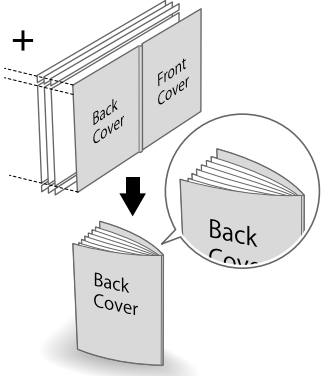
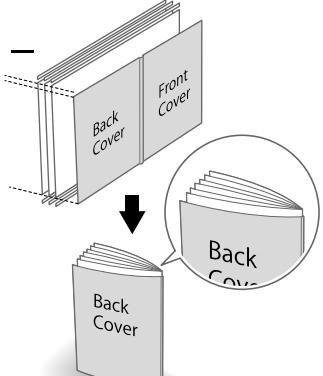


Function Name		Option	Setting item
[Fold]		[Off], [Half-Fold], [Z-Fold (A3/B4/Tabloid/8K)], [Z-Fold (Legal)], [Tri-Fold-In], [Tri-Fold-Out], [Double Parallel-Fold], [Gate-Fold], [Multi Tri-Fold], [Multi Half-Fold]	Set the fold function. From the drop-down list, specify the folding condition.
[Folding Direction]		[Inside], [Outside]	Specify whether to set the folding direction to the inside or outside.
[Multi Half-Fold Details]	[Fold and Staple]	[Off], [2 Positions], [4 Positions]	Specify the number of staple positions for Fold & Staple when [Fold and Staple] is selected.
	[Trim]	Off, On	Trims the edges of double-folded sheets for alignment when [Multi Half-Fold], including [Fold and Staple], is selected.

Function Name	Option	Setting item
[Spine Corner Forming]	Off, On	<p>Applies pressure to the spine of the folded &amp; stapled booklet, and forms a spine corner.</p> 
[Spine Corner Forming Strength]	[Strong+], [Strong], [Normal], [Weak], [Weak+]	Specify the strength to press the spine when forming a spine corner.
[Number of Crease]	[Off], [1 Piece], [2 Pieces], [3 Pieces], [4 Pieces]	Adds creases to fold paper, preventing toner flaking from occurring at the time of paper folding. Specify the number of creases.
[Crease Side]	[Front], [Back]	If [Front] is selected, "Output Order" is set to [Face Up].

Function Name	Option	Setting item
[Crease Position]	7.0 to 251 (or 290) (mm)	<p>Specify the crease position. Position (1) specifies the first crease position.</p> <p> <math display="block">La: 7 \text{ mm} \leq (1) \leq (La - 46) \text{ mm}</math> <math display="block">Lb: (Lb - 330) \text{ mm} \leq (1) \leq 290 \text{ mm}</math> </p>  <p>Position (2) specifies the second crease position. This is available when [Number of Creases] is set to two or more pieces.</p> <p> <math display="block">La: ((1) + 1.0) \text{ mm} \leq (2) \leq (La - 46) \text{ mm}</math> <math display="block">Lb: ((1) + 1.0) \text{ mm} \leq (2) \leq 290 \text{ mm}</math> </p>  <p>Position (3) specifies the third crease position. This is available when [Number of Creases] is set to three or more pieces.</p> <p> <math display="block">La: ((2) + 1.0) \text{ mm} \leq (3) \leq (La - 46) \text{ mm}</math> <math display="block">Lb: ((2) + 1.0) \text{ mm} \leq (3) \leq 290 \text{ mm}</math> </p>  <p>Position (4) specifies the fourth crease position. This is available when [Number of Creases] is set to four pieces.</p> <p> <math display="block">La: ((3) + 1.0) \text{ mm} \leq (4) \leq (La - 46) \text{ mm}</math> <math display="block">Lb: ((3) + 1.0) \text{ mm} \leq (4) \leq 290 \text{ mm}</math> </p> 
[2-Side Slitting]	[Off], [All Sheets], [Cover only]	<p>Trims the top and bottom in the paper feeding direction, and aligns the paper size. Specify whether to apply 2-side slitting to all sheets or only to the cover.</p>

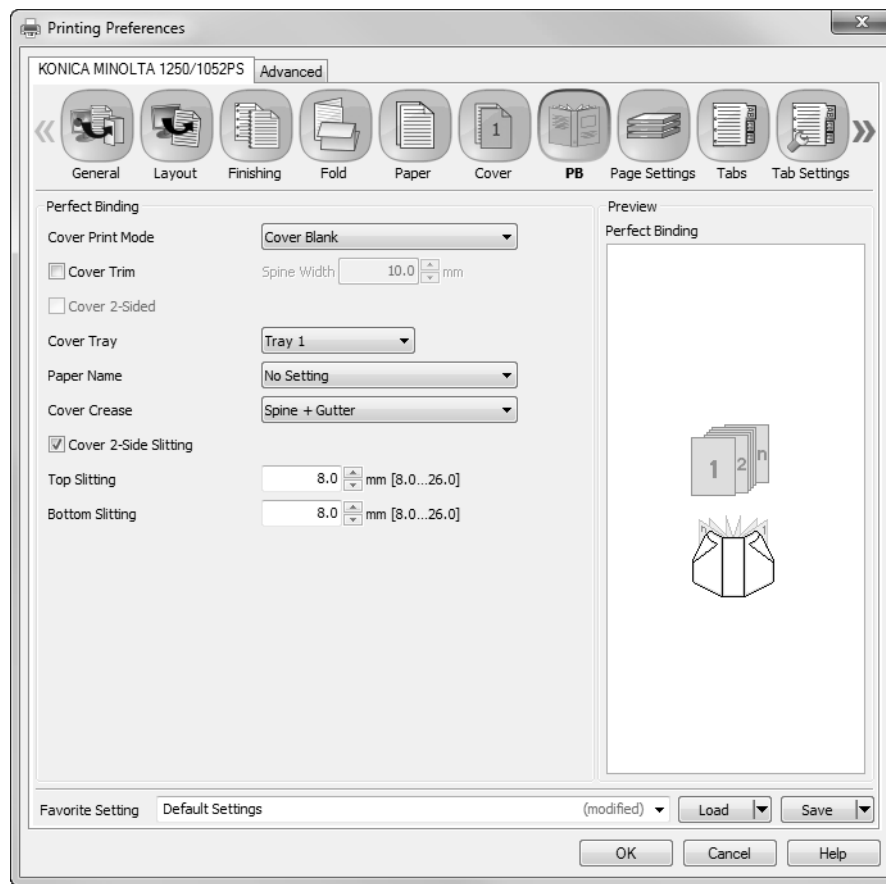
Function Name	Option	Setting item
[Top Slitting]	8.0 to 26.0 (mm)	<p>Specify the slitting at the top in the paper feeding direction.</p> 
[Bottom Slitting]	8.0 to 26.0 (mm)	<p>Specify the slitting at the bottom in the paper feeding direction.</p> 

Function Name	Option	Setting item
[Offset against Cover]	- 1.0 to 1.0 (mm)	<p>This is available only when [All Sheets] is selected. Enter the differential slitting to be applied to sheets other than covers. The value, which is obtained by adding or subtracting this setting value to or from the values specified in [Top Slitting] and [Bottom Slitting], is applied to sheets other than covers.</p> <p>Adjusting to the plus (+) side increases the slitting of the body against the cover.</p>  <p>Adjusting to the minus (-) side decreases the slitting of the body against the cover.</p>  <p>Even if the slitting is adjusted to either the plus (+) side or minus (-) side, the cover height remains unchanged.</p>

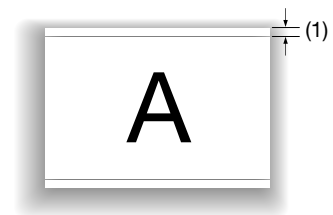
Reference

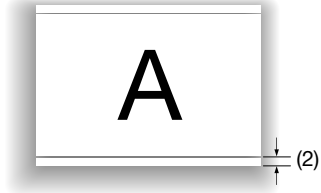
- [Spine Corner Forming] and [Spine Corner Forming Strength] are available only when **Folding Unit FD-504** is installed on this machine.
- [Number of Crease], [Crease Side], and [Crease Position] are available only when **Creaser Unit CR-101** is installed on this machine.
- [Cover 2-Side Slit], [Top Slitting], [Bottom Slitting], and [Offset against Cover] are available only when **Trimmer Unit TU-503** is installed on this machine.
- [Offset against Cover] is set to the total differential value between the top slitting and bottom slitting.

If this machine is equipped with **Saddle Stitcher SD-513** and **Creaser Unit CR-101**, **Trimmer Unit TU-503** or **Folding Unit FD-504** with Perfect Bind selected, the [PB] tab is displayed.



Function Name	Option	Description
[Cover Crease]	[Off], [Spine], [Gutter], [Spine + Gutter]	Adds fold lines (creases) on the perfect bind cover. Selecting [Spine] adds creases at two folding positions of the spine. Selecting [Gutter] adds creases at two positions on the gutter of the front cover and the back cover, making bound pages easier to flip. A crease is added only on [Back]. Selecting [Spine + Gutter] adds creases at two positions on each of the spine and gutter.
[Cover 2-Side Slitting]	Off, On	Trims the top and bottom of paper in the paper feeding direction of the cover, and aligns the paper size.
[Top Slitting]	8.0 to 26.0 (mm)	Specify the slitting at the top in the paper feeding direction of the cover.



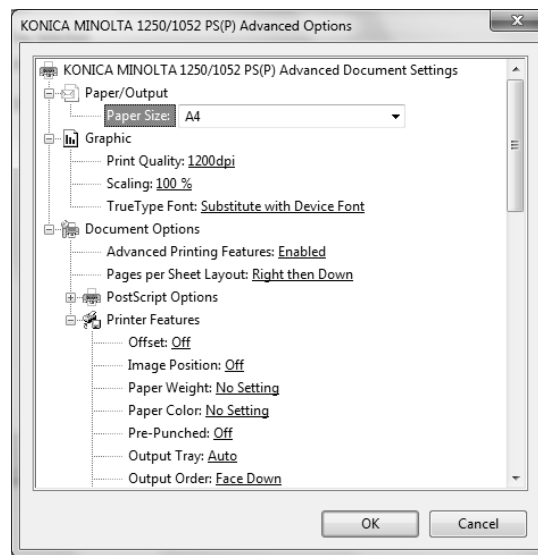
Function Name	Option	Description
[Bottom Slitting]	8.0 to 26.0 (mm)	<p>Specify the slitting at the bottom in the paper feeding direction of the cover.</p> 

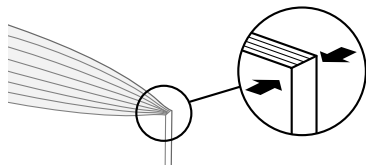
## Reference

- [Cover Crease] is available only when **Creaser Unit CR-101** is installed on this machine.
- [Cover 2-Side Slitting], [Top Slitting], and [Bottom Slitting] are available only when **Trimmer Unit TU-503** is installed on this machine.

### 4.14.2 PPD driver (Windows)

If this machine is equipped with **Saddle Stitcher SD-513** and **Creaser Unit CR-101**, **Trimmer Unit TU-503**, or **Folding Unit FD-504**, Fold & Staple functions can be configured in the [Advanced Options] window.



Function Name	Option	Setting item
[Fold]	[Off], [Z-Fold (A3/B4/Tabloid/8K)], [Z-Fold (Legal)], [Fold and Staple], [Fold and Staple + Trim], [Half-Fold - Inside], [Half-Fold - Outside], [Tri-Fold-In - Inside], [Tri-Fold-In - Outside], [Tri-Fold-Out - Inside], [Tri-Fold-Out - Outside], [Double Parallel-Fold - Inside], [Double Parallel-Fold - Outside], [Gate-Fold - Inside], [Gate-Fold - Outside], [Multi Tri-Fold - Inside], [Multi Tri-Fold - Outside], [Multi Half-Fold], [Multi Half-Fold + Trim]	Set the fold function.
[Spine Corner Forming]	Off, On	Applies pressure to the spine of the folded & stapled booklet, and forms a spine corner. 
[Spine Corner Forming Strength]	[Weak+], [Weak], [Normal], [Strong], [Strong+]	Specify the strength to press the spine when forming a spine corner.
[Crease]	Off, On	Adds creases to fold paper, preventing toner flaking from occurring at the time of paper folding.
[Perfect Binding Cover Trim]	Off, On	Trims the top and bottom of paper in the paper feeding direction of the cover, and aligns the paper size.

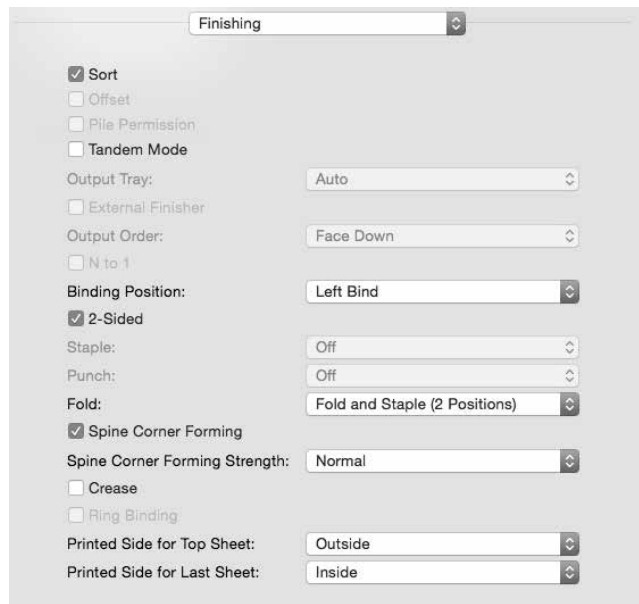
Function Name	Option	Setting item
[Perfect Binding Cover Crease]	[Off], [Spine], [Gutter], [Spine + Gutter]	Adds fold lines (creases) on the perfect bind cover. Selecting [Spine] adds creases at two folding positions of the spine. Selecting [Gutter] adds creases at two positions on the gutter of the front cover and the back cover, making bound pages easier to flip. A crease is added only on [Back]. Selecting [Spine + Gutter] adds creases at two positions on each of the spine and gutter.

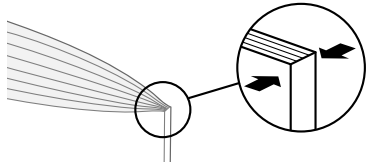
#### Reference

- The [Spine Corner Forming] function is available only when **Folding Unit FD-504** is installed on this machine.
- The [Crease] function is available only when **Creaser Unit CR-101** is installed on this machine.
- The details (the number of creases and crease position) of the [Crease] function are applied to the settings of this machine.
- [Perfect Binding Cover Crease] is available only when **Creaser Unit CR-101** is installed on this machine.
- [Perfect Binding Cover Trim] is available only when **Trimmer Unit TU-503** is installed on this machine.

### 4.14.3 PPD Driver (Mac OS X)

If this machine is equipped with **Saddle Stitcher SD-513** and **Creaser Unit CR-101**, **Trimmer Unit TU-503**, or **Folding Unit FD-504**, Fold & Staple functions can be configured in the [Finishing] window.



Function Name	Option	Setting item
[Fold]	[Off], [Z-Fold (A3/B4/Tabloid/8K)], [Z-Fold (Legal)], [Fold and Staple], [Fold and Staple + Trim], [Half-Fold - Inside], [Half-Fold - Outside], [Tri-Fold-In - Inside], [Tri-Fold-In - Outside], [Tri-Fold-Out - Inside], [Tri-Fold-Out - Outside], [Double Parallel-Fold - Inside], [Double Parallel-Fold - Outside], [Gate-Fold - Inside], [Gate-Fold - Outside], [Multi Tri-Fold - Inside], [Multi Tri-Fold - Outside], [Multi Half-Fold], [Multi Half-Fold + Trim]	Set the fold function.
[Spine Corner Forming]	Off, On	Applies pressure to the spine of the folded & stapled booklet, and forms a spine corner. 
[Spine Corner Forming Strength]	[Weak+], [Weak], [Normal], [Strong], [Strong+]	Specify the strength to press the spine when forming a spine corner.
[Crease]	Off, On	Adds creases to fold paper, preventing toner flaking from occurring at the time of paper folding.
[Perfect Binding Cover Trim]	Off, On	Trims the top and bottom of paper in the paper feeding direction of the cover, and aligns the paper size.

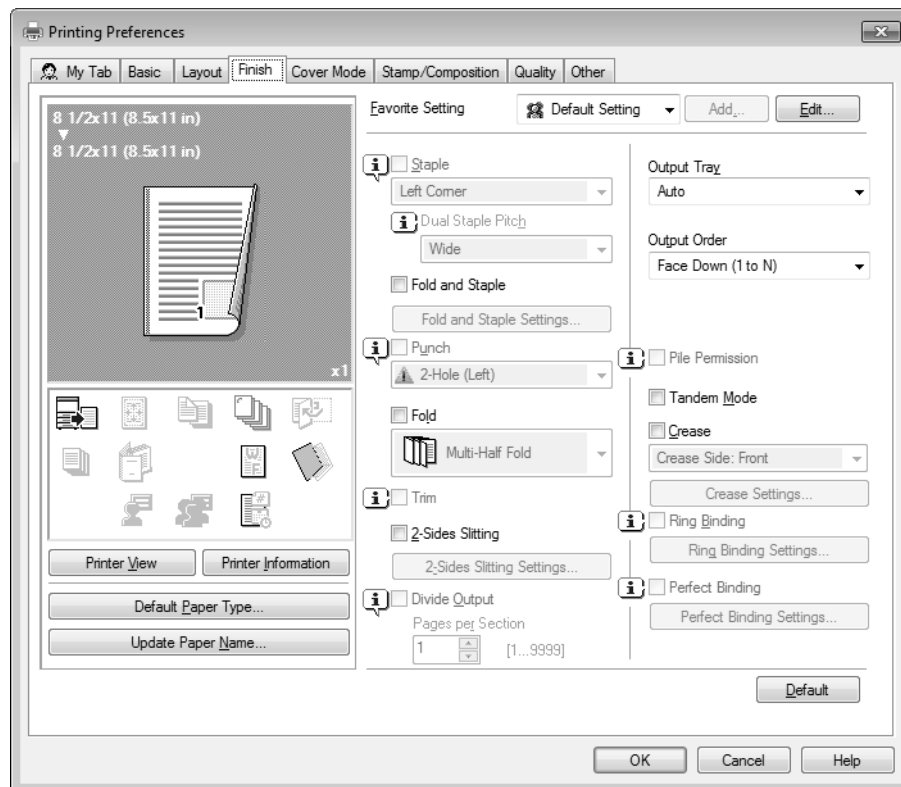
Function Name	Option	Setting item
[Perfect Binding Cover Crease]	[Off], [Spine], [Gutter], [Spine + Gutter]	Adds fold lines (creases) on the perfect bind cover. Selecting [Spine] adds creases at two folding positions of the spine. Selecting [Gutter] adds creases at two positions on the gutter of the front cover and the back cover, making bound pages easier to flip. A crease is added only on [Back]. Selecting [Spine + Gutter] adds creases at two positions on each of the spine and gutter.

## Reference

- The [Spine Corner Forming] function is available only when **Folding Unit FD-504** is installed on this machine.
- The [Crease] function is available only when **Creaser Unit CR-101** is installed on this machine.
- The details (the number of creases and crease position) of the [Crease] function are applied to the settings of this machine.
- [Perfect Binding Cover Crease] is available only when **Creaser Unit CR-101** is installed on this machine.
- [Perfect Binding Cover Trim] is available only when **Trimmer Unit TU-503** is installed on this machine.
- [Perfect Binding Cover Crease] and [Perfect Binding Cover Trim] are displayed in the [Setup] window.

#### 4.14.4 PCL driver (Windows)

If this machine is equipped with **Saddle Stitcher SD-513** and **Creaser Unit CR-101**, **Trimmer Unit TU-503**, or **Folding Unit FD-504**, Fold & Staple functions can be configured in the [Finish] window.



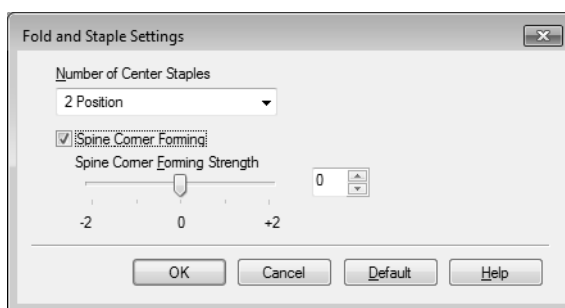
Function Name	Option	Setting item
[Fold and Staple]	Off, On	Enables Fold & Staple.
[Fold and Staple Setting]	-	Set stapling for Fold & Staple and spine corner forming when [Fold and Staple] is selected. For details on the Fold & Staple setting, refer to page 4-85.
[Fold]	[Z-Fold (A3, B4, 11 × 17, 8K)], [Z-Fold (8 1/2 × 14)], [Half Fold In], [Half Fold Out], [Letter Fold In], [Letter Fold Out], [Zigzag Fold In], [Zigzag Fold Out], [Double Parallel Fold In], [Double Parallel Fold Out], [Gate Fold In], [Gate Fold Out], [Multi-Letter Fold In], [Multi-Letter Fold Out], [Multi-Half Fold]	Set the fold function. From the drop-down list, specify the folding condition.
[Trim]	Off, On	Trims the edges of double-folded sheets for alignment when [Multi-Half Fold], including [Fold and Staple], is selected.
[2-Side Slitting]	Off, On	Trims the top and bottom in the paper feeding direction, and aligns the paper size.
[2-Side Slitting Settings]	-	Specify the target and slitting when [2-Side Slitting] is selected. See page 4-86 for details on the 2-side slitting setting.

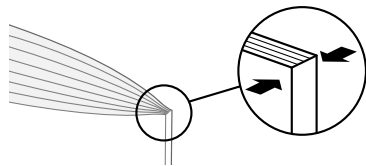
Function Name	Option	Setting item
[Crease]	Off, On	Adds creases to fold paper, preventing toner flaking from occurring at the time of paper folding. Specify whether to enable creasing.
	Crease Side: Front Crease Side: Back	Specify the crease side.
[Crease Settings]	-	Specify the crease details.

## Reference

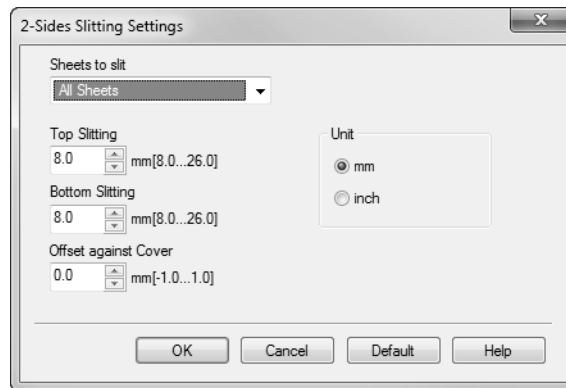
- The [Spine Corner Forming] function is available only when **Folding Unit FD-504** is installed on this machine.
- The [2-Side Slitting] function is available only when **Trimmer Unit TU-503** is installed on this machine.
- The [Crease] function is available only when **Creaser Unit CR-101** is installed on this machine.

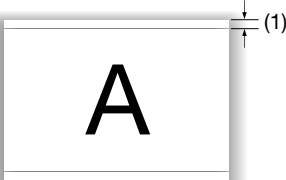
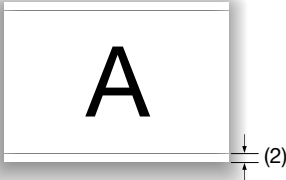
## Fold &amp; Staple Settings

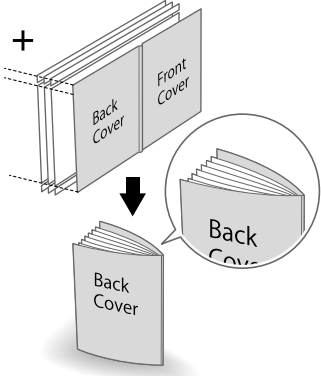
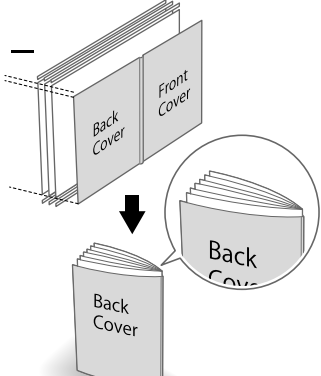


Function Name	Option	Setting item
[Number of Center Staples]	2 Positions, 4 Positions	Set the number of staples to 2 positions or 4 positions. However, 4 Positions is available only for the following paper sizes: A3, A3W, 11 × 17, 11 × 17W, and custom size.
[Spine Corner Forming]	Off, On	Applies pressure to the spine of the folded & stapled booklet, and forms a spine corner. 
[Spine Corner Forming Strength]	-2 to +2	Specify the strength to press the spine when forming a spine corner.

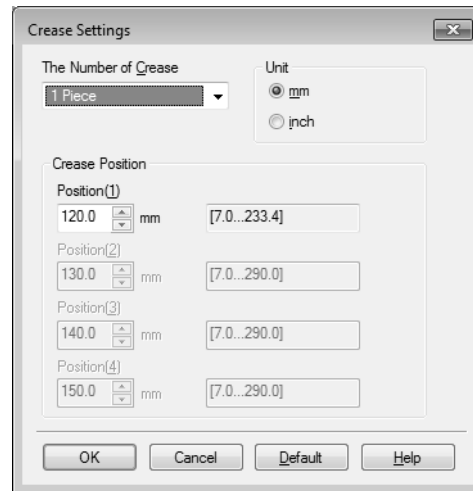
## 2-Side Slitting Settings



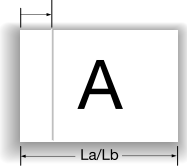
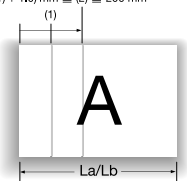
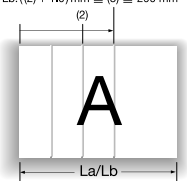
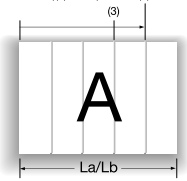
Function Name	Option	Setting item
[Sheets to Slit]	All Sheets, Cover Only	Specify whether to apply 2-side slitting to all sheets or only to the cover.
[Top Slitting]	8.0 to 26.0 (mm)	Specify the slitting at the top in the paper feeding direction. 
[Bottom Slitting]	8.0 to 26.0 (mm)	Specify the slitting at the bottom in the paper feeding direction. 

Function Name	Option	Setting item
[Offset against Cover]	-1.0 to 1.0 (mm)	<p>Enter the differential slitting to be applied to sheets other than the cover when [All Sheets] is selected for slitting.</p> <p>The value, which is obtained by adding or subtracting this setting value to or from the values specified in [Top Slitting] and [Bottom Slitting], is applied to sheets other than covers. Adjusting to the plus (+) side increases the slitting of the body against the cover.</p>  <p>Adjusting to the minus (-) side decreases the slitting of the body against the cover.</p>  <p>Even if the slitting is adjusted to either the plus (+) side or minus (-) side, the cover height remains unchanged.</p>
[Unit]	-	<p>Specify the unit in millimeters or inches.</p>

## Crease Settings



Function Name	Option	Setting item
[The Number of Creases]	1 to 4 Pieces	Specify the number of creases.

Function Name	Option	Setting item
[Crease Position]	7.0 to 251 (or 290) (mm)	<p>Specify the crease position. Position (1) specifies the first crease position.</p> <p> <math>La: 7 \text{ mm} \leq (1) \leq (La - 46) \text{ mm}</math>  <math>Lb: (Lb - 330) \text{ mm} \leq (1) \leq 290 \text{ mm}</math> </p>  <p>Position (2) specifies the second crease position. This is available when [The Number of Creases] is set to two or more pieces.</p> <p> <math>La: ((1) + 1.0) \text{ mm} \leq (2) \leq (La - 46) \text{ mm}</math>  <math>Lb: ((1) + 1.0) \text{ mm} \leq (2) \leq 290 \text{ mm}</math> </p>  <p>Position (3) specifies the third crease position. This is available when [The Number of Creases] is set to three or more pieces.</p> <p> <math>La: ((2) + 1.0) \text{ mm} \leq (3) \leq (La - 46) \text{ mm}</math>  <math>Lb: ((2) + 1.0) \text{ mm} \leq (3) \leq 290 \text{ mm}</math> </p>  <p>Position (4) specifies the fourth crease position. This is available when [The Number of Creases] is set to four pieces.</p> <p> <math>La: ((3) + 1.0) \text{ mm} \leq (4) \leq (La - 46) \text{ mm}</math>  <math>Lb: ((3) + 1.0) \text{ mm} \leq (4) \leq 290 \text{ mm}</math> </p> 
[Unit]	-	Specify the unit in millimeters or inches.

**NOTICE**

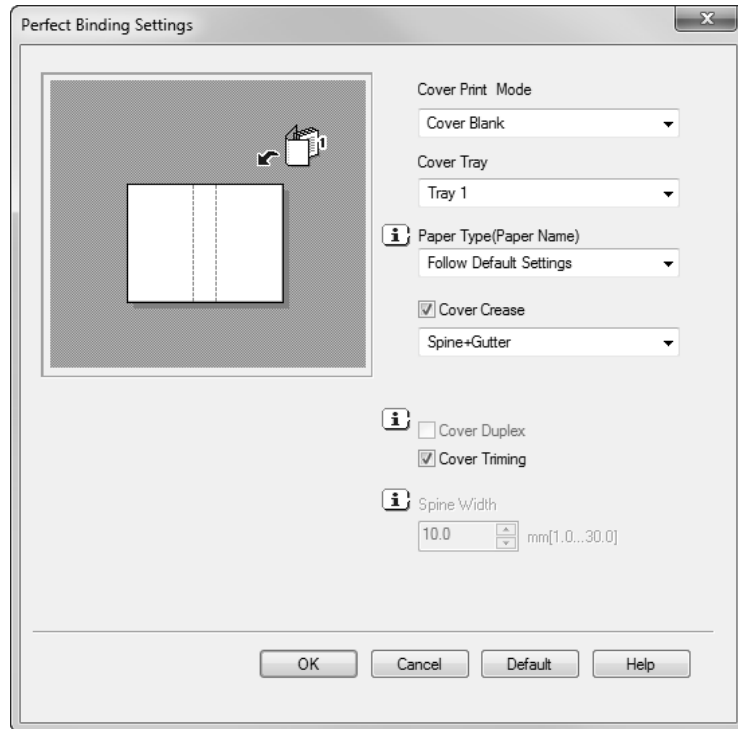
The number of creases is affected by the combined function.

When Fold & Staple or Multi Half Fold mode is selected, only a single crease can be specified for cover sheets. Creases cannot be added on body.

When Tri Fold mode is selected, only two creases can be specified for tri-folded sheets.

When Perfect Bind mode is selected, 2 creases or 4 creases can be specified for cover sheets. Creases cannot be added on body.

## Perfect Binding Settings



Function Name	Option	Description
[Cover Crease]	[Spine], [Gutter], [Spine + Gutter]	Adds fold lines (creases) on the perfect bind cover. Selecting [Spine] adds creases at two folding positions of the spine. Selecting [Gutter] adds creases at two positions on the gutter of the front cover and the back cover, making bound pages easier to flip. A crease is added only on [Back]. Selecting [Spine + Gutter] adds creases at two positions on each of the spine and gutter.
[Cover Trimming]	Off, On	Trims the top and bottom of paper in the paper feeding direction of the cover, and aligns the paper size.

### Reference

- [Cover Crease] is available only when **Creaser Unit CR-101** is installed on this machine.
- [Cover Trimming] is available only when **Trimmer Unit TU-503** is installed on this machine.

## 4.15 Job Operations

If this machine is equipped with **Saddle Stitcher SD-513** and **Creaser Unit CR-101**, **Trimmer Unit TU-503**, or **Folding Unit FD-504**, job operations may differ from normal operations.

### 4.15.1 Operating Prior Print

When Prior Print is specified to temporarily stop the currently output job and first output a ready job in the active job list, if **Saddle Stitcher SD-513** is installed on this machine, it may cause the following cases.

- If the print job in progress is using **Saddle Stitcher SD-513** while any output sheets are left inside the saddle stitcher, the machine suspends printing when a set currently output is completed.
- When **Creaser Unit CR-101** or **Trimmer Unit TU-503** is attached to **Saddle Stitcher SD-513**, if fold & staple or multi half-fold is used in combination with crease or 2-side slitting and if any output sheets are left inside any of the machine, the machine suspends printing when a set currently output is completed.
- If the suspended job is using **Saddle Stitcher SD-513** while no output sheets are left inside the saddle stitcher, the machine starts output for the top-priority job instead of the suspended job after restarting the operation.

### 4.15.2 Printing a Sample during Output and Checking it: Sample Print

Some types of print job do not allow you to check the output images till all the machine operations are completed. Use Sample Print to deliver a sample image to another tray without interrupting the job in process, so that you can check the quality of printed images at that time.

Sample printing is possible for a job that is folded & stapled and output using **Saddle Stitcher SD-513**. See the User's Guide supplied with this machine for details on sample printing.



---

A large, bold, black number '5' is centered within a light gray square. The square is positioned to the left of the chapter title.

## **Various Settings and Adjustment**

## 5 Various Settings and Adjustment

This section describes various settings and adjustment items when **Saddle Stitcher SD-513** is installed on this machine.

### 5.1 Tray Setting

This section mainly describes the tray setting for a 2-side slit cover when **Saddle Stitcher SD-513** and **Trimmer Unit TU-503** are installed on this machine.

#### 5.1.1 PI-PFU Tray Setting (bizhub PRESS 1250/1250P/1052)

PI-PFU trays are paper trays of **Large Capacity Post Inserter PI-PFU**, with **PI-PFU Kit FA-501** attached to **Paper Feeder Unit PF-703**.

The following paper can be loaded into the PI-PFU trays: Paper loaded into the PI-PFU trays cannot be for copying/printing.

- Front covers/back covers/insertions for Insert Sheet
- Perfect bind cover
- Cover that is to be put to 2-side slitting

Select PI-PFU trays from [Tray Setting] on the Machine Screen, then configure the following setting for each PI-PFU tray.



## Normal Use Setting, Common Setting, and Air Assist Setting

For the PI-PFU tray setting, specify Paper Type, Weight, or Double Feed Detection for the "Common Setting". This setting is applied in common to "Normal Use Setting (For Cover, Insert Sheet, etc.)", "Perfect Bind Cover Setting", and "Cover Size Setting [Slit(Cover Only)]".

For Standard Detect, the paper size loaded in the PI-PFU tray will be automatically detected. If the size is not distinctive, the machine identifies one size from the size groups in [Detect Size Setting] so that it can be distinguished from others.



### Reference

The normal use setting, "Common Setting", and air assist setting procedures are the same as the procedure with no **Saddle Stitcher SD-513** installed. See the User's Guide supplied with this machine for details.

## Tray setting for perfect bind covers

If **Perfect Binder PB-503** is attached, the perfect bind cover size for each PI-PFU tray can be specified in advance. The paper size setting for perfect bind cover is available in the "Perfect Bind Cover Setting". The setting can be viewed on the Machine Screen.

When **Trimmer Unit TU-503** is equipped in **Saddle Stitcher SD-513**, 2-side slitting can be performed on perfect bind cover.



### Reference

The tray setting procedure for perfect bind covers is the same as the procedure with no **Saddle Stitcher SD-513** installed. See the User's Guide supplied with this machine for details.

## Tray setting for 2-side slit covers

When **Trimmer Unit TU-503** is equipped in **Saddle Stitcher SD-513**, the paper size of the cover on which to perform 2-side slitting can be specified in advance.

To specify the cover size for 2-side slitting, use "Cover Size Setting [Slit(Cover Only)]". The 2-side slit cover size can be viewed on the Machine Screen when it has been specified for each PI-PFU tray. The paper size for each PI-PFU tray specified here is applied when the target PI-PFU tray is selected for [Front Cover] of [Post Insert Paper] that is displayed by selecting [COPY] screen - [Application] - [Insert Sheet].

- 1 Select [PI-PFU 1], [PI-PFU 2] or [PI-PFU 3] from under "PI-PFU Tray" on the Tray Setting Screen.  
The setting for the selected tray will be displayed in the right area of the Tray Setting Screen.
- 2 Press [Change Set] of [Paper Size] under "Cover Size Setting [Slit(Cover Only)]".



The Size Setting Screen will be displayed.

### 3 Specify the standard or custom size for 2-side slit covers.



Selecting [Standard] automatically enables detection of the size of paper loaded in the PI-PFU tray. If the size is not distinctive, the machine identifies one size from the size groups in [Detect Size Setting] so that it can be distinguished from others.



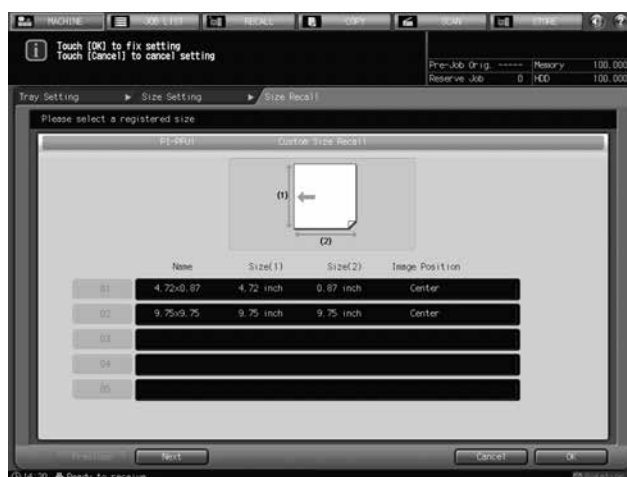
Selecting [Custom] displays the Custom Size Setting Screen.

Press the [(1)] or [(2)] button that displays the vertical or horizontal size value of the paper, then press the keypad, [▼], or [▲] on the screen to enter the desired size.

To recall a custom size previously registered, press [Size Recall].



Press [Next] or [Previous] to locate and select the desired key for a registered custom size, and press [OK].



Press [OK] on the Size Setting Screen.

- 4 Press [Recall] under "Common Setting".
  - If optionally changing the paper setting, proceed to step 6.
  - If no change is desired for paper setting, proceed to step 9.



The Recall Screen will be displayed.

- 5 Select paper conditions for 2-side slit covers.

Press [▲] or [▼] to scroll to the desired paper condition on the list to select the number.



Press [OK].

- 6 Press [Change Set] under "Common Setting".



- 7 Select paper conditions (paper type, weight, Dfeed detection) for 2-side slit covers as desired.



Press [Paper Type], and select the desired paper type from the right area of the screen.

Press [Weight], and select the desired weight from the right area of the screen.

Press [Dfeed Detection], and select either [ON] or [OFF].

Press [OK].

- 8 Press [Register] to register the paper conditions specified here.

Press [▲] or [▼] to scroll to the desired registration number, and press its number key to enter the desired name.



- 9 Press [Change Set] on the right side of "Air Assist".



The Air Assist Screen will be displayed.

- 10 Select [Auto] or [Manual] under "Air Assist".

Selecting [Manual] enables the following settings:

- Use [Weak] or [Strong] provided under "Lead" to select the desired air level within the range from [1] to [9].
- Use [Weak] or [Strong] provided under "Side" to select the desired air flow of the side within the range from [1] to [9].

Press [OFF] to turn off the air flow of the side.



- 11 Press [OK].

The Tray Setting Screen will be restored.

### 5.1.2 Tray Setting for PI Trays: Post Inserter of Folding Unit FD-503

The following paper can be loaded into the PI trays: Paper loaded into the PI trays cannot be for copy-ing/printing.

- Front covers/back covers/insertions for Insert Sheet
- Perfect bind cover
- Sheets to be punched/folded/folded and stapled/stapled manually
- Cover that is to be put to 2-side slitting

#### bizhub PRESS 1250/1250P/1052 setting

Select PI trays from [Tray Setting] on the Machine Screen, then configure the following setting for each PI tray. The air assist setting is not provided.

Tray Setting is not necessary for paper to be punched/folded/folded and stapled/stapled manually.



#### Normal Use Setting

For the PI tray setting, specify Paper Type and Weight for the normal use setting.

For Standard Detect, the paper size loaded in the PI tray will be automatically detected. If the size is not distinctive, the machine identifies one size from the size groups in [Detect Size Setting] so that it can be distinguished from others.



#### Reference

The normal use setting procedure is the same as the procedure with no **Saddle Stitcher SD-513** installed. See the User's Guide supplied with this machine for details.

#### Tray setting for perfect bind cover

If **Perfect Binder PB-503** is attached, the paper size, paper type, and weight for perfect bind cover for each PI tray can be specified in advance. To configure various settings, use "Perfect Bind Cover Setting". Each setting can be viewed on the Machine Screen.

When **Trimmer Unit TU-503** is equipped in **Saddle Stitcher SD-513**, 2-side slitting can be performed on perfect bind cover.



#### Reference

The tray setting procedure for perfect bind cover is the same as the procedure with no **Saddle Stitcher SD-513** installed. See the User's Guide supplied with this machine for details.

## Tray setting for 2-side slit covers

When **Trimmer Unit TU-503** is equipped in **Saddle Stitcher SD-513**, the paper size of the cover on which to perform 2-side slitting can be set to each PI tray in advance. "Normal Use Setting(For Cover, Insert Sheet, etc.)" applies to Paper Type and Weight.

To specify the cover size for 2-side slitting, use "Cover Size Setting [Slit(Cover Only)]". The 2-side slit cover size can be viewed on the Machine Screen when it has been specified for each PI tray. The paper size for each PI tray specified here is applied when the target PI tray is selected for [Front Cover] of [Post Inserter Paper] that is displayed by selecting [COPY] screen - [Application] - [Insert Sheet].

- 1 Select [PI1], or [PI2] from under "PI Tray" on the Tray Setting Screen.  
The setting for the selected tray will be displayed in the right area of the Tray Setting Screen.
- 2 Press [Change Set] of [Paper Size] under "Cover Size Setting [Slit(Cover Only)]".

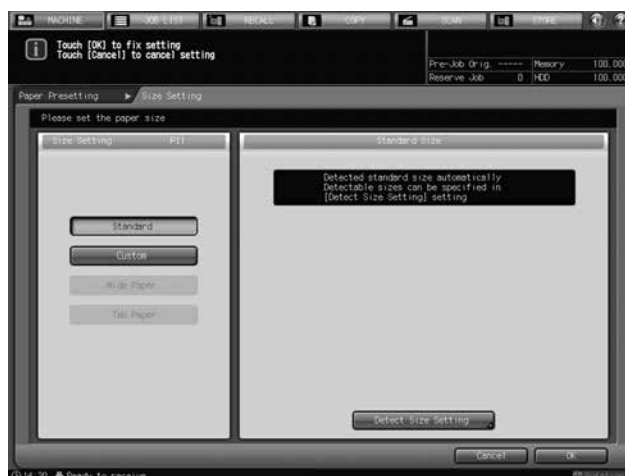


The Size Setting Screen will be displayed.

- 3 Specify the standard or custom size for 2-side slit covers.



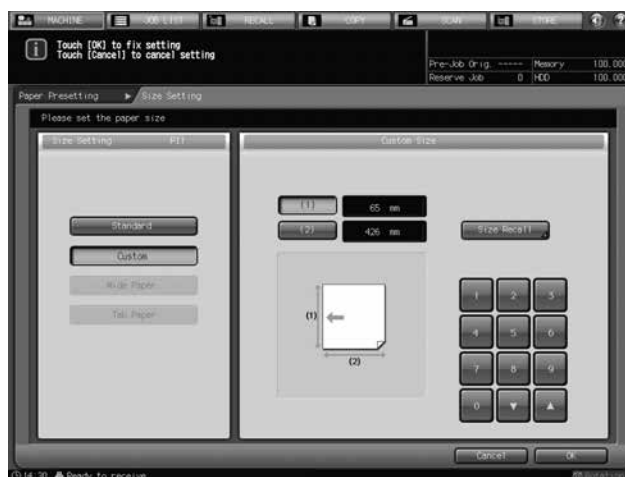
Selecting [Standard] automatically enables detection of the size of paper loaded in the PI tray. If the size is not distinctive, the machine identifies one size from the size groups in [Detect Size Setting] so that it can be distinguished from others.



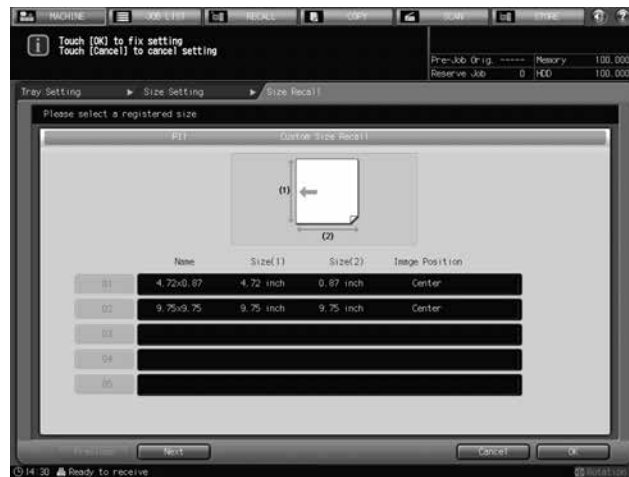
Selecting [Custom] displays the Custom Size Setting Screen.

Press the [(1)] or [(2)] button that displays the vertical or horizontal size value of the paper, then press the keypad, [▼], or [▲] on the screen to enter the desired size.

To recall a custom size previously registered, press [Size Recall].



Press [Next] or [Previous] to locate and select the desired key for a registered custom size, and press [OK].



Press [OK] on the Size Setting Screen.

- 4 Press [Recall] under "Normal Use Setting (For Cover, Insert Sheet, etc.)".  
→ If optionally changing the paper setting, proceed to step 6.



The Recall Screen will be displayed.

## 5 Select paper conditions for 2-side slit covers.

Press [▲] or [▼] to scroll to the desired paper condition on the list to select the number.



Press [OK].

## 6 Press [Change Set] under "Normal Use Setting (For Cover, Insert Sheet, etc.)".



- 7 Specify paper conditions (paper type, weight) for 2-side slit covers as desired.



Press [Paper Type], and select the desired paper type from the right area of the screen.  
 Press [Weight], and select the desired weight from the right area of the screen.  
 Press [OK].

- 8 Press [Register] to register the paper conditions specified here.

Press [▲] or [▼] to scroll to the desired registration number, and press its number key to enter the desired name.



- 9 Press [OK].  
 The Tray Setting Screen will be restored.

## bizhub PRESS C1070/C1070P/C1060/C71hc or bizhub PRESS C1100/C1085 setting

Select PI trays from [Paper Setting] on the Machine Screen, then configure the following setting for each PI tray. The air assist setting is not provided.

Press [Change Set], then specify the paper type, weight, and paper size.

Selecting Standard automatically enables detection of the size of paper loaded in the PI tray. If the size is not distinctive, the machine identifies one size from the size groups in [Detect Size Setting] so that it can be distinguished from others.

Selecting Custom allows you to specify a desired custom size.

Tab paper cannot be set to a tray for cover.



### Reference

The paper setting procedure is the same as the procedure with no **Saddle Stitcher SD-513** installed. See the User's Guide supplied with this machine for details.

## 5.2 [Saddle Stitcher Adjustment] - [Staple Center Adjustment]


### 5.2.1 Center Position of 2 Position Staples

Adjust the center position of 2 position staples determined by **Saddle Stitcher SD-513**.

#### NOTICE

Make this adjustment after [Half-Fold Position Adjustment] (page 5-32) has been completed.










- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Staple Center Position Adjustment Screen of 2 Position Staple.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [01 Staple Center Adjustment], and [01 2 Position Staple] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [01 Staple Center Position], and [01 2 Position Staple] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [01 Staple Center Position], and [01 2 Position Staple] in sequence.
- 3 Press [Print Mode].
- 4 Load 11 × 17 (A3)  paper into a tray, then select that tray key.
- 5 Press **Start** on the **control panel**. A sample pattern will be output.
- 6 Measure the difference between the center position of staples and that of paper.

- 7 Exit the print mode to return to the Staple Center Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 8 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -20 (To move rearward) to +20 (To move frontward) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
- 9 Press [Set] to change the current data.
- 10 Repeat the steps from 3 to 9 until the desired result is obtained.
- 11 Press [Return] to restore the Staple Center Position Adjustment Menu Screen.

### 5.2.2 Center Position of Front 2 Positions of 4 Position Staple

Adjust the center position of the front 2 positions of 4 position staples determined by **Saddle Stitcher SD-513**.

Objects of adjustment: Full Area (Offset for All Size), B4 , 8K , 11 × 17 , A3 , A3W , B4W , 11 × 17W , Custom

#### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).

#### NOTICE

Make this adjustment after [Half-Fold Position Adjustment] (page 5-32) has been completed.










- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.

- 2 Display the Staple Center Position Adjustment Screen of 4 Position Staple (Front 2 positions).
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [01 Staple Center Adjustment], and [02 4 Position Staple (Front 2)] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [01 Staple Center Position], and [02 4 Position Staple (Front 2)] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [01 Staple Center Position], and [02 4 Position Staple (Front 2)] in sequence.
- 3 Select the size to be adjusted.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Measure the distance from the edge to the center of the front 2 positions of 4 Position Staple relative to paper size.
- 8 Exit the print mode to return to the Staple Center Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -100 (To move rearward) to +100 (To move frontward) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
  - Available range of the adjustment may vary depending on paper sizes.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Staple Center Position Adjustment Menu Screen.

### 5.2.3 Center Position of Rear 2 Positions of 4 Position Staple

Adjust the center position of the rear 2 positions of 4 position staples determined by **Saddle Stitcher SD-513**.

Objects of adjustment: Full Area (Offset for All Size), B4 , 8K , 11 × 17 , A3 , A3W , B4W , 11 × 17W , Custom

#### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).

#### NOTICE

Make this adjustment after [Half-Fold Position Adjustment] (page 5-32) has been completed.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Staple Center Position Adjustment Screen of 4 Position Staple (Rear 2 positions).
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [01 Staple Center Adjustment], and [03 4 Position Staple (Rear 2)] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [01 Staple Center Position], and [03 4 Position Staple (Rear 2)] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [01 Staple Center Position], and [03 4 Position Staple (Rear 2)] in sequence.
- 3 Select the size to be adjusted.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.

- 7 Measure the distance from the edge to the center of the rear 2 positions of 4 Position Staple relative to paper size.
- 8 Exit the print mode to return to the Staple Center Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -100 (To move rearward) to +100 (To move frontward) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Staple Center Position Adjustment Menu Screen.

## 5.3 [Saddle Stitcher Adjustment] - [Staple Paper Width Adj.]

Adjust the width of adjustment plates of **Saddle Stitcher SD-513** to be used in Staple mode.

Objects of adjustment: Full Area (Offset for All Size), 11 × 17 □, A3 □, B4 □, 8.5 × 14 □, A4 □, 8.5 × 11 □, B5 □, 8 × 13 □, 8.125 × 13.25 □, 8.5 × 13 □, 8.25 × 13 □, 8K □, 16K □, 12 × 18 □, A3W □, B4W □, A4W □, B5W □, 12 × 18W □, 11 × 17W □, 8.5 × 11W □, Custom, SRA3 □, SRA4 □

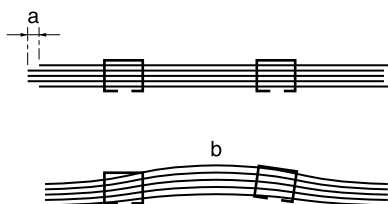
### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Staple Paper Width Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [02 Staple Paper Width Adj.] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [02 Staple Paper Width Adj.] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [02 Staple Paper Width Adj.] in sequence.
- 3 Select the size to be adjusted using [▲] or [▼] to scroll.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Check if the stapled set shows misalignment (a) (caused if specified paper width is larger than the actual width), or is curved (b) (caused if specified paper width is smaller than the actual width).

Allowance: a = 1 mm or less


























- 8 Exit the print mode to return to the Staple Paper Width Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -20 (narrow) to +20 (wide) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.4 [Saddle Stitcher Adjustment] - [Staple Pitch Adjustment]

### 5.4.1 Staple Pitch of 2 Position Staple

Adjust the staple pitch of 2 position staples determined by **Saddle Stitcher SD-513**.

Objects of adjustment: Full Area (Offset for All Size), 11 × 17 , A3 , B4 , 8.5 × 14 , A4 , 8.5 × 11 , B5 , 8 × 13 , 8.125 × 13.25 , 8.5 × 13 , 8.25 × 13 , 8K , 16K , 12 × 18 , A3W , B4W , A4W , B5W , 12 × 18W , 11 × 17W , 8.5 × 11W , Custom, SRA3 , SRA4 

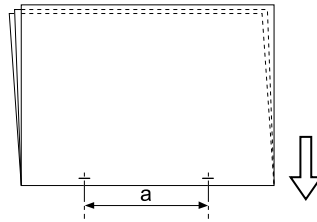
#### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Staple Pitch Adjustment Screen of 2 Position Staple.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [03 Staple Pitch Adjustment], and [01 2 Position Staple] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [03 Staple Pitch Adjustment], and [01 2 Position Staple] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [03 Staple Pitch Adjustment], and [01 2 Position Staple] in sequence.
- 3 Select the size to be adjusted using [▲] or [▼] to scroll.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.








- 7 Check the staple pitch (a) of the sample.



- 8 Exit the print mode to return to the Staple Pitch Adjustment Screen.
- In bizhub PRESS 1250/1250P/1052, press [Close].
  - In bizhub PRESS C1070/C1070P/C1060/C71hc or bizhub PRESS C1100/C1085, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
- Adjustable range: -20 (narrow) to +20 (wide) (1 step = 1.0 mm)
  - Use [+<->-] to specify the value to be positive or negative.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Staple Pitch Adjustment Menu Screen.

## 5.4.2 Staple Pitch of Front 2 Positions of 4 Position Staple

Adjust the staple pitch of the front 2 positions of 4 position staples determined by **Saddle Stitcher SD-513**.

Objects of adjustment: Full Area (Offset for All Size), B4 , 8K , 11 × 17 , A3 , A3W , B4W , 11 × 17W , Custom

### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).












- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Staple Pitch Adjustment Screen of 4 Position Staple (Front 2 positions).
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [03 Staple Pitch Adjustment], and [02 4 Position Staple (Front 2)] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [03 Staple Pitch Adjustment], and [02 4 Position Staple (Front 2)] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [03 Staple Pitch Adjustment], and [02 4 Position Staple (Front 2)] in sequence.
- 3 Select the size to be adjusted.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Measure the pitch of the front 2 positions of 4 Position Staple relative to paper size.
- 8 Exit the print mode to return to the Staple Pitch Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -10 (To shorten) to 10 (To lengthen) (1 step = 1.0 mm)
  - Use [+<->-] to specify the value to be positive or negative.
  - Available range of the adjustment may vary depending on paper sizes.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Staple Pitch Adjustment Menu Screen.

### 5.4.3 Staple Pitch of Rear 2 Positions of 4 Position Staple

Adjust the staple pitch of the rear 2 positions of 4 position staples determined by **Saddle Stitcher SD-513**.

Objects of adjustment: Full Area (Offset for All Size), B4 , 8K , 11 × 17 , A3 , A3W , B4W , 11 × 17W , Custom

#### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).





- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Staple Pitch Adjustment Screen of 4 Position Staple (Rear 2 positions).
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [03 Staple Pitch Adjustment], and [03 4 Position Staple (Rear 2)] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [03 Staple Pitch Adjustment], and [03 4 Position Staple (Rear 2)] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [03 Staple Pitch Adjustment], and [03 4 Position Staple (Rear 2)] in sequence.
- 3 Select the size to be adjusted.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Measure the pitch of the rear 2 positions of 4 Position Staple relative to paper size.

- 8 Exit the print mode to return to the Staple Pitch Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -10 (To shorten) to 10 (To lengthen) (1 step = 1.0 mm)
  - Use [+<->-] to specify the value to be positive or negative.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Staple Pitch Adjustment Menu Screen.

## 5.5 [Saddle Stitcher Adjustment] - [Tri-Fold Position Adj.]

Adjust the tri-fold positions determined by **Saddle Stitcher SD-513**.

Objects of adjustment: Full Area (Offset for All Size), A4 , 8.5 × 11 

### NOTICE

When adjusting both 1st Fold and 2nd Fold, be sure to start with the 1st Fold adjustment. The positions of both 1st Fold and 2nd Fold are calculated from the edge of the sheet. Consequently, the measurement (b) in step 7 is subject to the change in either position of the fold.

### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).

Maximum adjustment value for A4  in 1st Fold is +90.



Maximum adjustment value for 8.5 × 11  in 1st Fold is +30.

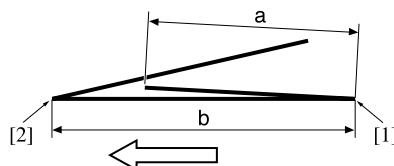


- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Tri-Fold Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [04 Tri-Fold Position Adj.] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [04 Tri-Fold Position Adj.] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [04 Tri-Fold Position Adj.] in sequence.
- 3 Select the size to be adjusted.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.

**7** Measure the lengths (a) and (b) of the output sheet.

For standard values, see the table below.

Paper size	a	b
A4 	$97.5 \pm 1.5$ mm	$102.0 \pm 3.0$ mm
8.5 × 11 	$91.6 \pm 1.5$ mm	$96.1 \pm 3.0$ mm



[1] 1st Fold    [2] 2nd Fold


**8** Exit the print mode to return to the Tri-Fold Position Adjustment Screen.

- In **bizhub PRESS 1250/1250P/1052**, press [Close].
- In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].

**9** Select [1st Fold].

- In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select [Fold 1].

**10** If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.

- Adjustable range 1st Fold: (To lengthen) -100 to +90 (+30 for 8.5 × 11 ) (To shorten) (1 step = 0.1 mm), 2nd Fold: (To lengthen) -50 to +50 (To shorten) (1 step = 0.1 mm)
- Use [+<->-] to specify the value to be positive or negative.
























**11** Press [Set] to change the current data.**12** Select [2nd Fold].

- In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select [Fold 2].

**13** Repeat step 10.**14** Press [Set] to change the current data.**15** Repeat the steps from 4 to 14 until the desired result is obtained.**16** Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.6 [Saddle Stitcher Adjustment] - [Fold Skew Adjustment]

Adjust the position of the alignment plates of **Saddle Stitcher SD-513**. Values can be set for single fold and multi fold, respectively.

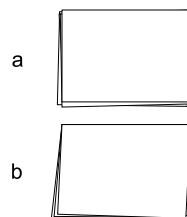
Objects of adjustment: Full Area (Offset for All Size), 11 × 17 , A3 , B4 , 8.5 × 14 , A4 , 8.5 × 11 , B5 , 8 × 13 , 8.125 × 13.25 , 8.5 × 13 , 8.25 × 13 , 8K , 16K , 12 × 18 , A3W , B4W , A4W , B5W , 12 × 18W , 11 × 17W , 8.5 × 11W , Custom, SRA3 , SRA4 , PI paper

### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Fold Skew Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [05 Fold Skew Adjustment] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [05 Fold Skew Adjustment] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [05 Fold Skew Adjustment] in sequence.
- 3 Select [Single Fold] or [Multi Fold], then select the size to be adjusted.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Check that any misalignment is found in the output set.
  - a: Folding becomes at random if insertion is too shallow.
  - b: Folding becomes misaligned to one side if insertion is too deep.



- 8 Exit the print mode to return to the Fold Skew Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -50 (To weaken) to +50 (To strengthen) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.7 [Saddle Stitcher Adjustment] - [Half-Fold Position Adjustment]

Adjust the half-folded position determined by **Saddle Stitcher SD-513**.

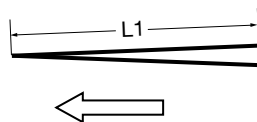
Objects of adjustment: Full Area (Offset for All Size), 11 × 17 □, A3 □, B4 □, 8.5 × 14 □, A4 □, 8.5 × 11 □, B5 □, 8 × 13 □, 8.125 × 13.25 □, 8.5 × 13 □, 8.25 × 13 □, 8K □, 16K □, 12 × 18 □, A3W □, B4W □, A4W □, B5W □, 12 × 18W □, 11 × 17W □, 8.5 × 11W □, Custom, SRA3 □, SRA4 □

### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Half-Fold Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [06 Half-Fold Position Adjustment] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [06 Half-Fold Position Adj.] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [06 Half-Fold Position Adj.] in sequence.
- 3 Select the size to be adjusted using [▲] or [▼] to scroll.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Measure the misalignment between the edges of output sheet.























L: the length of paper, L/2: half the length of paper  
 $L1 = L/2 \pm 1.5 \text{ mm}$   
 L1 is the actual measurement of paper when folded by the machine.

- 8 Exit the print mode to return to the Half-Fold Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -50 (shorter) to +50 (longer) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
  - The measurement L1 in step 7 will increase with positive value entered, and decrease with negative value entered.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.8 [Saddle Stitcher Adjustment] - [Fold Paper Width Adjustment]

Adjust the width of adjustment plates of **Saddle Stitcher SD-513** if half-folded or tri-folded sheets show misalignment.

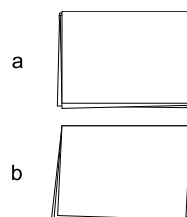
Objects of adjustment: Full Area (Offset for All Size), 11 × 17 , A3 , B4 , 8.5 × 14 , A4 , 8.5 × 11 , B5 , 8 × 13 , 8.125 × 13.25 , 8.5 × 13 , 8.25 × 13 , 8K , 16K , 12 × 18 , A3W , B4W , A4W , B5W , 12 × 18W , 11 × 17W , 8.5 × 11W , Custom, SRA3 , SRA4 , PI paper

### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).

















- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Fold Paper Width Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [07 Fold Paper Width Adjustment] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [07 Fold Paper Width Adj.] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [07 Fold Paper Width Adj.] in sequence.
- 3 Select the size to be adjusted using [▲] or [▼] to scroll.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Check that any misalignment is found in the output set.
  - a: Misalignment occurs at random if specified paper width is wider than the actual width.
  - b: Misalignment occurs in one direction if specified paper width is narrower than the actual width.



- 8 Exit the print mode to return to the Fold Paper Width Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -50 (narrow) to +50 (wide) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
  - If the setting data is too wide, misalignment may become worse.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.9 [Saddle Stitcher Adjustment] - [Fore-edge Trimming Adjustment]

Adjust the fore-edge trimming width determined by **Saddle Stitcher SD-513**. The trimming width should be 5 mm or more, otherwise the trimming operation may not performed properly.

Objects of adjustment: Full Area (Offset for All Size), 11 × 17 , A3 , B4 , 8.5 × 14 , A4 , 8.5 × 11 , B5 , 8 × 13 , 8.125 × 13.25 , 8.5 × 13 , 8.25 × 13 , 8K , 16K , 12 × 18 , A3W , B4W , A4W , B5W , 12 × 18W , 11 × 17W , 8.5 × 11W , Custom, SRA3 , SRA4 

### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, the trimming width will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Trimming Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [08 Fore-edge Trimming Adjustment] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [08 Fore-edge Trimming Adj.] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [08 Fore-edge Trimming Adj.] in sequence.
- 3 Select the size to be adjusted using [▲] or [▼] to scroll.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Check the trimming width (a) of the output sheets.  
Allowance: a = 5 mm or more



- 8 Exit the print mode to return to the Fore-edge Trimming Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].

- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -400 (small) to 400 (large) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
  - Enter the value so that the cover should be cut by 5.0 mm or more. If the trimming width is less than 5.0 mm, the trimming operation may not performed properly. Therefore, even if the trimming width is specified as 5.0 mm or less, actual trimming width is automatically adjusted so that it does not fall below 5.0 mm.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.10 [Saddle Stitcher Adjustment] - [Parallel Trimming Adjustment]


Adjust the parallelism between the trim line and the fore edge determined by **Saddle Stitcher SD-513**.

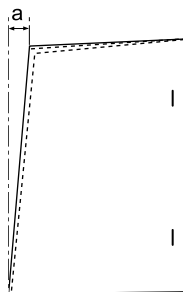
Objects of adjustment: Front, Rear

### NOTICE

The following adjustments can be made only when **Folding Unit FD-504** is mounted on **Saddle Stitcher SD-513**.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Parallel Trimming Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [09 Parallel Trimming Adjustment] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [09 Parallel Trimming Adjustment] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [09 Parallel Trimming Adjustment] in sequence.
- 3 Select [Front] or [Rear], then press [Print Mode].
- 4 Load 11 × 17 (A3)  paper into a tray, then select that tray key.
- 5 Press **Start** on the **control panel**. A sample pattern will be output.
- 6 Check the parallelism (a) of the trimmed edge.  
Allowance: a = 4.0 mm or less (with 50 half-folded sheets)



- 7 Exit the print mode to return to the Parallel Trimming Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].

- 8 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.  
→ Adjustable range: 0 (To narrow) to 30 (To widen) (1 step = 0.1 mm)
- 9 Press [Set] to change the current data.
- 10 Repeat the steps from 3 to 9 until the desired result is obtained.
- 11 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

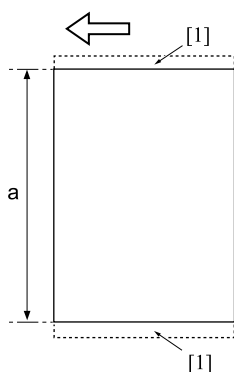
## 5.11 [Saddle Stitcher Adjustment] - [2-Side Slitting Adjustment]

Adjust the 2-side slitting width determined by **Trimmer Unit TU-503** mounted on **Saddle Stitcher SD-513**.

Objects of adjustment: Front, Rear



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the 2-Side Slitting Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [10 2-Side Slitting Adjustment] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [10 2-Side Slitting Adjustment] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [10 2-Side Slitting Adjustment] in sequence.
- 3 Select [Front] or [Rear], then press [Print Mode].
- 4 Load 11 × 17 (A3) paper into a tray, then select that tray key.
- 5 Press **Start** on the **control panel**. A sample pattern will be output.
- 6 Measure the length (a) of the output sheet and check the misalignment against the set value.  
Allowance: set value - a = within  $\pm 0.5$  mm



[1] Slit side

- 7 Exit the print mode to return to the 2-Side Slitting Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].

- 8 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -10 (To narrow) to +10 (To widen) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
- 9 Press [Set] to change the current data.
- 10 Repeat the steps from 3 to 9 until the desired result is obtained.
- 11 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.12 [Saddle Stitcher Adjustment] - [Crease Position Adjustment]

### 5.12.1 Half-Fold Crease Position

The half-fold crease position determined by **Creaser Unit CR-101** mounted on **Saddle Stitcher SD-513** can be moved. Adjust the distance between the cover edge of the output top face and the crease.

Objects of adjustment: Full Area (Offset for All Size), 11 × 17 □, A3 □, B4 □, 8.5 × 14 □, A4 □, 8.5 × 11 □, B5 □, 8 × 13 □, 8.125 × 13.25 □, 8.5 × 13 □, 8.25 × 13 □, 8K □, 16K □, 12 × 18 □, A3W □, B4W □, A4W □, B5W □, 12 × 18W □, 11 × 17W □, 8.5 × 11W □, Custom, SRA3 □, SRA4 □

#### NOTICE

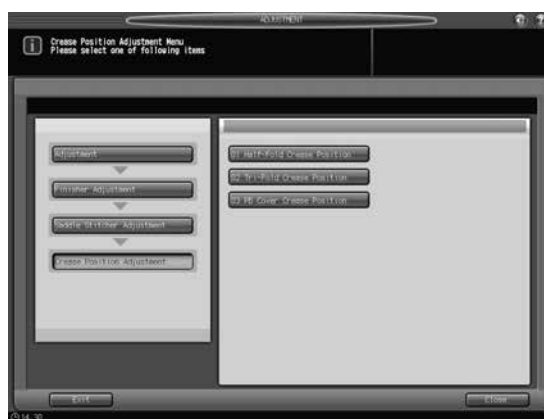
With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).

#### NOTICE

Make this adjustment after [Half-Fold Position Adjustment] (page 5-32) has been completed.

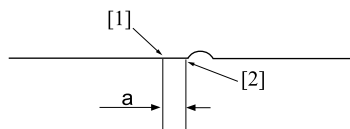
#### NOTICE

Depending on the paper weight, when the crease position is adjusted, it may no longer align with the fold position. In such a case, make this adjustment again so that the crease position aligns with the fold position.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Half-Fold Crease Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [11 Crease Position Adjustment], and [01 Half-Fold Crease Position] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [11 Crease Position Adjustment], and [01 Half-Fold Crease Position] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [11 Crease Position Adjustment], and [01 Half-Fold Crease Position] in sequence.

- 3 Select the size to be adjusted using [▲] or [▼] to scroll.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Check the misalignment (a) between the fold and crease of the output sheet.  
Allowance: a = within  $\pm 1$  mm



[1] Fold [2] Edge of crease

- 8 Exit the print mode to return to the Half-Fold Crease Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -20 (To shorten) to +20 (To lengthen) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
  - Adjust the distance between the cover edge of the output top face and the crease.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Crease Position Adjustment Menu Screen.

### 5.12.2 Tri-Fold Crease Position

The tri-fold crease position determined by **Creaser Unit CR-101** mounted on **Saddle Stitcher SD-513** can be moved. The position of 1st Fold Crease is calculated from the edge of the sheet, while that of 2nd Fold Crease is calculated from the position of 1st Fold Crease. Adjust the distance between each reference position and the crease position.

Objects of adjustment: Full Area (Offset for All Size), A4 , 8.5 × 11 

#### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).

#### NOTICE

Make this adjustment after [Tri-Fold Position Adj.] (page 5-28) has been completed.

#### NOTICE

Depending on the paper weight, when the crease position is adjusted, it may no longer align with the fold position. In such a case, make this adjustment again so that the crease position aligns with the fold position.

#### NOTICE

Depending on the crease position, the tri-fold position is drawn to the crease position, and the fold position may be changed.

In this case, carry out [Tri-Fold Position Adj.] (page 5-28) to determine the tri-fold position, then follow the steps below to adjust the crease position.

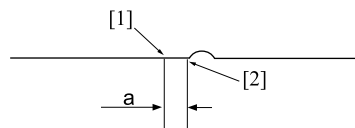
1. Move the crease position away from the tri-fold position. Move the crease position in the minus (-) or plus (+) direction so that each current position is displaced at a maximum before outputting sheets.
2. Check the output sheets, then measure the distance between the output crease position and the desired crease position.
3. Enter the distance measured above into the Setting Data field of Crease Position Adjustment.

See the steps below for details on the setting procedure.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.

- 2 Display the Tri-Fold Crease Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [11 Crease Position Adjustment], and [02 Tri-Fold Crease Position] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [11 Crease Position Adjustment], and [02 Tri-Fold Crease Position] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [11 Crease Position Adjustment], and [02 Tri-Fold Crease Position] in sequence.
- 3 Select the size to be adjusted.
- 4 Press [Print Mode].
- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Check the misalignment (a) between the fold and crease of the output sheet.  
Allowance: a = within  $\pm 1$  mm



[1] Fold [2] Edge of crease

- 8 Exit the print mode to return to the Tri-Fold Crease Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, select [1st Fold] or [2nd Fold] and use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -20 (To shorten) to +20 (To lengthen) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
  - Adjust the distance between the inside edge and the 1st or 2nd fold crease.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Crease Position Adjustment Menu Screen.

### 5.12.3 Perfect Bind Cover Crease Position

The perfect bind crease position determined by **Creaser Unit CR-101** mounted on **Saddle Stitcher SD-513** can be moved. Perfect bind cover crease is controlled so that the reference position is aligned with the perfect bind spine width. Specifically, the position of 1st Fold crease is calculated from the edge of the sheet, while that of 2nd Fold crease is calculated from the position of 1st Fold crease (the position of 2nd Fold crease is determined as the spine width from the position of 1st Fold crease). This adjustment controls the distance between each reference position and the crease position.

Objects of adjustment: Full Area (Offset for All Size), 11 × 17 □, A3 □, B4 □, 8.5 × 14 □, A4 □, 8.5 × 11 □, B5 □, 8 × 13 □, 8.125 × 13.25 □, 8.5 × 13 □, 8.25 × 13 □, 8K □, 16K □, 12 × 18 □, A3W □, B4W □, A4W □, B5W □, 12 × 18W □, 11 × 17W □, 8.5 × 11W □, Custom, SRA3 □, SRA4 □

#### NOTICE

With [Full Area] ([Offset for All Size]) selected, the entered value will be applied to all sizes. With a specific paper size selected, set value will be the sum of the entered value and the value previously specified for [Full Area] ([Offset for All Size]).



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the PB Cover Crease Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [11 Crease Position Adjustment], and [03 PB Cover Crease Position] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [11 Crease Position Adjustment], and [03 PB Cover Crease Position] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], [11 Crease Position Adjustment], and [03 PB Cover Crease Position] in sequence.
- 3 Select the size to be adjusted using [▲] or [▼] to scroll.
- 4 Press [Print Mode].

- 5 Load the paper size selected in step 3 into the tray, then select that tray key.
- 6 Press **Start** on the **control panel**. A sample pattern will be output.
- 7 Check the misalignment between the fold and crease of the output sheet.
- 8 Exit the print mode to return to the PB Cover Crease Position Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 9 If adjustment is required, select [Crease Line 1] or [Crease Line 2] and use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -20 (To shorten) to +20 (To lengthen) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
  - Adjust the distance between the paper edge in the top side of the perfect bind cover and the crease position.
- 10 Press [Set] to change the current data.
- 11 Repeat the steps from 4 to 10 until the desired result is obtained.
- 12 Press [Return] to restore the Crease Position Adjustment Menu Screen.

## 5.13 [Saddle Stitcher Adjustment] - [Flattening a Fold (Strength)]

Adjust the force to form the spine of saddle-stitched booklets with **Folding Unit FD-504** mounted on **Saddle Stitcher SD-513**.

### NOTICE

This allows you to adjust the reference value of the spine corner forming strength by selecting [COPY] - [Output Setting] - [Fold&Staple] - [Spine Corner Forming].

For example, if the strength is set to the strong direction in this adjustment, the reference value of the spine corner forming strength to be specified on the [COPY] screen above shifts in generally the strong direction. When the strength specified on the [COPY] screen is insufficient, it can be further increased in this adjustment. However, note that the reference value shifts in whole.

If the strength is set to the weak direction in this adjustment, the reference value of the spine corner forming strength to be specified on the [COPY] screen above shifts in whole to the weak direction.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Flattening a Fold (Strength) Adj. Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [12 Flattening a Fold (Strength)] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [12 Flattening a Fold (Strength)] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [12 Flattening a Fold (Strength)] in sequence.
- 3 Press [Print Mode].
- 4 Load 11 × 17 (A3) paper into a tray, then select that tray key.
- 5 Press **Start** on the **control panel**. A sample pattern will be output.
- 6 Check the spine of the output booklet.
- 7 Exit the print mode to return to the Flattening a Fold (Strength) Adj. Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 8 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -20 (To decrease the force) to +20 (To increase the force) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
- 9 Press [Set] to change the current data.
- 10 Repeat the steps from 3 to 9 until the desired result is obtained.
- 11 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.14 [Saddle Stitcher Adjustment] - [Flattening a Fold (Frequency)]

Adjust the number of back-and-forth motion of the roller when forming the spine of saddle-stitched booklets by **Folding Unit FD-504** mounted on **Saddle Stitcher SD-513**.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Flattening a Fold (Frequency) Adj. Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [13 Flattening a Fold (Frequency)] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [13 Flattening a Fold (Freq.)] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [13 Flattening a Fold (Freq.)] in sequence.
- 3 Press [Print Mode].
- 4 Load 11 × 17 (A3) paper into a tray, then select that tray key.
- 5 Press **Start** on the **control panel**. A sample pattern will be output.
- 6 Check the spine of the output booklet.
- 7 Exit the print mode to return to the Flattening a Fold (Frequency) Adj. Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 8 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range: -5 (To decrease) to +5 (To increase) (1 step = 1)
  - Use [+<->-] to specify the value to be positive or negative.
- 9 Press [Set] to change the current data.
- 10 Repeat the steps from 3 to 9 until the desired result is obtained.
- 11 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

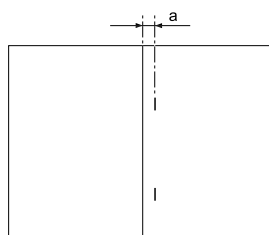
## 5.15 [Saddle Stitcher Adjustment] - [Staple Offset Adjustment]

Adjust staple position in **Saddle Stitcher SD-513**. The misalignment between the staples and the fold can be reduced.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Staple Offset Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [14 Staple Offset Adjustment] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [14 Staple Offset Adjustment] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [14 Staple Offset Adjustment] in sequence.

- 3 Press [Print Mode].
- 4 Load 11 × 17 (A3) paper into a tray, then select that tray key.
- 5 Press **Start** on the **control panel**. A sample pattern will be output.
- 6 Measure the difference (a) between the fold position and staples.  
Allowance:  $a = \pm 1 \text{ mm}$



- 7 Exit the print mode to return to the Staple Offset Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 8 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustable range:-10 (To move leftward) to +10 (To move rightward) (1 step = 0.1 mm)
  - Use [+<->-] to specify the value to be positive or negative.
- 9 Press [Set] to change the current data.
- 10 Repeat the steps from 3 to 9 until the desired result is obtained.
- 11 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.16 [Saddle Stitcher Adjustment] - [Staple Tip Adjustment]

Adjust the staple strength of **Saddle Stitcher SD-513** to change the staple foot shape.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Staple Foot Shape Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [15 Staple Tip Adjustment] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [15 Staple Tip Adjustment] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [15 Staple Tip Adjustment] in sequence.
- 3 Press [Print Mode].
- 4 Load 11 × 17 (A3) paper into a tray, then select that tray key.
- 5 Press **Start** on the **control panel**. A sample pattern will be output.
- 6 Check the staple shape.
- 7 Exit the print mode to return to the Staple Tip Adjustment Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 8 If adjustment is required, use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustment range: (To be round) -9 to +9 (To be flat) (1 step = 1 msec.)
  - Use [+<->-] to specify the value to be positive or negative.
- 9 Press [Set] to change the current data.
- 10 Repeat the steps from 3 to 9 until the desired result is obtained.
- 11 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

## 5.17 [Saddle Stitcher Adjustment] - [2-Side Slitting Finishing Adj.]

Adjust the 2-side slitting speed of **Trimmer Unit TU-503** mounted on **Saddle Stitcher SD-513** to reduce rough cut and curve of the slit parts.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the 2-Side Slitting Finishing Adj. Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], and [16 2-Side Slitting Finishing Adj.] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [16 2-Side Slit Finishing Adj.] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [16 2-Side Slit Finishing Adj.] in sequence.
- 3 Press [Print Mode].
- 4 Load 11 × 17 (A3) paper into a tray, then select that tray key.
- 5 Press **Start** on the **control panel**. A sample pattern will be output.
- 6 Check rough cut and curve of the slit parts.
- 7 Exit the print mode to return to the 2-Side Slitting Finishing Adj. Screen.
  - In **bizhub PRESS 1250/1250P/1052**, press [Close].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Exit PrintMode].
- 8 If adjustment is required, select the paper weight, then use the touch panel keypad or **control panel keypad** to enter the setting data.
  - Adjustment range: (Slower / Reduce fuzz) -4 to +4 (Faster / Reduce curve)  
(1 step = 5 mm/sec.)
  - Use [+ <-> -] to specify the value to be positive or negative.
- 9 Press [Set] to change the current data.
- 10 Repeat the steps from 3 to 9 until the desired result is obtained.
- 11 Press [Return] to restore the Saddle Stitcher Adjustment Menu Screen.

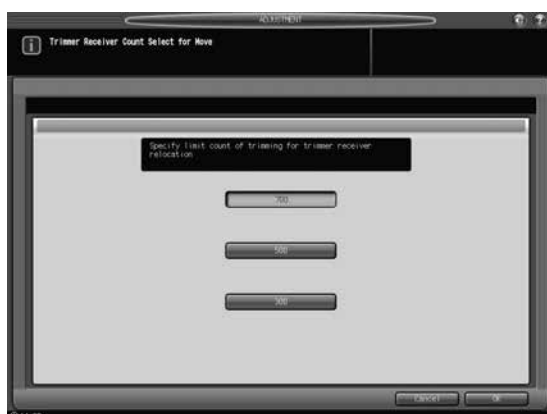
## 5.18 [Saddle Stitcher Adjustment] - [Trimmer Receiver Adjustment]

### 5.18.1 Count Select for Move

Frequent trimming operations may cause damage to the receiver, resulting in trimming failures. Specify the limit count of trimming for **Saddle Stitcher SD-513** trimmer receiver relocation.

#### NOTICE

The [Trimmer Receiver Adjustment] key is displayed only in the customer engineer setting mode. Contact your service representative, if desired.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Count Select for Move Screen for trimmer receiver.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [17 Trimmer Receiver Adjustment], and [01 Count Select for Move] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [17 Trimmer Receiver Adj.] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [17 Trimmer Receiver Adj.] in sequence.
- 3 Select [700], [500], or [300].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select the appropriate item in [Trim Count].
- 4 Press [OK] to restore the Trimmer Receiver Adjustment Menu Screen.

### 5.18.2 Moving Pitch Select

Specify the distance for the trimmer receiver of **Saddle Stitcher SD-513** to move.

#### NOTICE

The [Trimmer Receiver Adjustment] key is displayed only in the customer engineer setting mode. Contact your service representative, if desired.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Moving Pitch Select Screen for trimmer receiver.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [17 Trimmer Receiver Adjustment], and [02 Moving Pitch Select] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [17 Trimmer Receiver Adj.] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [17 Trimmer Receiver Adj.] in sequence.
- 3 Select [1.0], [1.5], or [2.0] (Unit: mm).
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, select the appropriate item in [Move Pitch].
- 4 Press [OK] to restore the Trimmer Receiver Adjustment Menu Screen.

### 5.18.3 Forcibly Move

The trimmer receiver of **Saddle Stitcher SD-513** is forcibly moved 1 pitch.

#### NOTICE

The [Trimmer Receiver Adjustment] key is displayed only in the customer engineer setting mode. Contact your service representative, if desired.



- 1 Press [Adjustment] on the Machine Screen to display the Adjustment Menu Screen.
- 2 Display the Forcibly Move Screen for trimmer receiver.
  - In **bizhub PRESS 1250/1250P/1052**, press [02 Finisher Adjustment], [08 Saddle Stitcher Adjustment], [17 Trimmer Receiver Adjustment], and [03 Forcibly Move] in sequence.
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc**, press [04 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [17 Trimmer Receiver Adj.] in sequence.
  - In **bizhub PRESS C1100/C1085**, press [03 Finisher Adjustment], [04 Saddle Stitcher Adjustment], and [17 Trimmer Receiver Adj.] in sequence.
- 3 Press [Start].
  - In **bizhub PRESS C1070/C1070P/C1060/C71hc** or **bizhub PRESS C1100/C1085**, press [Execute Compulsive Movement].
- 4 Press [Return] to restore the Trimmer Receiver Adjustment Menu Screen.





## Troubleshooting

## 6 Troubleshooting

### 6.1 If [Mishandled paper] Message Is Displayed

When a paper misfeed occurs in an output job, the machine displays the message [Mishandled paper] and misfeed area(s) on the screen.

The **Start LED** turns orange on the **control panel**, and machine operation cannot be continued until all the locations are cleared.

#### 6.1.1 Precautions for Removing Mishandled Paper from Saddle Stitcher SD-513

---

##### CAUTION

Removing Stuck Staples  
Staples are very sharp!

- Be careful of removing staples stuck inside the machine so as not to get injured.
-

## 6.2 Troubleshooting Tips

Case	Checkpoint	Remedy
Using fore-edge trimming function, printed sheets cannot be trimmed.	Does the SD Trim Scrap Box Full indicator light on the Machine Screen?	Empty the trim scrap box of <b>Saddle Stitcher SD-513</b> .
Using 2-side slitting function, printed sheets cannot be trimmed.	Does the SD Slit Scrap Box Full indicator light on the Machine Screen?	Empty the slit scrap box of <b>Saddle Stitcher SD-513</b> .

If remedies mentioned above do not work, contact your service representative.



---

# **7**

## **Cleaning**

## 7 Cleaning

### 7.1 Cleaning the conveyance belt of the bundle exit tray

The **conveyance belt** of **bundle exit tray** should be kept clean, otherwise soil marks may be printed. Follow the procedure below to clean the **conveyance belt** of **bundle exit tray**.

In order to maintain optimum print quality, we recommend to clean it every time before using the tray.

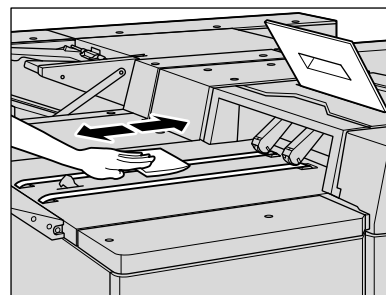
If any soil marks are found on the **conveyance belt** while printing, perform this cleaning procedure immediately.

#### 1 Open the **clamp section upper door**.

- The **clamp section upper door** cannot be opened while the saddle stitcher is in the initializing state. Open the clamp section upper door when the saddle stitcher exits the initializing state.

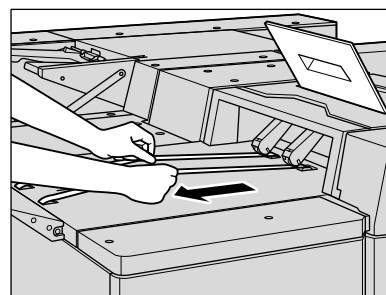


#### 2 Clean the surface of the **two conveyance belts** with a soft cloth dampened slightly with alcohol (cleaner).



#### 3 Move the **conveyance belt** to clean the whole length of the **conveyance belt**.

- Raise the **two conveyance belts** lightly, then pull them both leftward at the same time in order to show the hidden parts.
- Clean the **conveyance belt** using a soft cloth dampened with alcohol (cleaner).
- Repeat steps 2 and 3 (about three times) to clean the whole round of the belts.



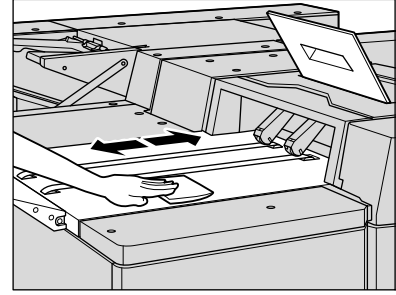
#### **NOTICE**

*Do not pull the **conveyance belt** while the saddle stitcher is in the idle state. Pulling the belts with force may cause unexpected machine trouble. When pulling the conveyance belt, be sure to check that the saddle stitcher exits the idle state, then open the **clamp section upper door**.*

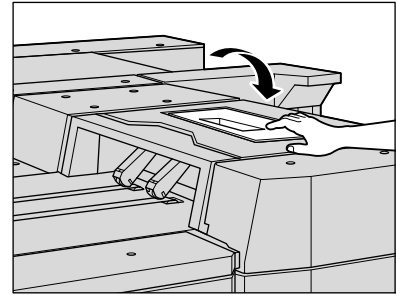
#### **NOTICE**

*Do not raise the **conveyance belt** higher than necessary. Or, never fail to pull the two belts at the same time. Otherwise, machine trouble may be caused.*

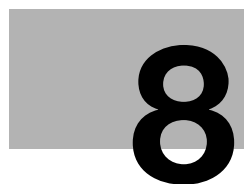
- 4 Clean the bottom plate of the **bundle exit tray**.
- Wipe the whole surface of the bottom plate with a soft cloth slightly dampened with alcohol (cleaner).



- 5 Close the **clamp section upper door**.






















## Appendix

































## 8 Appendix

### 8.1 Typical Specifications



























In order to incorporate improvements, the product specifications are subject to change without notice.

#### 8.1.1 Saddle Stitcher SD-513



































Name		SD-513
Type		Saddle stitch book binding machine
Output methods	Output to secondary (sub) tray	Outputs sheets to the <b>secondary (sub) tray</b> without processing (performs 2-side slitting or creasing when <b>Trimmer Unit TU-503</b> or <b>Creaser Unit CR-101</b> is installed on this machine).
	Straight output	Outputs sheets to the finishing device without processing (performs 2-side slitting or creasing when <b>Trimmer Unit TU-503</b> or <b>Creaser Unit CR-101</b> is installed on this machine).
	Fold & Staple	Performs fold & staple, and outputs sheets to the <b>bundle exit tray</b> .
	Fold & Staple + Trimming	Performs fold & staple and fore edge trimming, and outputs sheets to the <b>bundle exit tray</b> .
	Multi Half-Fold	Folds a single or multiple sheets in half, and outputs them to the <b>bundle exit tray</b> .
	Multi Tri-Fold	Folds a single or multiple sheets in three, and outputs them to the <b>tri-fold tray</b> .
	Crease	With <b>Creaser Unit CR-101</b> installed, you can perform fold & staple, half-fold, and tri-fold for creased paper. Sheets are output to the <b>secondary (sub) tray</b> . See page 8-4 for details on the specifications.
	2-Side Slitting	With <b>Trimmer Unit TU-503</b> installed, you can perform fold & staple, half-fold, and tri-fold for 2-side slit paper. Sheets are output to the <b>secondary (sub) tray</b> . See page 8-5 for details on the specifications.
	Spine Corner Forming	With <b>Folding Unit FD-504</b> installed, you can flatten the spine of the folded & stapled booklet. See page 8-6 for details on the specifications.
Fold	Fold type	Multi Half-Fold, Multi Tri-Fold (Multi Fold is released when crease or 2-side slitting is combined.)
	Paper size	<ul style="list-style-type: none"> <li>Multi Half-Fold Standard: A3 , B4 , A4 , B5 , Foolscap, SRA3 , SRA4 , 12 × 18 , 11 × 17 , 8.5 × 14 , 8.5 × 11 , 7.25 × 10.5 , 8K , 16K </li> <li>Custom: min. 4.72" × 10.12" to max. 13.03" × 19.21" (min. 120 mm × 257 mm to max. 331 mm × 488 mm)</li> <li>Wide paper</li> <li>Multi Tri-Fold Standard: A4 , 8.5 × 11 </li> </ul>
	Paper weight	Multi Half-Fold: 14 lb Bond to 80 lb Bond (50 g/m <sup>2</sup> to 300 g/m <sup>2</sup> ) Multi Tri-Fold: 14 lb Bond to 24 lb Bond (50 g/m <sup>2</sup> to 91 g/m <sup>2</sup> ) Tri-Fold combined with Crease (When Multi Fold is released): 29 to 57 lb Bond (106 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )
	Maximum number of multi-fold sheets	Multi Half-Fold: 5 sheets (14 to 22 lb Bond (50 g/m <sup>2</sup> to 81 g/m <sup>2</sup> )) 3 sheets (23 to 34 lb Bond (82 g/m <sup>2</sup> to 130 g/m <sup>2</sup> )) 2 sheets (35 to 80 lb Bond (131 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )) Multi Tri-Fold: 5 sheets (14 to 22 lb Bond (50 g/m <sup>2</sup> to 81 g/m <sup>2</sup> )) 3 sheets (23 to 24 lb Bond (82 g/m <sup>2</sup> to 91 g/m <sup>2</sup> ))

	Load capacity	Multi Half-Fold: 30 sets (with full-load detection activated) Multi Tri-Fold: Single-sheet fold: 40 sets 2-sheet fold: 20 sets 3-sheet fold: 13 sets 4-sheet fold: 10 sets 5-sheet fold: 8 sets (21 lb Bond (80 g/m <sup>2</sup> ) paper, with full-load detection activated))
Fold & Staple / Trimming	Paper size	Standard: A3  , B4  , A4  , B5  , Foolscap, SRA3  , SRA4  , 12 × 18  , 11 × 17  , 8.5 × 14  , 8.5 × 11  , 7.25 × 10.5  , 8K  , 16K  Custom: min. 4.72" × 10.12" to max. 13.03" × 19.21" (min. 120 mm × 257 mm to max. 331 mm × 488 mm) Wide paper
	Paper weight	14 to 80 lb Bond (50 g/m <sup>2</sup> to 300 g/m <sup>2</sup> )
	Staple position	Variable (2.36" to 6.53" (60 to 165.8 mm))
	Maximum number of folded & stapled sheets	See page 2-14 for details.
	Maximum number of trimmed sheets	Twice as many as the maximum number of folded & stapled sheets
	Load capacity	See page 2-14 for details.
Straight output / Output to secondary (sub) tray	Paper size	Standard: A3  , B4  , A4  , B5  , A5  , B6  , Foolscap, Postcard, SRA3  , SRA4  , A6  , 13 × 19  , 12 × 18  , 11 × 17  , 8.5 × 14  , 8.5 × 11  , 5.5 × 8.5  , 9 × 11  , 7.25 × 10.5  , 8K  , 16K  Custom: min. 3.74" × 5.24" to max. 13.03" × 19.21" (min. 95 mm × 133 mm to max. 331 mm × 488 mm) Wide paper Tab Paper (Tab edge only at output)
	Paper weight	11 lb Bond to 93 lb Bond (40 g/m <sup>2</sup> to 350 g/m <sup>2</sup> ) (The load of 13 lb Bond (49 g/m <sup>2</sup> ) or less is not guaranteed.)
	Load capacity	Loading height (Full-load detected by sensor): 30 mm, approx. 200 sheets (22 lb Bond (80 g/m <sup>2</sup> )) Z-Fold: 20 sheet Half-Fold: 20 sheets
Size		Single unit: 48.86"* (W) × 56.34" (D) × 40.16" (H) (1,241* (W) × 1,431 (D) × 1,020 (H) mm) *: Excluding the booklet tray part 9.29" (236 mm) Rear console section: 48.86" (W) × 28.46" (D) × 40.16" (H) (1,241 (W) × 723 (D) × 1,020 (H) mm) Front console section: 31.50" (W) × 34.25" (D) × 40.16" (H) (800 (W) × 870 (D) × 1,020 (H) mm)
Weight		743 lb (337 kg)
Power supply		AC 100 to 240 V, 50/60 Hz DC 5/24 V (some are supplied from the machine)
Power consumption		350 W














### 8.1.2 Creaser Unit CR-101 (equipped in Saddle Stitcher SD-513)

Name		CR-101
Type		Creaser unit for crease blade driving
Function	Crease	Adds creases (fold lines) on sheets.
	Through pass	Outputs sheets to the finishing device without processing.
Crease	Number of creases	1 to 4 pieces However, the following rules are provided depending on which function is combined with the Crease function. <ul style="list-style-type: none"> <li>• Fold &amp; Staple / Half-Fold + Crease: 1 piece</li> <li>• Tri-Fold + Crease: 2 pieces</li> <li>• Perfect Binding + Crease: 2 or 4 pieces (with gutter fold lines)</li> <li>• Crease only: 1 to 4 pieces</li> </ul>
	Paper size	Standard: A3  , B4  , A4  , B5  , Foolscap, SRA3  , SRA4  , 12 × 18  , 11 × 17  , 8.5 × 14  , 8.5 × 11  , 7.25 × 10.5  , 8K  , 16K  Custom: min. 4.72" × 10.12" to max. 13.03" × 19.21" (min. 120 mm × 257 mm to max. 331 mm × 488 mm) Wide paper
	Paper weight	21 to 93 lb Bond (80 g/m <sup>2</sup> to 350 g/m <sup>2</sup> ) However, the maximum weight conforms to the specifications of the combined functions.
	Crease position standard	Inlet edge stopper (Output edge side of main body)
	Setting unit	0.1 mm
	Min. line interval	1.0 mm
Through pass	Paper size	Standard: A3  , B4  , A4  , B5  , Foolscap, SRA3  , SRA4  , 12 × 18  , 11 × 17  , 8.5 × 14  , 8.5 × 11  , 7.25 × 10.5  , 8K  , 16K  Custom: min. 4.72" × 10.12" to max. 13.03" × 19.21" (min. 120 mm × 257 mm to max. 331 mm × 488 mm) Wide paper
	Paper weight	11 to 93 lb Bond (40 g/m <sup>2</sup> to 350 g/m <sup>2</sup> )
Size		8.31" (W) × 18.11" (D) × 5.39" (H) (211 (W) × 460 (D) × 137 (H) mm)
Weight		14.99 lb (6.8 kg)
Power supply		DC 5/24 V (Supplied from <b>Saddle Stitcher SD-513</b> )
Power consumption		25 W or less

## 8.1.3 Trimmer Unit TU-503 (equipped in Saddle Stitcher SD-513)

Name		TU-503
Type		Upper and lower round blade rotation slitter (Slitter blade moving type)
Function	2-Side Slitting	Slits both edges of sheets (based on the head and foot determined when sheets are positioned for conveyance).
	Through pass	Outputs sheets to the finishing device without processing.
2-Side Slitting	Paper size	<ul style="list-style-type: none"> <li>Standard size for Fold &amp; Staple, Half-Fold, straight output, or output to secondary (sub) tray: A3 , B4 , A4 , B5 , Foolscap, SRA3 , SRA4 , 12 × 18 , 11 × 17 , 8.5 × 14 , 8.5 × 11 , 7.25 × 10.5 , 8K , 16K , Custom size: min. 4.72" × 10.12" to max. 13.03" × 19.21" (120 mm × 257 mm to max. 331 mm × 488 mm), Wide paper</li> <li>Tri-Fold standard size: A4 , 8.5 × 11 </li> </ul>
	Paper weight	14 to 93 lb Bond (50 g/m <sup>2</sup> to 350 g/m <sup>2</sup> ) However, the maximum weight conforms to the specifications of the combined functions.
	Cutting position	Head and foot determined when sheets are positioned for conveyance
	Cutting width	0.20" to 1.02" (5 mm to 26 mm) The head and foot cutting widths can be specified individually. However, the difference between the head and foot cutting widths must be within 10 mm.
Through pass	Paper size	Standard: A3  , B4  , A4  , B5  , A5  , B6  , Foolscap, Postcard, SRA3  , SRA4  , A6  , 13 × 19  , 12 × 18  , 11 × 17  , 8.5 × 14  , 8.5 × 11  , 5.5 × 8.5  , 9 × 11  , 7.25 × 10.5  , 8K  , 16K  Custom: min. 3.74" × 5.24" to max. 13.03" × 19.21" (min. 95 mm × 133 mm to max. 331 mm × 488 mm) Standard tab paper (The rear edge side of tab paper is not guaranteed at output.) Wide paper
	Paper weight	11 to 93 lb Bond (40 g/m <sup>2</sup> to 350 g/m <sup>2</sup> )
Size		11.97" (W) × 24.80" (D) × 15.00" (H) (304 (W) × 630 (D) × 381 (H) mm)
Weight		Main body: 36.37 lb (16.5 kg) (Including two rotary cutters) Scrap shutter (including the shooter): 4.85 lb (2.2 kg) Scrap box (2 units): 2.20 lb (1.0 kg) × 2
Power supply		DC 5/24 V (Supplied from <b>Saddle Stitcher SD-513</b> )
Power consumption		50 W or less

### 8.1.4 Folding Unit FD-504 (equipped in Saddle Stitcher SD-513 as option)

Name		FD-504
Type		Spine corner forming machine for clamp-type roller pressure welding
Function	Fold & Staple + Spine Corner Forming	Flattens the spine of the folded & stapled booklet.
Paper size		Standard: A3  , B4  , A4  , B5  , Foolscap, SRA3  , SRA4  , 12 × 18  , 11 × 17  , 8.5 × 14  , 8.5 × 11  , 7.25 × 10.5  , 8K  , 16K  Custom: min. 4.72" × 10.12" to max. 13.03" × 19.21" (min. 120 mm × 257 mm to max. 331 mm × 488 mm) Wide paper
Paper weight		14 to 57 lb Bond (50 g/m <sup>2</sup> to 216 g/m <sup>2</sup> )
Minimum number of processed sheets		5 sheets
Maximum number of processed sheets		See page 2-14 for details.
Load capacity		<Fold & Staple + Spine Corner Forming> 5 to 10 sheets stapled: 30 sets or more 11 to 25 sheets stapled: 20 sets or more 26 to 50 sheets stapled: 10 sets or more (Body paper of 24 lb Bond (91 g/m <sup>2</sup> ) or less, with full-load detection activated)
Size		25.31" (W) × 10.16" (D) × 7.76" (H) (643 (W) × 258 (D) × 155 (H) mm)
Weight		28.66 lb (13 kg)
Power supply		DC 5/24 V (Supplied from <b>Saddle Stitcher SD-513</b> )
Power consumption		60 W or less

MEMO

MEMO



**KONICA MINOLTA**

<http://konicaminolta.com>