

2 Machine description

2.1 Feeder folding data

2.1.1 Flat pile feeder

	FFH 56	FFH 66	FFH 82
Maximum format (cm)	56 x 90	66 x 104	82 x 120
Minimum format (cm)	14 x 18		
Min. format (cm) with dual suction wheel	–	20 x 18	
Max. strokes per hour	50000		
Maximum pile height (cm)	80		
Maximum paper weight (g/m ²)	250		
Min. paper weight (g/m ²)	40		

Tab. 2

2.1.2 Round continous feeder

	RFH 56	RFH 66	RFH 82
Maximum format (cm)	56 x 128	66 x 128	82 x 128
Minimum format (cm)	14 x 18		
Min. format (cm) with dual suction wheel	—	20 x 18	
Max. strokes per hour	50000		
Maximum pile height (cm)	8		
Maximum paper weight (g/m ²)	250		
Min. paper weight (g/m ²)	40		

Tab. 3

2.1.3 Pallet feeder

	PFH 66	PFH 82
Maximum format (cm)	66 x 104	82 x 120
Minimum format (cm)	14 x 18	
Min. format (cm) with dual suction wheel	20 x 18	
Max. strokes per hour	50000	
Maximum pile height (cm)	120	
Maximum paper weight (g/m ²)	250	
Min. paper weight (g/m ²)	40	

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2.2 Folder folding data

2.2.1 BUH 56

	BUH 56			
	1st unit	2nd station	3rd station	4th station
Standard buckle plate	Buckle plate swing deflector			
Possible number of buckle plates	4/6	4/6	2/4	2/4
Maximum fold length of 1st buckle plate (cm)	58	46		33
Minimum fold length (cm)	6			
Maximum speed (m/min)	230	210		
Minimum speed (m/min)	25			

Tab. 5

2.2.2 BUH 66

	BUH 66		
	1st unit	2nd station	3rd station
Standard buckle plate	Buckle plate swing deflector		
Possible number of buckle plates	4/6/8 ¹⁾	4/6/8	2/4
Maximum fold length of 1st buckle plate (cm)	62	58	46
Minimum fold length (cm)	6		
Maximum speed (m/min)	230	210	
Minimum speed (m/min)	25		

Tab. 6

¹⁾ 8 buckle plates are not possible with a BUH 66 first station in connection with a CUH 66.

2.2.3 BUH 82

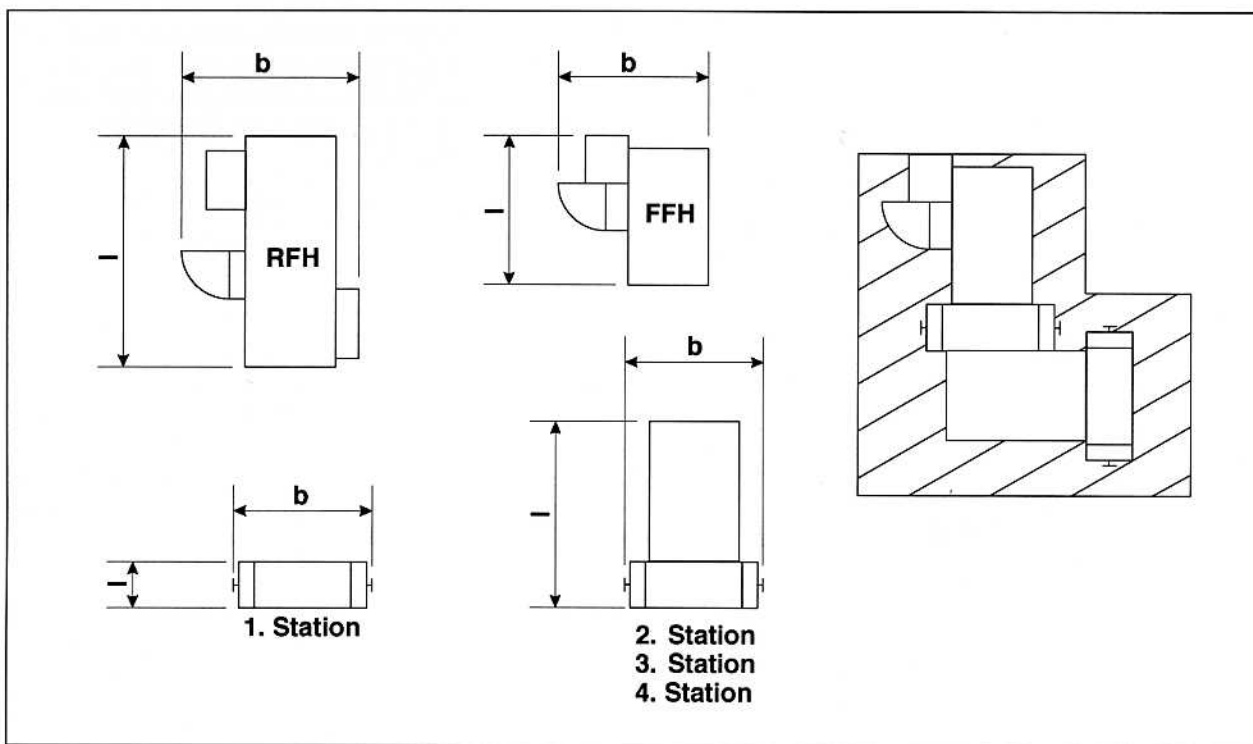
	BUH 82	
	1st unit	2nd station
Standard buckle plate	Buckle plate swing deflector	
Possible number of buckle plates	4/6/8	4/6/8
Maximum fold length of 1st buckle plate (cm)	62	58
Minimum fold length (cm)	6	
Maximum speed (m/min)	230	210
Minimum speed (m/min)	25	

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2.3 Dimensions and workplace areas

The modular design of the units means that it is not possible to define the precise dimensions of the individual machine versions. All dimensions are approximate. The shaded areas in the graphics represent the workplace area on the units. Do not move or obstruct this area. The distance between the machine and the wall/neighboring machines must be approx. 700...1,000 mm.

2.3.1 TH 56 workplace area and dimensions



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Fig. 10 TH 56 workplace area and dimensions

Machine/unit	Length l (mm)	Width w (mm)	Weight (kg)
Flat pile feeder (FFH)	2384	2080	470
Round continuous feeder (RFH)	3187	2108	540
Folder (1st station) – 4 buckle plates	442	1202	410
Folder (1st station) – 6 buckle plates	487	1202	450
Folder (2nd station) - 4 buckle plates and cross carrier table	1812	1202	610
Folder (2nd station) - 6 buckle plates and cross carrier table	1857	1202	650

Machine/unit	Length l (mm)	Width w (mm)	Weight (kg)
Folder (3rd station) - 2 buckle plates and cross carrier table	1767	1202	590
Folder (3rd station) – 4 buckle plates and cross carrier table	1812	1202	630
Folder (4th station) – 2 buckle plates and cross carrier table	1767	1202	590

Tab. 8

**Note**

If a **front-mounted** cutter shaft is located on the buckle folder, the length (l) of the feeder increases by 90 mm. If a **2nd downstream** cutter shaft is located on the buckle folder, the length (l) of the 1st station increases by 78 mm.

2.3.2 TH 66 workplace area and dimensions

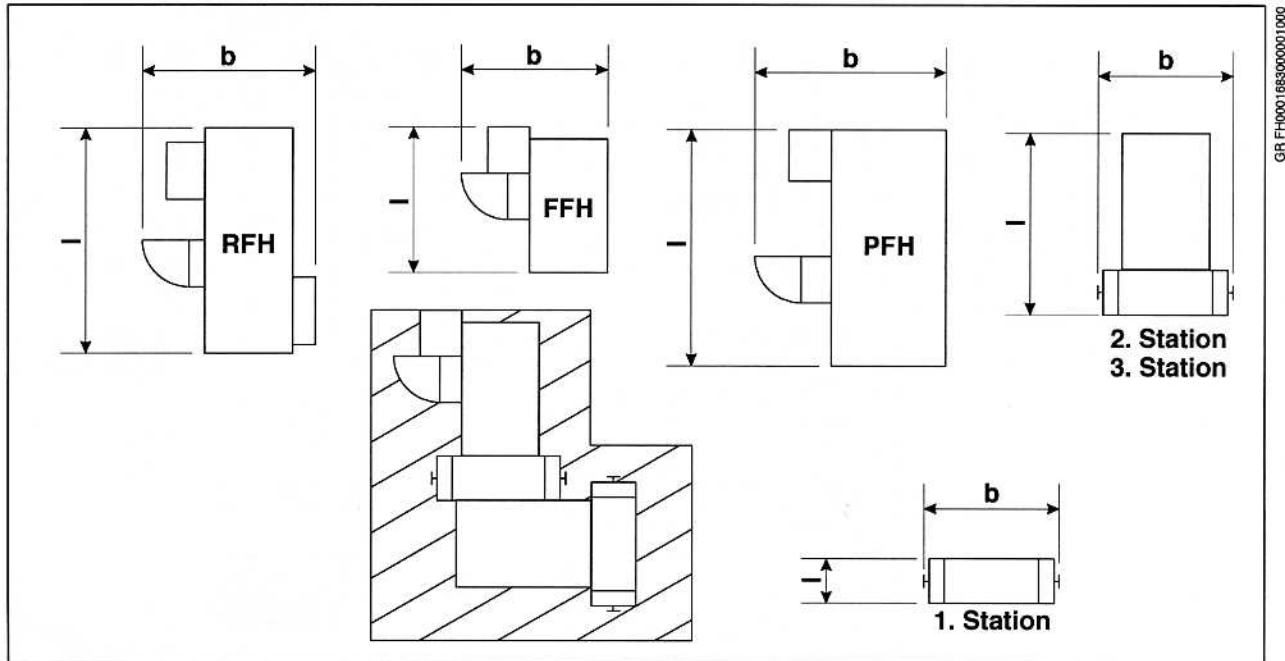


Fig. 11 TH 66 workplace area and dimensions

Machine/unit	Length l (mm)	Width w (mm)	Weight (kg)
Flat pile feeder (FFH)	2764	2183	560
Round continuous feeder (RFH)	3178	2208	650
Pallet feeder (PFH) without ramp	2655	2202	620
Pallet feeder (PFH) with ramp	2967	2514	625
Folder (1st station) – 4 buckle plates	442	1302	480
Folder (1st station) – 6 buckle plates	487	1302	520
Folder (1st station) – 8 buckle plates	532	1302	560
Folder (2nd station) - 4 buckle plates and cross carrier table	1957	1302	760
Folder (2nd station) - 6 buckle plates and cross carrier table	2002	1302	800
Folder (2nd station) - 8 buckle plates and cross carrier table	2047	1302	840
Folder (3rd station) - 2 buckle plates and cross carrier table	1912	1302	620
Folder (3rd station) – 4 buckle plates and cross carrier table	1957	1302	660

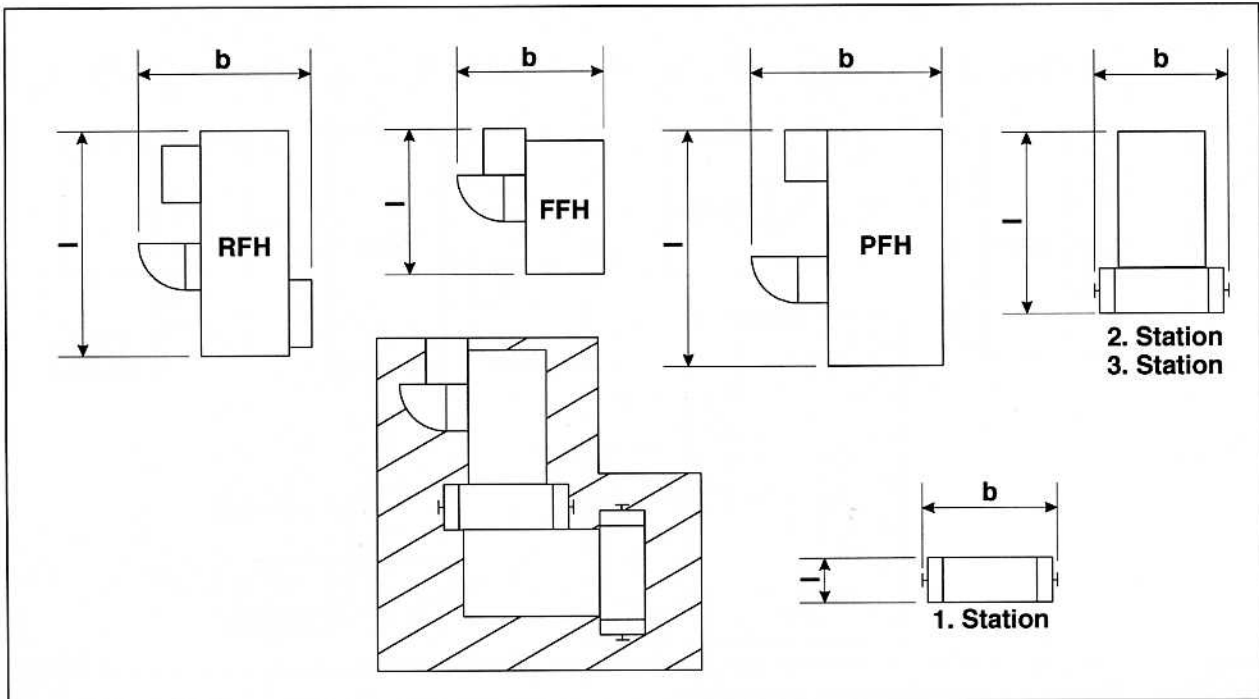
Tab. 9



Note

If a **front-mounted** cutter shaft is located on the buckle folder, the length (l) of the feeder increases by 90 mm.
If a **2nd downstream** cutter shaft is located on the buckle folder, the length (l) of the 1st station increases by 78 mm.

2.3.3 TH 82 workplace area and dimensions



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Fig. 12 TH 82 workplace area and dimensions

Machine/unit	Length l (mm)	Width w (mm)	Weight (kg)
Flat pile feeder (FFH)	2924	2343	780
Round continous feeder (RFH)	3178	2368	960
Pallet feeder (PFH) without ramp	2815	2362	1190
Pallet feeder (PFH) with ramp	3127	2674	1195
Folder (1st station) – 4 buckle plates	442	1462	600
Folder (1st station) – 6 buckle plates	487	1462	640
Folder (1st station) – 8 buckle plates	532	1462	680
Folder (2nd station) - 4 buckle plates and cross carrier table	2127	1462	900
Folder (2nd station) - 6 buckle plates and cross carrier table	2172	1462	940
Folder (2nd station) - 8 buckle plates and cross carrier table	2217	1462	980

Tab. 10

**Note**

If a **front-mounted** cutter shaft is located on the buckle folder, the length (l) of the feeder increases by 90 mm.
 If a **2nd downstream** cutter shaft is located on the buckle folder, the length (l) of the 1st station increases by 78 mm.

2.4 Connection



Warning – Risk of injury from electrical cables!

Check the electrical wiring for breaks and cracks every week. Only allow trained and authorized staff to work on electrical cables.



Note

You may only connect the machine after obtaining approval from the network operator. To comply with the EN 61000 – 3 – 11 standard, network impedance must be smaller than 0.105 Ω .

Connect each of the subsequent folding stations, units and deliveries (except for the 2nd station) to the previous folding station or unit via the plug-in connection.

The 1st station is connected directly. If you are using a second station, connect this to the control cabinet.

The electrical connection cable is used both as power supply and data cable for the connected units.



Note

Always lay electrical cables and compressed air hoses in such a way that they do not generate any potential obstacles for tripping over.

To connect the cable, pull back the sleeve on the attachment plug. Insert the plug carefully into the socket. The locking mechanism on the plug makes it impossible to insert the plug incorrectly.



Note

Never use force when establishing a plug-in connection.

2.5 Electrical data

You can find electrical data in the wiring diagram attached.

2.6 Measured sound level

The sound pressure level will not exceed 85 dB(A) as long as the speed does not exceed 160 m/min and the measurement is performed in line with DIN 45 635, Section 27 (measurement conditions: 80 % of the maximum output).

However, with certain types of fold and paper the sound pressure level can marginally exceed 85 dB(A) at higher speeds. In this case the operator is obliged to wear personal sound protection or reduce the speed accordingly.