



**Gathering Machine
3691/ASAC**

for efficient, reliable production
with signatures and single sheets

MÜLLER MARTINI



Greater Reliability... Higher Output

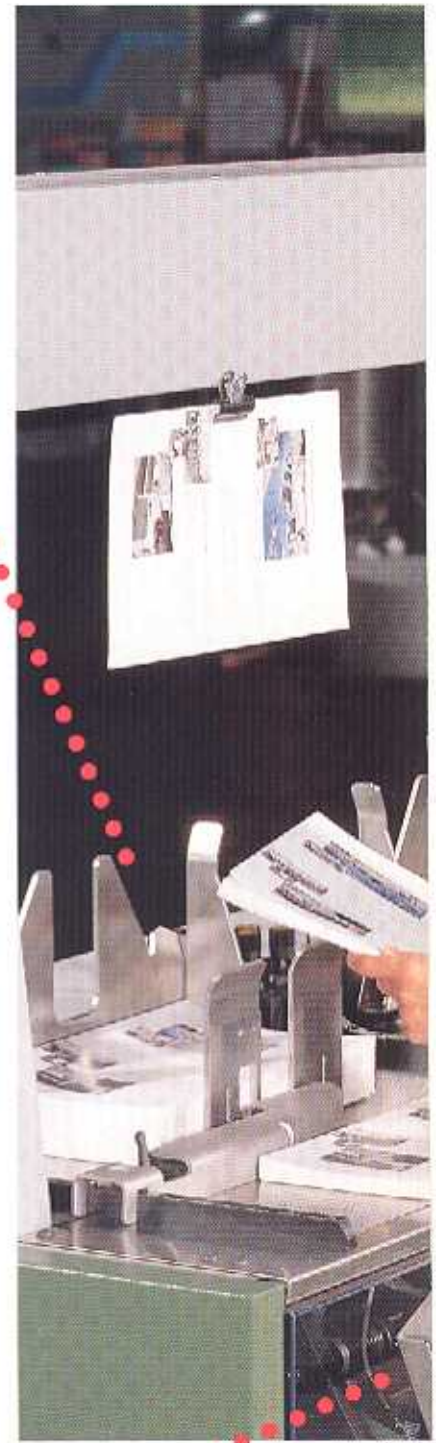
- universal hoppers can be loaded and operated from either side
- ASAC fully automatic, self-adjusting calipers for signature thickness measurement
- ASIR automatic signature image recognition (optional)
- sequential start-up of feeders
- positive transfer of signatures from hopper to gatherer raceway
- centralized and individually adjustable signature accelerators
- air-cushioned, waffle plated raceway
- automated bundle loading from stream feeders (optional)



Universal hopper



Stream Feeder 3736



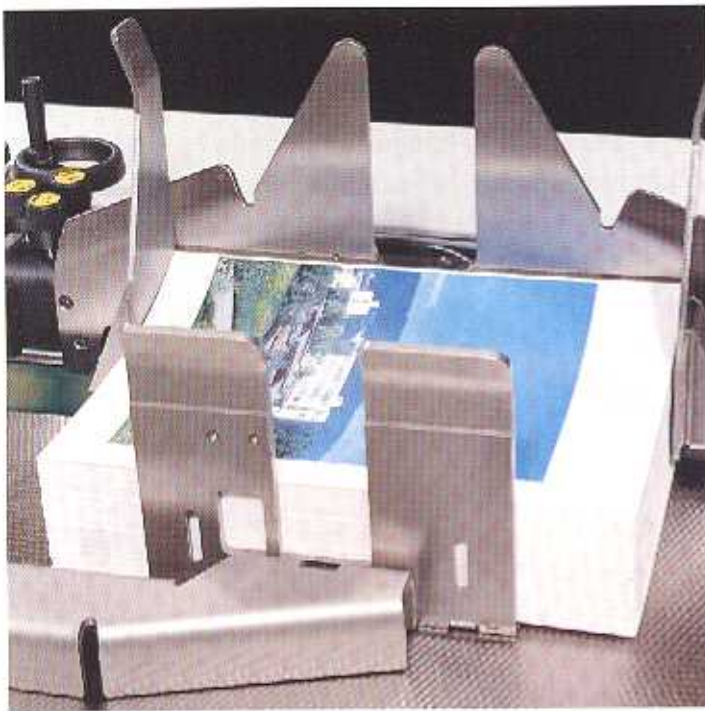
Signature accelerator



Raceway height adjustment



Controls/operating console



Universal Hopper

- three stations per module
- easily adjustable hoppers – no tools required
- optional bundle loading from stream feeders – no additional parts needed
- signature separators can be adjusted externally – with hoppers fully loaded and while the machine is running
- suckers are easily and laterally adjustable to suit products of various spine lengths.



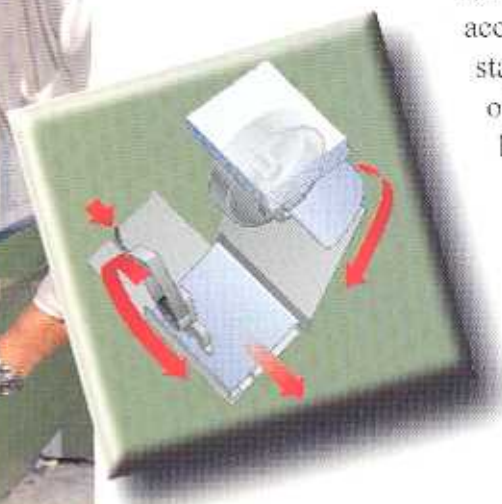
Controls/Supervision

- three stations per module
- centralized controls conveniently arranged above the drive module
- overhead console for easy operation
- one key pad per module, for individual control of each station
- function selector switch for doubles/missing sections
- on/off button at each station
- tolerances can be selected at each station



Signature Accelerators

- centralized adjustment of signature accelerators per module
- independent adjustment capability for individual signature accelerators per station, for products of various spine lengths





Raceway Height Adjustment

- raceway height is adjustable in steps during production and without tools
- low drop ensures reliable production especially with light-weight and difficult signatures
- optimum signature transfer for small product sizes



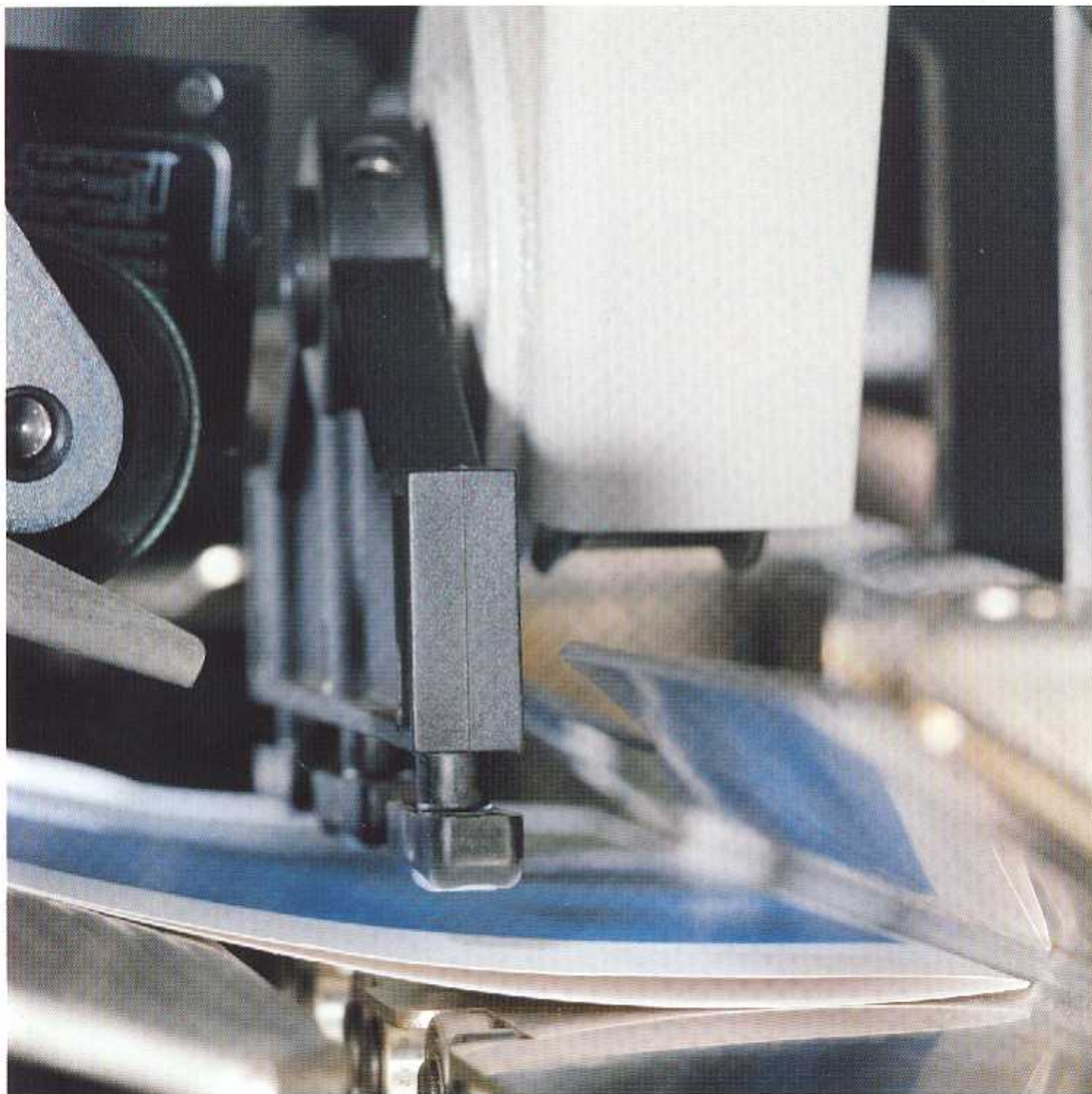
ASAC Operating Principle

- signature thickness is measured by the gripper (1). The gripper opening is controlled by a rotating sensor (2) and the signal transferred without contact (3) to the controls (4)
- the preset tolerance value is automatically compared with the reference value of the measured signature thickness



Reject Gate 3614

- in set-up mode, the gathered sets of signatures are diverted for visual inspection
- products with doubles or missing sections are automatically rejected at full running speed
- the need for removal of incorrectly gathered sets and refeeding of signatures is substantially reduced, thereby greatly increasing net output



Gathering Machine 3691/ASAC

with signature accelerators:
efficient and reliable gathering of
a wide variety of sections

This brochure may show components which are not standard equipment and are available as options only.

In some cases, protective covers in the photographs have been removed or opened for illustrative purposes.

Design and equipment configuration subject to change.

Sales and Service

Müller Martini Corp.

40 Rabro Drive
USA - Hauppauge, N.Y. 11788
Phone 516-582-4343
Fax 516-348-1961

MÜLLER MARTINI

Müller Martini Marketing AG

Untere Brühlstrasse 13
CH-4800 Zofingen, Switzerland
Phone +41-62-745 45 75
Fax +41-62-751 55 50
E-mail info@mullermartini.com
Internet <http://www.mullermartini.com>



Model 3691 Gathering Machine with ASAC

Specifications

Equipment	24"		
Mechanical speed	maximum 12,000 c/hr.		
Number of feeder stations	maximum 54		
Sizes, standard	Spine length	maximum	500 mm 19 1/2"
		minimum	140 mm 5 1/2"
	Book width	maximum	320 mm 12 5/8"
		minimum	100 mm 4"
Signature thickness	maximum	6 mm 1/8"	
Raceway clearance	maximum	80 mm 3 1/8"	
Length of 3-station element	maximum	2061 mm 6'9 1/8"	
Vacuum required per element	36 Nm ³ /h at 60%	21,2 cfm @ 60%	
Compressed air required per element	25 Nm ³ /h at 6 bar	14,7 cfm @ 87 psi	
Air-blow	50 Nm ³ /h at 0,1 bar	29,4 cfm @ 1 1/2 psi	

Other sizes on request

Design, specifications and measurements subject to change

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Müller Martini Marketing AG

Untere Brühlstrasse 13
CH-4800 Zofingen, Schweiz

Phone ++41-62-745 45 75

Fax ++41-62-751 55 50

E-mail info@mullermartini.com

Internet <http://www.mullermartini.com>