

Finishing
systems

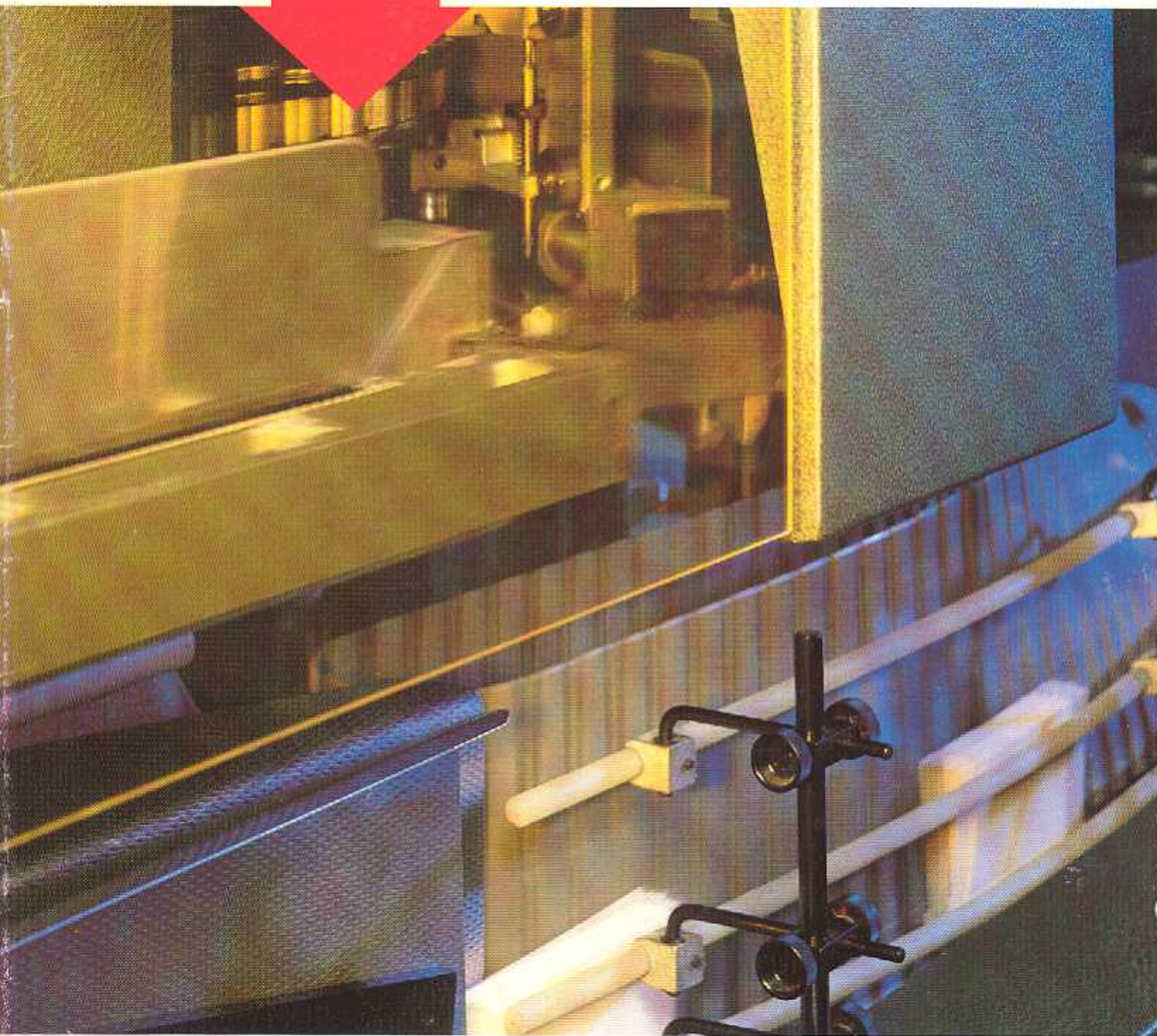
Perfect binding

Saddle stitching

Business forms
printing presses

Mailroom
systems

Electronics



**Modular Binders NB-E and NB-S –
The most versatile modular system for
adhesive binding, offering unparalleled advantages**

MÜLLER MARTINI

MÜLLER MARTINI – for superior binding and trimming quality



MÜLLER MARTINI adhesive binding lines from a single source

The versatility to combine a full range of gathering machines, adhesive binders, transfer units, trimmers, counter stackers and other finishing machines makes it possible to tailor production lines to the exact needs of the user.

Modular design of all components – as its name suggests – is a key feature of the binder itself. The entire line can be adapted to suit the widest possible range of applications. High productivity, superior

binding quality, quick changeover capability and ease of operation are built into every MÜLLER MARTINI adhesive binding line. The knowledge gained through decades of experience coupled with single source responsibility ensure competent service and support to our customers.

Modular Binder NB-E and NB-S

Wide range of applications

Modular Binders NB-E and NB-S are designed to meet the requirements of binderies with a broad range of work. Brochures, magazines, catalogues, telephone directories, pocket books and lined book blocks have been produced economically on these machines for many years, using either hotmelt or cold emulsion adhesive.

Any Modular Binder can be expanded economically to meet changing requirements.

The basic design concept

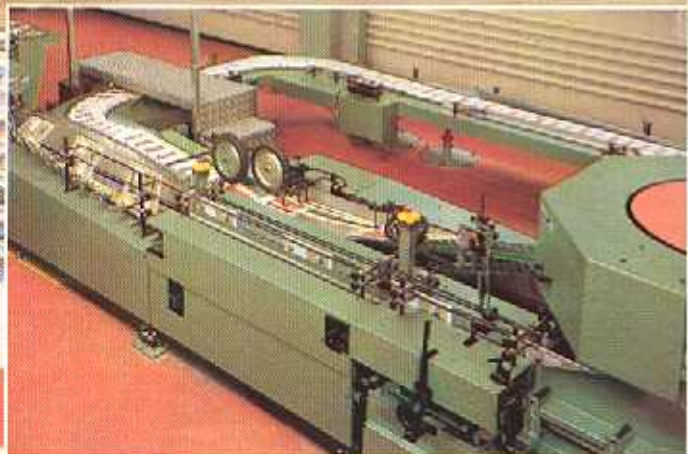
- standard modules with 5 or 8 clamps
- Modular Binders NB-1E to NB-7S with 15-45 clamps
- heavy-duty, parallel closing clamp system
- high performance stream cover feeder
- «on-the-fly» nipping
- laydown device for gentle handling of products

Operating convenience

- low-silhouette for convenient operation
- height adjustable work stations for both soft cover books and book blocks.
- externally adjustable roughening heads
- rail mounted glue pots and side gluers
- automatic glue level control
- quick changeover of crash feeder
- hinged, electrically interlocked covers, padded to reduce noise level

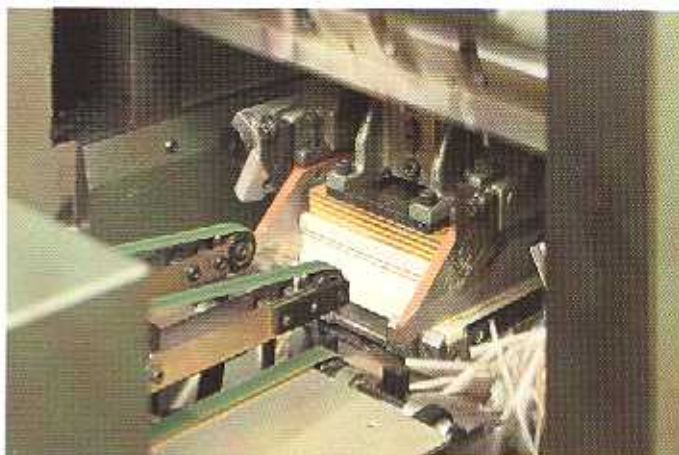
Optional features

- digital readouts to allow repeat settings on work stations
- DC drive for uniform notching regardless of binder speed
- crash feeder
- side gluing units with cam controlled doctor blades for glue control
- intermediate infra-red or gas dryers and high frequency final drying



High performance three-knife trimmer

Neat, square 3-sided trimming makes an important contribution to the quality of an adhesive bound or sewn product. The high performance Model 3670 3-Knife Trimmer trims books against cutting sticks in single or collect mode. Front, head and tail trimming in a single station at constant speed results in exceptionally high trim accuracy. Automatic knife control prevents the knives from contacting the cutting sticks when no book is present, thus increasing knife life significantly. Offering a unique combination of quality and performance, the Trimmer 3670 is the best choice to complete a modern adhesive binding line.



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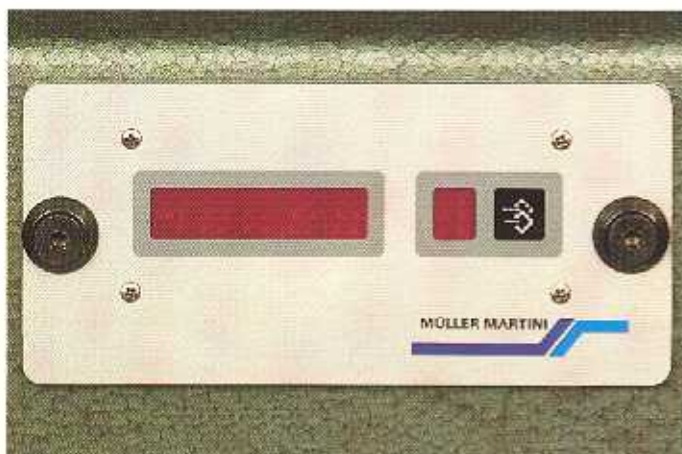
Digital makeready system with displays reduces changeover time



The Modular Binder series E and S offer unmatched versatility, based on an ingenious building block principle which allows for expansion and changes in its configuration at any time. Fast makeready is an overriding consideration with today's product mix. High productivity – quick makeready to reduce downtime between jobs.

The MÜLLER MARTINI digital makeready system reduces the time required for changeover and fine adjustment at individual work stations. The height of the levelling shelf and all backbone preparation, gluing and pressing stations are individually adjustable. Digital readouts indicate the actual heights which have been set, either in absolute terms or with respect to the milled spine. The readings of a particular job can be recorded and then reproduced when the job is repeated. The various stations are accurately set to the respective readings before production starts.

The result is greatly reduced changeover time, less waste and more consistent binding quality. The MÜLLER MARTINI digital makeready system with displays is an optional accessory which can significantly contribute to productivity.



Digital readout of height settings on the milling and notching station of a Modular Binder NB-S.

**heavy-duty,
dependable construction**

**Gathering machines
Models 210 and 256**



The reliability of the gathering machine determines productivity of the entire line. MÜLLER MARTINI gathering machines handle single sheets, 4 page sections, cross-folded and three-side-open sections efficiently.

MÜLLER MARTINI builds four different types of gathering machines to fulfill today's production requirements and conditions. Simple, easily accessible design and non-stop rotary movements guarantee continuous, dependable operation.

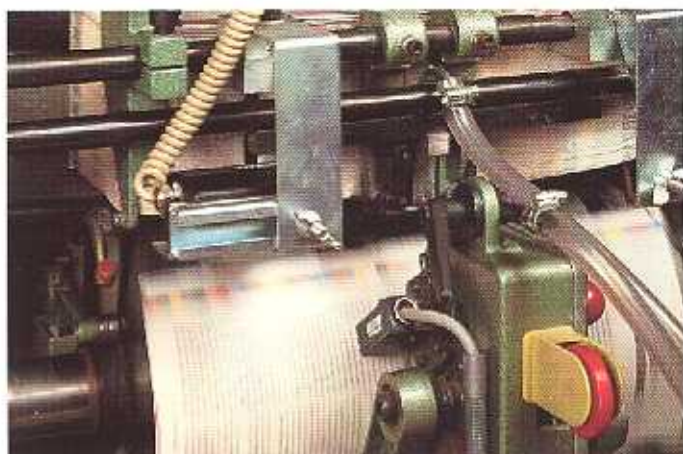
Modular design allows easy expansion of the gathering machine.

Reliable gathering

High output is achieved, even with single sheets and light stock, as a result of the following features:

- computer design cams of the feeder drums and the rotary gripper system
- blast air assisted separation

- wide support drums and guide rollers for positive control of sections
- oscillating trays for gentle acceleration
- air cushion in the gathering track to reduce friction
- mechanical misfeed and double sheet detectors with warning lights for highest possible reliability
- low-silhouette design of all gathering machines for convenient loading from either side without need for platforms.



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Efficient, space-saving design

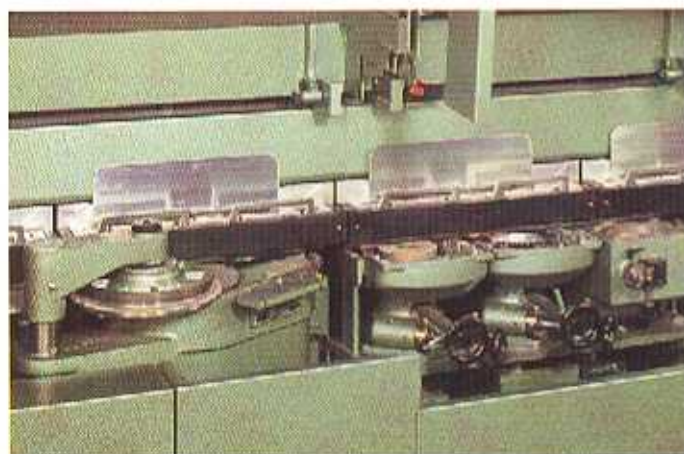


Inclined infeed with joggling shelf

A properly joggled book block is essential for high quality finishing. Efficient joggers in the inclined infeed ensure that all types of signatures, even the very lightest, are accurately joggled against the chain pin before they enter the clamp. This key advantage is only found in MÜLLER MARTINI binding lines.

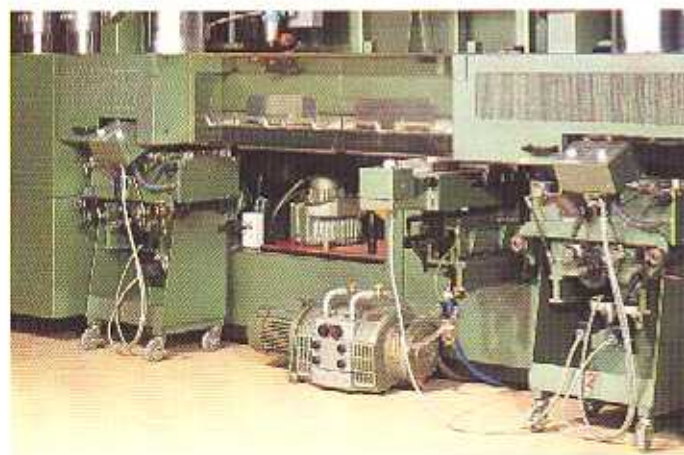
Heavy-duty clamp system

The patented clamp closing system guarantees that book blocks are held securely throughout the binding operation. From infeed to delivery, the book block is gripped by the same parallel closing clamp. Pressing discs apply additional pressure over the full length of the book as it passes over the milling station. This assures uniform spine preparation and even glue application.



Versatile backbone preparation

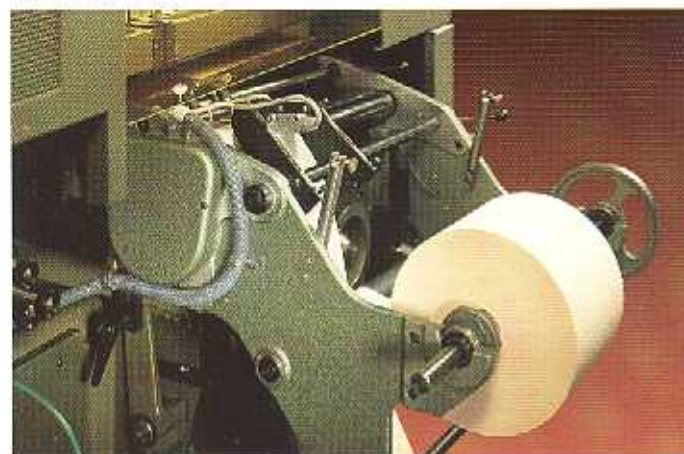
Excellent backbone preparation is required to produce a book of high binding quality. In addition to the standard milling station, extra roughening spindles can be incorporated. Tools for these roughening spindles are interchangeable and are designed for levelling, sanding, notching, and brushing. They can be selected depending on type of paper stock or backbone preparation desired.



Rail mounted glue stations

Glue stations are mounted on rails for easy access and are interchangeable. Glue stations are available for hotmelt, cold emulsion, and animal glue. They can be used in various combinations or for multiple glue applications, depending on the desired result. The automatic hotmelt glue level control replenishes adhesive in small amounts as needed.

In addition to spine gluing, side-gluing stations for use with hotmelt or cold emulsion glue can be added.



Accurate crash feeding

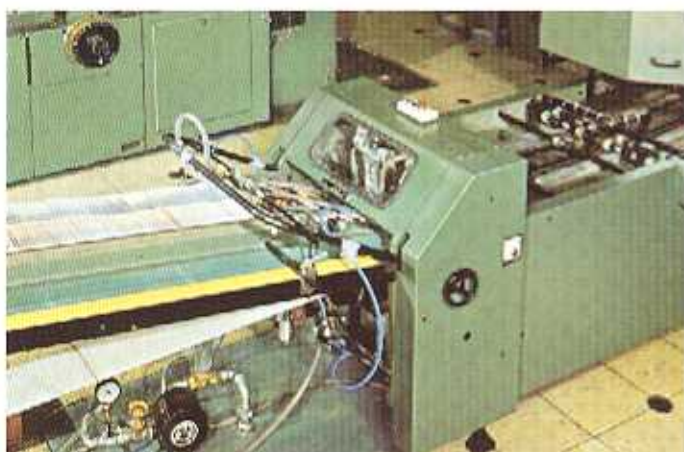
The crash feeder can be used for crash or other back lining material. The material is advanced smoothly and precisely under positive control. The feeder is equipped with swingout lateral trimming knives, knurled draw roller and quickchange vacuum table. Vacuum and air blast control is standard and ensures reliable feeding, even at maximum binder speed.

Modular Binder NB-E and NB-S



The versatile S-type cover feeder

Modular binders of the E- and S-series are available with the proven, versatile S Type cover feeder which allows continuous loading while the machine is running. The feeder is designed for quick changeover. Covers are separated automatically, scored one to six times and precisely aligned before entering the nipping station, where they are firmly pressed against the spine of the book block.



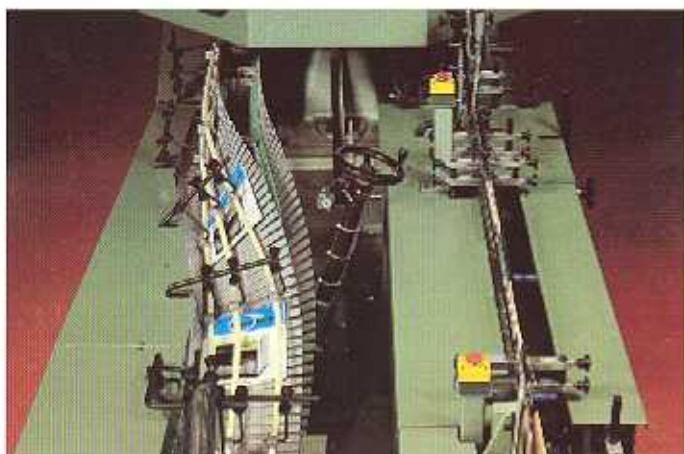
The SF-type stream cover feeder for continuous operation

The new, advanced design uses a precision operating principle and a feeder table placed at an incline to assure continuous, high-speed operation. These features permit efficient running with all types of covers. The cover feeder is equipped with an automatic advance and cover infeed, centering guides, detectors to monitor the feeding of critical light covers, 4-line scoring which is adjustable on the fly, an overload clutch and a pressure/vacuum pump. The protective cover of the feeding mechanism has see-through windows for easy supervision.



In-line high frequency dryer

High frequency drying makes in-line trimming possible when using cold emulsion glue. The combination of a newly designed electrode table and longer dwell time results in efficient drying. The subsequent rub-down roller and second pressing station are important features for achieving superior binding quality. Following a cooling and drying time of 3-4 minutes, emulsion-bound products can be trimmed in-line - allowing economical finishing of this type of product.



Positive Laydown

The laydown of the Modular Binder series E and S is suitable for all types of books and binding methods. Gentle handling of the product without marking. A packer box delivery is available for binders with no drying capability, for cold emulsion bound books which cannot be trimmed in-line.

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From adhesive binder to complete finishing line



Separate gathering and binding

By adding a criss-cross delivery and a feeder for pregathered book blocks, the gathering machine and the modular binder can operate independently of each other.

● Criss-cross delivery for gathering only

Using the criss-cross delivery (left side of picture), loose book blocks from the gathering machine are delivered staggered on their spines.

● Book block feeder for pregathered book blocks

The Book Block Feeder 3606 (right side of picture) is placed in the transfer after the criss-cross delivery. Thread-sewn book blocks are fed into the top loading/bottom feeding, easily adjustable hopper and transferred to the Modular Binder.



Professional in-line endsheet tipping

The endsheet tipping machine can be installed in the transfer of the Modular binding line before the criss-cross delivery or after the book block feeder.

An even strip of hotmelt or cold emulsion glue is applied to the book block by side gluing. Endsheets are pressed firmly against the first and last sections. Applying glue to the side rather than the spine of the book block is an exclusive MÜLLER MARTINI feature which assures that endsheets remain permanently attached.



Three-knife trimmer with automatic knife control

Products to be trimmed are fed into the hopper of the three knife trimmer automatically. A photocell control ensures constant stack height. Products are advanced to the trimming station under positive control. Pusher fingers register the spines against front stops and the product is laterally aligned. The patented trimming system enables face, head and foot trimming to be done in the same station. This is essential for highest trim accuracy.

After the face cut is made, the hinged front knife is moved a few millimeters away from the head and foot knives so that the head and foot cut can take place earlier – an important advantage for high speed and smooth running. If no book is present, the trimmer continues to run at full speed – with the control system preventing contact between the knives and the cutting sticks.



PrintStack CB-15 Compensating Counter Stacker

The PrintStack CB-15 handles a wide range of product thicknesses. Its main features are:

- heavy-duty construction (for thick products and 3-shift operation)
- adjustable infeed height
- wrenchless makeready
- microprocessor control with diagnostic capability and display
- electrically interlocked covers with large see-through windows

The PrintStack CB-15 is the most advanced delivery system for modern adhesive binding lines.

Drying and cooling section



Modular conveyor system

Modular transfer system

MÜLLER MARTINI has the experience needed to lay out a transfer system with proper cooling and drying times.

- The lengths of conveyors and telescopic belts are in multiples of 0.6 m (24")
- Each belt is independently driven by a DC motor
- Height adjustable and/or on casters
- Can be equipped with hinged gates
- 90° or 180° Rex chain power turns with DC drive

Space-efficient drying and cooling section

Depending on the machine configuration and available space, products up to 20 mm (¾") thick can be shingled and cooled on space-saving «double-decker» conveyors. This results in considerably longer overall cooling and drying time to enhance binding quality in subsequent finishing stages.

Automatic Diverter 3621

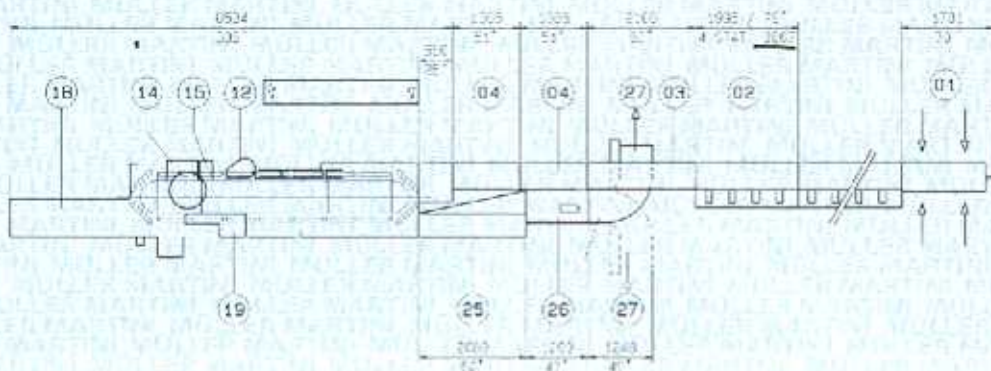
The programmable Diverter 3621 splits production into two trimming lines, determined by product type or available trimming capacity.

Escape delivery

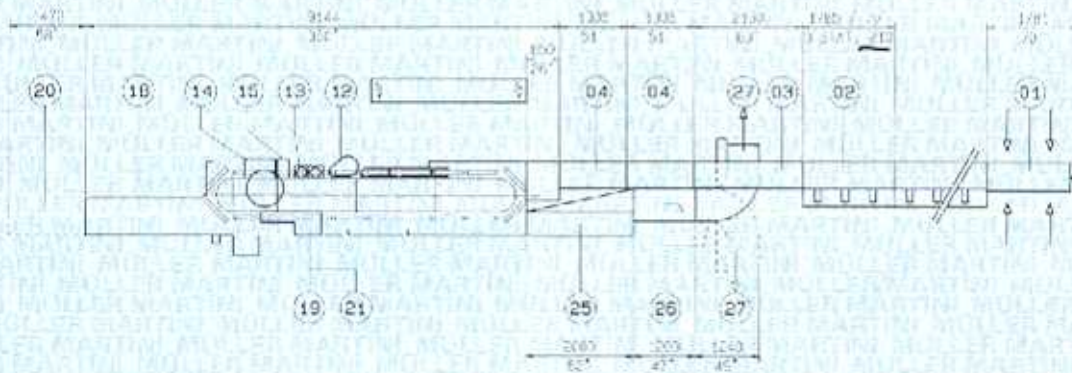
To take full advantage of the production potential of an automatic adhesive binding line, an escape delivery should be located before every three-knife trimmer or splitting saw so that binding line production is not affected by stops of subsequent finishing machines. Diverted products are automatically shingled on an escape delivery belt. The diverter is reset manually and products can be re-fed into the line manually during a break in production.

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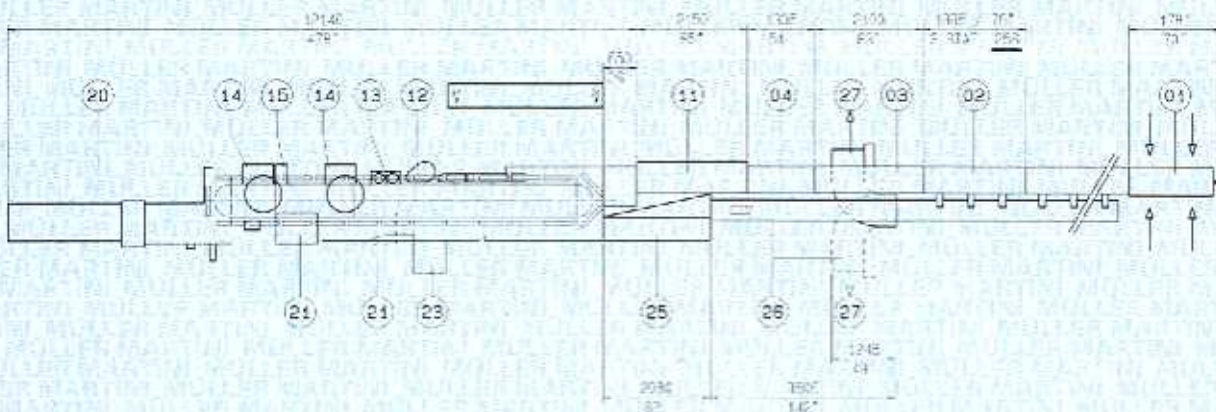
High performance Modular Binder for one or two-shot hotmelt binding with a maximum speed of 10000 cph and with in-li



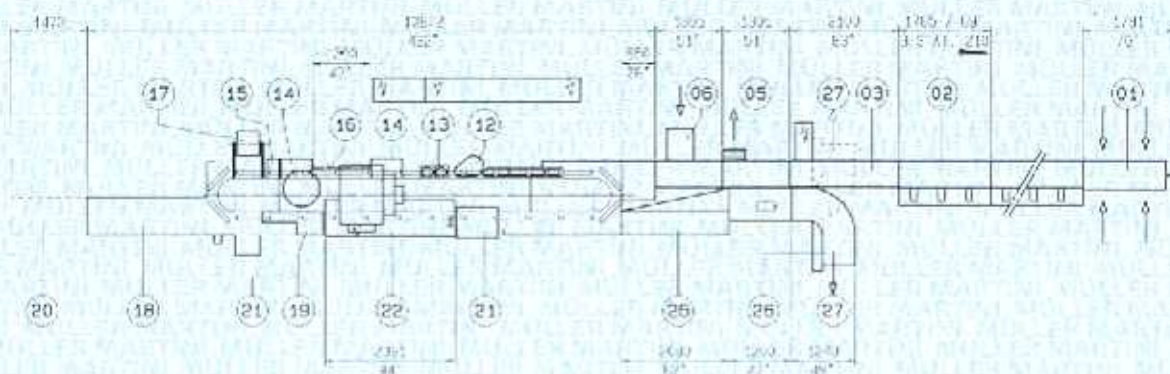
Modular 18-clamp Binder NB-1S



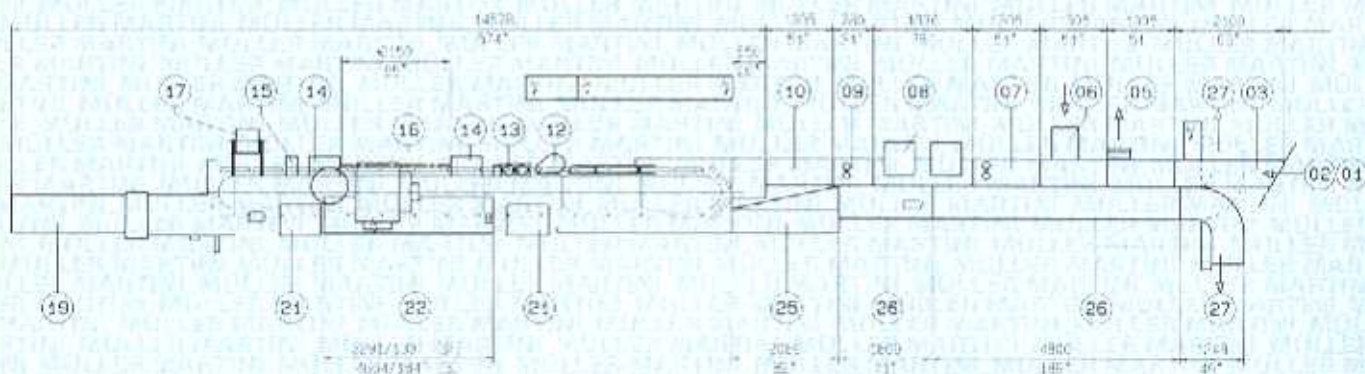
Modular 20-clamp Binder NB-2S



Modular 25-clamp Binder NB-3S (for two shot hotmelt binding)



Modular 26-clamp Binder NB-2E



Modular 33-clamp Binder NB-4S

- | | |
|-------------------------------------|--|
| 1 Manual feeding | 15 Cold emulsion or hotmelt side gluing unit |
| 2 Gathering machine | 16 Infra-red intermediate drying |
| 3 Spiral raceway | 17 Crash and lining station |
| 4 Jogger | 18 S-type stream cover feeder |
| 5 Criss-cross delivery | 19 S-type cover nipper |
| 6 Book block feeder | 20 SF-type stream cover feeder |
| 7 Endsheets tapper | 21 SF-type cover nipper |
| 8 Endsheets feeder | 22 High frequency drying (12 kW) |
| 9 Endsheets pressing station | 23 Packer box delivery |
| 10 Spacer | 24 Control panel |
| 11 Side Stitcher 3604 | 25 Delivery channel with Rex chain laydown |
| 12 Milling and fold pressing | 26 Conveyor belts |
| 13 Separate backbone preparation | 27 Finishing |
| 14 Cold emulsion or hotmelt station | |

Modular Binder NB-E and NB-S

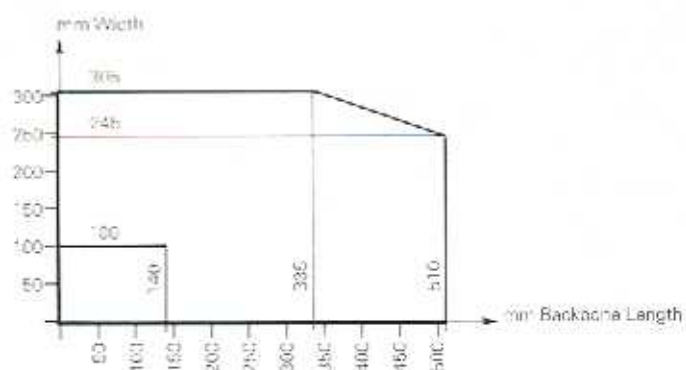
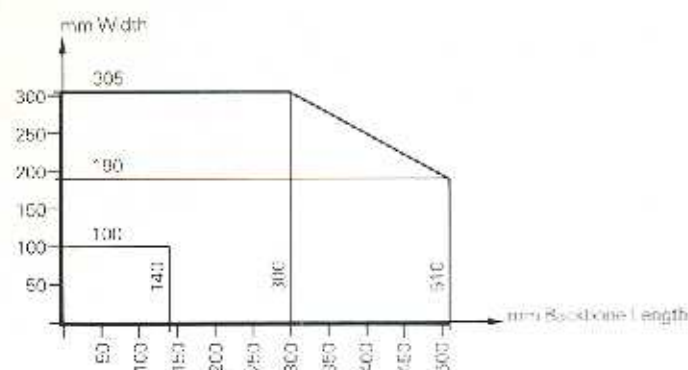
Specifications

1. Modular Binder	NB-E	NB-S
Maximum mechanical speed	6 000 cph	10 000 cph
Clamp pitch	24"	24"
Number of clamps	15-30	15-40
Central clamp adjustment	0-78 mm (108 mm) 0-3" (4 1/4")	0-78 mm (108 mm) 0-3" (4 1/4")
Spine length	max. 510 mm 20" min. 140 mm 5 1/2"	510 mm 20" 140 mm 5 1/2"
Book width	max. 305 mm 12" min. 100 mm 4"	305 mm 12" 100 mm 4"
Book thickness	60 mm 2 3/8" (70 mm) (2 3/4")	60 mm 2 3/8" (70 mm) (2 3/4")
Cover width (open)	max. 642 mm 25 1/4" min. 203 mm 8"	642 mm 25 1/4" 203 mm 8"

2. Gathering Machine	210-E	256-E	210-S	256-S	3667
Maximum mechanical speed	7 500 cph	7 500 cph	10 000 cph	10 000 cph	10 000 cph
Chain pitch	21"	24"	21"	24"	18"
Number of stations per element	3	3	3	3	4
Unit length	1 785 mm 70 1/4"	1 995 mm 78 1/2"	1 785 mm 70 1/4"	1 995 mm 78 1/2"	1 995 mm 78 1/2"
Raceway clearance	60 or 85 mm 2 3/8" / 3 3/8"	60 or 85 mm 2 3/8" / 3 3/8"	60 or 85 mm 2 3/8" / 3 3/8"	60 or 85 mm 2 3/8" / 3 3/8"	60 or 85 mm 2 3/8" / 3 3/8"
Spine length	max. 450 mm 17 3/4" min. 140 mm 5 1/2"	510 mm 20" 140 mm 5 1/2"	450 mm 17 3/4" 140 mm 5 1/2"	510 mm 20" 140 mm 5 1/2"	380 mm 14 3/4" 140 mm 5 1/2"
Section width	max. 305 mm 12" min. 100 mm 4"	305 mm 12" 100 mm 4"	305 mm 12" 100 mm 4"	305 mm 12" 100 mm 4"	305 mm 12" 100 mm 4"
Small size kit	min. 70 mm 2 3/4"	70 mm 2 3/4"	-	-	-

Other sizes on request.
Design, specification and measurements subject to change.

Thickness



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