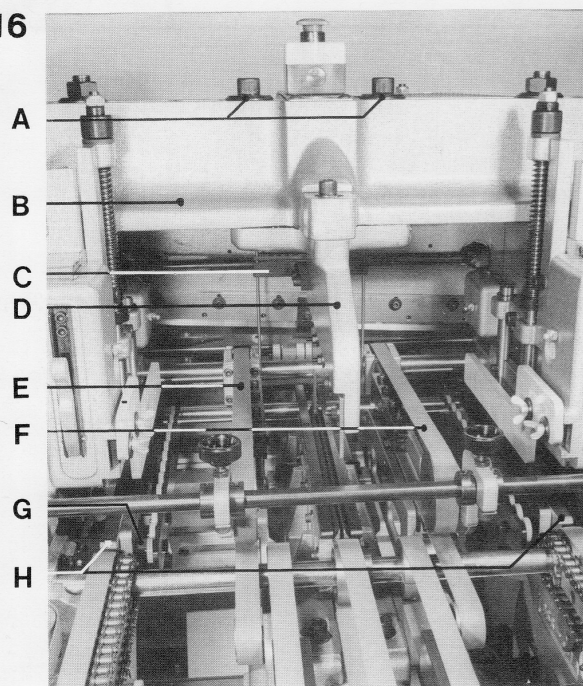
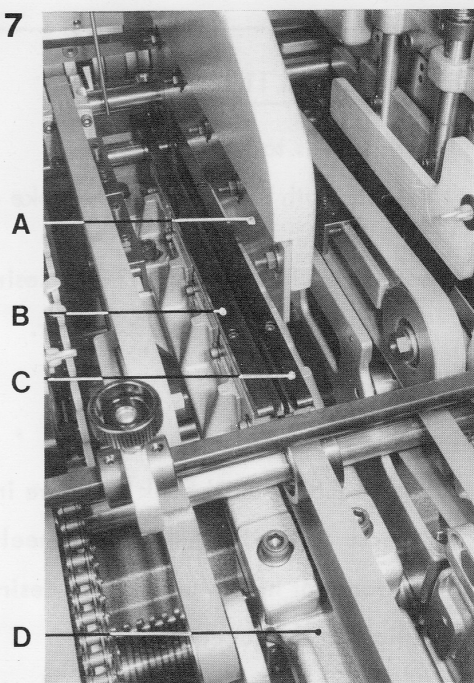


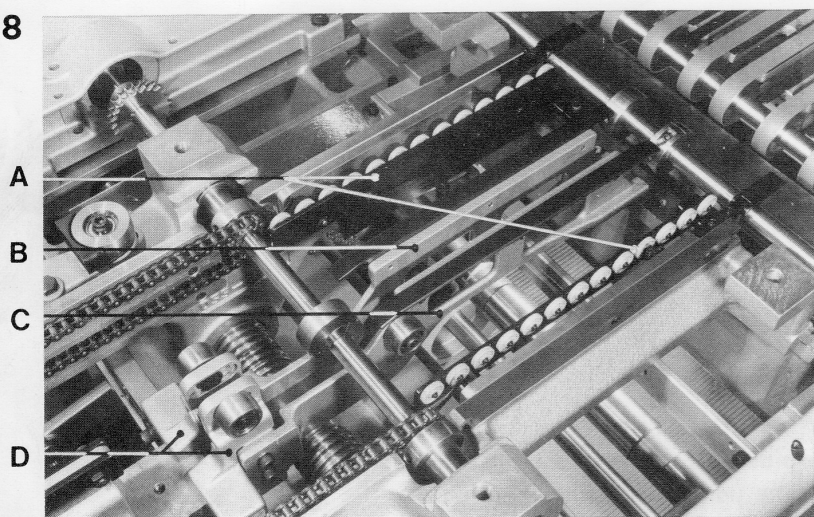
16



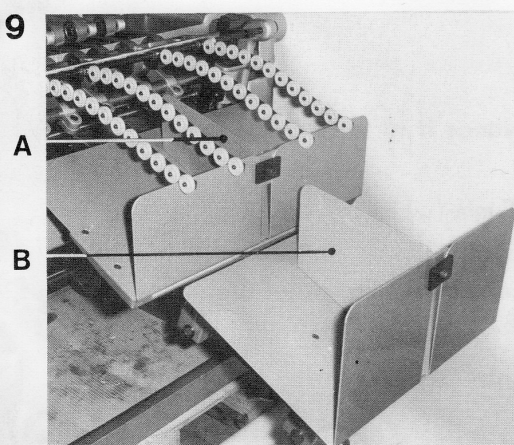
17



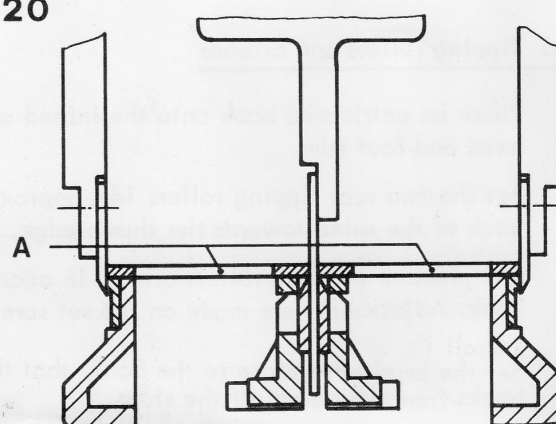
18

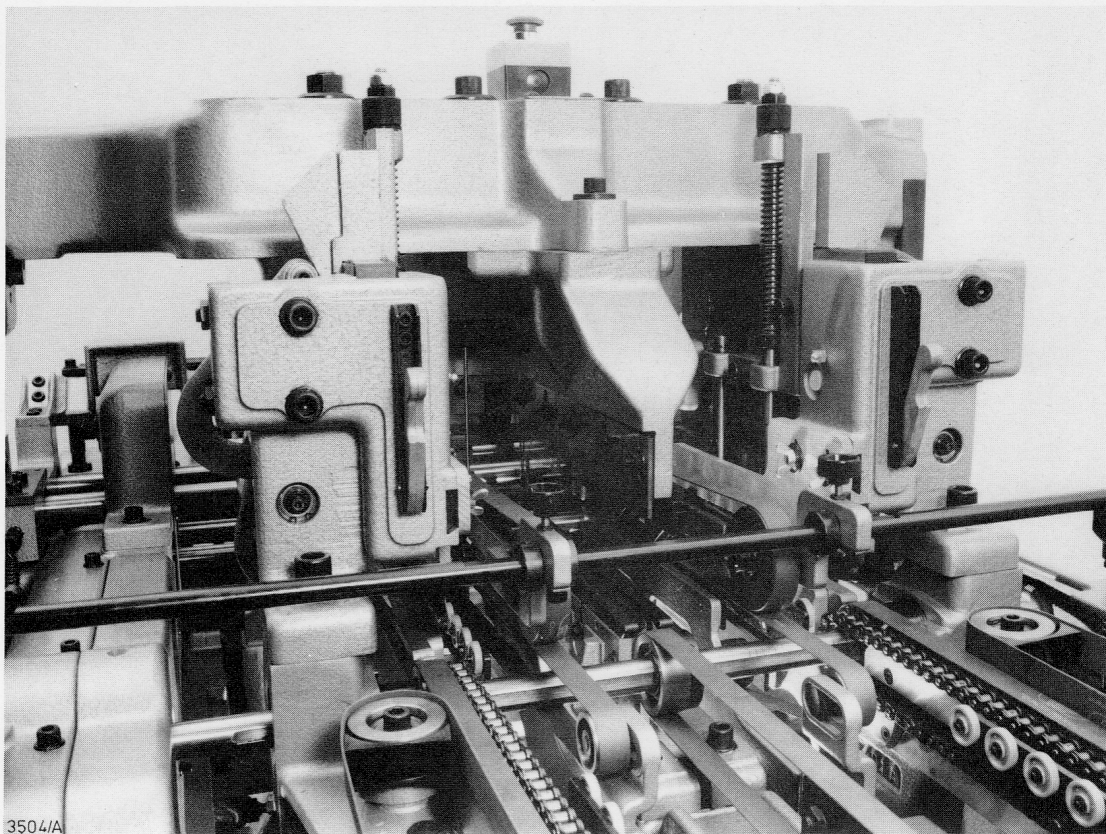


19



20





890.2609.1

890.2643.4

890.2661.4

890.2661.4

890.2688.4

031.0755

890.2691.4

890.2690.4

890.2686.4

890.2606.2

890.2662.2

890.2610.4

890.4304.3

890.2605.1

890.2608.3

3442/B



## 6. 4TH AND 5TH KNIFE

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### 6.1 Installation of Punch cut

- The belt assemblies 16E and 16F, as well as the belt supports 18B and 18C are moved apart as necessary.
- Install center support 17D and align it to center line of trimmer.
- Mount the knife holders 17B and 17C including the fitted knives. Spread the holders and do not tighten the M12 screws.
- Install the upper knife holder 16D to the yoke 16B.
- Bolt the upper knife 17A to the holder 16D.
- Lower the yoke 16B carefully with handwheel 5D in its lowest position.
- Use the special gauge 20A to center and align the upper knife holder 16D to the side knives. Tighten the bolts of the holder (Fig. 20).
- Remove the gauge 20A.
- Set the bottom knives 17B and 17C against the upper knife 17A and now tighten the screws M12.
- Set head and foot trim (spine length) in accordance with item 5.1.
- Set belt assemblies 16E and 16F as well as the belt supports 18B and 18C to centers of the two book halves.
- Replace sensor rod 21C with shorter one for 4th and 5th knife.
- Install the sensor holder 16C.
- In case of a dual pocket delivery the two separation plates 19A and 19B must be installed.
- Check setting by cutting a sample in accordance with item 9.4.

### 6.2 Installation of split cut

Except for using only one bottom knife, all parts are installed as described in item 6.1.

### 6.3 Installation of special small size attachment 100 x 100 mm (4" x 4") for 4th and 5th knife

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- The bottom knife holders 17B and 17C are replaced with the special holders.
- The knives 16A for head and foot trim are replaced with the special knives.
- Remove belt supports 18B and 18C.
- The roller support 18D is exchanged with a special support.
- Instead of the roller bar 18A install the special belt support.
- The washers 16A are replaced with specially machined ones.
- Install the additional wider stops in the center of the front cut.