

Operator Manual STR0202 & SFM0704
DBCB-0512-0066-V005

STR0202 2-Side Trimmer & SFM0704 Square Fold Module



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1. Safety



- The 2-Side Trimmer may only be plugged in to an approved and by circuit breakers protected electrical installation, that is secured with a maximum of 16A.
- The outlet socket shall be installed near the equipment and shall be easily accessible.
- Never put your hands, other body parts or anything else then booklets within trimming specifications in the infeed or outfeed of the 2-Side Trimmer.
- Before cleaning, maintenance or repairs, always be sure to switch off the power switch and disconnect the appropriate power cord.
- Always follow all warnings marked on or supplied with the equipment.
- The equipment should only be placed on a solid surface with adequate strength to hold the extra weight of the machine besides the usual maximum load.
- Always exercise care while moving or relocating the equipment.
- Keep magnets and all devices with a strong magnetic field away from the machine.
- Never attempt to perform maintenance or repairs other than described in this manual.
- Never remove covers or guards that are fastened with screws.
- Never install the equipment near a radiator or any other heat source.
- Never override or bypass electrical or mechanical interlock devices.
- In case of unusual sounds or noises, abnormal surface temperature or odours disconnect the equipments power source immediately and consult a qualified technician.



The manufacturer cannot be held responsible for arbitrary changes in the machine and the originated damage.



Make sure that the 2-Side Trimmer is NOT powered during installation or service activities.



This is a Class A product. In a domestic environment this machine may cause radio interference. In which case the user may be required to take adequate measures.

Note: A domestic environment is an environment in which a radio and television receivers can be expected inside a range of 10 meters of the concerning machines.

RoHS
compliant

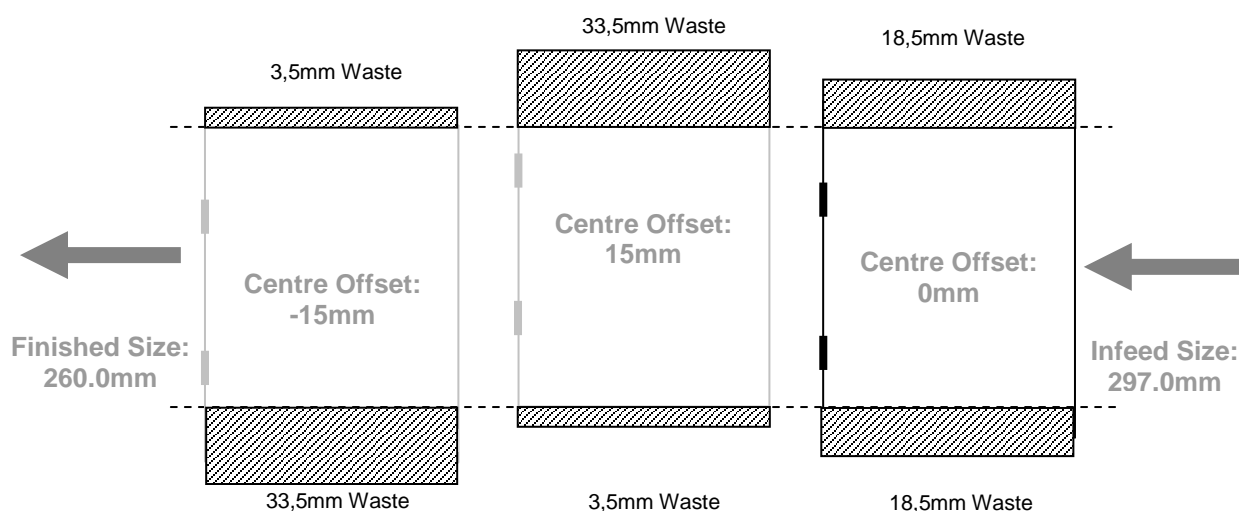
The 2-Side Trimmer is RoHS compliant.
ONLY use RoHS compliant replacement parts ordered from SDD.

2. General

With the addition of the 2-Side Trimmer STR0202 to the SDD product range, a cost effective full-bleed solution is available which has a small footprint and is easily to operate. This machine is designed with high reliability in mind, which means that it has been designed for long run production .

The main goal of the 2-Side Trimmer, further referred to as STR, is that it can be used for trimming the bleed off the booklet. Booklets with a maximum up to 25 sheets 80g/m2 (50 folded) can be trimmed from 2mm to 35mm on each short edge of the booklet, to a minimum of 200mm and a maximum of 320mm finished size. Thereby it is also possible to trim asymmetrical. All actions concerning operating the STR and adjusting the trim settings can easily be done by using the User Interface (UI) on the STR.

For example in the schedule mentioned below is schematically rendered some results which are possible with the STR by using a different Center Offset (symmetrical or asymmetrical):

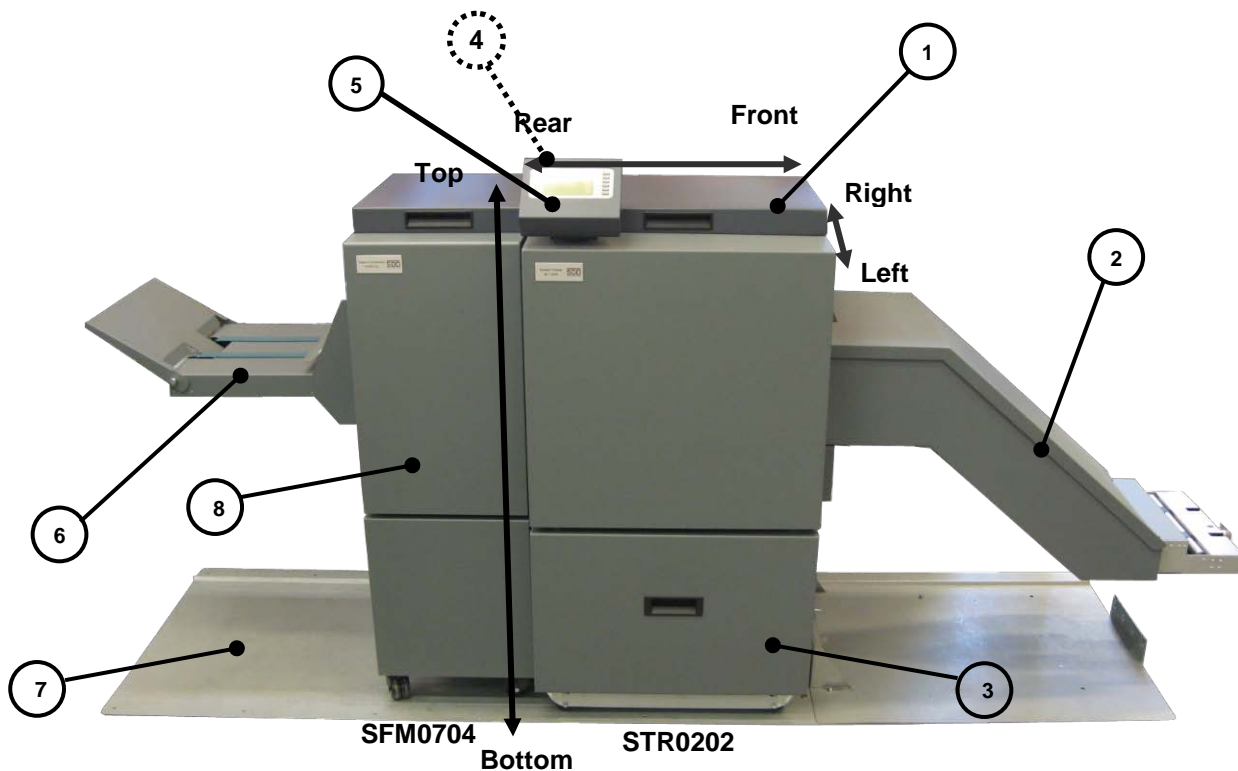


3. Basic information

See the picture below to get familiar with the components of the 2-Side Trimmer.



All directions are seen from the paper flow direction.



No.	Description
1	Top Cover
2	Booklet Infeed Unit
3	Trim Waste Bin
4	Power switch (inside)
5	User Interface (UI)
6	Belt Stacker
7	Driving Plate
8	Option: SquareFold Module SFM7704 (SQF)

This manual applies to the STR0202 and SFM0704

Due to mirroring, typical Front and Rear designations which are normally viewed from the operator location have been replaced by Left and Right. Left and Right are viewed from the paper input direction.

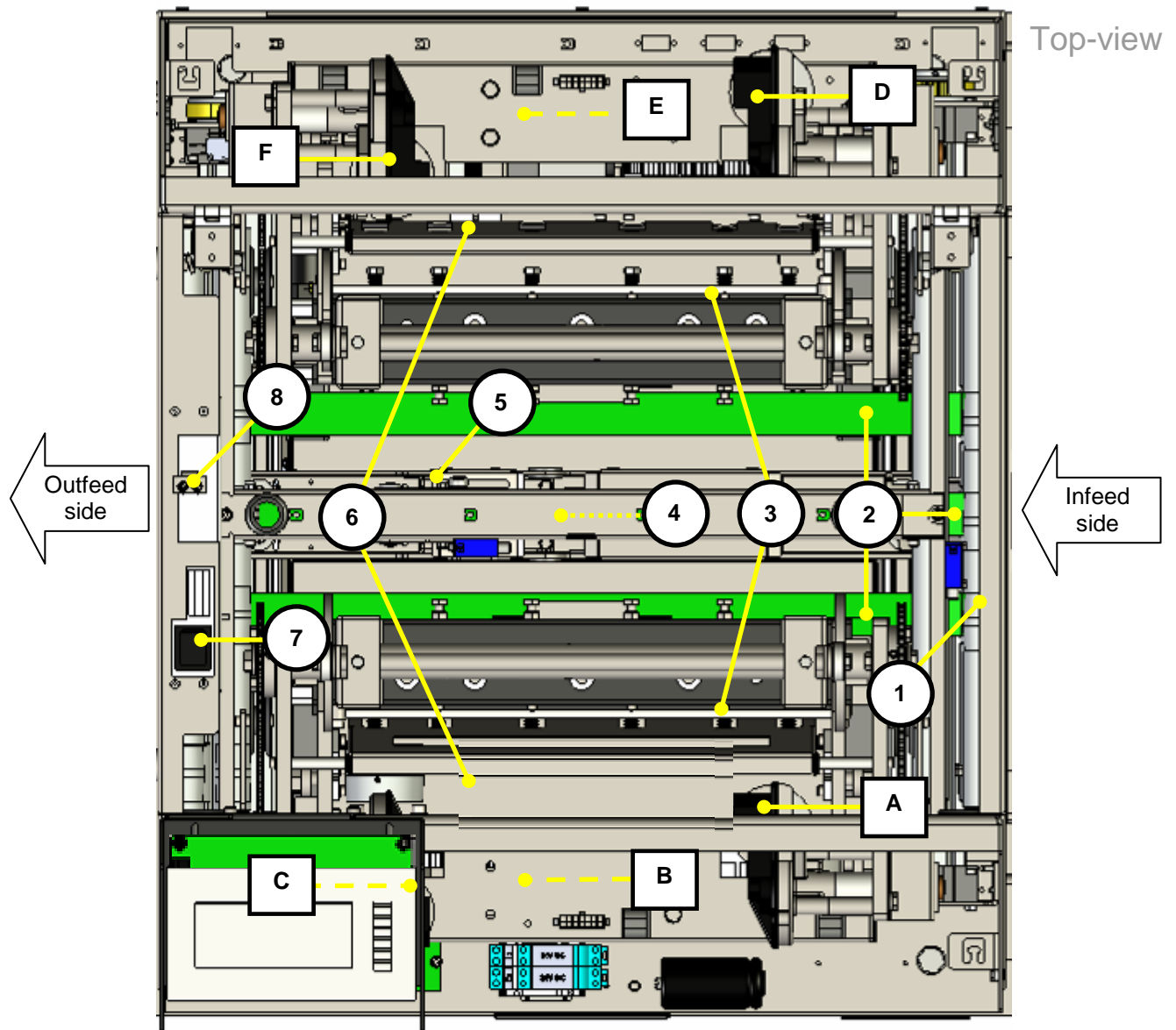
Clarification:

Left = Front for STR0202 and SFM0704

Right = Rear for STR0202 and SFM0704

3. Basic Information (continued)

Study the **STR0202 Top View** below to become familiar with the components.



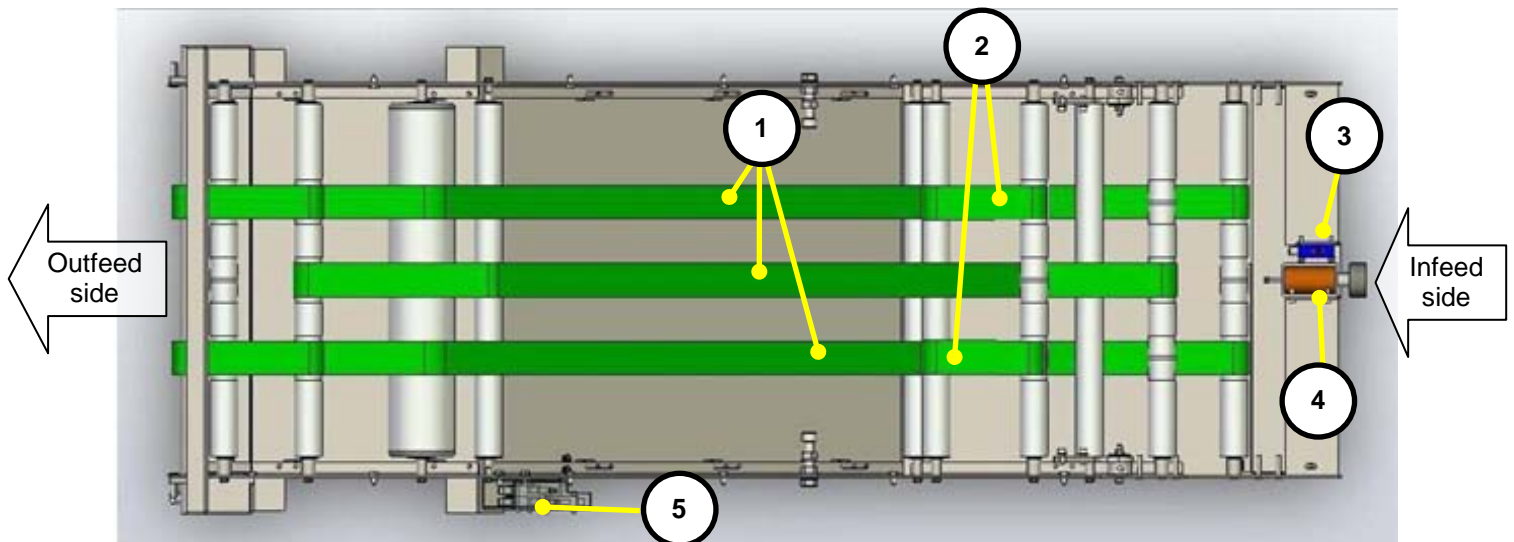
No.	Description
1	Docking Bracket
2	Transport Belts
3	Knives
4	Solenoid
5	Trimmer Stop
6	Side Joggers
7	Power Switch
8	Interlock Switch

No.	Description
A	Motor 1, Knife
B	Motor 7, Side Jogger
C	Motor 2, Knife
D	Motor 3, Knife
E	Motor 8, Side Jogger
F	Motor 4, Knife

3. Basic Information (continued)

Study the **Infeed Top View** below to become familiar with the components.

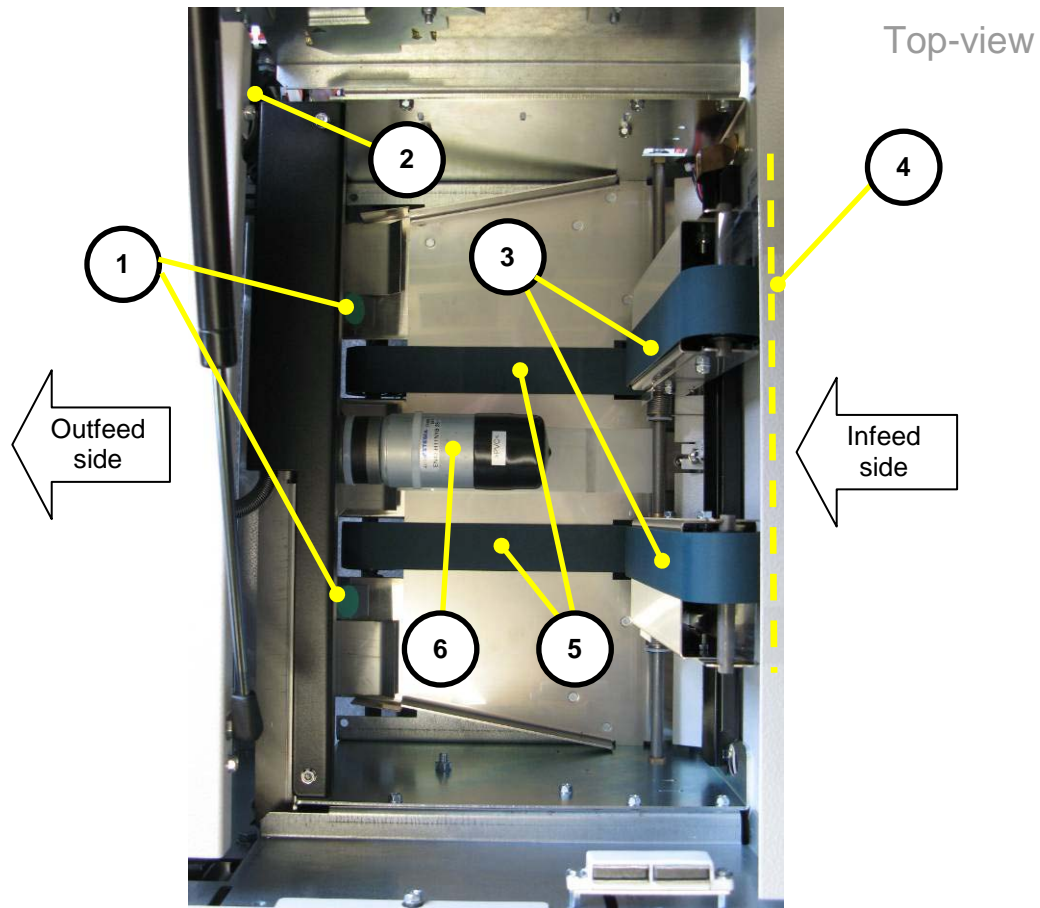
Top-view



No.	Description
1	Transport Belts
2	Support Belts
3	Photo Sensor
4	Error Solenoid
5	Interlock Switches

3. Basic Information (continued)

Study the **SFM0704 Top View** below to become familiar with the components.



No.	Description
1	Upper Feed Belt Latches
2	Roller Motor (not visible in picture)
3	Upper Feed Belts (lifted position)
4	Docking Bracket (not visible in picture)
5	Lower Feed Belts
6	Booklet Clamp Motor

4. Operating the STR

This section explains how to use the STR in standard operation.



From either side (top or bottom) 40mm of the finished booklet should be free from staples to ensure safe operation.



NOTE: The System Setup has to be done once.

4.1 System Setup

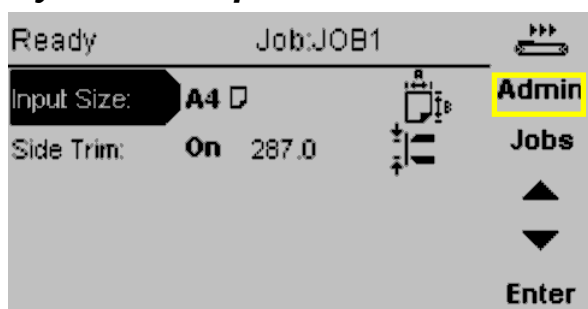


Fig. 1

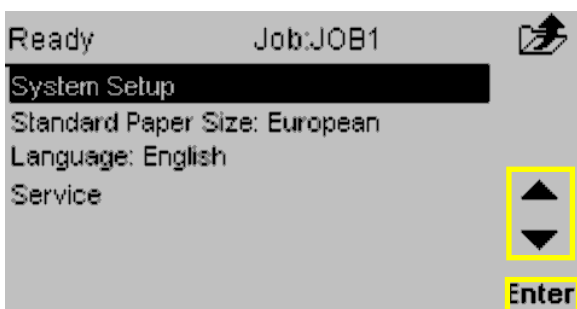


Fig. 2

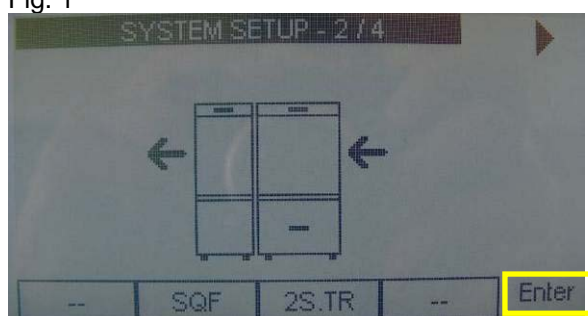


Fig. 3

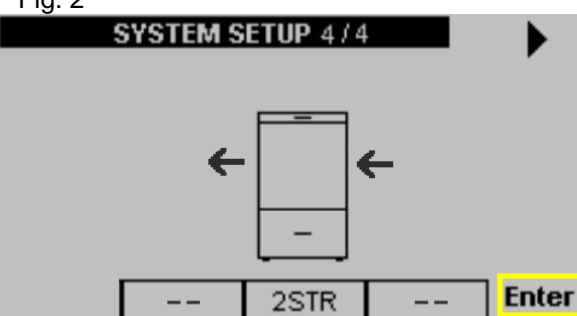


Fig. 4

Step	Action	Remarks
1.	Open the Top cover of the STR.	
2.	Turn on the STR with the Power Switch	Attention: Check if the Trim Waste Bin Drawer is closed, otherwise the STR displays a 'Cover Open' error.
3.	Close the Top cover of the STR.	
4.	Enter 'Admin' menu	Press the 'Admin' button (Fig. 1)
5.	Enter 'System Setup' menu	Use the '▲ / ▼' buttons to select 'System Setup' and press the 'Enter' button. (Fig. 2)
6.	Select System Setup with or without SquareFold Module	Select the correct System Setup e.g. STR (2 / 4 or 4 / 4) (Fig. 3 and 4) Save and confirm with [Enter] Attention: After saving the STR will restart (Fig. 4).

4. Operating the STR (continued)

4.2 Language



NOTE: The Language has to be set once.

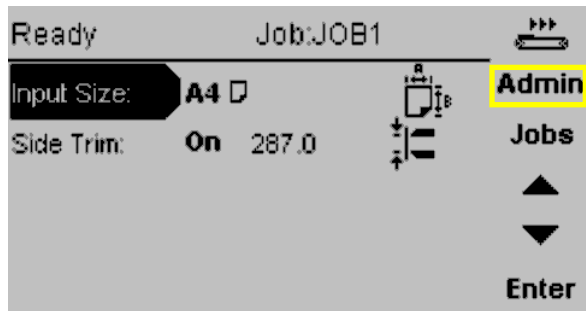


Fig. 1

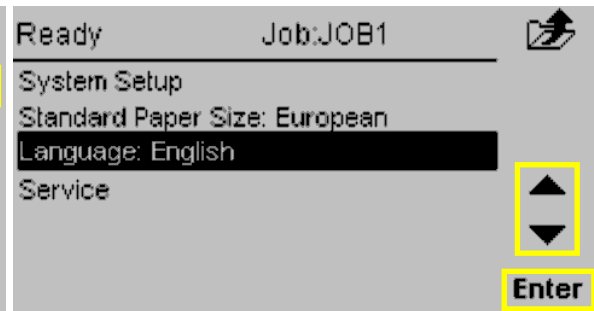


Fig. 2

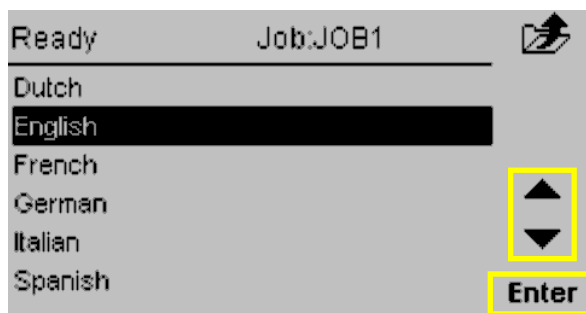


Fig. 3

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

4. Operating the STR (continued)

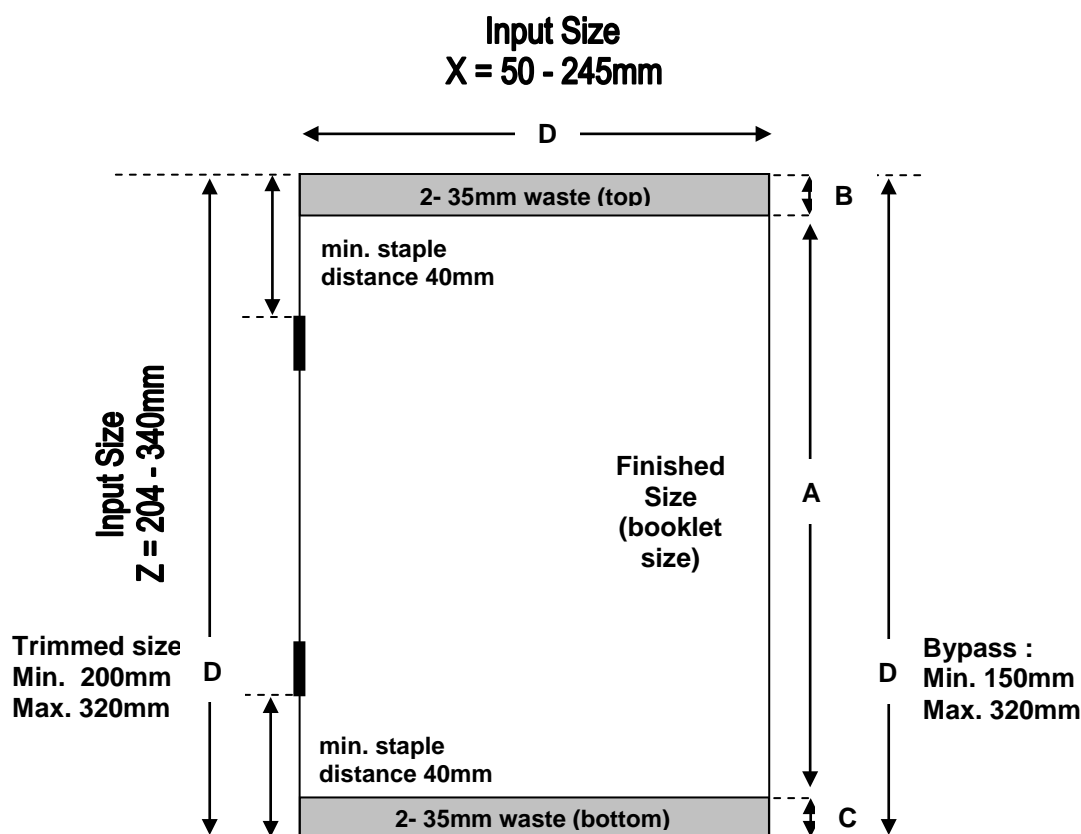
4.3 Job Setup

Proceed the following steps to set up the Job:

- 1) Determine the length of the booklet before trimming (= D 'Input Size') in mm.
- 2) Determine the length of the booklet after trimming (= A 'Finished Size') in mm.
- 3) Subtract 'A' from 'D' and spread the difference (= 'Total Waste') over 'B' and 'C'.



If necessary, adjust the Trim Size symmetrical or asymmetrical (See Chapter [4.9 Center Offset](#)).



As a rule, the following formula has to be correct in order to get the desired result:

Finished Size (booklet after trimming) (A)

Waste (front trim) (B)

Waste (rear trim) (C) +

Equals:

Input Size (booklet before trimming) (D)

or short:

A + B + C = D

4. Operating the STR (continued)

4.4 Paper Size Setup



NOTE: “Standard paper size” has to be set once.



NOTE: “Select Paper Size” which is suitable to your requirements.

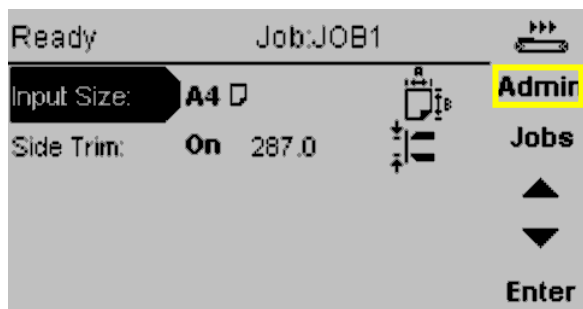


Fig.1

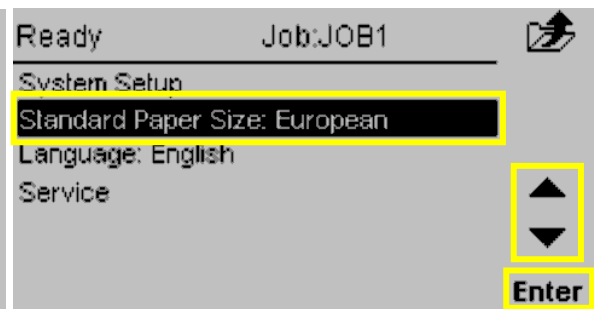


Fig.2

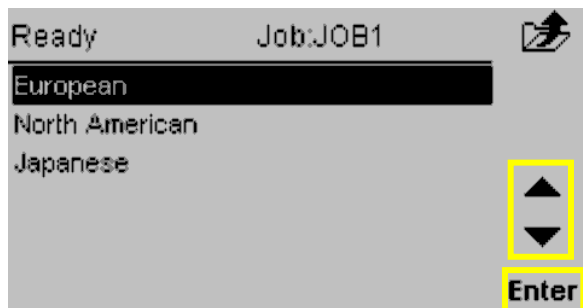


Fig.3

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

4. Operating the STR (continued)

4.5 Job Setup

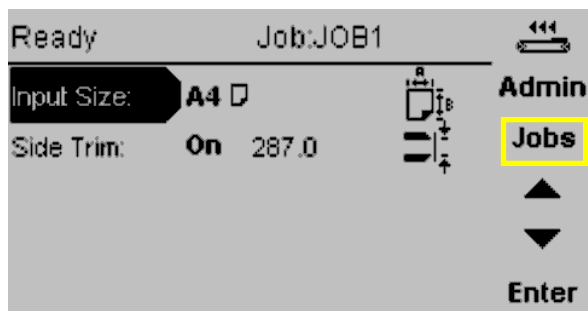


Fig. 1

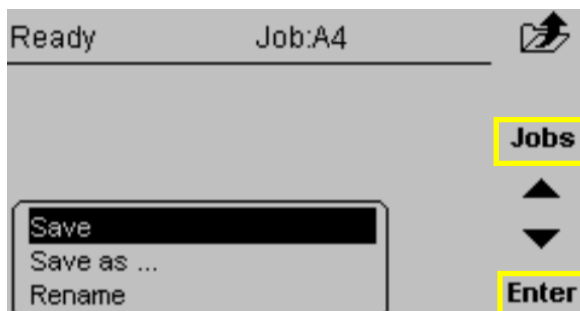


Fig. 2

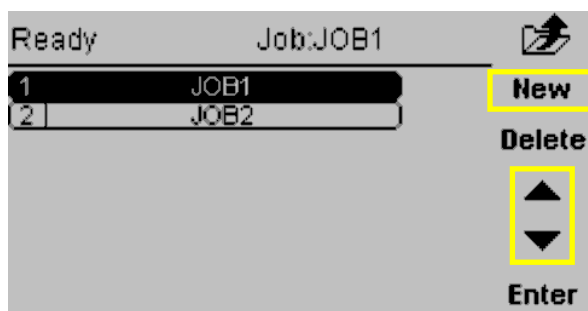


Fig. 3

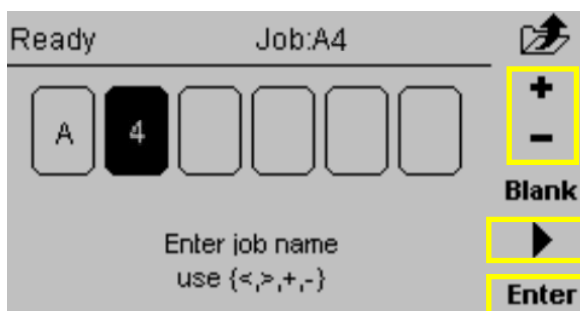


Fig. 4

Step	Action	Remarks
1.	Job Setup	Press the 'Jobs' button two times (Fig. 1 & 2).
2A.	Make a new Job	Press the 'New' button (Fig. 3).
2A.	Enter Job name	Use the '+ / -' and '►' buttons (Fig. 4) to Enter the Job name and press the 'Enter' button. ⚠ A "Loading Job" message appears for a few seconds.
2B.	Adjust a Job	Use the '▲ / ▼' buttons to select a Job and press the 'Enter' button to load or confirm. ⚠ A "Loading Job" message appears for a few seconds.
3.	Adjust Input Size and/or Side Trim	Use the '▲ / ▼' and the '+ / -' buttons to set the desired settings for Input Size and Side Trim (See Chapter: 4.6 Paper Input Size Setup 4.7 Side Trim ON/OFF)
4.	Save Job	After adjusting press 'Jobs' (Fig. 1) and save the current Job or 'Rename' the adjusted Job by pressing the 'Enter' button (Fig. 2). ⚠ A "Saving Job" message appears for a few seconds. ⚠ After Renaming a Job, repeat step 2A: 'Enter Job name'.

4. Operating the STR (continued)

4.6 Paper Input Size Setup



NOTE: In the "Input Size" menu of the STR the paper Input Size can set or adjusted.

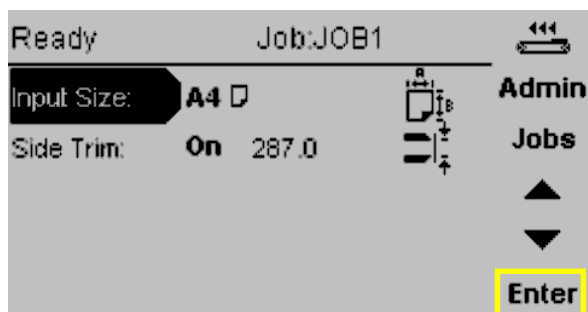


Fig. 1

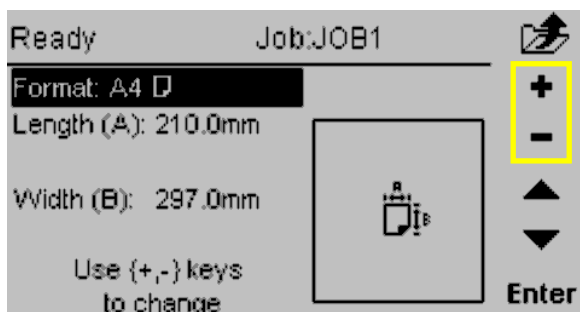


Fig. 2

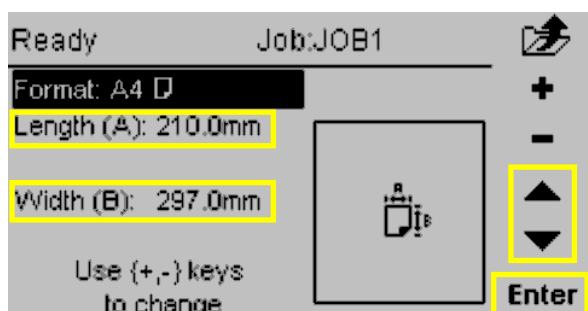


Fig. 3

Step	Action	Remarks
1.	Input Size adjustment	Use the '▲ / ▼' buttons to select 'Input Size' and press the 'Enter' button (Fig. 1).
2A.	Adjust 'Input Size' A4 / A5	Use the '+ / -' buttons (Fig. 2) to switch between 'A4' and 'A5' paper Input Size .
2B.	Adjust 'Input Size' Length(A) / Width (B)	Use the '▲ / ▼' buttons (Fig. 3) to adjust the 'Length (A)' or 'Width (B)' in mm and use the '+ / -' buttons to adjust the values (A) or (B).
3.	Save Input Size adjustments	Save and confirm with [Enter] (Fig. 3).

4. Operating the STR (continued)

4.7 Side Trim ON / OFF

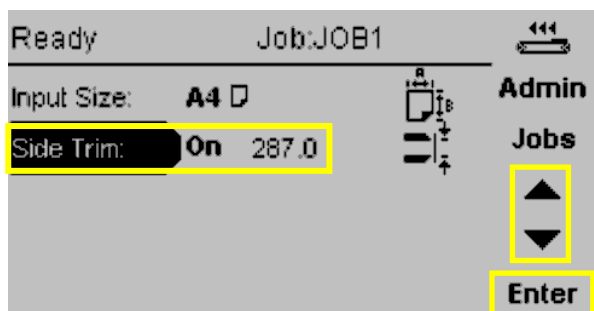


Fig. 1

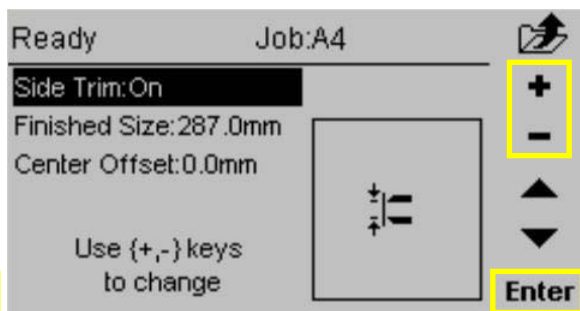


Fig. 2

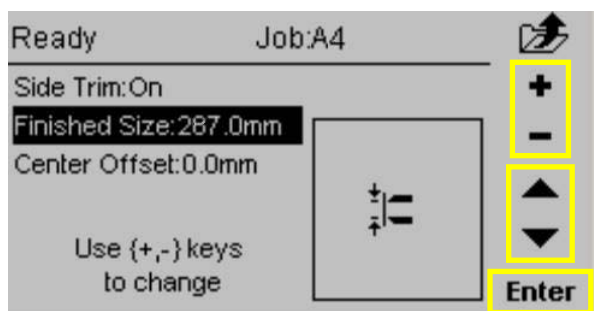


Fig. 3

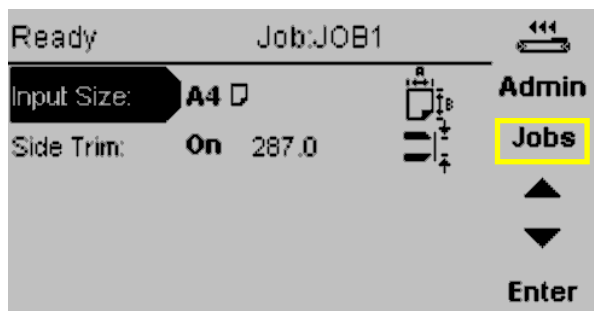


Fig. 4

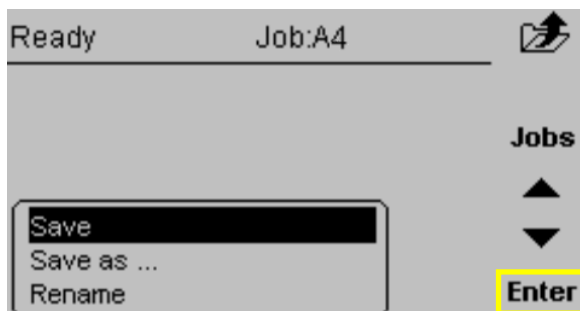


Fig. 5

Step	Action	Remarks
1.	Side Trim ON/OFF	Use the '▲ / ▼' buttons on the UI to select 'Side Trim' and press the 'Enter' button (Fig. 1).
2.	Adjust 'Side Trim'	Use the '+ / -' buttons to select ON / OFF
3.	Adjust 'Finished Size'	Use the '▲ / ▼' buttons (Fig. 3) to select 'Finished Size' and use the '+ / -' buttons to adjust the 'Finished Size'. Press 'Enter' (Fig. 3) to confirm the settings.
4.	Save settings.	After all desired settings are adjusted press 'Jobs' (Fig. 4) and press 'Enter' (Fig. 5) to save the settings. ⚠ A "Saving Job" message appears for a few seconds.

4. Operating the STR (continued)

4.8 SquareFold Module (SFM), SQF ON / OFF

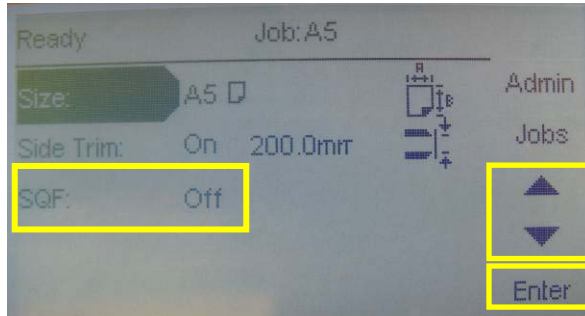


Fig. 1

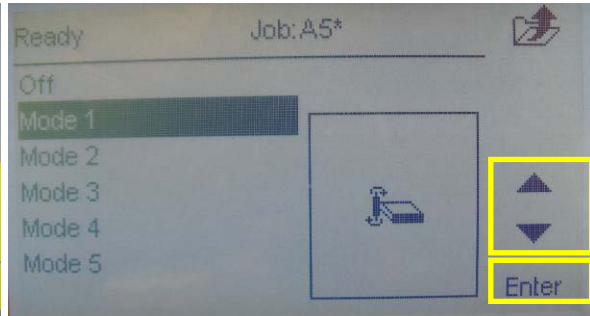


Fig. 2

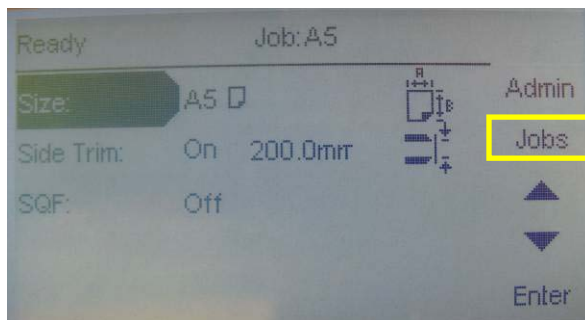


Fig. 3

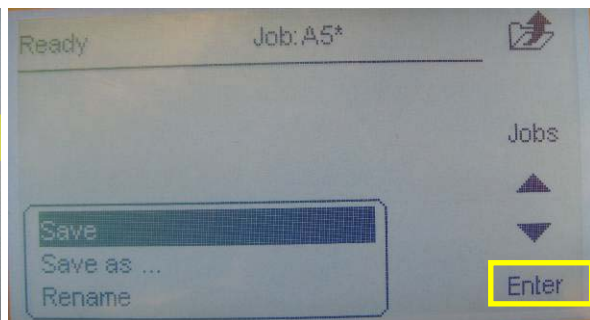


Fig. 4

Step	Action	Remarks
1.	Square Folding ON/OFF	Use the '▲ / ▼' buttons on the UI to select 'SQF' and press the 'Enter' button (Fig. 1).
2.	Adjust 'SFM Mode'	Use the '▲ / ▼' buttons (Fig. 2) to select 'Mode': Off for about 1 to 5 sheets (bypassing the SFM) Mode 1 for about 6 to 10 sheets Mode 2 for about 11 to 15 sheets Mode 3 for about 16 to 20 sheets Mode 4 for about 21 to ... sheets Mode 5 only pressing the sheets Press 'Enter' to confirm the settings.
3.	Save settings.	After all desired settings are adjusted press 'Jobs' (Fig. 3) and press 'Enter' (Fig. 4) to save the settings. ⚠ A "Saving Job" message appears for a few seconds.

4. Operating the STR (continued)

4.9 Centre Offset

For trimming the bleed off the booklet a Center Offset can be set. This means that it is possible to trim asymmetrical (trim more from the upper or lower side of the booklet)



A **positive** Center Offset will result in a booklet trimmed more on the **upper** side of the booklet.
 A **negative** Center Offset will result in a booklet trimmed more on the **lower** side of the booklet.
 (See example below: Input Size 297.0mm, Finished Size 260.0mm)

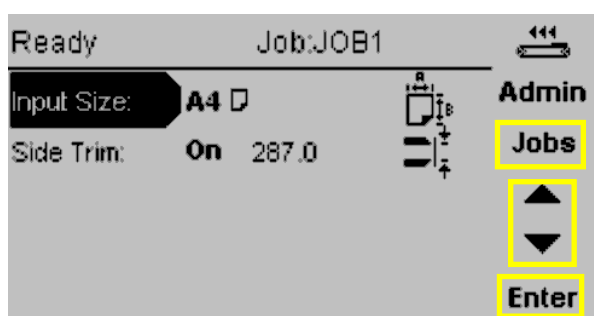
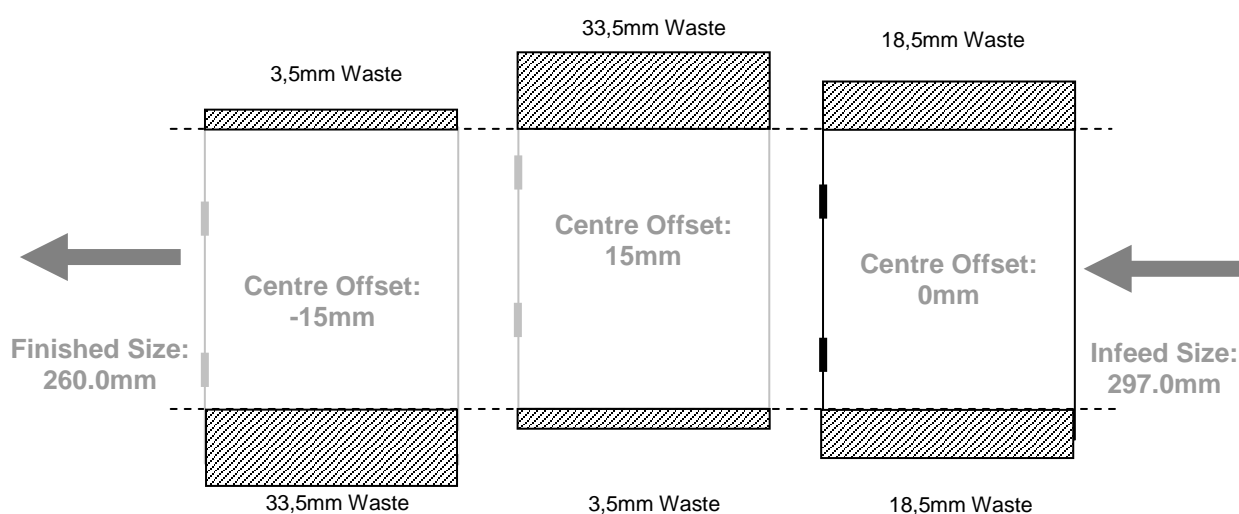


Fig. 1

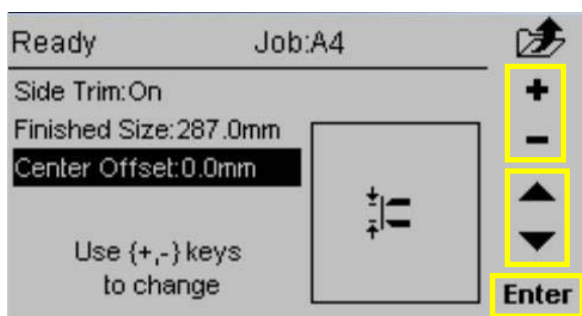


Fig. 2

Step	Action	Remarks
1.	Center Offset (if necessary)	Use the '▲ / ▼' buttons to select 'Side Trim' and press the 'Enter' button (Fig. 1).
2.	Adjust 'Center Offset'	Use the '▲ / ▼' buttons (Fig. 2) to select 'Center Offset' and use the '+ / -' buttons to adjust the 'Center Offset'. Press 'Enter' (Fig. 3) to confirm the settings.
3.	Save settings.	After the Center Offset is adjusted press 'Jobs' (Fig. 1) and press 'Enter' (Fig. 2) to save the settings.

4. Operating the STR (continued)

4.10 Purge Button

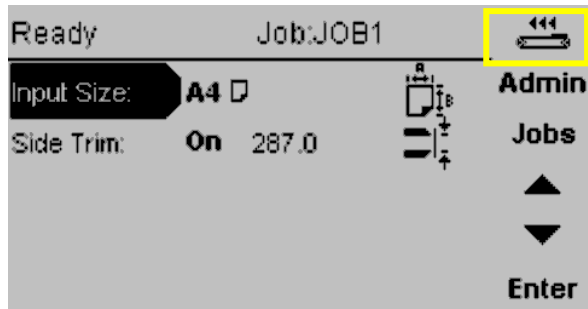


Fig.1

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

5. Troubleshooting

There are some Errors or Fault codes that may be solved by the operator:

- When the Trim Waste Bin is full or Cutting Waste is prevented from falling down into the Waste Bin, the message 'Empty Trim Bin' will be displayed (Fig. 1).
- When a Paper Jam appears, like Clear Area, the message 'Error STR...' will be displayed.

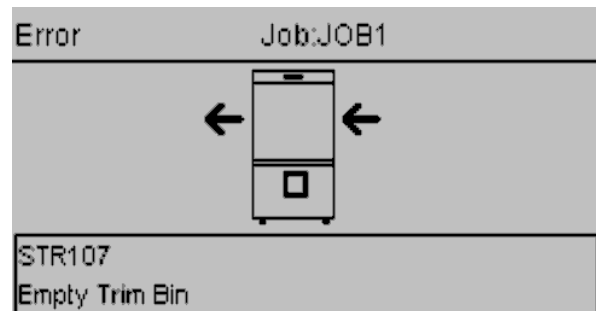


Fig. 1

5.1 Trim Waste Bin Full



Fig. 2

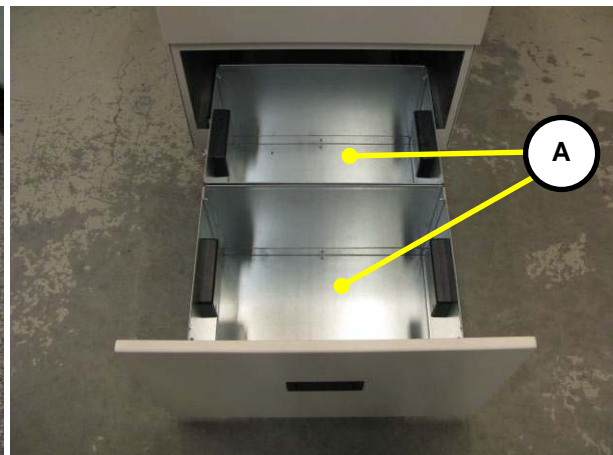



Fig. 3

Step	Action	Remarks
1.	Open the Trim Waste Drawer.	(Fig. 2)
2.	Empty both Trim Waste Bins (A).	(Fig. 3)
3.	Remove the remaining Cutting Waste.	 It is possible that there still is some Cutting Waste left inside the STR.
4.	Place the Trim Waste Bins back in the Trim Waste Drawer.	(Fig. 3)
5.	Close the Trim Waste Drawer.	(Fig. 2)

5. Troubleshooting (continued)

5.2 Clearing a Paper Jam

5.2.1 Warnings / Cautions



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



The STR Upper Knife Blades are protected by a Knife Safety Plate that moves away during the Trim cycle movement.



WARNING! Never put fingers or other body parts between or near the knives.

5.2.2 Clearing jams - STR

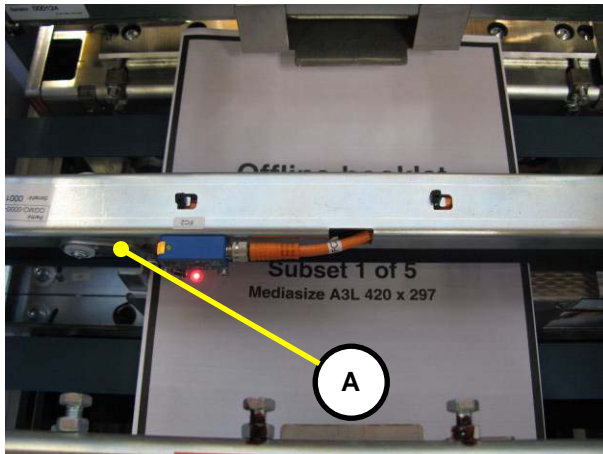


Fig.1

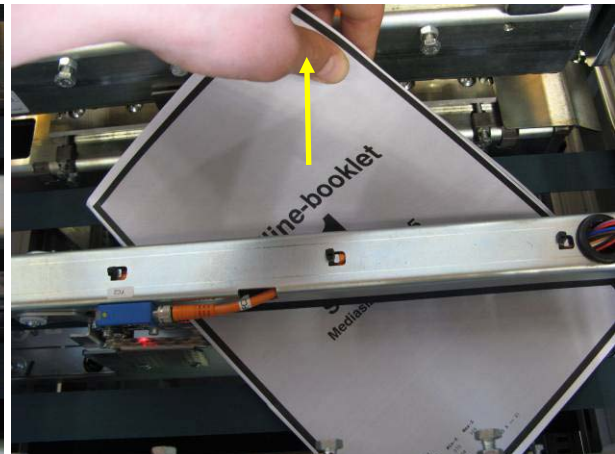


Fig. 2

Step	Action	Remarks
1. 1.1. 1.2.	Open the Top Cover. Close the Top Cover. The STR is trying to empty the machine.	The STR will automatically try to empty the machine when a Paper Jam is detected. When the jam is not cleared, the Knife blocks will automatically move outward to create space.
2.	Pay attention to the indicated area	Pay attention to the indicated area displayed on the UI
3.	Open the Top Cover.	
4.	Turn 'OFF' the STR.	
5.	Clear the indicated area : Take the booklet out of the machine	The indicated area is displayed on the UI. If necessary push down the Paper Stop (A).
6.	Turn 'ON' the STR.	A 'Cover Open' message will appear.
7.	Close the Top Cover.	The Knife blocks will automatically return to the position which was set for the current Job.

5. Troubleshooting (continued)

5.2 Clearing a Paper Jam (continued)

5.2.2. Clearing Jams - Inside STR (continued)

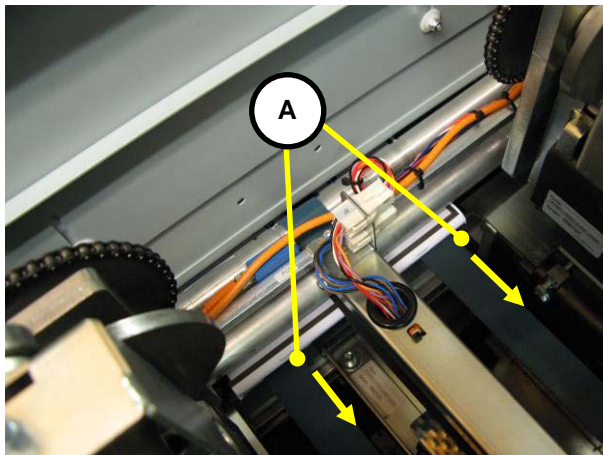


Fig. 1

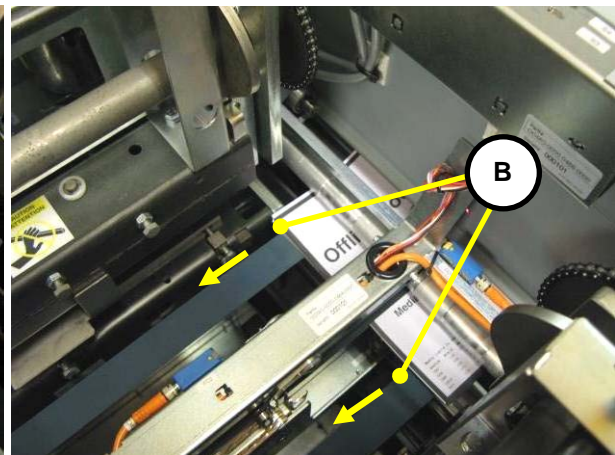






Fig. 2

Step	Action	Remarks
1. 1.1. 1.2.	Open the Top Cover. Close the Top Cover. The STR is trying to empty the machine.	The STR will automatically try to empty the machine when a Paper Jam is detected.  When the jam is not cleared, the Knife blocks will automatically move outward to create space..
2.	Pay attention to the indicated area	 Pay attention to the indicated area displayed on the UI.
3.	Open the Top Cover.	
4.	Turn 'OFF' the STR.	
5.	Clear the indicated area: Take the booklet out of the machine	Pull the belts (A) in the STR towards the input area. The booklet will move into the STR. Pull the belts (B) in the STR towards the output area. The booklet will move into the STR.
6.	Take the booklet out of the machine.	Push or pull the booklet inside the STR so it is possible to take the booklet out of a machine.
7.	Turn 'ON' the STR.	 A 'Cover Open' message will appear.
8.	Close the Top Cover of the STR.	 The Knife blocks will automatically return to the position which was set for the current Job.

5. Troubleshooting (continued)

5.2 Clearing a Paper Jam (continued)

5.2.3 Clearing Jams - Infeed Unit

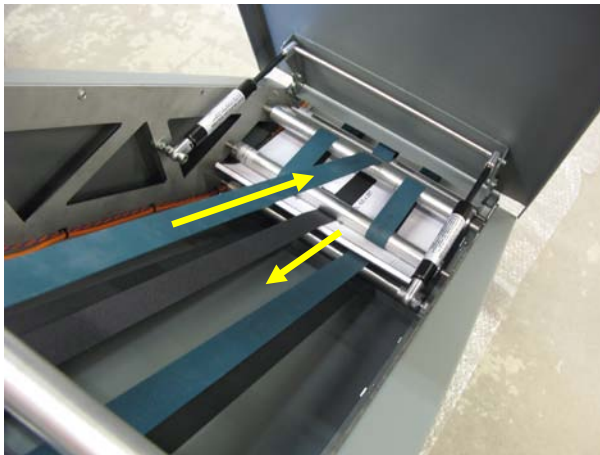


Fig. 1

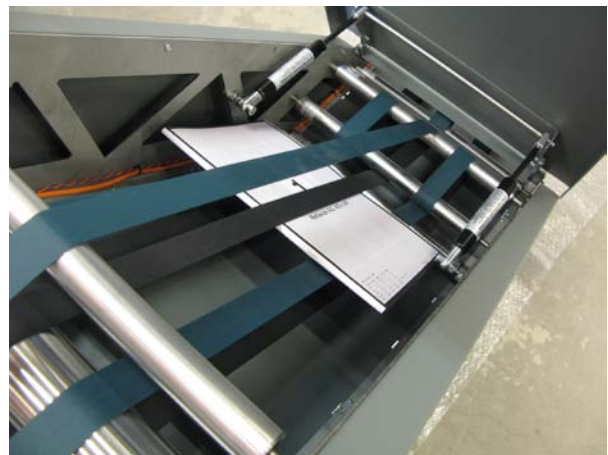


Fig. 2



Fig. 3



Fig. 4

Step	Action	Remarks
1.	Open the Top Cover of the Infeed Unit.	The STR will automatically try to empty the machine when a Paper Jam is detected.
2.	Move the Booklet to the center of the Infeed Unit.	Lightly pull the center Feed Belt as indicated in Fig. 1.
3.	Remove the Booklet from the Infeed Unit.	(See Fig. 3 & Fig. 4)

5. Troubleshooting (continued)

5.2 Clearing a Paper Jam (continued)

5.2.4 Clearing Jams - SFM

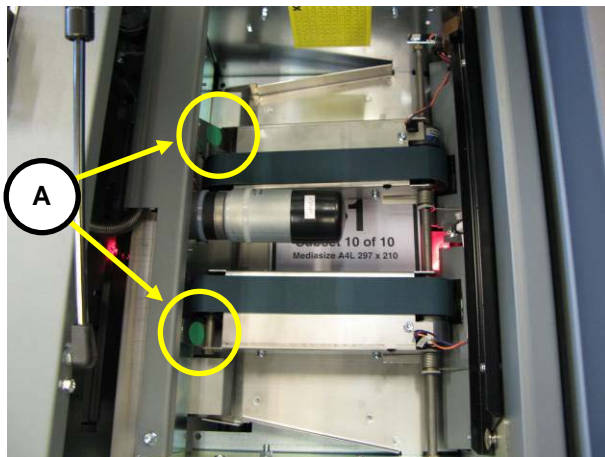



Fig. 1



Fig. 2

Step	Action	Remarks
1.	Open the Top Cover of the SFM. The SFM is trying to empty the machine.	The SFM will automatically try to empty the machine when a Paper Jam is detected.
2.	Clearing a Paper Jam	 Pay attention to the indicated area displayed on the UI.
3.	Open the top cover of the SFM	
4.	Clear the indicated area: Take the booklet out of the machine	Push the green-labeled latches (A) in the SFM to lift the Upper Feed Belts. (Fig. 1)
5.	Remove the Paper Jam	(Fig. 2)
6.	Reposition the Upper Feed Belts .	Lower the Feed Belts after removal of the booklet.
8.	Close the Top Cover of the SFM.	

5. Troubleshooting (continued)

5.3 Stop if booklet is too thick

NVM 'Stop if booklet too thick' is a value to set a warning for the Operator when a booklet is too thick to trim. There are 3 different warnings adjustable, which are:

Value 1

Booklet too thick! not trimmed
 (NO STOP: only message in UI display)

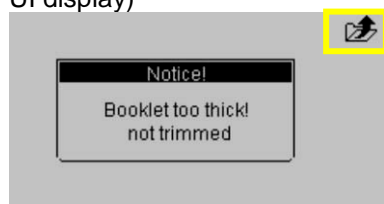


Fig. 1

Value 2

Booklet too thick (STR003)
 (SOFT STOP: booklet transported outside the machine)

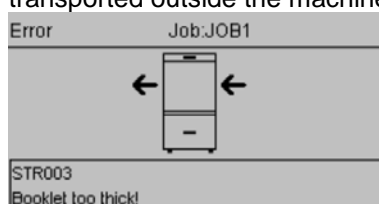


Fig. 2

Value 3

Booklet too thick (STR108)
 (HARD STOP: booklet still inside the machine)

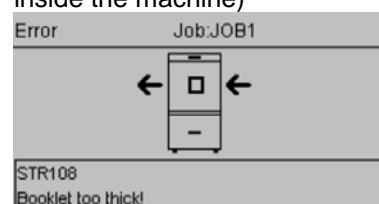






Fig. 3



Ask your service technician to install one of the Values which will suit to your requirements.



Next step is only for Value 2 and 3. For Value 1 just push "Escape" (Fig.1).

Step	Action	Remarks
1. 1.1. 1.2.	Open the Top Cover. Close the Top Cover. The STR is trying to empty the machine.	The STR will automatically try to empty the machine when a Paper Jam is detected.  When the jam is not solved, the Knife blocks will automatically move outward to create space.
2.	Pay attention to the indicated area	 Pay attention to the indicated area displayed on the UI.
3.	Open the Top Cover.	
4.	Turn 'OFF' the STR.	
5.	Clear the indicated area: Take the booklet out of the machine	Pull the belts (A) in the STR towards the input area. The booklet will move into the STR. Pull the belts (B) in the STR towards the output area. The booklet will move into the STR.
6.	Take the booklet out of the machine.	Push or pull the booklet inside the STR so it is possible to take the booklet out of a machine.
7.	Turn 'ON' the STR.	 A 'Cover Open' message will appear.
8.	Close the Top Cover of the STR.	 The Knife blocks will automatically return to the position which was set for the current Job.

6. Cleaning / Maintenance

6.1 General



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



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



The exterior can be cleaned with a slightly moist cloth.



With the exception of the belts, the interior of the STR does not require cleaning.

6.2 Cleaning the belts

The belts of the STR need to be cleaned regularly during normal conditions and if the STR has not been used for a period of time. How often this should be done depends on the paper type and print quality. An increasing number of jams is an indication of the need to clean the belts.



Clean the belts with water and a lint free cloth.

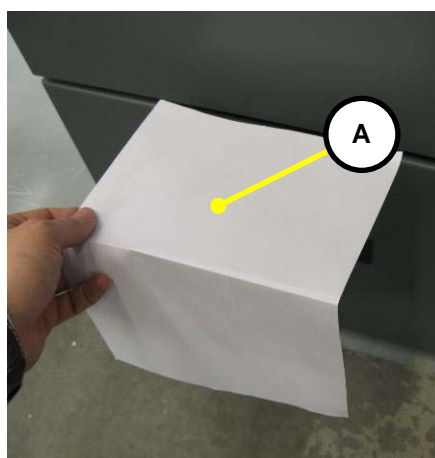


Fig. 1

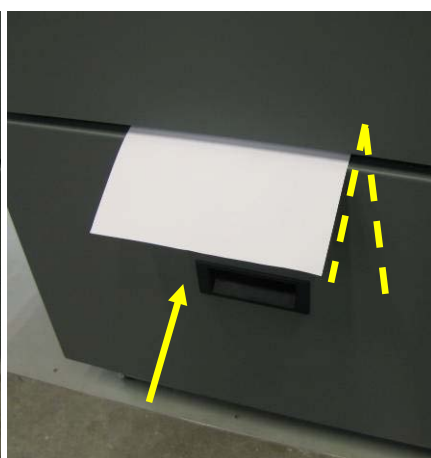



Fig. 2



Fig. 3

Step	Action	Remarks
1.	Cover reflection sticker.	Take a paper (A) fold it in the middle and put it between the Trim Waste Drawer and Front cover (Fig. 1 & 2).
2.	Open and close the Top Cover.	(Fig. 3)  The Knife blocks will automatically move outward to make space for cleaning the belts.
3.	Open the Top Cover	
4.	Turn off the STR	(Continue next page)

6. Cleaning / Maintenance (continued)

6.2 Cleaning the belts (continued)

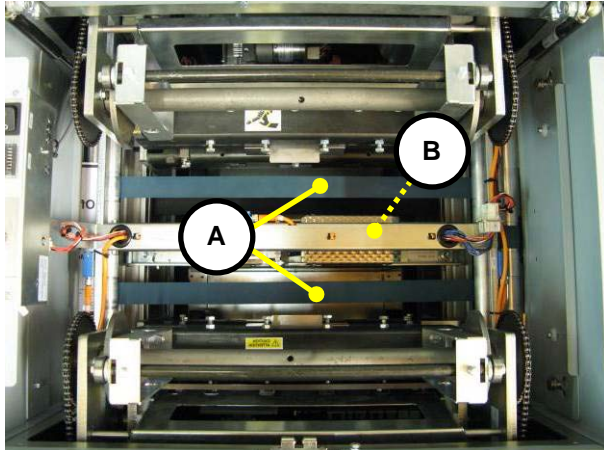




Fig. 1



Fig. 2

Step	Action	Remarks
5.	Clean the belts	The upper belt (B) can easily be rotated in either direction. The lower belts (A) can be rotated in either direction by pulling them (Fig. 1).
6.	Place the belts in normal position.	(It is possible that after cleaning and rotating the belts, the belts are removed from their normal position.)
7.	Remove the paper	Remove the paper between the Trim Drawer and the Front cover.(Fig. 2).
8.	Turn 'ON' the STR.	 A 'Cover Open' message will appear.
9.	Close the Top Cover.	 The Knife blocks will automatically return to the position which was set for the current Job.

7. Technical information

Capabilities:

Electrical:

<i>Compatibility:</i>	<i>Standalone STR0202:</i>	<i>50Hz:</i>	230/240V, 2.0A
		<i>60Hz:</i>	230/240V, 2.0A
		<i>60Hz:</i>	100/110/120/127V, 4.0A (upon request, rewiring required.)
<i>Capacity:</i>	Up to 25 sheets (80 g/m ² , 100 pages booklet)		

The 2-Side Trimmer should only be connected to an approved electrical system which is rated at a maximum of 16A and which is protected by circuit breakers.

Physical:

	Operational	On Pallet in box
<i>Height</i>	1200 mm	1440 mm
<i>Width</i>	700 mm	760 mm
<i>Depth</i>	1510 mm	1410 mm
<i>Weight</i>	~208 Kg	~250 Kg

Booklet specifications

	<i>before trimming:</i>	<i>trimmed:</i>
<i>Minimum booklet height:</i>	204 mm	200 mm
<i>Maximum booklet height:</i>	340 mm	320 mm

Technical specifications

<i>Speed (max.)</i>	1800 booklets/hour	
<i>Trimmed size (min-max)</i>	2mm - 35mm each side	4mm - 70mm together
<i>Paper Weight (min-max)</i>	60 g/m ² - 300 g/m ²	
<i>A-symmetrical trim (min-max)</i>	±15mm	
<i>Input / Output sheets</i>	Booklet Width (X) from 50 mm up to 245 mm	Note: Heights between 320 mm and 340 mm must be trimmed back to 320mm or shorter.
	Booklets Height (Z) 204 mm up to 340 mm	
<i>Booklet Staple Clearance from top/bottom (minimal)</i>	40mm	
<i>Noise Level (max)</i>	70dB	

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STR0202 2-Side Trimmer & SFM0704 Square Fold Module



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STR0202 2-Side Trimmer & SFM0704 Square Fold Module



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