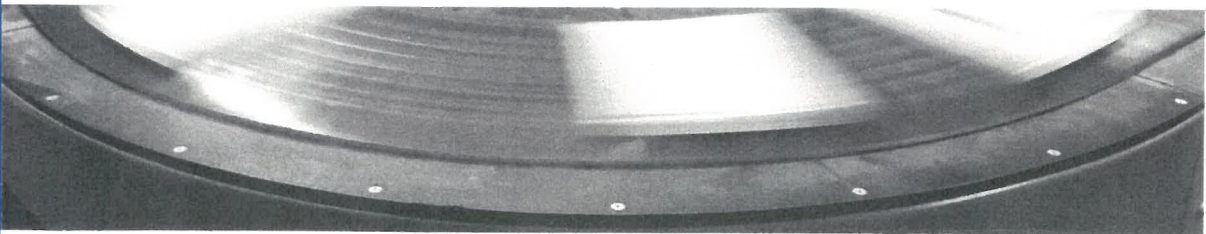


Adhesive Binder Master 6501

wohlenberg

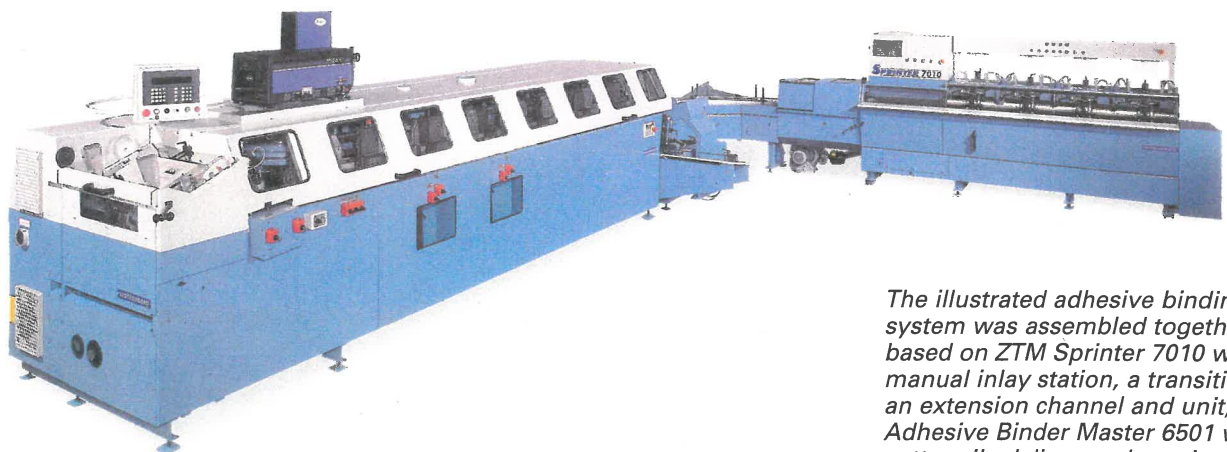
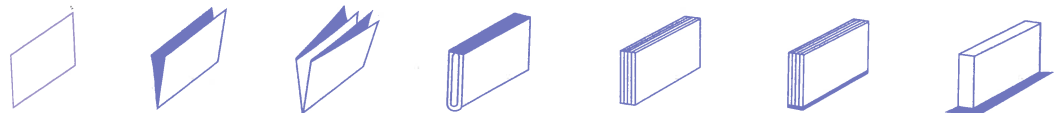


The inventors of perfect binding.

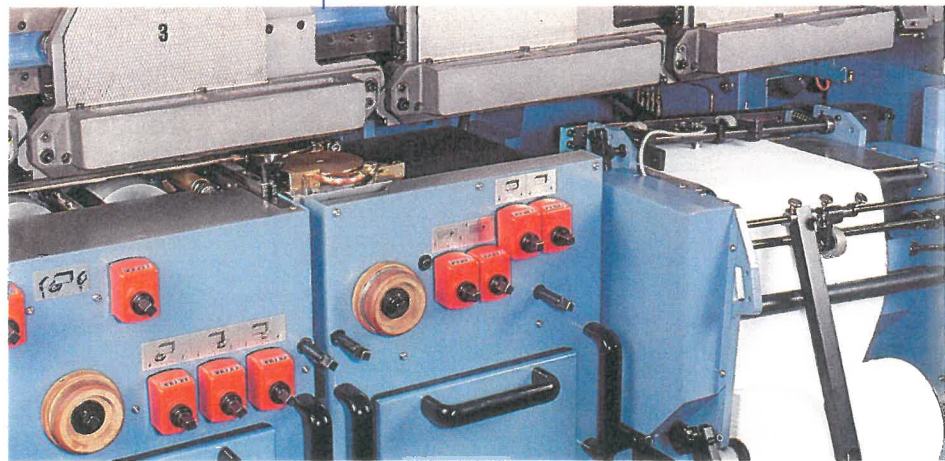
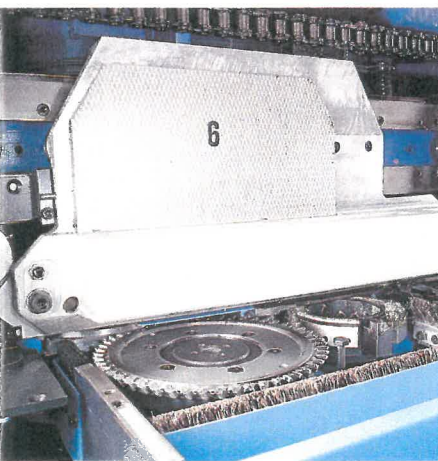
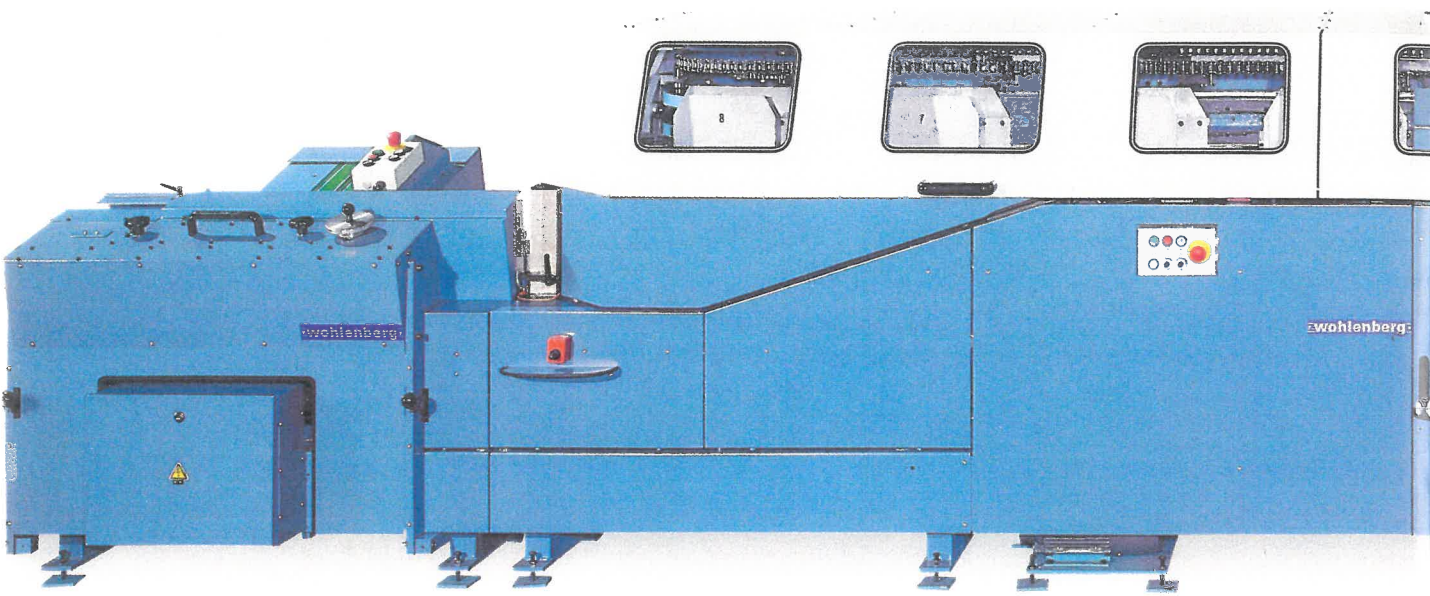
Swiss Brochure, Otabind...

Master 6501 is a universal adhesive binder with **cold-setting adhesive, hot-melt and polyurethane equipment** for manufacturing brochures and book sheets.

It impresses by its **short set-up times** and offers so, the ideal prerequisites for cost effective processing of short runs as well. Master 6501 can be delivered as a **single unit machine** or as an **inline-adhesive binder**. The secret lies in the **arrangement** of the working stations for brochures and book block manufacturing in combination with binding techniques such as Swiss brochure, Otabinding or Eurobinding brochures. Its **modular design concept** makes it flexible and enables specified adaptation to customer specific demands as well as to the subsequent expansion with respective processing modules. Thus, Master 6501 is **the most universal adhesive binder** in its performance class. Central piece of the adhesive binder is the coated **clamping carriage system** with central adjustment from 0-90 mm, ball-bearing mounted double guides, a refined unlocking mechanism for easy opening of clamping carriage and possibility of setting the product protrusion from 8-15 mm. The **gluing unit system** of the Master 6501, with its **mobile gluing units** enables exchange in just a few minutes. The amply dimensioned hingable safety covers provide a high **safety standard** by optimum **operating comfort**.

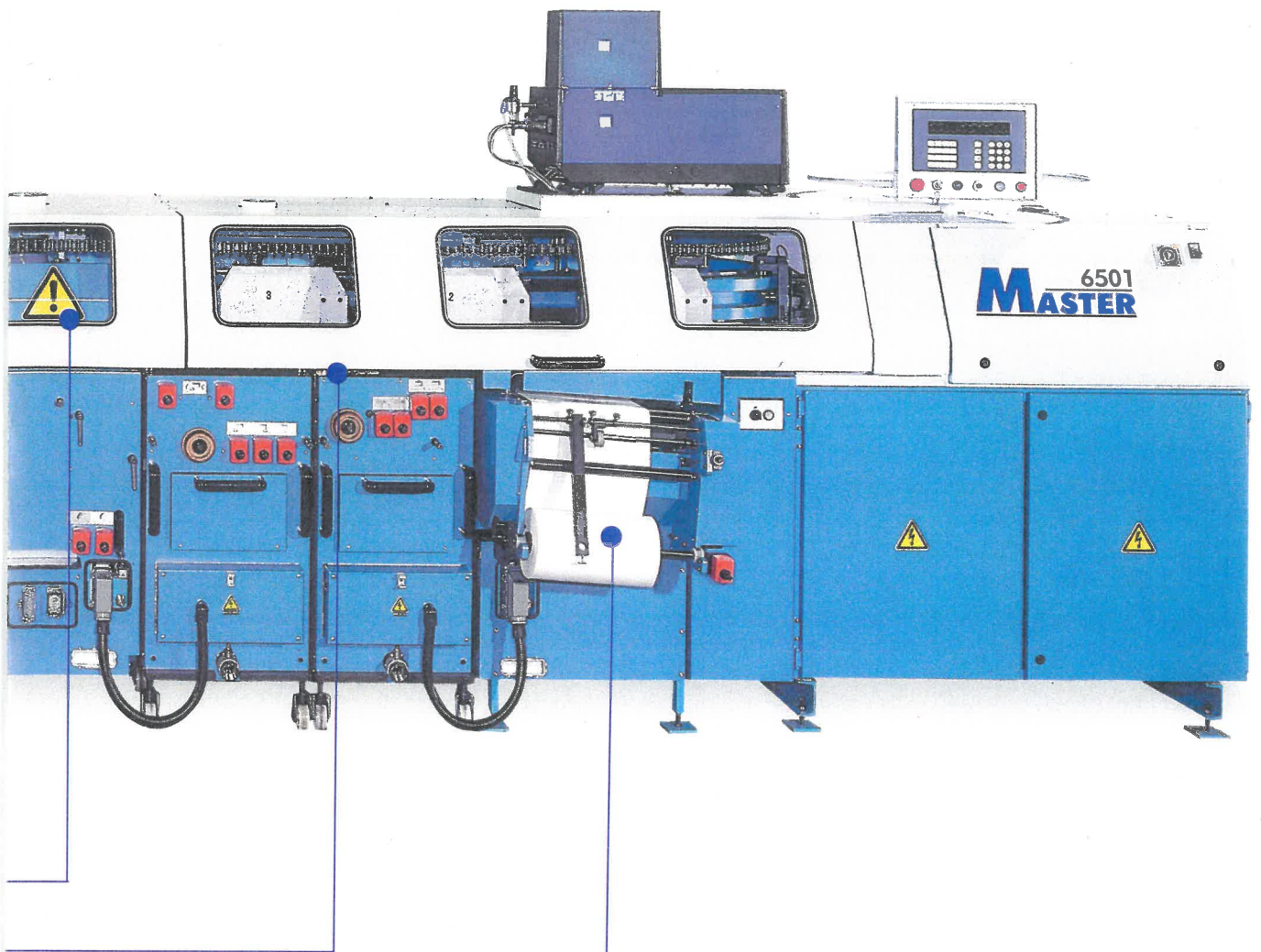


The illustrated adhesive binding system was assembled together, based on ZTM Sprinter 7010 with a manual inlay station, a transition unit, an extension channel and unit; Adhesive Binder Master 6501 with a cutter pile delivery, a lowering device, diverse transition and acceleration belts, roller-guides and a three-knife cutter trim-tec 56 i. This system configuration with a capacity of 7000 T/h, and its precisely matched modules offers essential flexibility for the demands in industrial book binding.

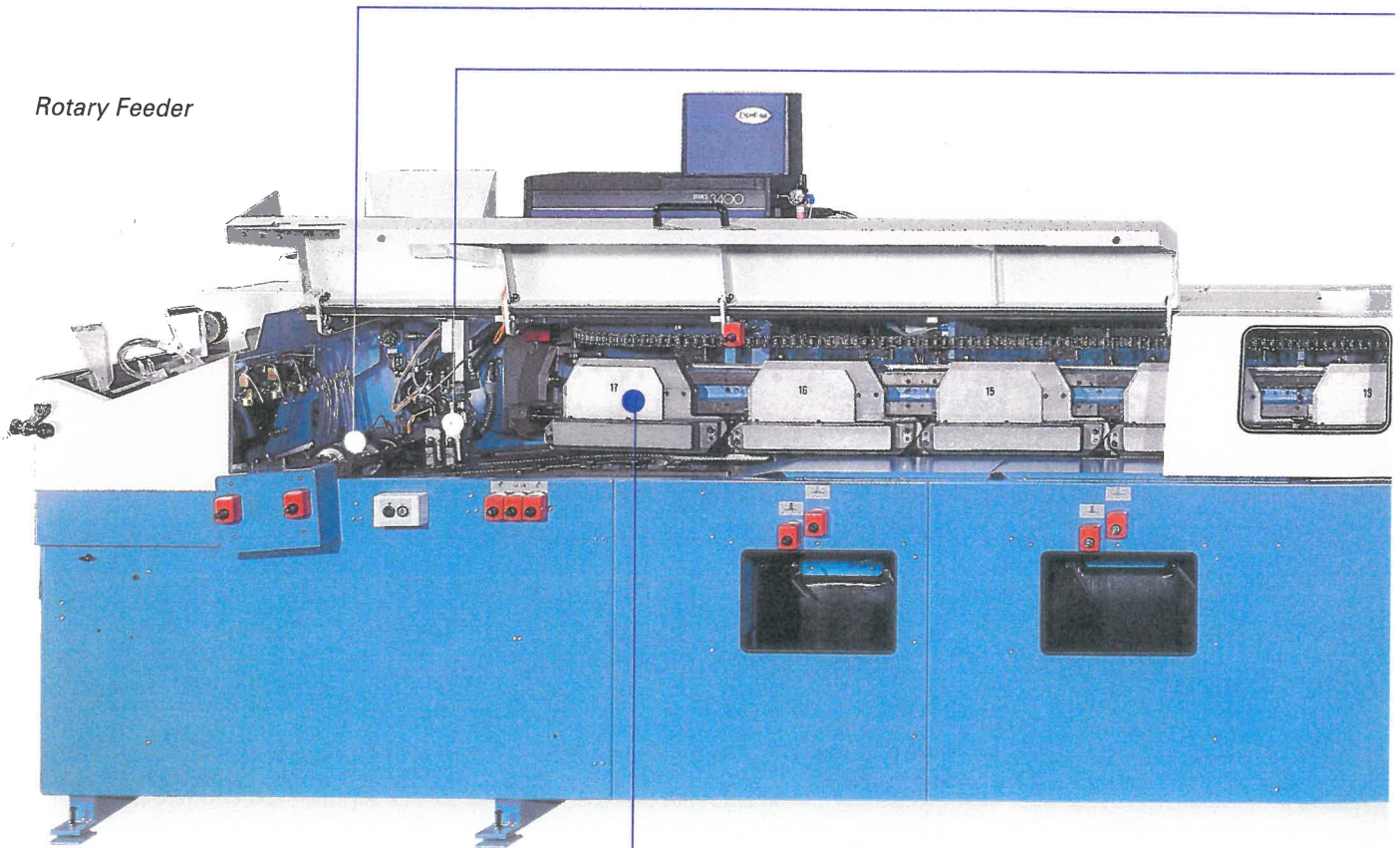


The Spine Preparation Station consists of a milling unit with 6.2 kW motor power rating, a centrally adjustable clamping rail for increasing the clamping pressure in the clamping carriage and a **combined notching, grinding and brushing station** with variable height adjustment. For thread-stitched products, the milling station can be lowered easily. For adaptation to different materials, there are options for **fine and rough milling**.

The separate mobile hot-melt side gluing unit with horizontal gluing discs and **scraper control** has an individual height and sheet-thickness adjustment device. The **patented premelter** that is integrated in both gluing units is fitted with a **minimum indicator** for the adhesive reservoir. **The gauging station** can be integrated onto the back of the Master 6501, without problems. A speed optimized feed system ensures accurate laying of gauging stripes even at high speed.



Rotary Feeder

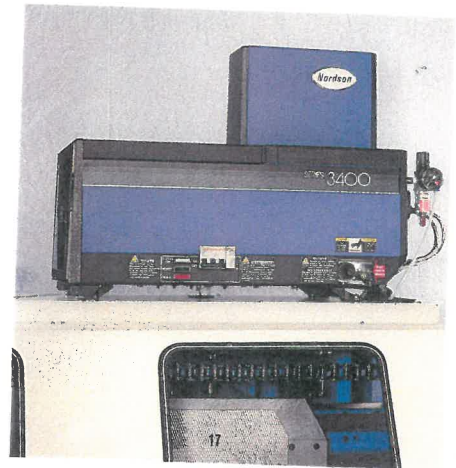


A **scoring device** for 2 and 4 grooves is fitted with a **central adjustment system** for the main and decorative grooves plus separate ancillary tools for adapting to heavy cover materials. The central adjustment for cover widths, parallel adjustment for cover stand and diagonal

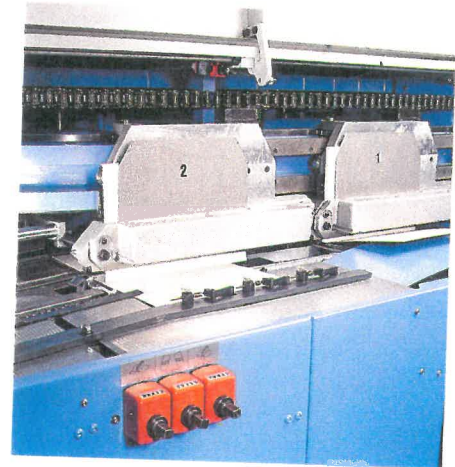
adjustment for fine adaptation in case of cutting and printing differences, enable the processing of the most diverse cover formats and materials. **The scoring tool** with 100 mm diameter ensures optimum forming of even the heaviest covering materials.



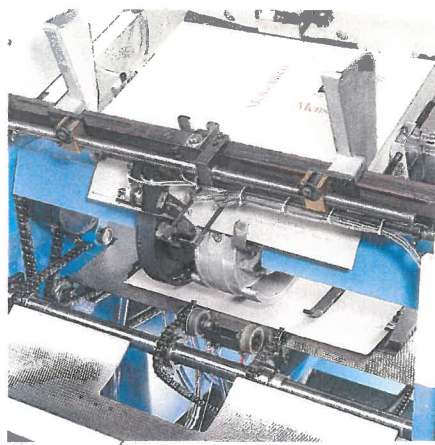
For processing Swiss brochures and **Eurobinding techniques**, an **upper gluing mechanism** is built adjacent to the creasing station, which enables the covers to be attached on to the overhanging flaps or gauze stripes (Lay-Flat-Binding) by means of electronic control of adhesive application via 1 or 2 nozzles.



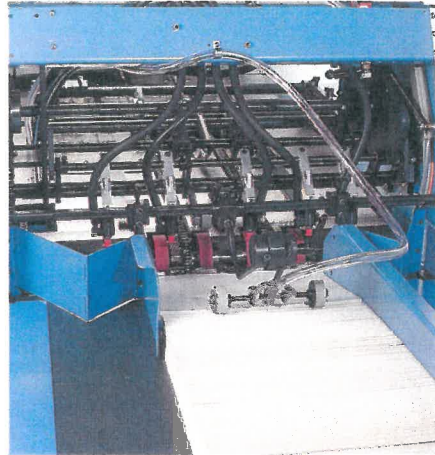
The press-on station caters for accurate arrangement and press-on of cover material even at high speeds. A combined **cam-controlled system**, which controls the vertical and longitudinal strokes ensures optimum operative smoothness. Arrangement ensues synchronously with the clamping carriage movement. Press-on time, thickness and heights can be individually set. Product-specific **forming tools** optimize book-sheet formation. A **second press-on station** can be installed if necessary.



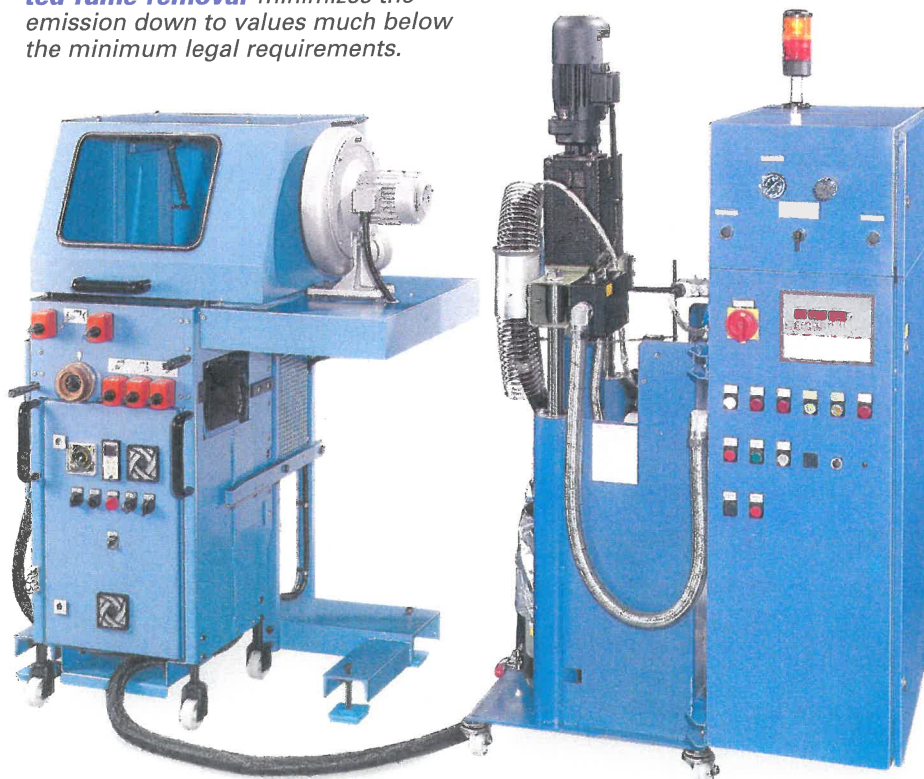
The Rotary Cover Feeder processes 4, 6, and 8-page covers of diverse quality. The face-up cover picture and the 20° inclination of the cover hopper enhance operating comfort. Proven elements such as pneumatic jets, picking devices and cam-controlled grippers transport the material carefully into the cover guidance.



The Stream Feeder offers, in the case of **shallower pile height**, a large pre-pile volume for covers and is especially applicable by very sensitive materials, long runs and high machine capacities



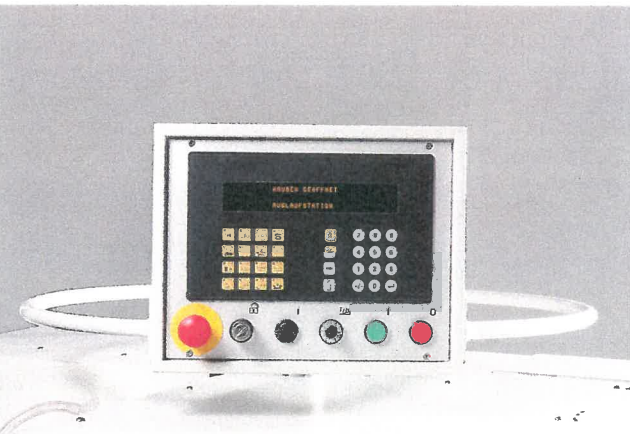
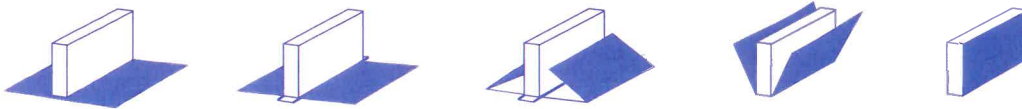
Cleaning Station. The **external** heat-up and cleaning station for **polyurethane gluing unit** accelerates the exchange of adhesives for the binder. By heating up the adhesive outside of the binder, the optimum working temperature is achieved prior to the application of the gluing unit and thus the set-up time between applications is shortened. Mechanized cleaning with **integrated fume removal** minimizes the emission down to values much below the minimum legal requirements.



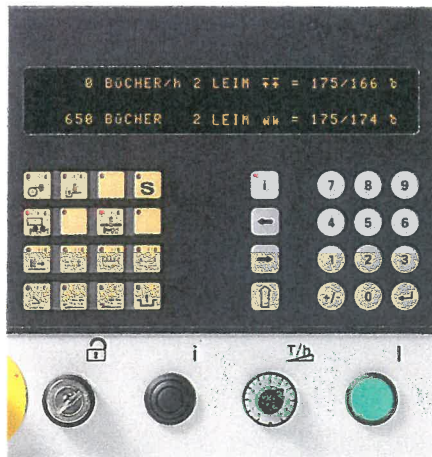
Systems for every Job.

**The answer to growing demands on adhesive binding:
A number of innovative solutions.**

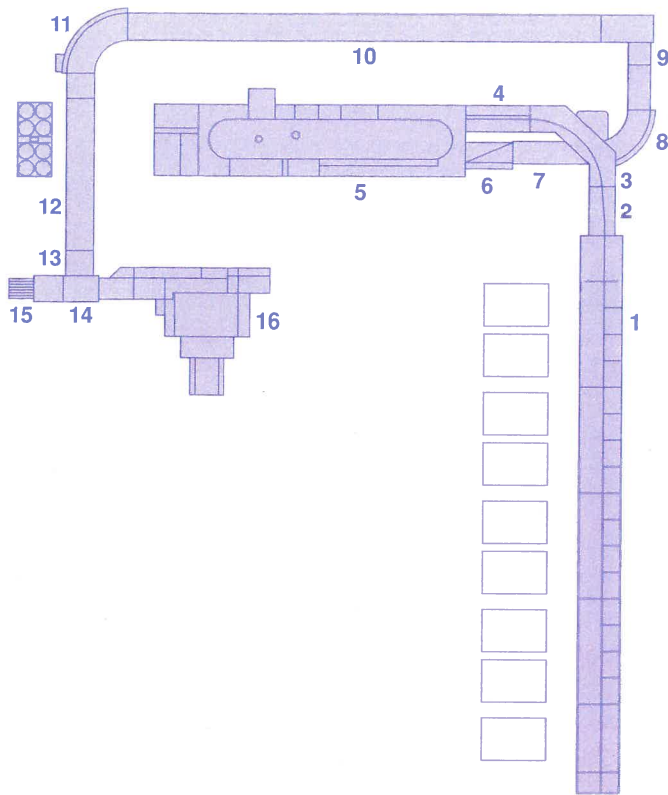
- PLC - Stored Program Control with error diagnosis terminal
- Quick adjustment possibilities through optimized actuators
- Feed-in station with optimized feed-in geometry in the clamping carriage
- Coated clamping carriage with 18 clamps and central adaptation for changing sheets thickness
- Spine processing with individual motor for fine and rough milling as well as a combined tool for notching, grinding and brushing
- Wohlenberg universal gluing unit for cold-setting adhesive, hot-melt and polyurethane operation with optimized glue application and a minimum of indicators
- Possibility of choice between rotary or stream feeder
- Alignment and press-on station, 100 mm traverse
- Delivery variations with through passage to a three-knife-trimmer



The PLC - control is fitted with a swivel control panel and prepared for electronic networking of machines and equipment (Profibus). Main motor is a maintenance-free frequency controlled **three-phase motor**. Machine position and book recognition are **program controlled**. With the command „gluing unit change“ e.g., the machine traverses automatically to the correct coupling position of different gluing units for cold-setting adhesive, hot-melt or polyurethane.



The diagnosis terminal is equipped with a multi-lingual **plain text display** incl. an info-key and an **advance warning system**. Influences which could lead to a machine standstill are indicated. All machine parameter can be invoked at any time.



Technical data

Mechanical capacity	1000 - 7000 T/h
Clamp opening	90 mm
Book overhang	min. 8 mm, max. 15 mm
Sheet feeder	Sheet 15° standing
Hopper length	900 mm
Manual feed station length	1238 mm
Manual feed station width	82 mm



Approved by GS and equipped according to CE-standard with inspection by a certifying authority.

Product types

Sheet-pile gluing for single sheets and layers
Book sheet-pile with fold or gauze
Brochure with 4, 6, and 8-paged cover
Folding and hanging of 3. cover page with 4, 6, and 8-page covers (in 2 passages)
Lay Flat (in 1 passage)

Covers

Cover weight

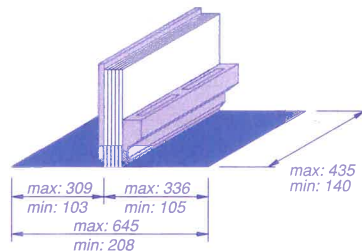
Cold-setting adhesive: up to 320 g/m ²
Hot-melt: up to 400 g/m ²
Polyurethane: up to 320 g/m ²

Gauze and Folding stripes

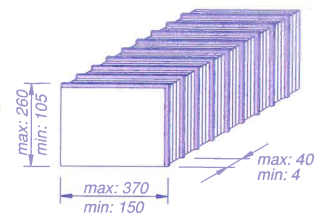
Breadth: min. 16 mm/max. 92 mm
Length: min. 140 mm/max. 430 mm

- 1 Assembling Machine Sprinter 7010 with a manual feed station
- 2 Transfer
- 3 Curve 90°
- 4 Extension unit
- 5 Adhesive Binder Master 6501
- 6 Lowering device
- 7 Transport belt
- 8 Curve with fly leaf
- 9 Acceleration belt
- 10 Transport belt with fly leaf belt and delivery station
- 11 Curve with fly leaf
- 12 Transport belt
- 13 Acceleration belt
- 14 Transport belt, reversible
- 15 Roller guides
- 16 Three-knife cutter trim-tec 56 i

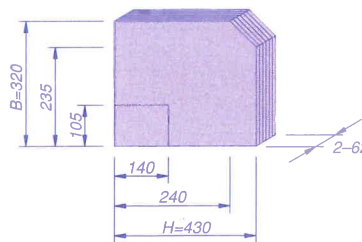
Formats	
Height	Breadth
240	320
250	310
260	300
270	295
280	275
290	270
300	260
310	258
320	255
330	252
340	248
350	245
360	243
370	240
380	235
390	235
400	235
410	235
420	235
430	235



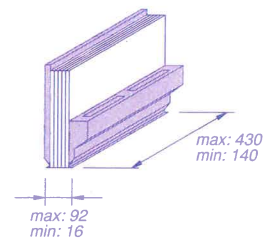
Cover formats and flap lengths



Book sheet feeder formats



With small format device:
H=105, B=75



Gauze stripes formats
(Other formats on request)

System expansions

- Speed increase to 7000 cycles
- Machine extension by 4 clamps
- Manual feed for 2 people
- Transition of ZTM in straight line
- Transition of ZTM with 90° curve, left-ward or right-ward swivel option
- 180° curve, right-ward swivel option
- Sheet feeder
- Hot-melt spine gluing unit with integrated premelter
- Cold-setting adhesive spine gluing unit with an integrated pneumatic pump
- Polyurethane spine gluing unit with a tank melting equipment
- Polyurethane cleaning unit
- Hot-melt page-gluing unit with integrated premelter
- Cold-setting adhesive side-gluing unit with integrated pneumatic pump
- Rotary cover feeder
- Stream feeder
- Gauze station
- 2. Press-on station
- Plate chain conveyor, long or short
- Cutter pile feeder with passage to the lowering device
- Lay down for connection to a Wohlenberg three-knife cutter
- Additional scoring tools
- Frequency control for constant notching distances
- Small format outfit 75 x 105 mm
- Large text display

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wohlenberg

The inventors of the perfect binding.

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