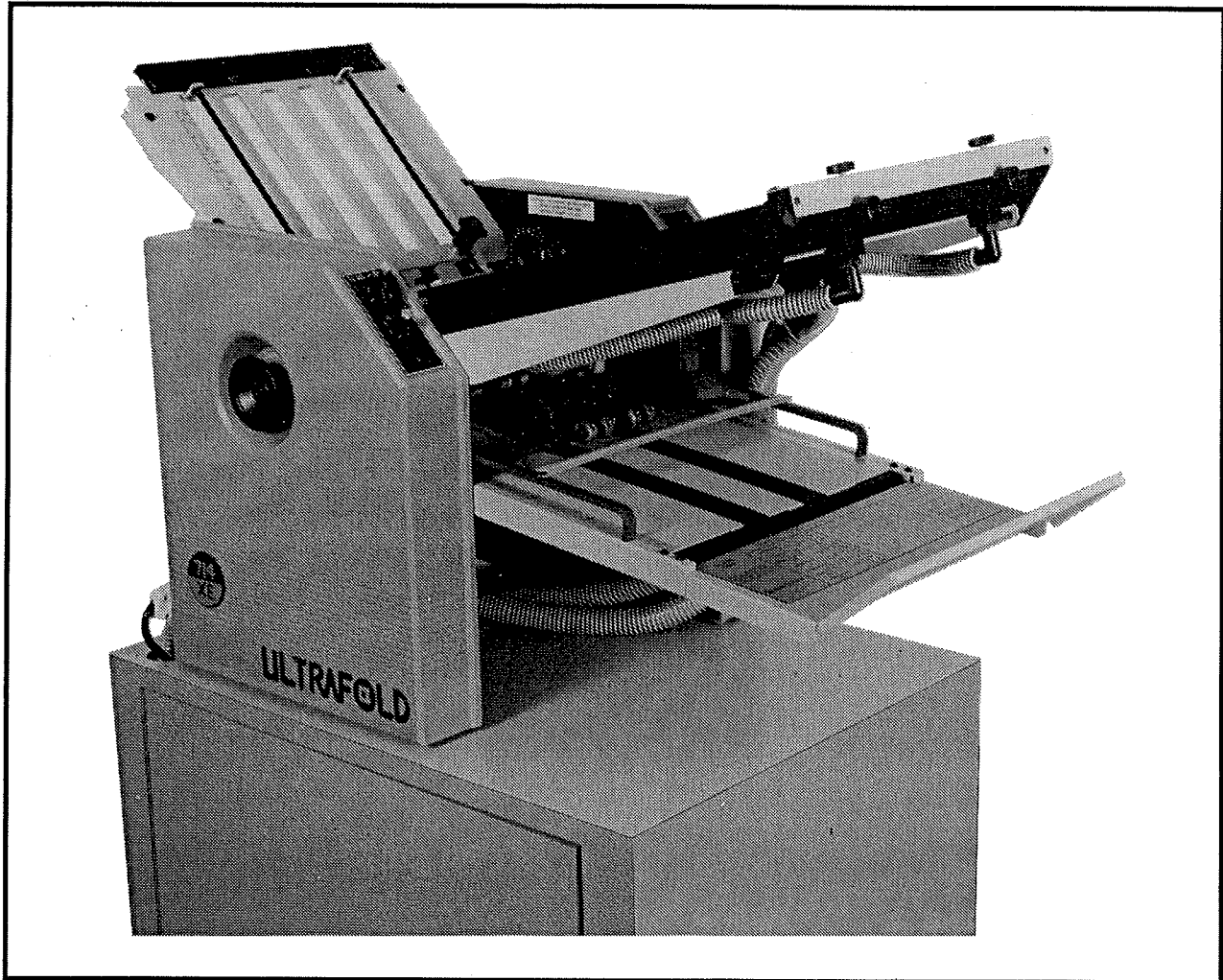


714XE ULTRAFOLD AIR FEED

INSTALLATION, OPERATION, MAINTENANCE & PARTS MANUAL



BAUMFOLDER
Corporation

World's Finest Bindery Equipment

1660 Campbell Road • Sidney, Ohio 45365
Phone: 513/492-1281 or 800/543-6107 • Fax: 513/492-7280



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WARNING

- Do not operate this machine without all guarding in place.
- Do not make adjustments or perform maintenance on this machine with power on.
- Keep the machine and the work area clean and free of spills to prevent accidents.
- Be sure to replace any safety decals that may have been detached for any reason.

Baumfolder Corporation reserves the right to make changes in design or to make additions or improvements in its products without imposing any obligation upon itself to install them on its products previously manufactured. It is recommended that modifications to this equipment not be made without the advice and express written consent of Baumfolder Corporation.

INTRODUCTION

Your new Baumfolder Ultrafold 714XE Air Feed Table Top Folder has been designed to give you many years of useful service provided it is installed, maintained, and operated according to the instructions in this manual.

Your Ultrafold Air Feed is a unique and versatile paper folding machine, capable of folding paper measuring between 3 x 5 inches (7.6 x 12.7 cm) and 14 x 20 inches (35.5 x 50.8 cm), at speeds up to 35,000 sheets per hour of 8 1/2x11 (21.6x27.9 cm) and up to 65,000 sheets per hour of 3x5 (7.6x12.7 cm). The Ultrafold will make six types of folds: single fold, letter fold, fan fold, French fold, double-parallel fold and a double-letter fold, with a few simple settings. (Note: The French fold and double-letter fold requires either two passes or the use of an Ultrafold right-angle unit)

Your Ultrafold is built rigid enough to ensure years of trouble-free performance, and at the same time, it is compact enough to fit any table or desk. It is portable, so it can be moved anywhere it is needed.

SPECIFICATIONS

Model No.....	714XE
Minimum Sheet Size.....	3 x 5" (7.6 x 12.7 cm)
Maximum Sheet Size.....	14 x 20" (35.5 x 50.8 cm)
Minimum Size Fold.....	2 1/4" (5.7 cm)
Maximum Paper Weight.....	65 lb. Cover
Stack Height.....	2" (5.1 cm)
Fold Roll Speed.....	Infinitely variable between 0"/min. and 7200"/min. (18,288 cm/min. or 182 m/min.)
Fold Plate Depth.....	#1 Plate, 13.5" (34.3 cm) #2 Plate, 13.5" (34.3 cm)
Fold Roll Width.....	14 1/8" (35.8 cm)
Fold Roll Diameter.....	1 1/2" (3.8 cm)
Overall Physical Dimensions.....	Height 26" (66 cm) Length 34" (88 cm) Width 23 1/2" (60 cm)
Operating Voltage.....	110 VAC 60 Hz
Power Consumption (folder).....	250 Watts
Power Consumption (pump).....	1500 Watts
Amperage (pump).....	13.6 Amp

INSTALLATION

Unpacking & Inspection

The Baumfolder Ultrafold Air Feed is packaged in three cartons, crated together as one package. It is broken down into 12 major assemblies for shipment (Figure 1). These are:

- A) Main Folder Assembly
- B) Pump Assembly
- C) Feed Table Assembly (not shown)
- D) Slitter Shaft Assembly
- E) Stacker Wheel Assembly
- F) Accessory Package (not shown)
- G) Fold Roll Guards (2)
- H) Stacker Tray
- I) Fold Pans (2)
- J) Hose Assembly (2)
- K) Literature Package (not shown)
- L) 1/2 Pint Surewash (not shown)

NOTICE

Immediately upon unpacking, carefully inspect each of the above assemblies for shipping damage. If any damage is found, be sure to contact the delivery freight carrier to file a damage claim. Save all packaging material for the claims adjuster to inspect.

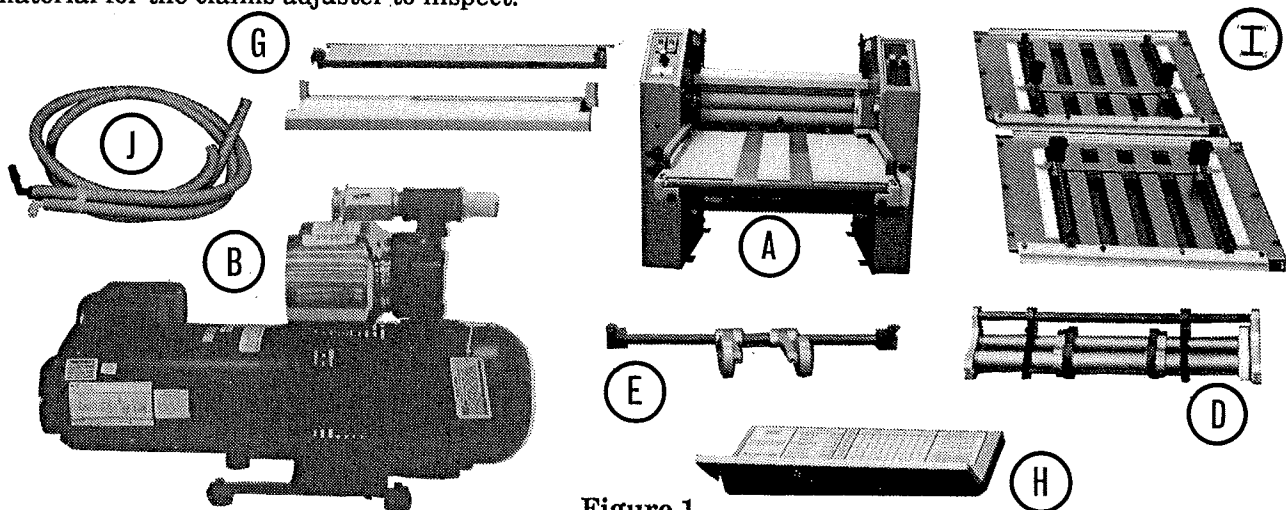


Figure 1

WARNING

Do not plug the power cord into AC outlet until the Ultrafold Air Feed is fully assembled, adjusted and ready to use. Unplug the Ultrafold any time disassembly is required.

ASSEMBLY

Main Unit

To assemble the Ultrafold Air Feed unit, first remove the four bolts holding it to the skid. Next, get the four rubber buttons from the accessory kit and put in mounting feet.

Place the folder on the stand or table where it is to be installed. The optional air feed moveable stand (Part #55849-001) is ideally suited to this machine since it has a shelf to hold the pump assembly. If not using this type of stand, the pump assembly can be placed on the floor beneath the machine, or on a platform. (See Figure 2)

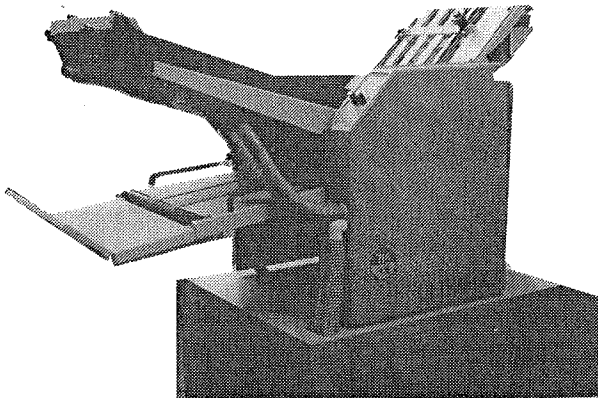


Figure 2

Pump Electrical Connections

The pump has a plug/cord set attached. This plug fits directly into the rear of the left-hand side cover. (See Figure 3)

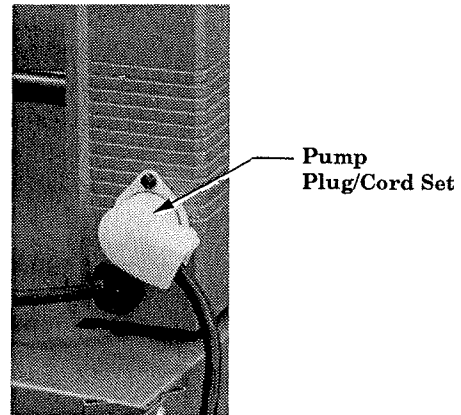


Figure 3

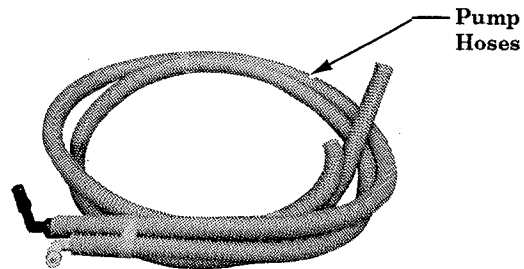


Figure 4

The manifold block located on the right-hand side of the folder is also color-coded black and white. Connect the hoses to both the manifold block and the pump according to this color code. (See Figure 5)

Pump Hose Connections

Two hoses come with your Ultrafold Air Feed. The hoses are color-coded with black or white fittings to match the hose connections. Black is for air blow and white is for vacuum. (See Figure 4)

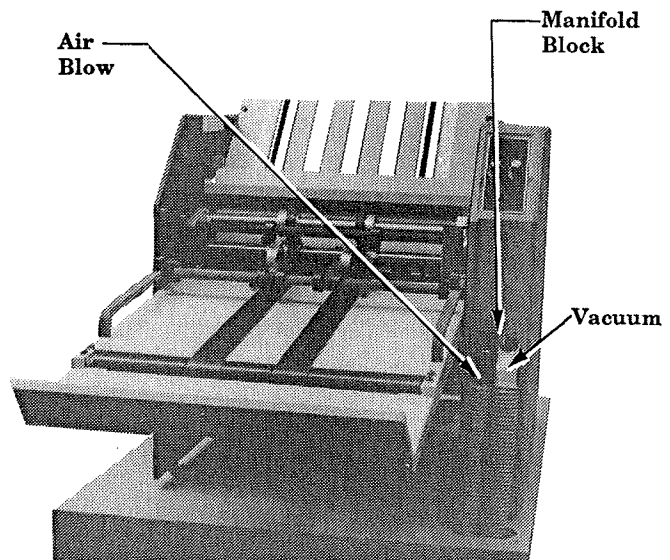


Figure 5

Roll Guard Installation

To install the roll guards, first loosen the locking knobs on both side frames. You can tell which roll guard goes in which position by being able to read the warning labels from the front and back of the machine.

Place the top roll guard over the #1 roll with the mounting tabs fitting over the knobs. Be sure there is approximately 1/4" clearance between the guard and the fold roll.

The other roll guard is installed in the same manner. Secure the guards by tightening the locking knobs. (See Figure 6)

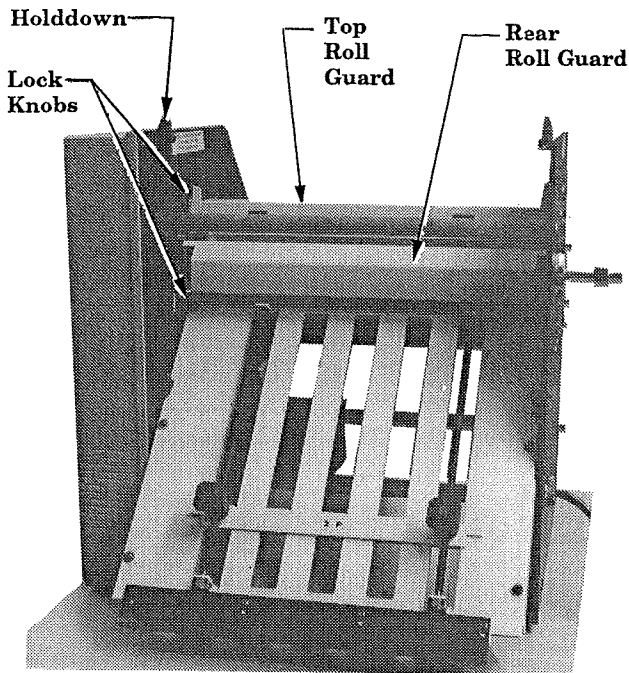


Figure 6

Slitter Shaft Installation

To install the slitter shaft, hold it with the grooves in the boxings down. Be sure the slitter shafts are free-turning.

Insert the slitter shaft and seat the grooves in the boxings on the lower locating pins in the side frames. (See Figure 7)

Check for proper gear engagement between the upper slitter shaft gear and the 19-tooth frame idler gear by turning the handwheel.

Once in place, snug the plunger in the left-hand boxing to take out any end play.

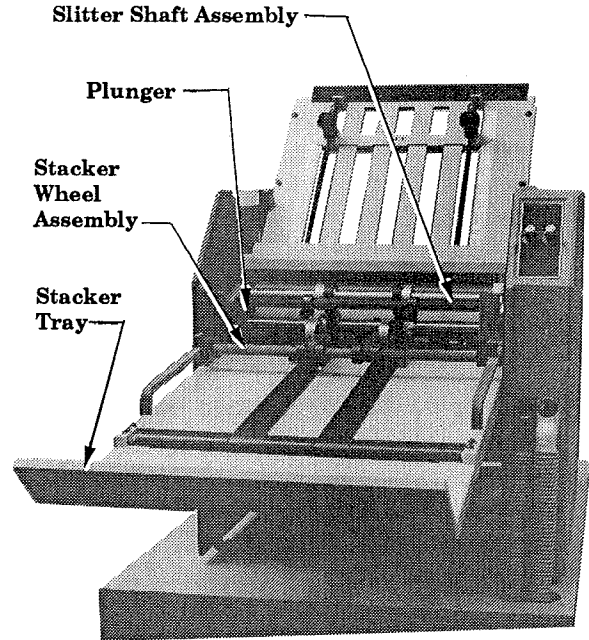


Figure 7

Stacker Tray and Wheel Installation

To install the stacker tray, loosen the knobs on either side of the stacker table. Drop the tray over the knobs and retighten.

Angle the rod of the stacker wheel assembly and insert the notches on the black steel rails of the stacker table, with the wheels towards the fold rolls. (See Figure 7)

The wheels should be positioned directly above the belts and in close enough to the pull-out tires to allow the folded product to tuck slightly under the wheels as it exits the tires. The sheet metal arms can be positioned laterally by sliding the arm on the rod. The wheels can be positioned in and out by moving the side brackets, swinging the arms from front to rear of the cross-rod, and by turning the entire assembly from end to end.

Feed Table Assembly Installation

Insert the feed table with the feed wheels toward the fold rolls. Slide the paper feed table over both sets of locating pins. (See Figure 8)

The first notch in the front part of the feed table should rest on the pins. Then drop the rear notch down on the upper dowel pins.

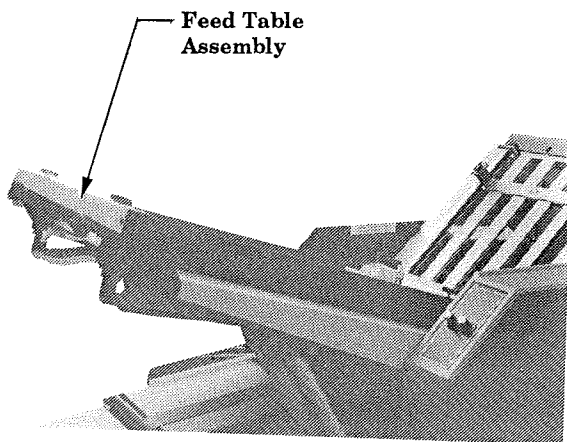


Figure 8

Rotate the handwheel to check that the gears are properly meshed.

Connect the feed table hoses following the black/white color coding of the fittings and connections. Black is for air blow, white is for vacuum. Push the fittings into the corresponding holes in the manifold block. (See Figure 9)

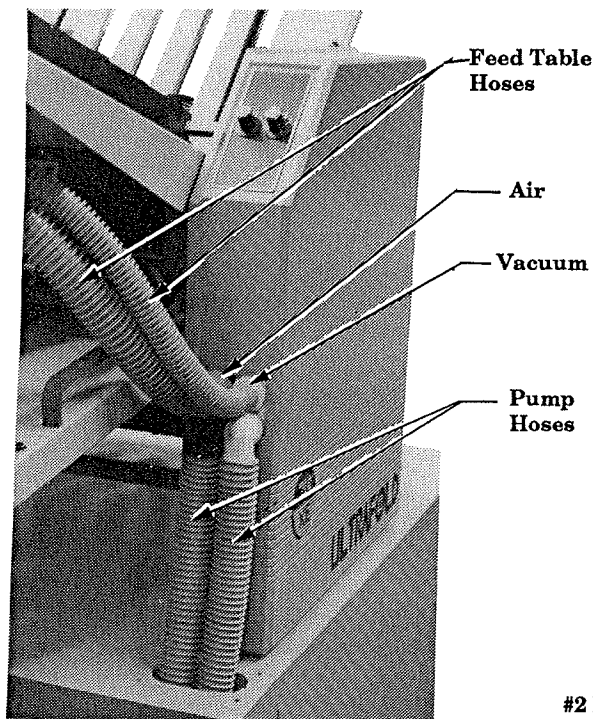


Figure 9

Fold Plate Installation

WARNING

Unplug the AC power cord when installing or removing fold plates.

The fold plates are marked #1 and #2 and are not interchangeable. The #1 fold plate is installed in the top position, the #2 fold plate in the lower position.

Each fold plate has an open end which is toward the fold rolls if you are folding in that plate. If you are not folding in that plate, the plate is reversed so that the deflector end is toward the fold rolls.

Consult the chart located on the stacker tray for the fold you are going to make to determine which end goes nearest the fold rolls.

To install the fold plates, pivot the fold plate holddowns out of the way and slide the fold plate in position so that the slots in the leading edge of the fold plate engage the two locating pins in the side frames. (See Figure 10)

The center notches should seat on the second set of locating pins. Pivot the fold plate holddowns back into position to secure the fold plates.

Turn the handwheel to be sure that the fold plates are properly installed and not rubbing on the fold rolls.

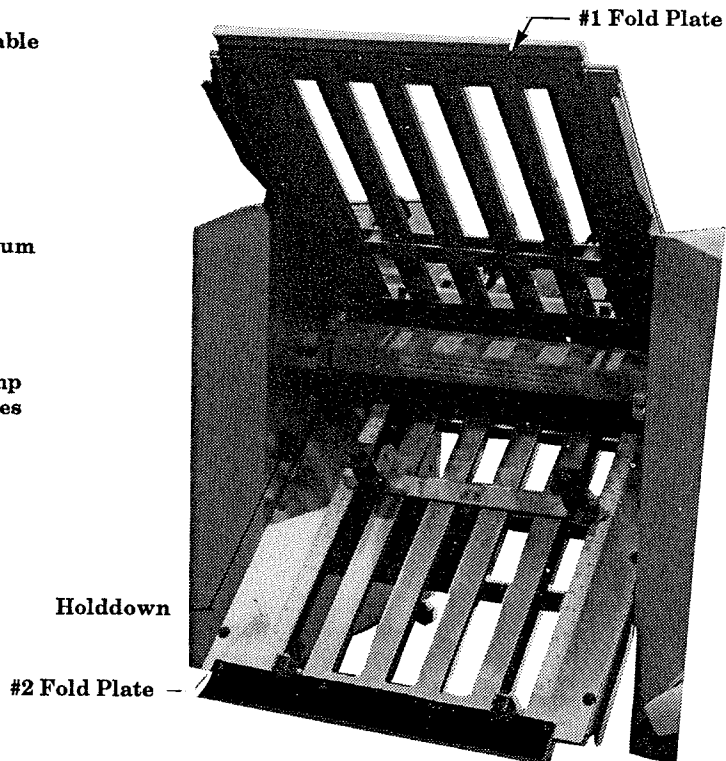


Figure 10

ELECTRICAL ACCESS

WARNING

Unplug the AC power cord before attempting any electrical repair.

The electrical controls are located in the left-hand side cover. The handwheel must be removed for access to these controls.

The cover can be removed by taking out the four button head screws located on the inside of the frame with the allen key provided in the accessory package.

Always consult your authorized Ultrafold Dealer before attempting any electrical repair.

SETUP

You are now ready to set up a job on your Ultrafold Air Feed by following these simple procedures:

1) Setting of Controls

The operator controls are conveniently located on a control panel on the left-hand side of the Ultrafold. (See Figure 11)

These controls consist of an On/Off power switch, which is an overload reset, a speed control potentiometer, a pump On/Off switch, and counter with zero reset.

Set these initially at:

- A) Power Switch Off position
- B) Speed Control "0" position
- C) Pump Switch Off position
- D) Counter "0" position

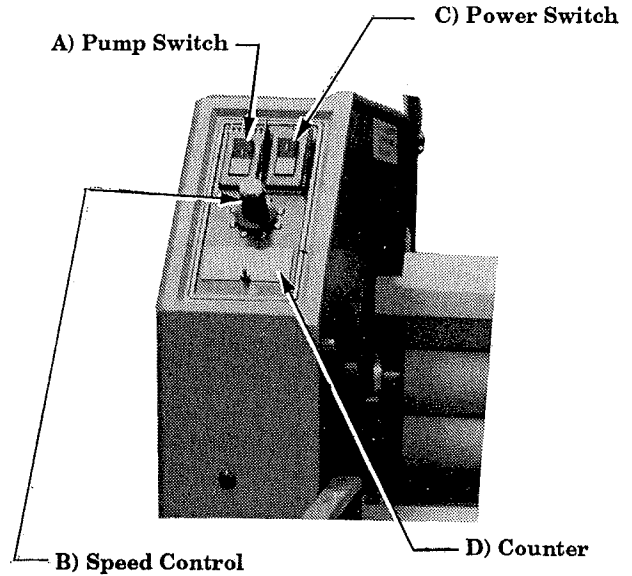


Figure 11

2) Determining Paper Size and Type of Fold

The next step is to determine the paper size and type of fold to be made, following the steps below:

- A) Measure a sample sheet of the job to be run to determine its size. Retain this information for later use.
- B) Refer to the printed chart on the stacker tray (See Figure 13) and locate the type of fold that you want to make. (Example: letter fold)
- C) Locate on the chart the columns corresponding to the sheet size measured in Step A. (Example: 8 1/2 x 11)








FOLDING CHART	TYPE OF FOLD	FOLD PAN	6 X 9	8 1/2 X 11	8 1/2 X 14	11 X 17	14 X 20	DEFLECTOR SETTING
			LETTER FOLD 	1ST 2ND	C C	E E	H H	
BECAUSE THE PAPER SIZE & SQUARENESS VARY, MINOR ADJUSTMENT OF THE PAPER STOPS MAY BE REQUIRED.	FAN FOLD 	1ST 2ND	M C	R E	U H	X L	Z N	TWO FOLD POSITION
	DOUBLE PARALLEL FOLD 	1ST 2ND	G A	K B	P D	T F	V J	TWO FOLD POSITION
	SINGLE FOLD 	1ST 2ND	G --	K --	P --	T --	V --	SINGLE FOLD POSITION
	FRENCH FOLD 	1ST 2ND	G --	K --	P --	T --	V --	SINGLE FOLD POSITION & ONE SCORING ROLLER
	DOUBLE LETTER FOLD 	1ST 2ND	G --	K --	P --	T --	V --	SINGLE FOLD POSITION & TWO SCORING ROLLERS
	ENGINEERING FOLD 	1ST 2ND			W D	Y F		TWO FOLD POSITION
	BAUMFOLDER							

Figure 12

D) Locate the point on the chart where the columns for the type of fold and the sheet size intersect. You will notice that there are either two letters or a dash and a letter. These letters and/or dash tell you where to set the paper stop on the fold plate, and whether or not one of the fold plates will be installed in the deflector position.

Example #1: To make a letter fold to an 8 1/2 x 11 sheet, set the paper stops for the #1 and #2 fold plates on the letter E. No dash appears, so neither fold plate is installed in the deflector position.

Example #2: To make a single fold to an 8 1/2 x 11 sheet, install the #2 fold plate in the deflector position. Set the paper stop for the #1 fold plate at the letter K.

3) Paper Stop Adjustment

To move the paper stops to the correct position as determined in Step #2, depress the coarse adjustment knobs on the paper stop and slide the paper stop until the indicating edge is aligned with the proper letter on the fold plate. (See Figure 13)

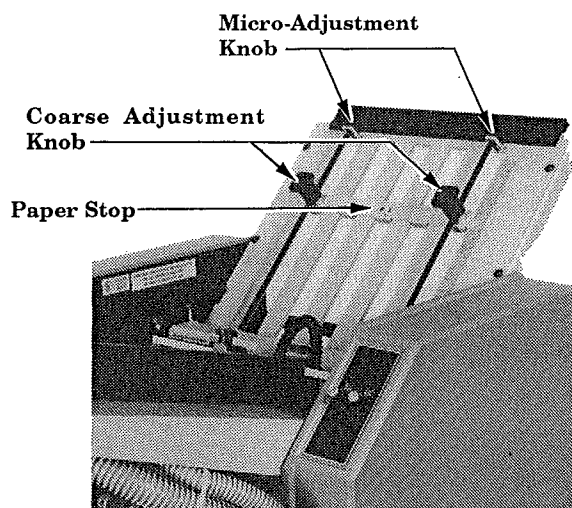


Figure 13

To obtain an exact setting on the paper stops, turn the micro-adjustment knobs until the indicating edge of the paper stop is perfectly aligned with the line adjacent to the letter on the fold plate.

4) Gap Adjustment

With the machine running, insert two sheets of paper between the tab and the sucker wheel. Turn the gap knob counter-clockwise until there is a slight drag on the paper. Remove the paper. The correct gap is now set. (See Figure 14)

6

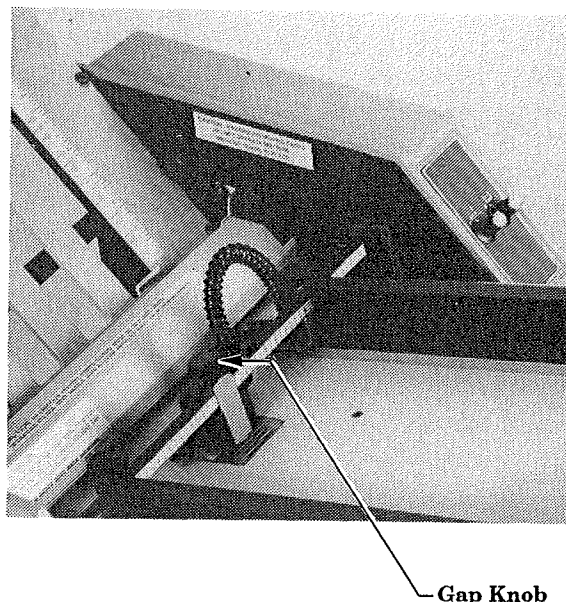


Figure 14

5) Feed Table Adjustment

On the paper feed table there are two guides which keep the stack of paper properly aligned for feeding into the folder. Adjust these guides to correspond with the different widths of paper being fed. (See Figure 15)

To adjust the paper feed guides, loosen the two side guide locking knobs on each guide. Slide the guides from side to side until the inside edge of each guide is aligned with the number corresponding to the width of the paper being folded.

Example: For an 8 1/2-inch wide sheet, move the side guides until the inside edges align with the "8 1/2" on the feed table.

An additional check is to lay a sheet of paper on the feeder, close to but not touching the side guides. Push the sheet down into the nip of the fold rolls. Then align the guide by loosening the adjusting knobs and aligning the guide so that it is parallel to the edge of the paper. When one side is square, the other side can be moved into position.

Tighten the locking knobs to secure the paper guides in position.

When you load the actual job, you may have to move these guides slightly to take care of variations in sheet size. To feed properly, the paper must slide freely between these guides.

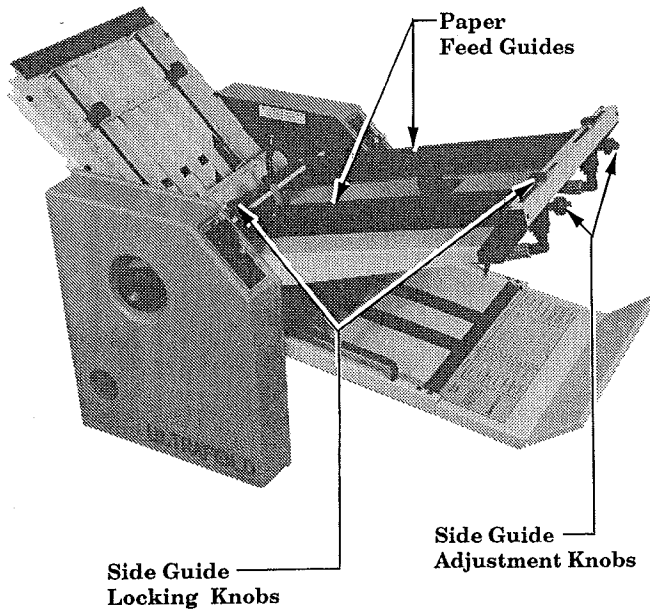


Figure 15

6) Air Blow Adjustment

Turn the air blow adjustment on the vacuum/air control panel fully counter-clockwise to the + position. Except for when very small sheets are being run, the air blow adjustment is left adjusted for maximum air. (See Figure 16)

Once the amount of air blow has been selected using the air blow adjustment, the feeder valve knob may be used to direct the air (see page 20, item 12).

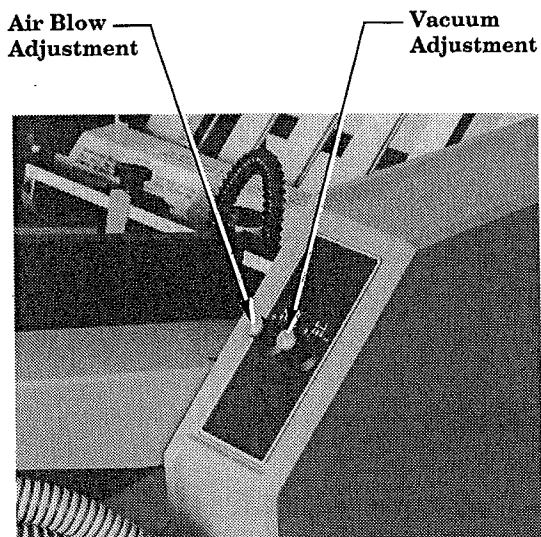


Figure 16

Turn the knob to the right to obtain more blow on the right side and front of the feed table. Turn the knob to the left to obtain more blow on the left side and lessen the front blow.

Turn the vacuum adjustment clockwise all the way down. This setting is used for most light and medium papers. Heavy paper will require more vacuum.

OPERATION

1) Loading of Feed Table

Before you can load the paper on the feed table, you must determine which way the paper is to be loaded by running a few sample sheets. (Example: printing face up or face down)

Then you can load a stack of paper no higher than two inches between the paper feed guides. Let the stack slide freely down into position between the side guides.

2) Starting the Vacuum/Air Feeder

After the vacuum and air adjustments have been made, start the vacuum/pump, then start the folder.

Additional paper can be loaded on top of the stack of paper already in the feeder without stopping the machine.

If the feeder runs out of paper or if you want to stop the machine for any reason, first turn off the vacuum pump, then the folder.

3) Stacker Wheel Adjustment

The stacker wheels must be positioned to ensure proper stacking of the folded sheets of paper.

To determine the proper position turn on the Ultrafold and set the speed control at a slow speed. Feed a single sheet of paper and observe where the folded sheet first hits the stacker belts.

Slide the stacker wheels toward the approximate spot where the folded sheet hit the stacker belts, right behind and tucking under the stacker wheels.

As a final check, feed several sheets of paper individually through the Ultrafold and check the spacing of the stacked sheets. Readjust the stacker wheels if necessary.

4) Check Squareness of Fold

Examine the folded sheets on the stacker to make sure that you are getting an even and square fold.

The inside fold is your first fold. The outside fold is your second fold. Use the micro-adjustment knobs for the paper stops on the fold plates to adjust for an even fold. By turning the micro-adjustment clockwise, you lengthen the fold; counter-clockwise will shorten the fold.

If the fold is short, we shorten both the #1 and #2 fold plates, then run another test sheet and recheck the fold.

When you are satisfied with the quality of the fold, you are ready to put a production job on the Ultrafold.

5) Paper Jams

Should a jam-up occur, shut off the machine before clearing it out. Try to determine the cause of the jam and correct it before restarting the machine.

6) Use of Handwheel

The handwheel is used to help clear jams and for setup. To use the handwheel, shut off the folder and turn the handwheel in either direction.

PERFORATING, SCORING & SLITTING

In addition to folding, your Ultrafold Air Feed can perforate, score and slit.

WARNING

Be careful when handling perforator and slitting blades. They are extremely sharp.

Perforating

The Ultrafold can be used to perforate either the folded sheet (to assist in making a right-angle fold) or to perforate sheets delivered flat. Baumfolder supplies one standard 41-tooth perforator blade. Additional perforator blades are available through the Baumfolder Parts Department.

The perforator blade should be mounted loosely to the blade holder with the retainer collar to give better support to the perforator blade. Always be sure that the flat side of the blade is against the blade holder. Loosen the brass-tipped set screws in the perforator collar and blade holder before attempting to place them on the slitter shafts.

The perforating blade holder assembly is then slid onto the upper slitter shaft along with the necessary pull-out tire assemblies. Then tighten the screws holding the perforator blade to the blade holder, aligning the blade to the holder. This allows for free horizontal movement on the shaft.

Slide the grooved perforator collar onto the lower slitter shaft along with the other pull-out tire assemblies. The flat side of the perforator blade should just touch the side of the groove in the perforator collar. (See Figure 17)

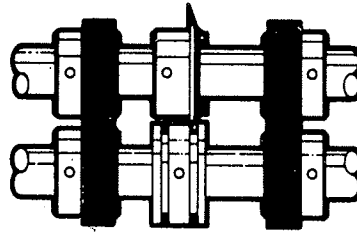


Figure 17

The perforator collar and blade holder can be slid to the desired position on the slitter shaft, then lock the blade holder and perforator collar into position with the brass-tipped set screw.

The perforator stripper fits onto the slitter shaft bar in between or next to the perforating blade. (See Figure 18) This strips the paper off for delivery and prevents it from wrapping around the perforator blade.

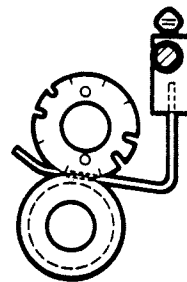


Figure 18

Scoring

The Ultrafold can be used to score a sheet and deliver it flat, or to score a sheet after a fold or folds have been made.

To ensure accuracy in making right-angle folds, always score the sheet where the fold is to be made. This applies in all instances when a perforator cannot be used.

Attach the scoring blade loosely to the blade holder for mounting on the slitler shaft. Scoring blades can be mounted on either the upper or lower slitler shaft. Once on the shaft, tighten the screws, aligning both the blade and the collar. This allows free horizontal movement on the shaft. Scoring blades should be placed so that the fold will be made with rather than against the scoring, or, in a continuing direction to the pressure of the crease that has been applied by the scoring blade.

For a wide, well-rounded score, use the two steel scoring collars. (See Figure 19) Sharpness and the depth of the score can be controlled by regulating the distance the collars are placed away from the scoring blade.

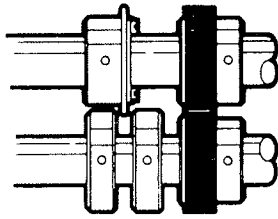


Figure 19

The scoring collars can also be placed on either side of the rubber scoring collar. The two collars can be compressed against the rubber collar, causing the rubber to bulge up for a deeper score. (See Figure 20)

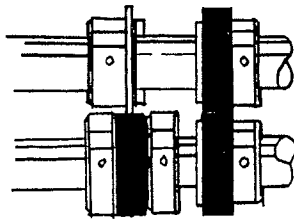


Figure 20

Slitting

NOTE: Slitting accessories are optional on your Ultrafold and can be ordered from your Baumfolder Parts Department.

The Ultrafold can be used to cut folded or flat sheets apart. The general setup for blades and collars is shown in Figure 21. Two or more cuts may be made if duplicate sets of cutters are used.

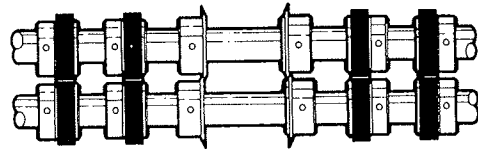


Figure 21

Use care in mounting slitler blades to the collars in order to avoid ragged edges during slitting operations. Ragged edges can be caused by two conditions:

- 1) Nicks or burrs on the collars or blades. Remove carefully by filing or using a fine piece of emery cloth.
- 2) Incorrect mounting of blades caused by tightening with the wrong type of screw. Always use flat head screws on the side of the blade and blade holder collar, which are countersunk.

Before tightening the blade to the collar, slide the blade with the collar loosely attached on the end of the shaft. Then tighten securely, thus aligning both the blade and collar, allowing free horizontal movement along the shaft.

Place the blade, mounted on the collar, on the upper shaft in the proper position where the cut is to be made. Then move the blade and collar on the lower shaft so that the two flat edges of the blades are pressed snugly together. Too much space between the blades will produce a ragged cut.

Space the rubber pull-out tires to support the sheet.

MAINTENANCE

Maintenance and Care of Ultrafold

The Ultrafold Air Feed has been designed to give you years of useful service, provided you maintain it according to these instructions.

Lubrication

Apply one or two drops of light machine oil at all slitter shaft bearings and the feed table bearings and idler gear once a week. Be sure to keep oil off any surface which may contact the paper.

Cleaning of Fold Rolls

Periodically wipe off the rubber surface of the fold rolls using an approved solvent such as Surewash or its equivalent. Surewash is available from Baumfolder in 1-quart (P/N 24108-001) and 1-gallon (P/N 24108-002) containers. A complementary bottle of Surewash is included with your machine.

Cleaning Filters

The filters on the pump should be checked periodically and cleaned as needed. The filters can be reached by unscrewing the filter jars.

Counter Eye Detector

Occasionally wipe off the counter eye detector.

Replacement Parts

To order replacement parts for your Baumfolder Ultrafold Air Feed, contact your authorized Ultrafold Dealer, or call the Baumfolder Parts Department toll free, **800/543-6107**.

Always be sure to give the model number and serial number of your Ultrafold to ensure receiving the proper parts.

SUREWASH

MATERIAL SAFETY DATA SHEET

NOTICE: Surewash is a product of RBP Chemical Corporation, 150 S. 118th St., P.O. Box 14069, Milwaukee, Wisconsin 53214-0069. Tel. 414/258-0911, 800/558-0747.

H M I S R A T I N G

Health: 1
Flammability: 2
Reactivity: 0
Personal Protection: 8

HAZARDOUS INGREDIENTS

Name: Medium Aliphatic Solvent Naptha (Syn: 140 HF Mineral Spirits)
CAS#: 64742-88-7
ACGIH TLV: 100ppm
OSHA PEL: 500ppm
%: <95

PHYSICAL/CHEMICAL CHARACTERISTICS

Boiling Point: ND
Solubility in Water: Insoluble
% Volatiles (by vol.): 95
Specific Gravity: 0.786
Appearance and Odor: Clear, light blue liquid with pleasant odor.

FIRE AND EXPLOSION HAZARD DATA

Flash Point: 140° F
Extinguishing Media: CO₂, Dry chemical, Foam
Special Fire Fighting Procedures: Wear self-contained breathing apparatus for any fire involving chemicals.
Unusual Fire and Explosion Hazards: None

REACTIVITY DATA

Stability: Stable
Incompatibility: Strong oxidizers
Hazardous Decomposition By-products: Carbon dioxide/monoxide
Hazardous Polymerization: Will not occur
Conditions to Avoid: Heat, Sparks, and Open Flames

HEALTH HAZARD DATA

Routes of Entry: Inhalation, Primary; Skin, Secondary; Ingestion, Unlikely
Health Hazards Acute and Chronic: Chronic inhalation of high concentrations may cause respiratory tract irritation and may affect central nervous system. May cause skin irritation. Chronic over-exposure to many petroleum hydrocarbons may cause liver or kidney injury. May cause eye irritation.

Emergency & First Aid Procedures:
Skin Contact: Wash affected area with soap and water. Remove contaminated clothing.
Eye contact: Flush eyes with water for at least 15 minutes. Consult a physician.
Inhalation: Remove to fresh air. Restore breathing if required. Get medical attention.
Ingestion: DO NOT induce vomiting. Get medical attention.
Carcinogenicity: None of the ingredients in this product are listed by IARC, NTP, or OSHA as carcinogenic.
Signs and Symptoms of Over-exposure: Headache, dizziness, nausea, irritation of the mucous membranes, respiratory tract irritation or mild narcosis at high concentrations.
Medical Conditions Aggravated by Exposure: May aggravate an existing dermatitis.

PRECAUTIONS FOR USE AND DISPOSAL

Spills: Small spills can be soaked up with suitable absorbent. For large spills, dike the spill and pump to salvage tank.
Waste Disposal: Incineration or absorbent disposal according to local, state, or federal regulations.
Special Storage/Handling Precautions: None

CONTROL MEASURES

Respiratory Protection: Organic vapor respirator for concentrations above the TLV.
Ventilation: Mechanical
Eye Protection: Recommended
Gloves: Recommended, butyl, rubber or neoprene.
Other: Eye bath or safety shower should be located in the work place when working with chemicals.

*ND = No data found or not determined.

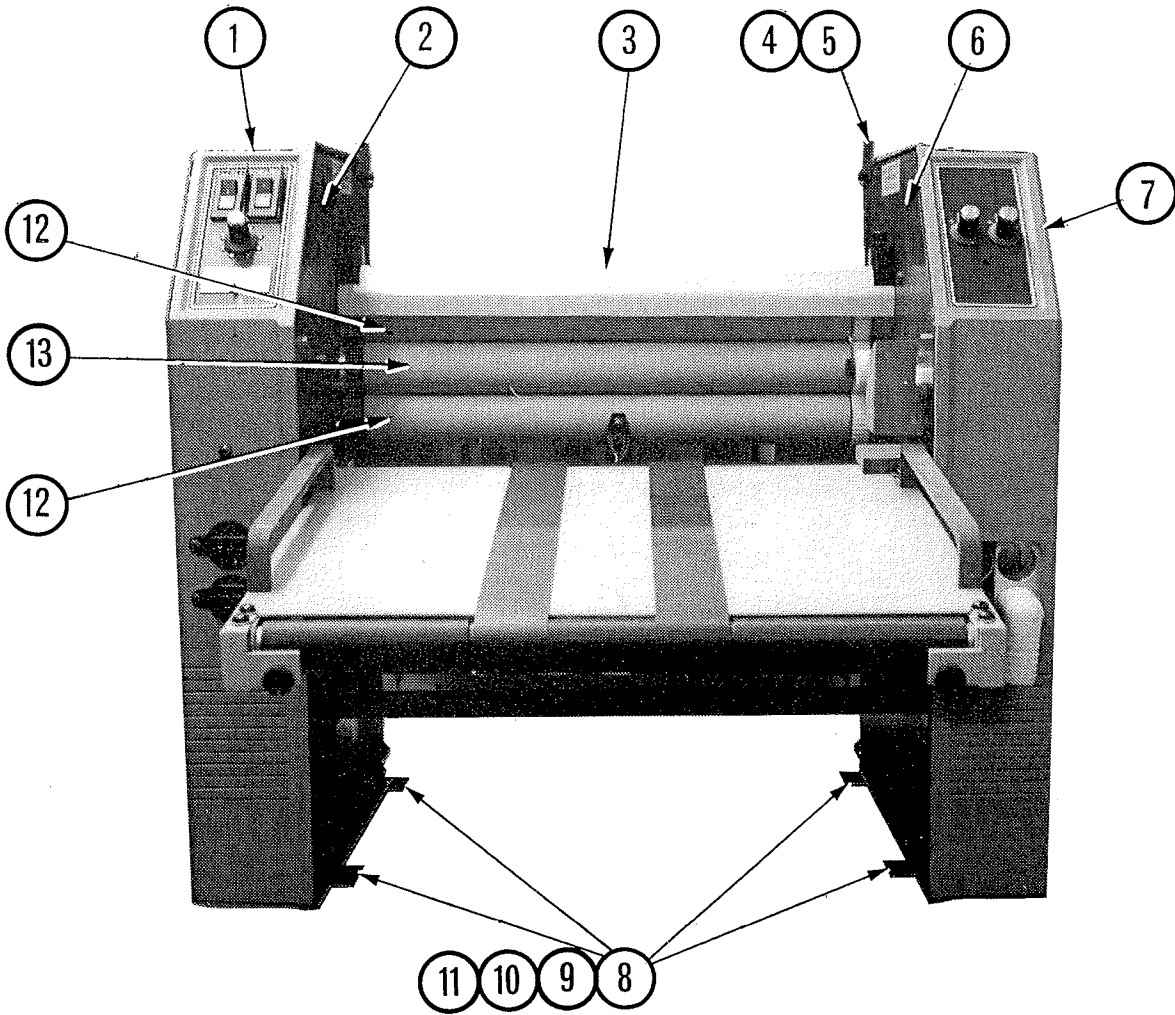
The information contained herein is furnished without warranty of any kind. Users should consider this data a supplement to other information gathered by them and are responsible for completeness of information to assure proper use of these materials and the safety and health of their employees.

This MSDS was prepared under the direction of Wayne Koontz, Safety Director, 10-5-87; Revised 2-10-88 WJK, Rev. Code:01B.

To order Surewash call toll free, 800/543-6107.

Part numbers: 24108-001 (quart) & 24108-002 (gallon)

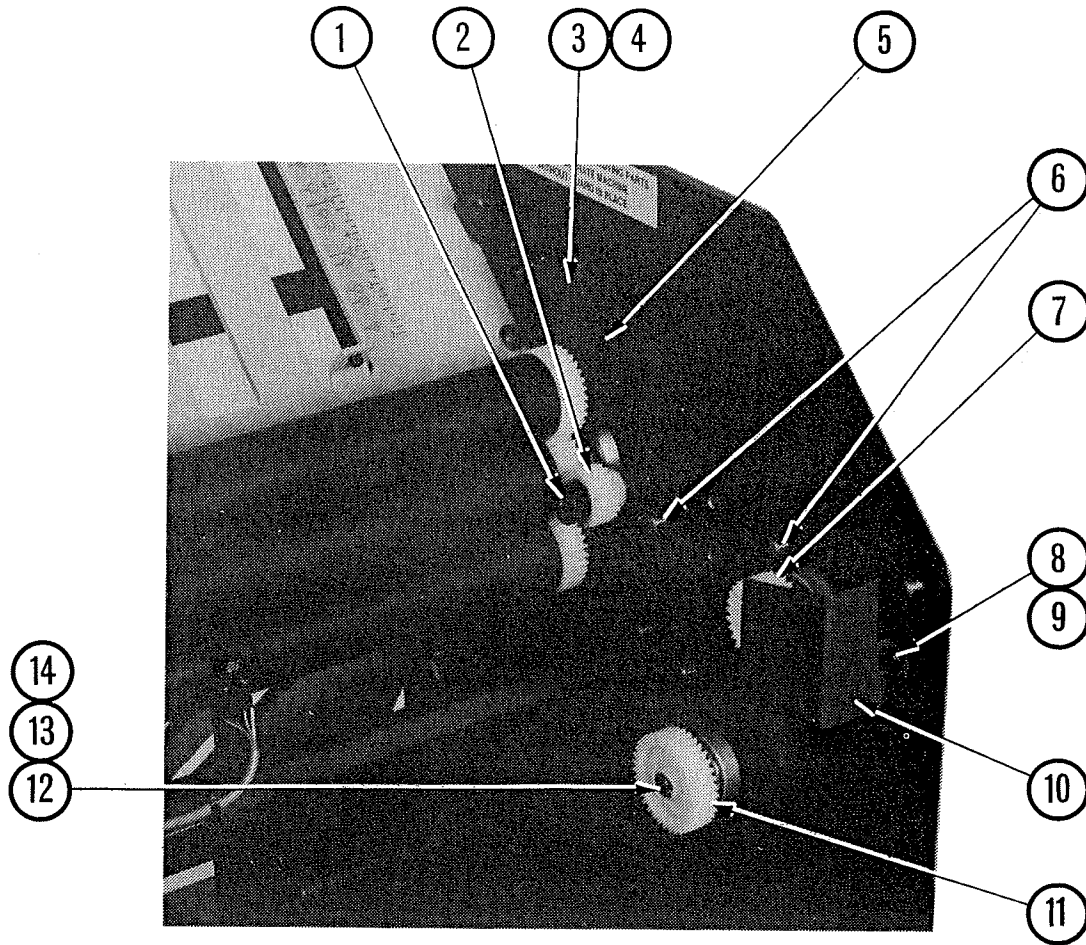
Include machine model & serial number when ordering parts.



FRAME - OVERALL

Item	Description	Part #'s
1.	Assembly - Electrical Control	56156-001
2.	Frame - LH	56189
3.	Assembly - Fold Roll Guard, Top	53489-002
NS	Knob - Fold Roll Guard	41916
4.	Holddown	48616
5.	Screw - Shld, 10-24x3/8	22460
6.	Frame - RH	56190
7.	Guard - RH	56316
8.	Mount - Bumper	47314-002
9.	Screw - But Hd, 1/4-20x5/8	22570
10.	Washer - Plain, 1/4	20489
11.	Washer - Lock, 1/4	20481
12.	Roll - Idler	45073-002
13.	Roll - Main Drive	53007-002

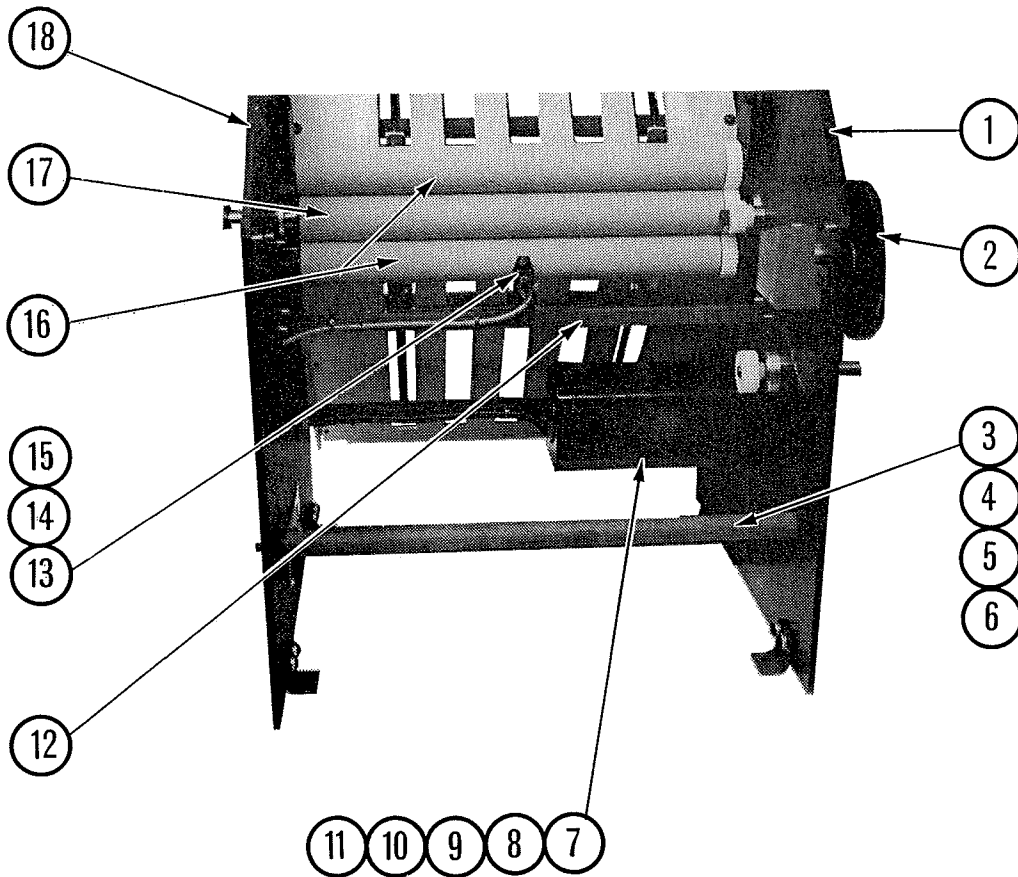
Include machine model & serial number when ordering parts.



INSIDE RH FRAME

Item	Description	Part #'s
1.	Stud - Idler	261-339-01-00
2.	Assembly - Gear, Idler 19T	56239
3.	Boxing - Fold Roll	56178
4.	Assembly - Boxing Slide	56202
--	Slide - Boxing	56175
--	Bearing - Ball	31449
5.	Pin - Spirol	23051
6.	Pin - Dowel	22973
7.	Gear - Spur, 30T	45230
8.	Screw - Soc Hd, 1/4-20x1/2	20152
9.	Screw - Shoulder, 1/4-20x5/8	24812
10.	Guard - Feeder Drive	45366-002
11.	Gear - Spur, 35T	56850
12.	Ring - Retaining	21073
13.	Shaft	45233
14.	Shim - 1/2x3/4	24314

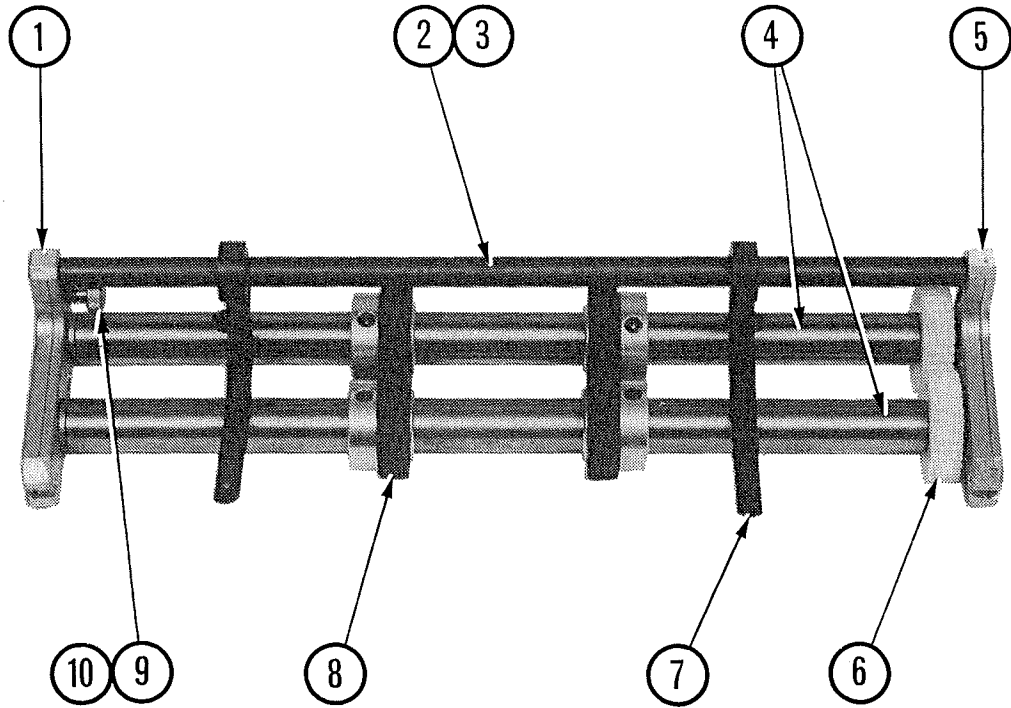
Include machine model & serial number when ordering parts.



FRAME & MOTOR

Item	Description	Part #'s
1.	Frame - RH	56190
2.	Handwheel	30923
3.	Bar - Tie	45029-002
4.	Screw - Soc Hd, 5/16-18x5/8	20163
5.	Washer - Lock, 5/16	20484
6.	Washer - Plain, 5/16	20492
7.	Assembly - Motor	53230-001
--	Motor	22970-020
8.	Screw - Soc Hd, 10-24x3/4	20144
9.	Washer - Lock, 10	20480
10.	Cable - Tie	30986
11.	Connector	30079
12.	Bar - Counter, Tie	53281-002
13.	Retrofit - Sensor Support	261-424-BG-01
--	Support - Sensor Eye	261-401-01-00
--	Nut - Sensor Eye	261-402-01-00
--	Screw - Pan Hd Mach, 2-56x1/4	261-423-01-00
14.	Screw - Soc Hd, 10-24x1/2	20142
15.	Washer - Lock, 10	20480
16.	Frame - LH	56189

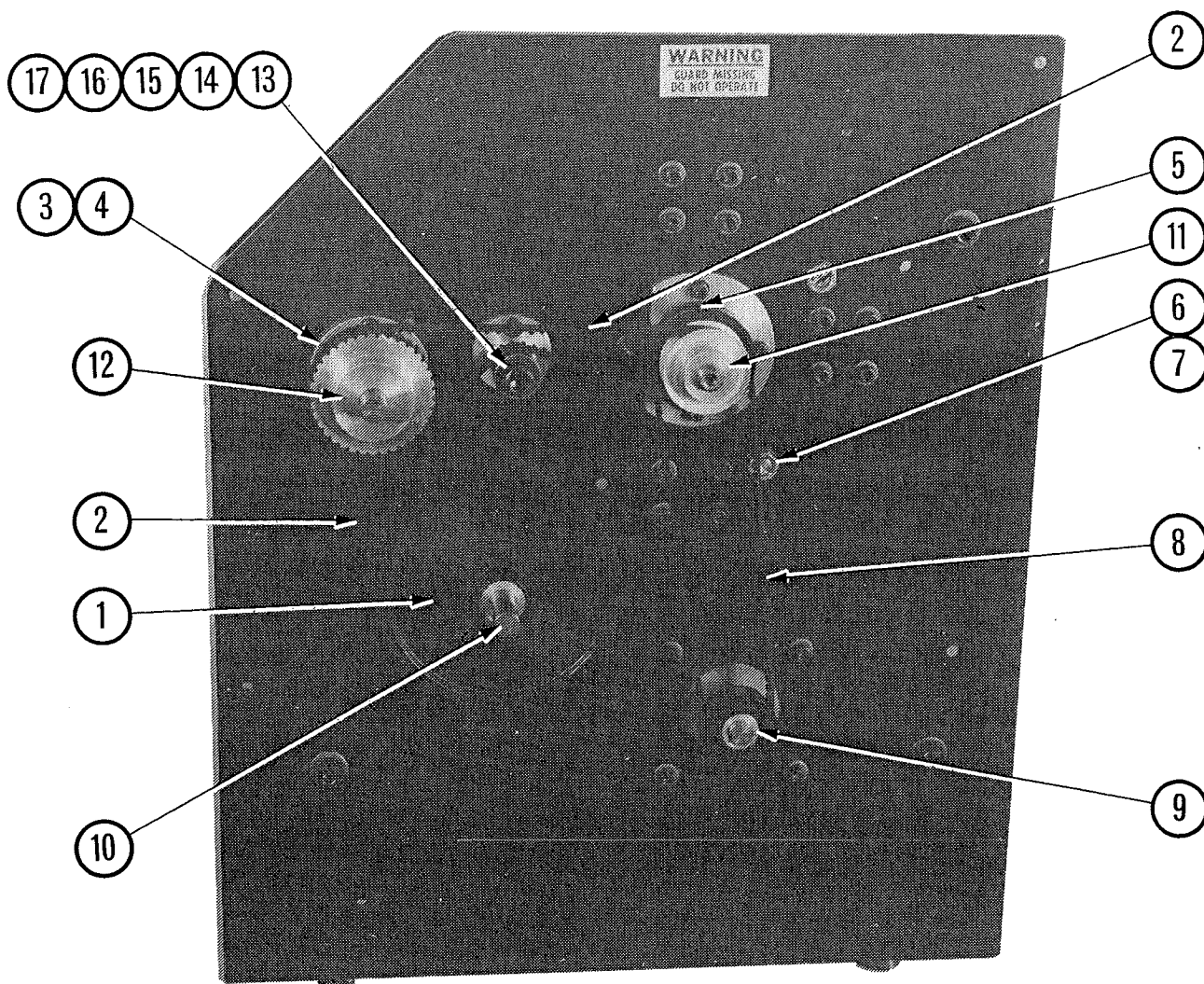
Include machine model & serial number when ordering parts.



SLITTER SHAFT

Item	Description	Part #'s
1.	Assembly - Slitter Boxing, LH	48571
--	Boxing	48548
--	Bearing - Flanged	24148
2.	Bar - Tie	48547-002
3.	Screw - Fl Hd Soc, 1/4-20x1	20364
4.	Shaft - Slitter	45034
5.	Assembly - Slitter Boxing, RH	48572
--	Boxing	48548
--	Bearing - Flanged	24148
6.	Gear - Spur, 35T	45211
7.	Assembly - Deflector, Paper	260-950-BG-01
--	Assembly - Collar and Deflector	260-949-BG-01
--	Screw - Finger, 1/4-20x3/8	260-951-01-00
8.	Assembly - Sheet Pullout	06404
--	Sleeve - Sheet Pullout	06997
--	Band - Sheet Pullout	06402
--	Screw - Br Tip Set, 5/16-18x5/16	20438
9.	Plunger	31683
10.	Nut - Hvy Hex St Jam, 5/16x18	20615

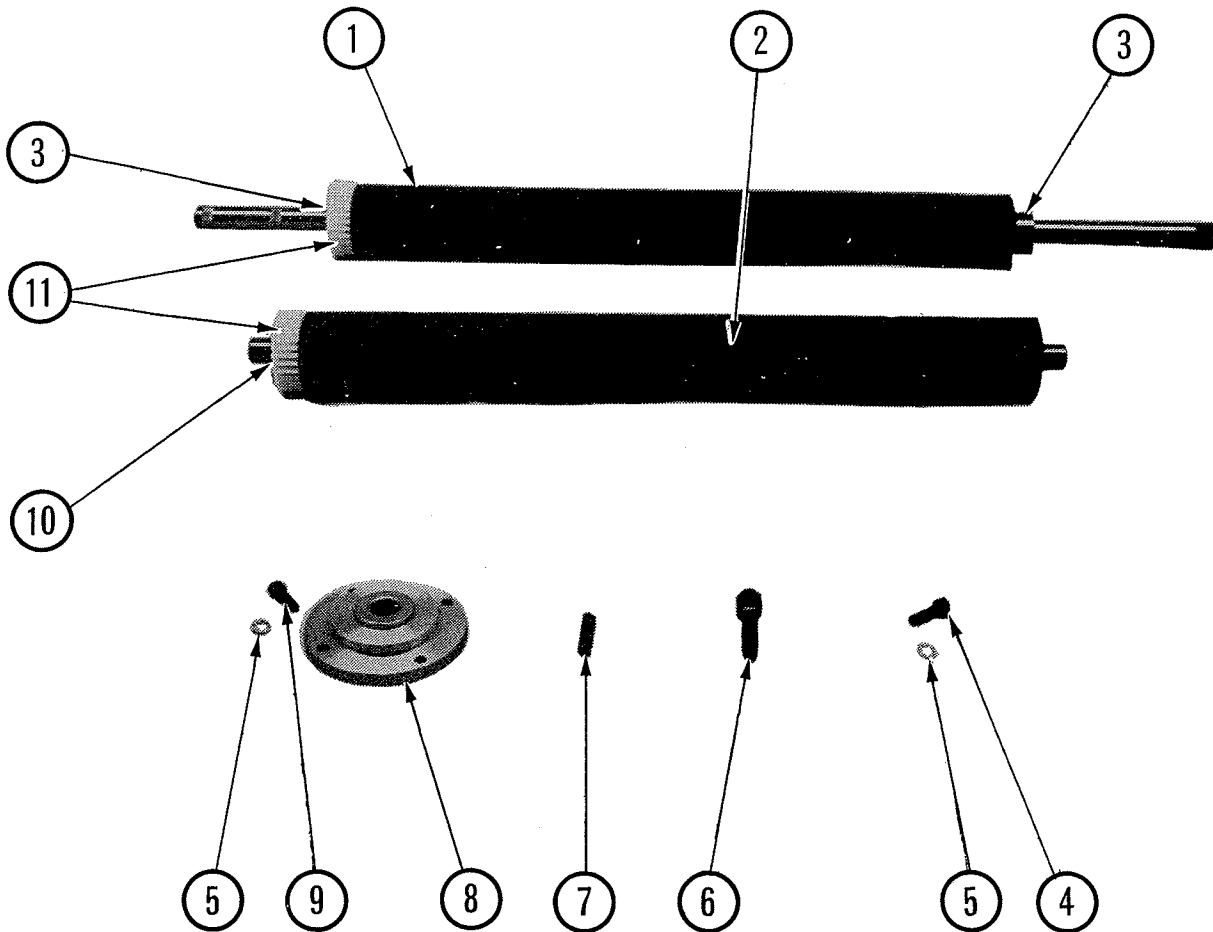
Include machine model & serial number when ordering parts.



DRIVE SYSTEM

Item	Description	Part #'s
1.	Pulley - 72 Groove	31688
2.	Belt - Gear, 190XL037	24163
3.	Pulley - 14 Groove	45253
4.	Assembly - Bearing Retainer	56194
--	Retainer - Bearing	56192
--	Bearing - Flanged	31449
5.	Pulley - 28 Groove	31689
6.	Stud - Eccentric	45272
7.	Nut - Hex Jam, 3/8-24	20627
8.	Belt - Gear, 200XL037	24783
9.	Pulley - 20 Groove	31690
10.	Shaft	45233
11.	Pulley - 22 Groove	31691
12.	Pulley - 36 Groove	261-697-01-00
13.	Spacer - Idler	261-552-01-00
14.	Bearing - Ball	31233
15.	Screw - Soc Hd Cap, 3/8-16x1	20179
16.	Screw - But Hd Cap, 10-24x1/2	22754
17.	Washer - Lock, 10	22133

Include machine model & serial number when ordering parts.



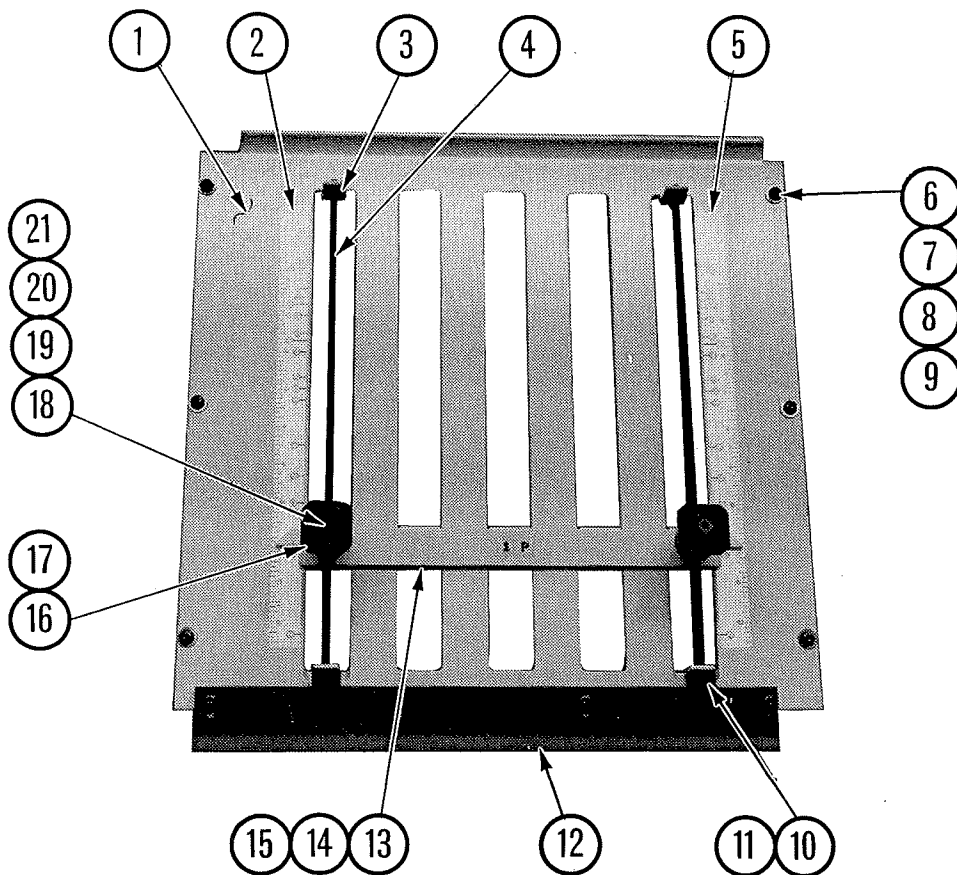
FOLD ROLLS

Item	Description	Part #'s
1.	Roll - Main Drive	53007-002
2.	Roll - Idler	45073-002
3.	Bearing	24153
4.	Screw - Soc Hd Cap, 10-24x5/8	20143
5.	Washer - Shakerproof	22133
6.	Screw - Soc Hd Cap, 5/16-18x5/8†	20163
--	Screw - Soc Hd Cap, 5/16-18x3/4††	20164
7.	Spring	24216
8.	Assembly - Bearing Retainer	56200
--	Retainer - Main Drive Bearing	56191
--	Bearing - Ball	31449
9.	Screw - Soc Hd Cap, 10-24x1/2	20142
10.	Bushing - Thrust	24152
11.	Gear - Spur, 30T	45223
NS	Shim - 1/2x3/4x.015	24315
NS	Shim - 1/2x3/4x.005	24316

†Used on roll #1 only.

††Used on roll #2 and #3.

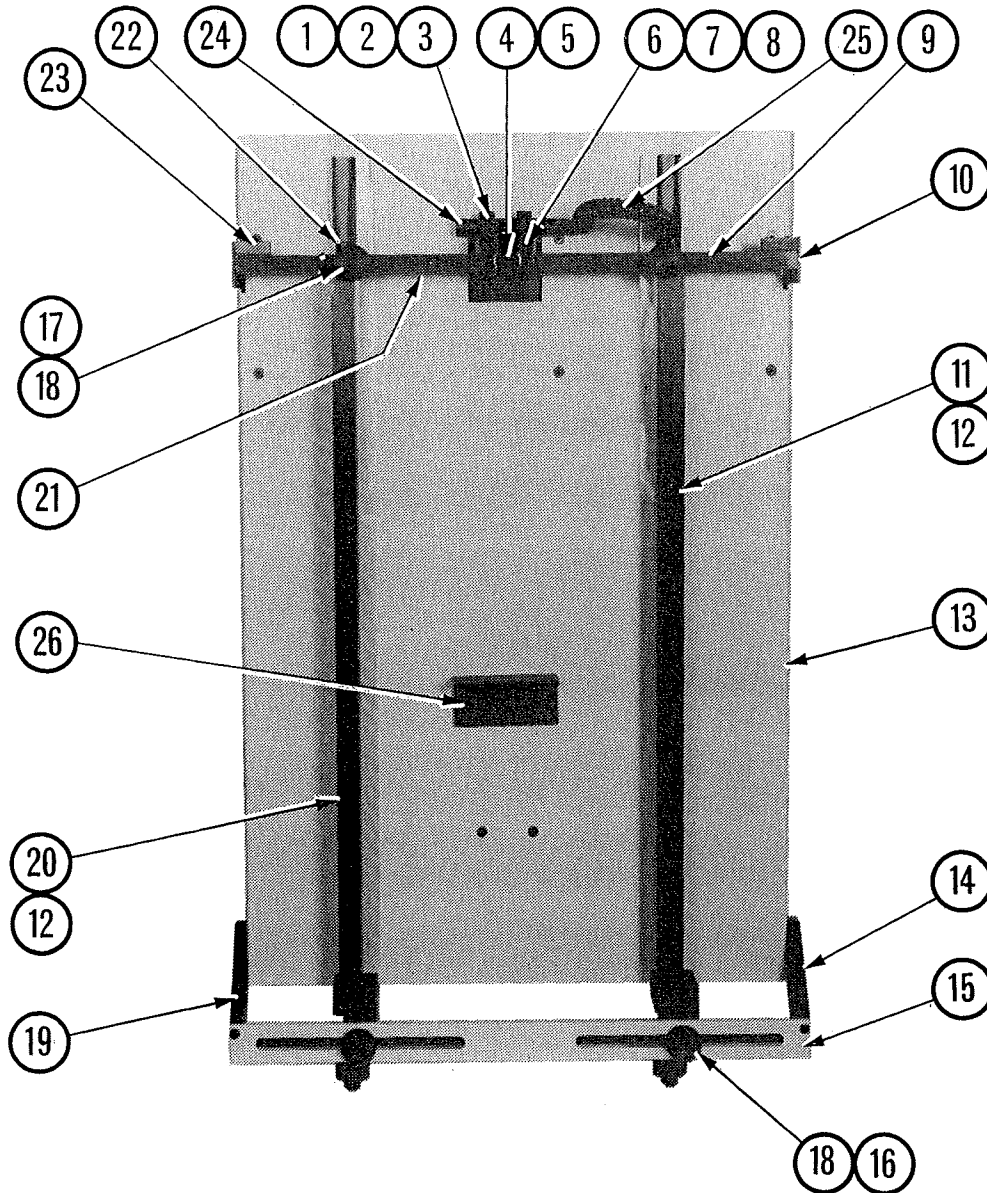
Include machine model & serial number when ordering parts.



FOLD PANS

Item	Description	Part#'s	
		#1 Pan	#2 Pan
1.	Pan - Fold	47114-002	47114-002
--	Plate - Fold	47115-002	47115-002
2.	Scale - RH	56247	56247
3.	Ring - Retaining	23026	23026
4.	Screw - Adjustment Stop	47110	47110
5.	Scale - LH	56248	56248
6.	Screw - But Hd Soc, 10-24x1/2	22754	22754
7.	Washer - Lock, 10	22133	22133
8.	Spacer	06568	06568
9.	Washer - Plain, 3/16	20488	20488
10.	Knob	24421	24421
11.	Screw - Soc Set, 6-32x1/4	24156	24156
12.	Deflector - Paper	45245-002	45245-002
13.	Stop - Paper	47111-002	47111-002
14.	Plate - Paper Stop	47107	47107
15.	Screw - But Hd Soc, 10-24x5/8	22828	22828
16.	Retainer - Spring	47113	47113
17.	Spring	24342	24342
18.	Knob	47112	47112
19.	Screw - Fl Hd Soc, 10-24x5/8	20349	20349
20.	Pin - Paper Stop Guide	47109	47109
21.	Spacer - Paper Stop	47108	47108

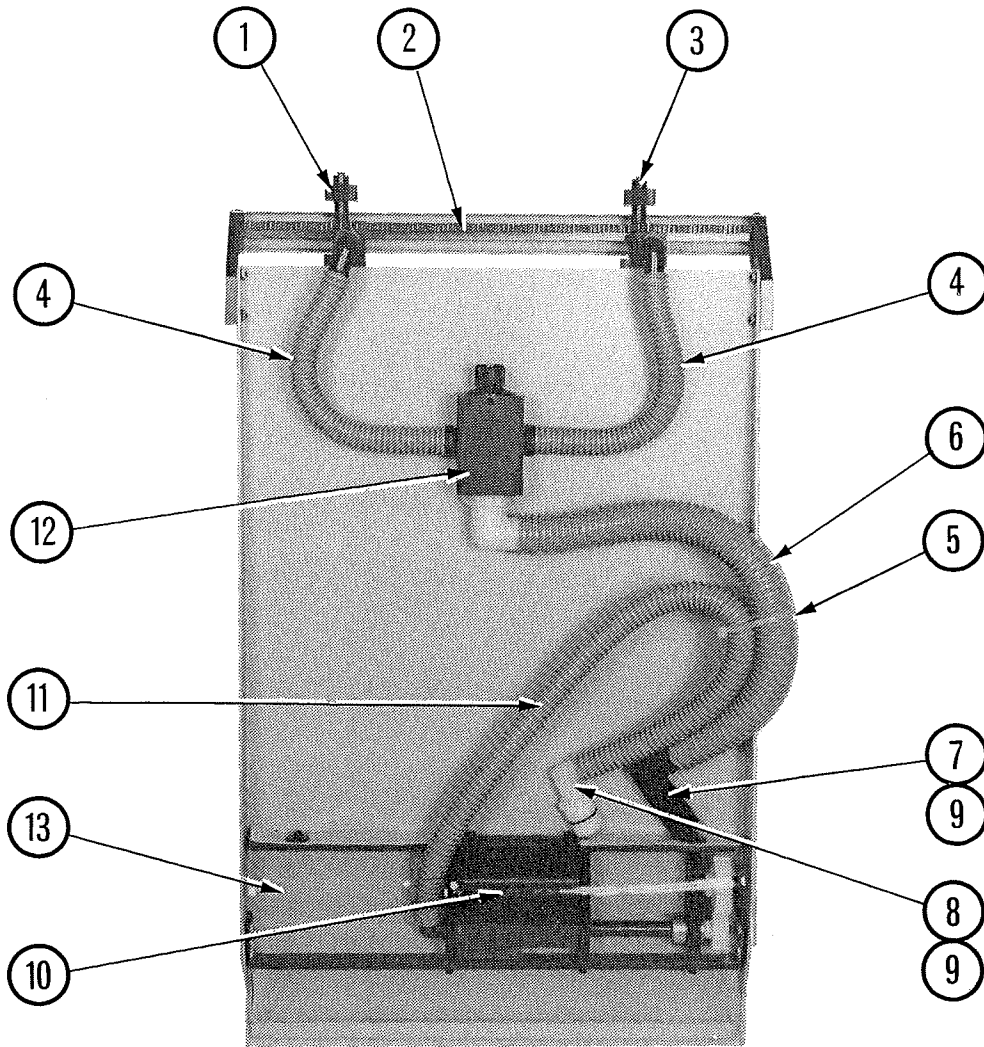
Include machine model & serial number when ordering parts.



FEED TABLE - TOP

Item Description	Part #'s	Item Description	Part #'s
1. Body - Caliper	261-678-01-00	15. Cover - Side Guide Adj	56329-002
2. Nose - Caliper	261-681-01-00	16. Screw - 1/4-20x3/4	31671
3. Assembly - Tab, Sheet Detector	261-680-BG-01	17. Screw - 1/4-20x1/2	31708
4. Knob - Knurled	31720	18. Knob - Side Guide Adjust Stop	23364
5. Decal - Dial, Caliper	261-545-01-00	19. Bracket - Rack Mounting, LH Rear	56322
6. Spring	24216	20. Assembly - Feed Guide, LH	261-593-BG-01
7. Stud - Caliper	261-693-01-00	-- Tube - Feed Guide, LH	261-513-01-00
8. Nut	24747	-- Block - Front, Side Guide LH	261-516-01-00
9. Rack - Side Guide Adj, Front	56303	-- Block - Rear, Side Guide End	56313
10. Plate - Adapter Rack	56176	21. Scale	56400
11. Assembly - Feed Guide, RH	261-594-BG-01	22. Assembly - Shaft & Front Gear	56398
-- Tube - Feed Guide, RH	261-514-01-00	-- Shaft - Side Guide Adj	56307
-- Block - Front, Side Guide, RH	261-517-01-00	-- Gear - Side Guide Adj	56375
-- Block - Rear, Side Guide End	56313	23. Retarder - Rotation	261-372-01-00
12. Assembly - Mylar	56493	24. Assembly - Pipe, Blow	53333
13. Table - Feed	56308	25. Conduit - Cut To Length	54829-006
14. Bracket - Rack Mtg, RH Rear	56342	26. Assembly - Stop, Paper	51634

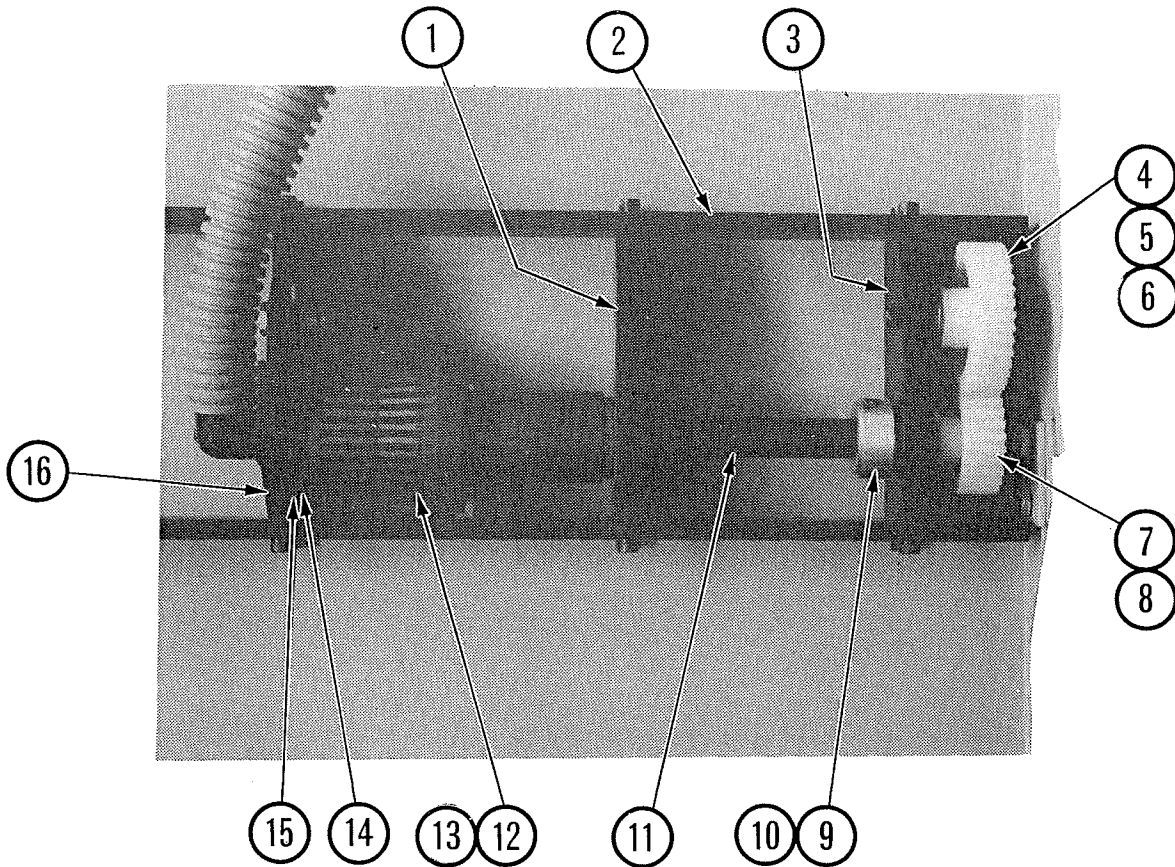
Include machine model & serial number when ordering parts.



FEED TABLE - BOTTOM

Item	Description	Part #'s
1.	Knob - Side Guide Gear Adj	56306
2.	Rack - Side Guide Adj, Rear	56459
3.	Collar - Feed Guide	56304
4.	Hose - 5/8x9	53209-009
5.	Tie - Cable	24298
6.	Hose - 1x16	53331-003
7.	Coupler - Black, 1	56251
8.	Coupler - White, 5/8	56255
9.	O-ring	31390
10.	Guard - Sucker Wheel	56399
11.	Hose - 5/8x24	53209-002
12.	Assembly - Feeder Valve	56393
--	Block - Valve	56315
--	Spool - Valve	56314
--	Fitting - Hose Adaptor	30942
--	Fitting - Adaptor, Elbow	31706
--	Knob	31707
13.	Assembly - Exit Cover	261-627-BG-01

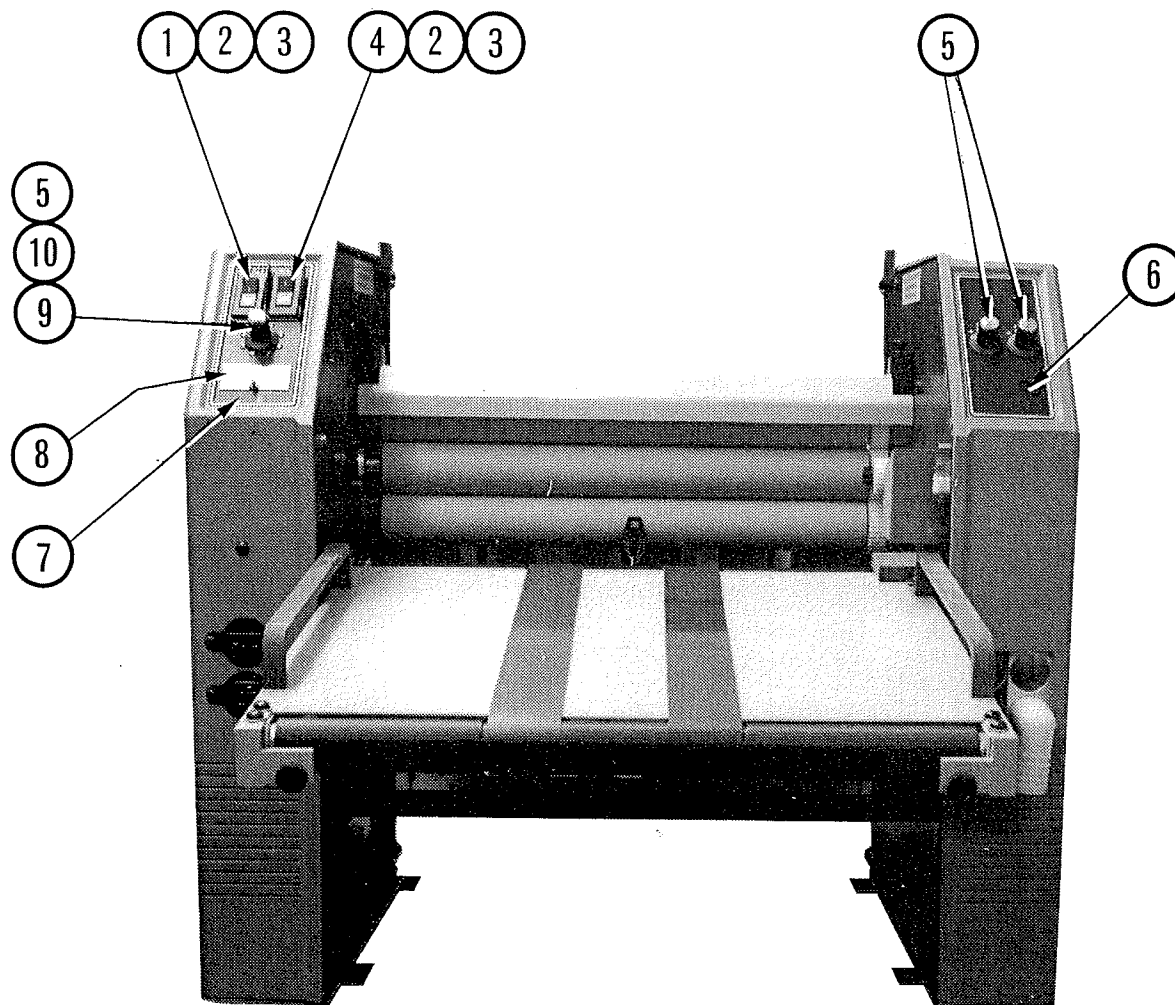
Include machine model & serial number when ordering parts.



FEEDER DRIVE ASSEMBLY

Item	Description	Part #'s
--	Assembly - Feed Drive	56387
1.	Assembly - Bearing Retainer, LH	261-471-BG-01
2.	Bar - Tie	56312
3.	Assembly - Bearing Retainer, RH	261-472-BG-01
--	Retainer - Bearing	261-469-01-00
--	Bearing - Flange	24145
4.	Assembly - Gear	56390
--	Gear - Spur, 35T	45218
--	Bearing - Sleeve	20969
5.	Screw - Shoulder	23231
6.	Bearing - Thrust	30123
7.	Gear - Spur, 25T	45226
8.	Ring - Retaining	21073
9.	Collar	06358
10.	Screw - Br Pt Soc Set, 1/4-20x1/4	24011
NS	Bearing - Thrust	24152
11.	Shaft - Feeder	56320
12.	Assembly - Sucker Wheel	56391
--	Wheel - Sucker	56305
13.	Bearing - Roller	24143
14.	Adapter - Vacuum	56364
15.	Arm - Vacuum Adapter	56309
NS	Spring	31704
16.	Plate - Vacuum Adapter	261-470-01-00

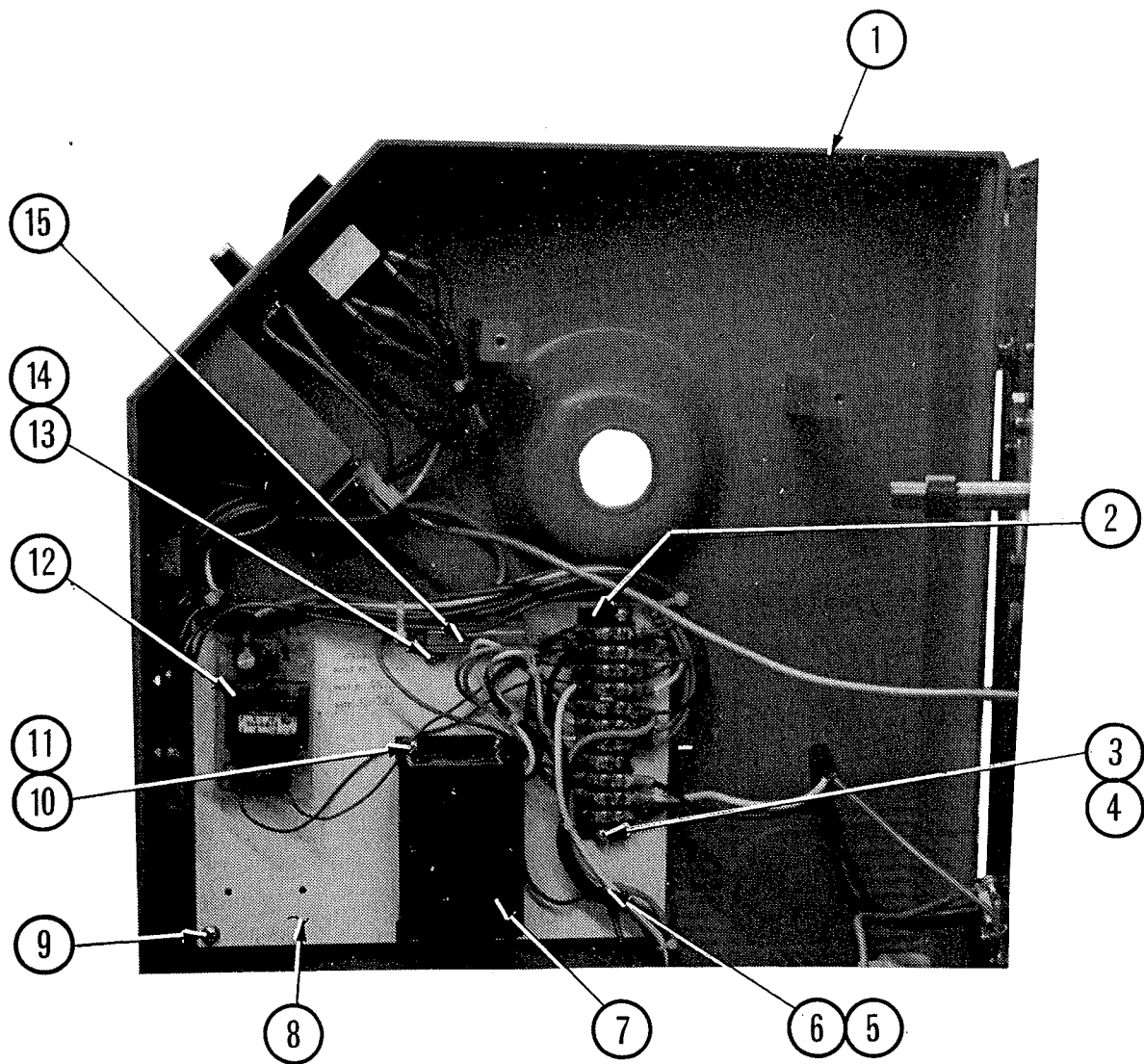
Include machine model & serial number when ordering parts.



PANEL & ELECTRICAL CONTROLS

Item	Description	Part #'s
1.	Breaker (Pump)	30920
2.	Terminal	22999
3.	Resistor	22900-333
4.	Breaker (Power)	30921
5.	Knob - Knurled	30922
6.	Panel - Pneumatic	261-207-01-00
7.	Assembly - Control Panel	56149-001
--	Panel - Control	261-209-01-00
8.	Counter	31682
9.	Potentiometer	22906-007
10.	Nut - Hex, 3/8-32	23617
--	Diagram - Wiring	56195-001

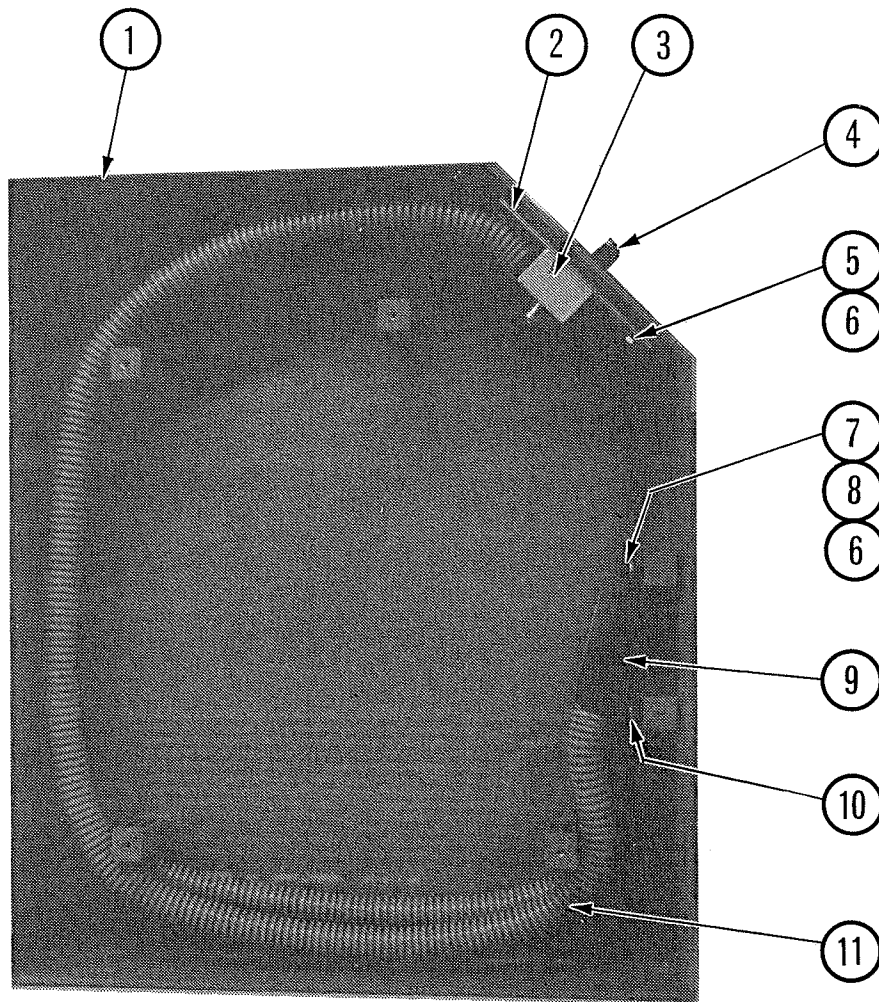
Include machine model & serial number when ordering parts.



INTERIOR PANEL ASSEMBLY

Item	Description	Part #'s
--	Assembly - Electrical Control	56156-001
1.	Guard - LH	56196
--	Assembly - Interior Panel	56193-001
2.	Block - Terminal	30918-011
3.	Screw - Rd Hd Mach, 6-32x3/8	22044
4.	Washer - Int Tooth, 6	23082
5.	Screw - Rd Hd Mach, 10-32x3/4	31142
6.	Washer - Lock, 10	22133
7.	Control - DC	24324-001
8.	Detail - Subpanel	53018
9.	Standoff	30941
10.	Screw - Rd Hd, 8-32x1/4	22290
11.	Washer - Lock, 8	23083
12.	Counter (Reference Only)	31682
13.	Screw - But Hd Cap, 4-40x1/4	23903
14.	Washer - Lock, 4	22138
15.	Resistor - 2 Ohms	30948-4020G
NS	Logo - 714XE	56461

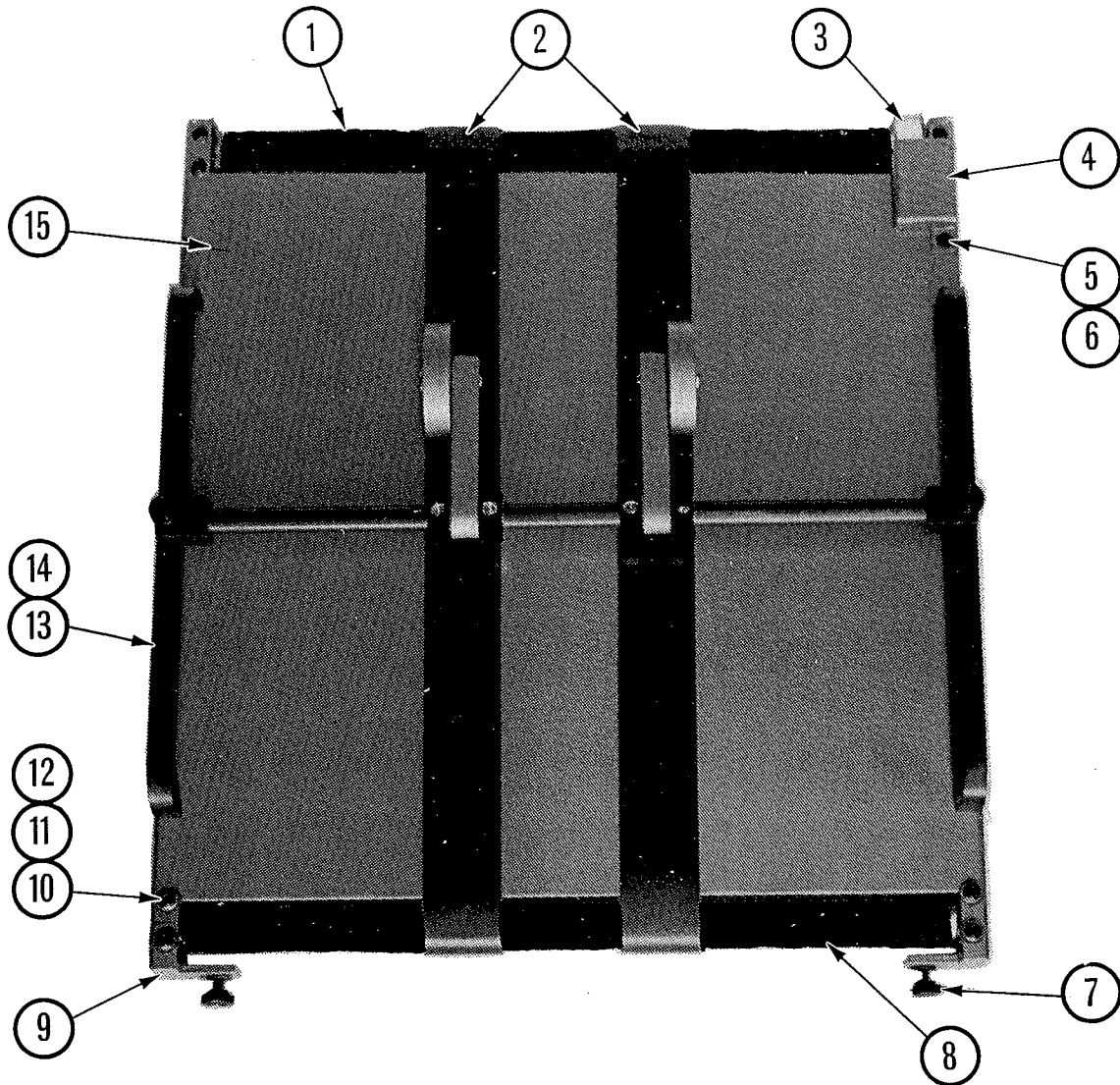
Include machine model & serial number when ordering parts.



PNEUMATIC CONTROL

Item	Description	Part #'s
1.	Guard - RH	56316
2.	Panel - Pneumatic	261-207-01-00
3.	Assembly - Control Manifold	261-213-BG-01
--	Block - Manifold	56426
--	Adapter - Straight	30403
--	Pin - Roll	22493
--	Assembly - Valve	261-212-BG-01
4.	Knob	30922
5.	Nut - Hex, 10-24	20613
6.	Washer - Lock, 10	22133
7.	Screw - Soc Hd, 10-24x5/8	20143
8.	Washer - Flat, 8	22162
9.	Block - Junction	56197
10.	Adapter	30942
11.	Hose - 5/8 ID	53209-004

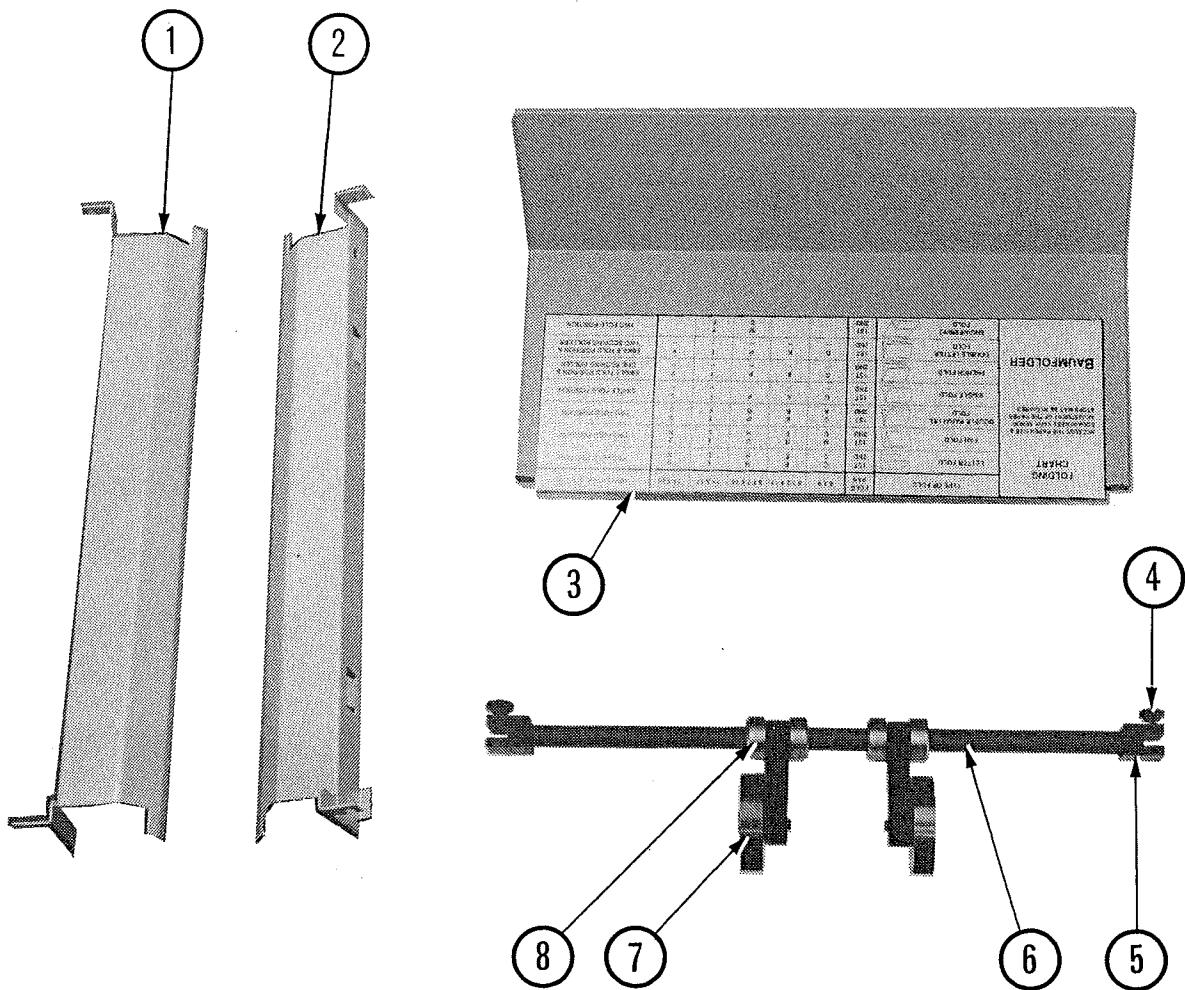
Include machine model & serial number when ordering parts.



STACKER TABLE ASSEMBLY

Item	Description	Part #'s
1.	Roll - Drive	52907-002
2.	Belt - Endless Flat	21771
3.	Gear - 25T	56851
4.	Guard - Stacker Gear	45353-002
5.	Screw - But Hd Cap, 8-32x1/4	24077
6.	Washer - Lock, 8	23083
7.	Assembly - Knob	52240-001
8.	Roll - Idler	52906-002
9.	Assembly - Bearing Block	53329
10.	Screw - But Hd Soc, 10-24x1/2	22754
11.	Washer - Lock, 10	22133
12.	Washer - Plain	20488
13.	Rail - Stacker	47149-002
14.	Screw - Soc Hd, 10-24x3/8	20141
15.	Assembly - Stacker Table	56860
--	Table - Stacker	52908-002
--	Scale (NS)	56861

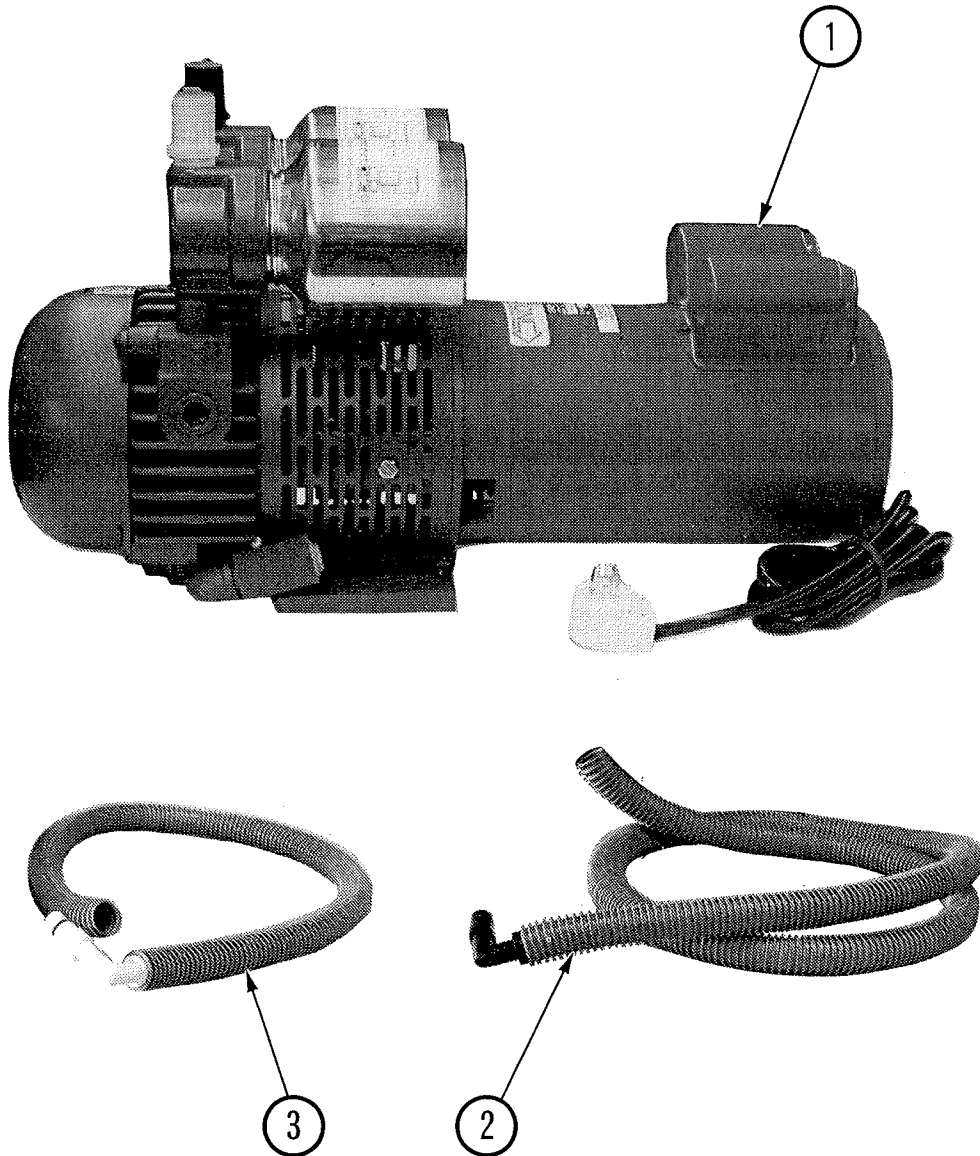
Include machine model & serial number when ordering parts.



STACKER WHEELS & RECEIVING TRAY

Item	Description	Part #'s
1.	Assembly - Guard, Top	53489-002
--	Guard - Fold Roll, Top	56254-001
--	Label - Moving Parts (NS)	50215
2.	Assembly - Guard, Side	53488-002
--	Guard - Fold Roll, Side	56252-001
--	Label - Moving Parts (NS)	50215
3.	Assembly - Stacker Tray	56208-001
--	Tray - Stacker	52909-005
--	Chart - Folding	56246
4.	Assembly - Knob	52240-001
--	Knob - Adjusting	23725
--	Screw - Soc Hd, 10-24x3/8	20141
5.	Slide - Stacker	51693
6.	Rod - Stacker	47148-002
7.	Assembly - Stacker Wheel	47457
--	Support - Stacker Wheel	45088
--	Wheel - Stacker	47367
--	Pin - Stacker Wheel	45091
--	Screw - Soc Set, 10-24x1/4	20446
8.	Collar - Setscrew	31685

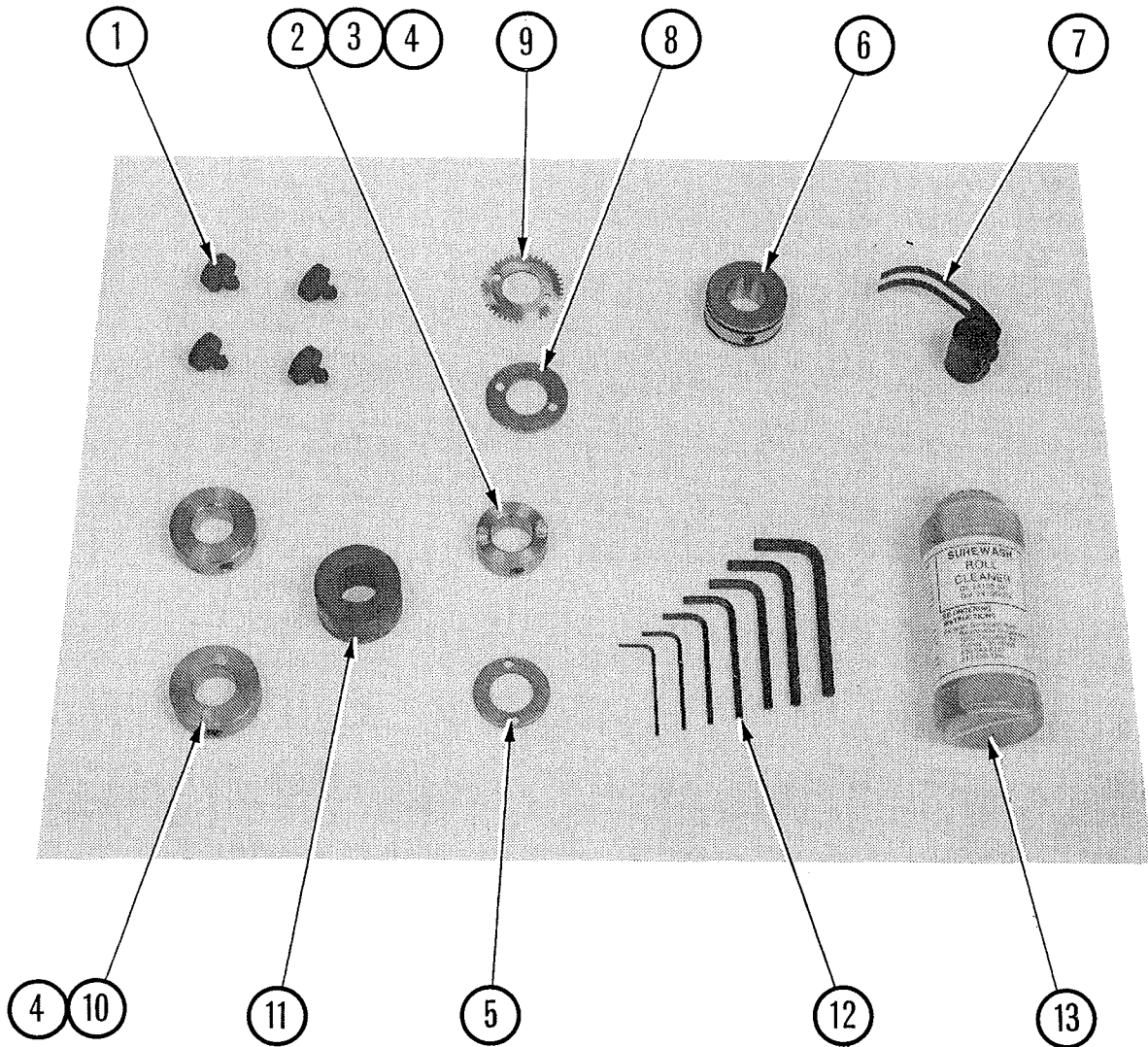
Include machine model & serial number when ordering parts.



PUMP SYSTEM

Item	Description	Part #'s
1.	Assembly - Pump System	52952
2.	Assembly - Hose (black fitting)	53399-003
--	Hose	53331-001
--	Fitting - Hose Coupler, Black	56251
--	O-ring	31390
3.	Assembly - Hose (white fitting)	53399-004
--	Hose	53331-001
--	Fitting - Hose Coupler, White	56253
--	O-ring	31390

Include machine model & serial number when ordering parts.



ACCESSORY PACKAGE

Item	Description	Part #'s	Item	Description	Part #'s
1.	Button - Bumper	22844	--	Stripper	45208
2.	Collar - Blade Holder	06411	--	Washer - Flat, 10	20488
3.	Screw - Fil Hd, 10-24x3/8	20312	--	Screw - Br Tip Soc, 5/16-18x5/16	20438
4.	Screw - Br Tip Soc, 5/16-18x5/16	20438	8.	Blade - Scoring, Thin	06379
5.	Collar - Retainer	06412	9.	Blade - Perforator, 41T	07791
6.	Collar - Female Perforator	06799	10.	Collar - Scoring	07780
7.	Assembly - Stripper	45297	11.	Tire - Scoring	07781
--	Collar	45207	12.	Set - Hex Key, 7 Piece	31003
			13.	Solvent - Cleaning, Surewash	24108-003

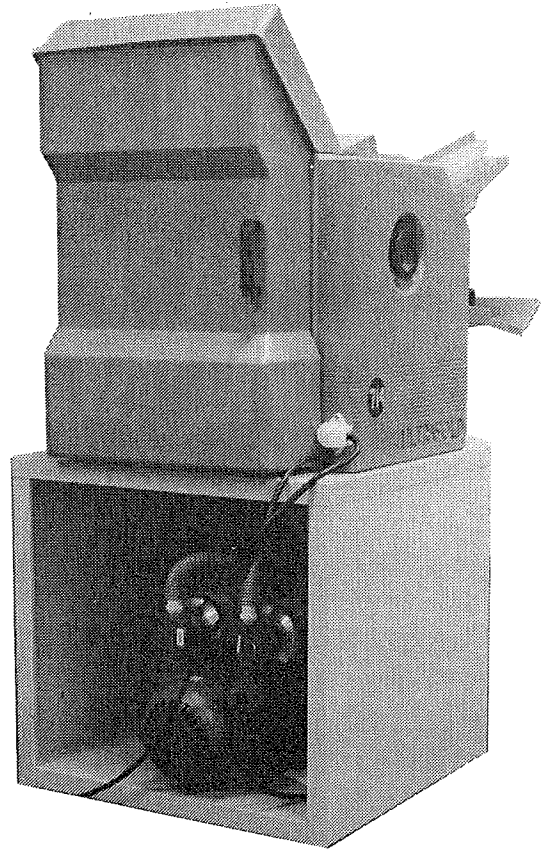
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OPTIONAL 714XE ACCESSORIES

Spare Parts Kit: Part #242-924

Includes the following:

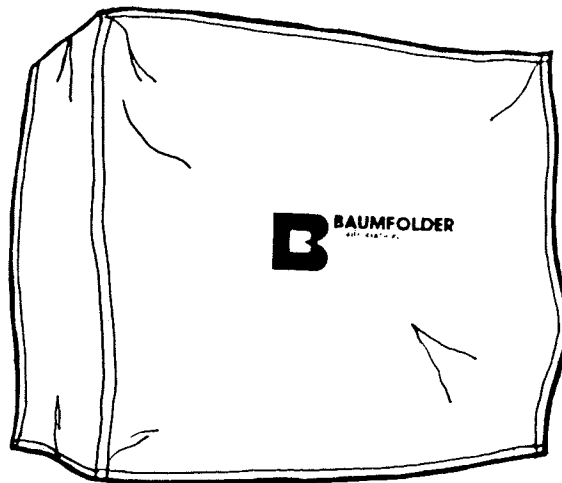
1 Belt - Stacker	24163
1 Belt - Main Drive	24783
1 Belt - Feed	24165
1 24 Tooth Perforator Blade	07619
1 Blade	06798
1 Blade	11962
1 Gear - Spur 30T, Roll	45223
1 Gear - Spur 30T	45230
1 Blade Holder	06411
2 Socket Head Screws	20438
2 Button Head Socket Screws	22378



Surewash: Part#24108-001 (quart)
#24108-002 (gallon)

Baumfolder recommends the use of Surewash to clean the fold rolls and sucker tires on your 714XE Air Feed Ultrafold. See page 10 for usage instructions.

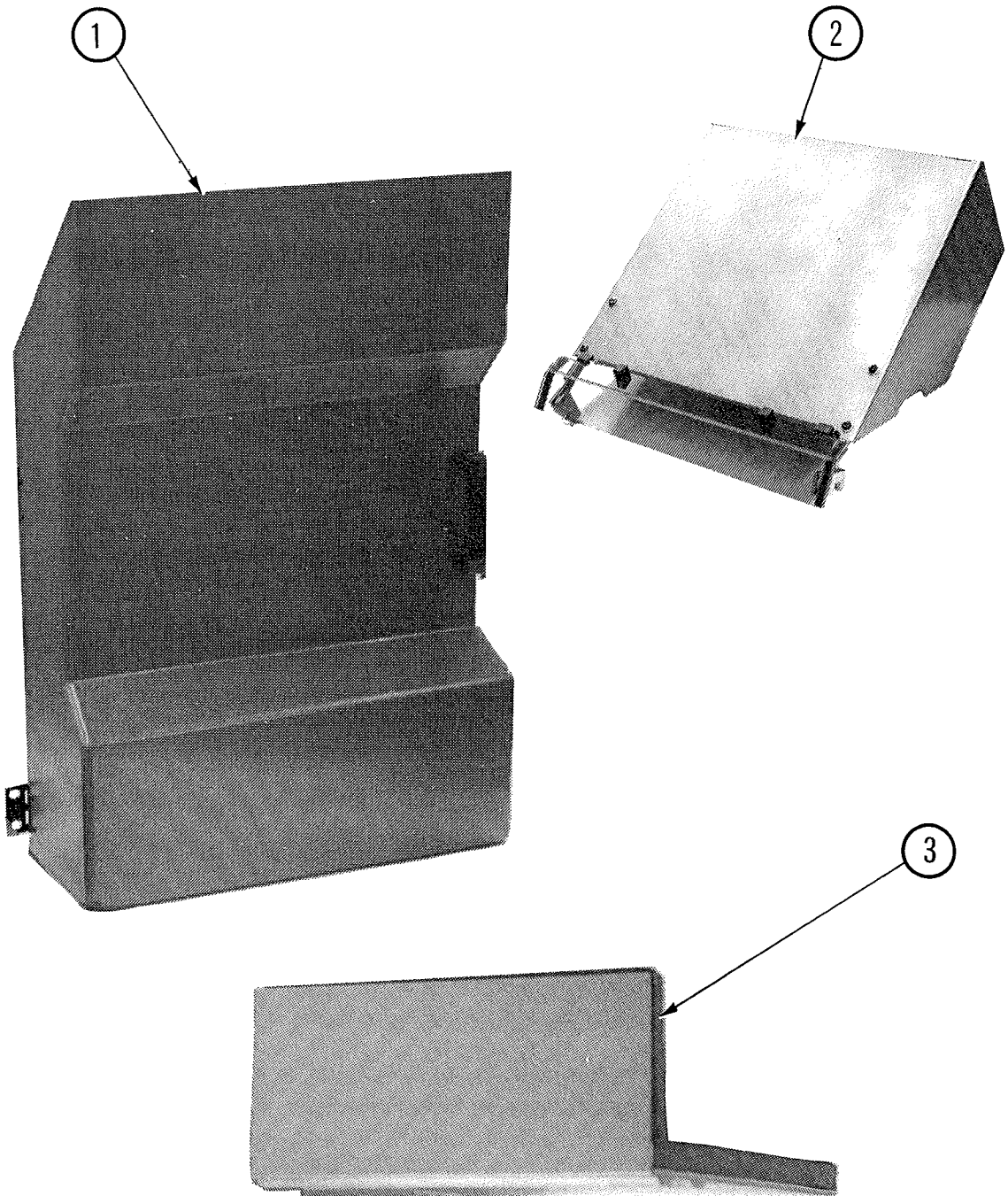
Optional Air Feed Cart: Part#55849-001



Optional Air Feed Dust Cover: Part #51011

Include machine model & serial number when ordering parts.

OPTIONAL SOUND COVERS



Include machine model & serial number when ordering parts.

OPTIONAL SOUND COVERS

Item	Description	Part #'s
1.	Assembly - Sound Cover, Rear	53443-004
--	Hinge	53512
--	Cover - Rear	53447
--	Bracket	53736
--	Screw - #35	31127
--	Screw - But Hd Soc Cap, 10-24x3/8	22755
--	Washer - Int Tooth, 10	22133
--	Washer - Flat, 10	20488
--	Screw - But Hd Soc Cap, 1/4-20x5/8	22570
--	Washer - Lock, 1/4	20481
--	Washer - Flat, 1/4	20489
--	Foam	53456
--	Foam	53459
--	Foam	53458
--	Foam	53460
2.	Assembly - Sound Cover, Top	53442-002
--	Top	53446-002
--	Foam	53454
--	Foam	53455
--	Bracket - Side, RH	54510
--	Bracket - Side, LH	54509
--	Bracket	53453
--	Screw - But Hd Soc Cap, 10-24x3/8	22755
--	Washer - Flat, 10	20488
--	Washer - Int Tooth, 10	22133
--	Bracket	53677
--	Assembly - Caliper Cover	53445-002
--	Foam	53990
3.	Assembly - Sound Drawer	53444-003
--	Drawer - Sound	53448
--	Foam	53457
--	Foam	53461

Include machine model & serial number when ordering parts.

WARNING LABELS

WARNING

**GUARD MISSING
DO NOT OPERATE**

50495

CAUTION

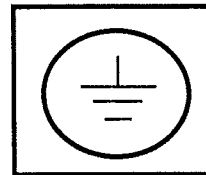
**IMPROPER PLACEMENT
OF SHEET GUIDES WILL
CAUSE ROLL DAMAGE**

KEEP NIP GUARDS IN PLACE

41404

**OPTIONAL
BATCH COUNTER
RECEPTACLES
CONTACT BAUMFOLDER
PARTS AT 1-800-543-6107**

56377



53792

**EARTH
GROUND LABEL**

**CAUTION - HAZARDOUS MOVING PARTS - GUARD MUST BE IN PLACE WHEN
OPERATING FOLDER - KEEP HANDS, HAIR & LOOSE ARTICLES AWAY FROM MOVING PARTS.**

50215

CAUTION

**BAUMFOLDER RECOMMENDS USE OR RBP SUREWASH
TO CLEAN FOLD ROLLS.
THE USE OF ANY OTHER CLEANING SOLVENT CAN DAM-
AGE THE ROLLS AND VOID THE WARRANTY.**

**CONTACT BAUM USA TO ORDER SUREWASH SOLUTION,
1-800/543-6107.**

45533

NOTES

1. Splice red lead to the resistor using butt terminal 30988, crimp the other resistor lead with wire #11 or #13 as indicated.
2. Apply insulating tubing 23898 to both resistor leads of R2 and R3.
3. Complete P/N by adding appropriate suffix.
4. Resistors not used on -002.

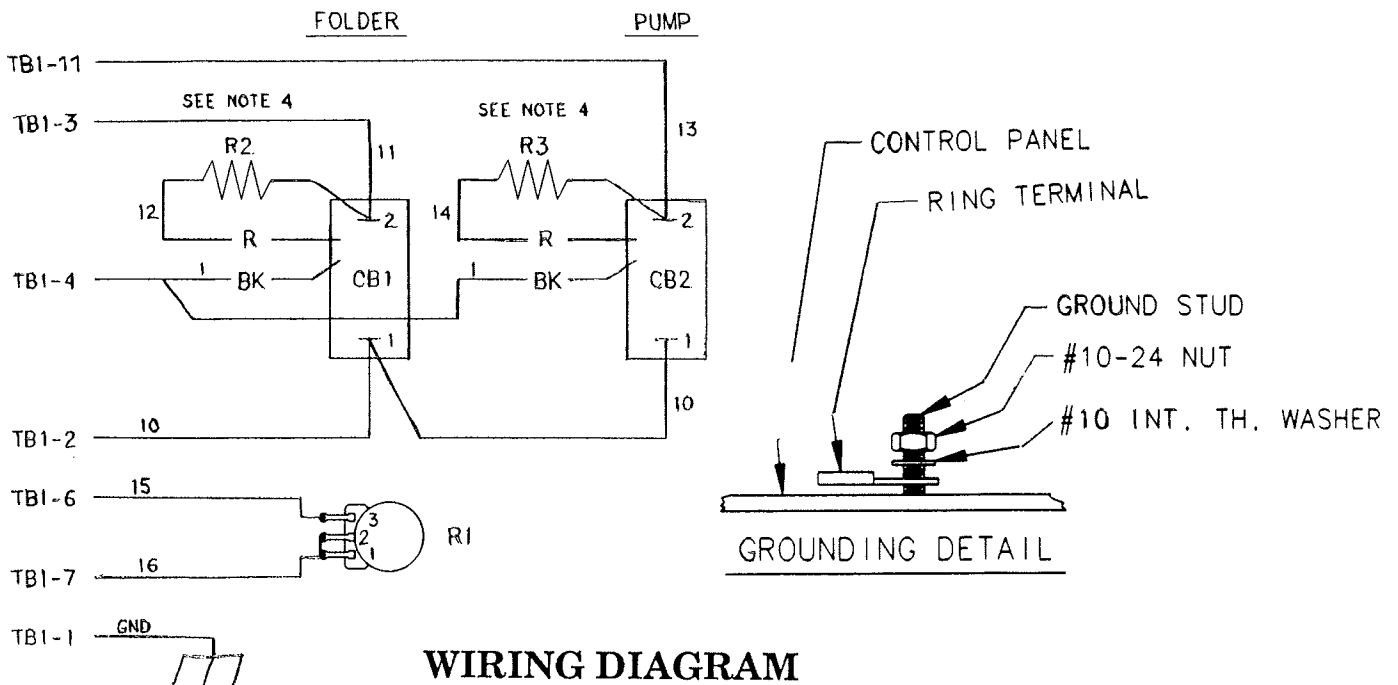
TERMINATION LIST

TERM	QTY.	PART NO.	DESCRIPTION
1	5	22278	#6 SPADE 18 AWG.
2	1	23265	#10 RING 18 AWG.
3	2	21748	#6 SPADE 14 AWG.
4	1	22527	BUTT SPLICE 22 AWG.
5	2	22951	.25 SLIP ON 14 AWG.
6	3	23712	.25 SLIP ON P.B. 14 AWG.
7	2	22999	.25 SLIP ON 18 AWG.
8	3		SOLDER TERMINATIONS

WIRING LIST

CKT NO.	-001 COLOR	-002	AWG.	FROM (T)	LENGTH	
					TO (T)	INCHES
* 1	WH		18	CB1-BK	TB1-5 (1)	21
* 1				CB1-BK	CB2-BK (4)	
10	RD	BR	14	CB1-1 (6)	TB1-2 (3)	23
10	RD	BR	14	CB1-1 (5)	CB2-1 (5)	3
11	RD	BR	18	CB1-2 (6)	TB1-3 (1)	23
* 11				R2	CB1-2 (7)	Note 1
* 12	RD			CB1-R	R2	Note 1
13	RD	BR	14	CB2-2 (6)	TB1-11 (3)	25
* 13				R3	CB2-2 (7)	Note 1
* 14	RD			CB2-R	R3	Note 1
15	V	V	18	R1-3 (8)	TB1-6 (1)	23
16	V	V	18	R1-1 (8)	TB1-7 (1)	23
16			18	R1-1 (8)	R1-2 (8)	
GND	G/Y	G/Y	18	GND (2)	TB1-1 (1)	20

* CIRCUIT NOT PRESENT ON EXPORT FOLDERS (-002)



**WIRING DIAGRAM
56394-001**

NOTES

1. This wire to be 15" long. Terminate with ring terminal 23265. Leave end loose.
2. This circuit not required on export models (243-154).
3. Schematic #56382.

TERMINATION DESIGNATION

TERM QTY. PART NO. DESCRIPTION

1	22	22278	#6 SPADE 18 AWG.
2	4	23265	#10 RING 18 AWG.
3	4	21748	#6 SPADE 14 AWG.

COMPLETE PART NO. BY ADDING APPROPRIATE SUFFIX

WIRING LIST

CKT NO.	AWG.	SUFFIX		FROM (T)	TO (T)
		-001	-002		
		COLOR	COLOR		
1	14	WH	BL	RECP1-Y	TB1-4 (3)
1	18	BL	BL	DCMC	TB1-5 (1)
1	18	RD	RD	CNTR	TB1-5 (1)
1	18	WH	BK	RECP2-2	TB1-5 (1)
10	18	RD	RD	CNTR	TB1-2 (1)
10	18	RD	BR	RECP2-3	TB1-2 (1)
11	18	RD	BR	DCMC	TB1-3 (1)
13	14	BK	BR	RECP1-X	TB1-11 (3)
15	18	WH	WH	DCMC	TB1-6 (1)
16	18	WH	WH	DCMC	TB1-7 (1)
17	18	R	R	DCMC	TB1-8 (1)
17	18	V	V	R4-1	TB1-8 (1)
18	18	V	V	R4-2	TB1-10 (1)
19	18	BK	BK	DCMC	TB1-9 (1)
20	20	RD	RD	CNTR	RECP4-1
21	20	BK	BK	CNTR	RECP4-2
22	20	GN	GN	CNTR	RECP4-3
	14	GN	GN/Y	GND (2)	TB1-1 (3)
	14	GN	GN/Y	GND (2)	RECP1-W
	14	GN	GN/Y	GND (2)	(NOTE 1)

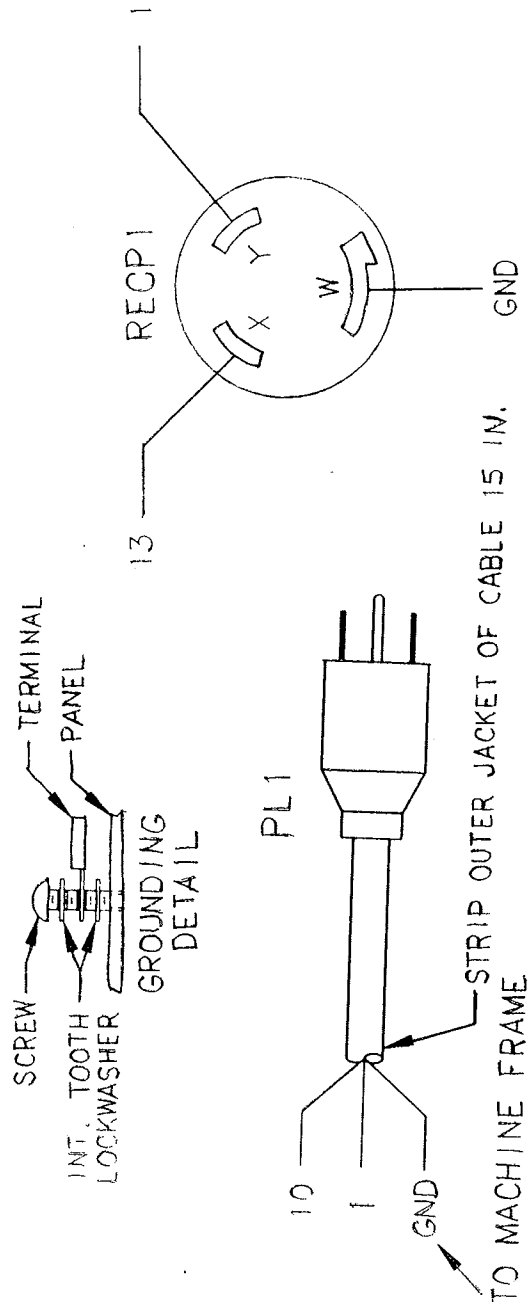
CONTROL PANEL

1	WH	(NOTE 2)	TB1-5 (1)
10	RD	BR	TB1-2 (3)
11	RD	BR	TB1-3 (1)
13	RD	BR	TB1-11 (3)
15	V	V	TB1-6 (1)
16	V	V	TB1-7 (1)
	GN	GN/Y	TB1-1 (1)

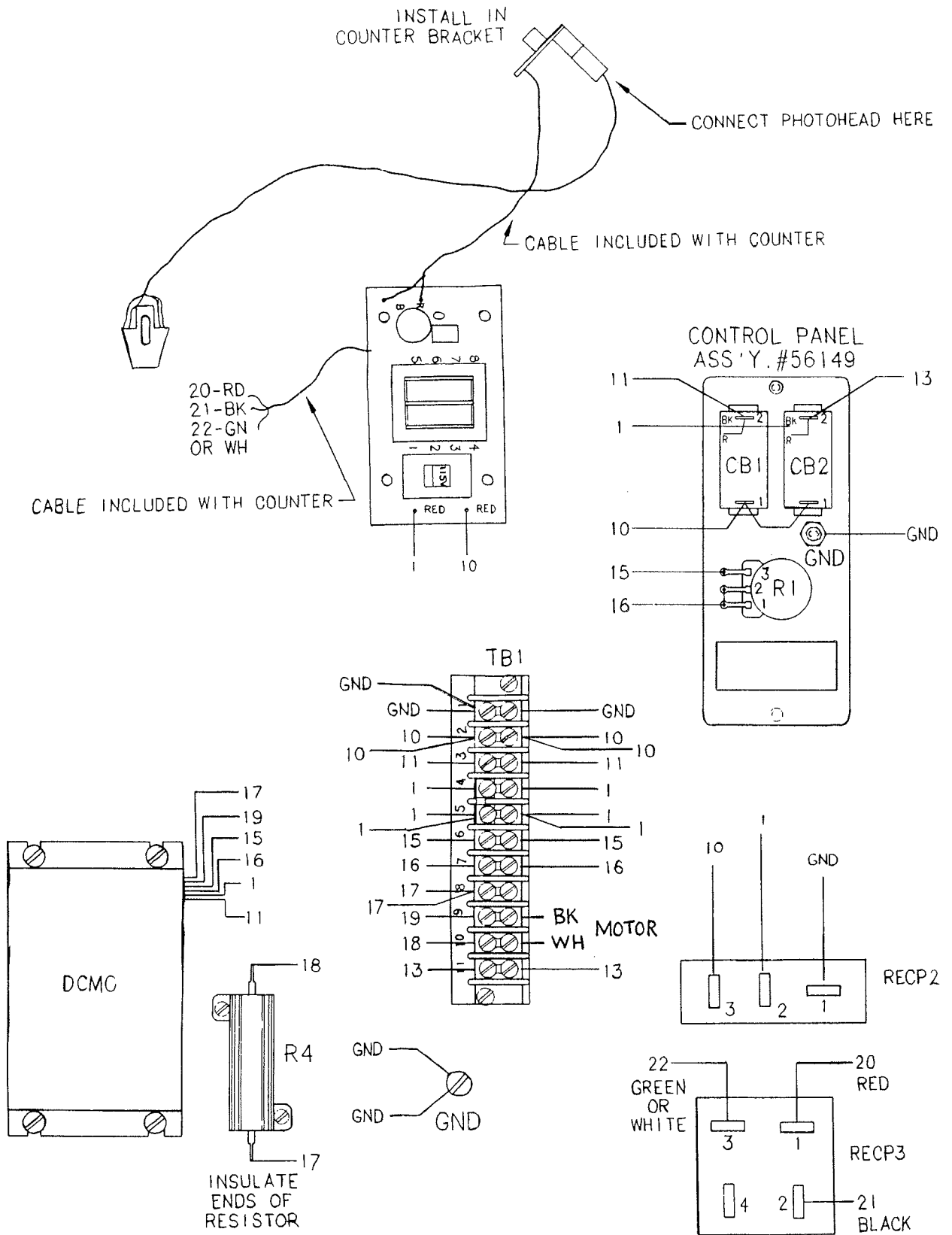
POWER CORD

1	WH	BL	TB1-4 (3)
10	BK	BR	TB1-2 (3)

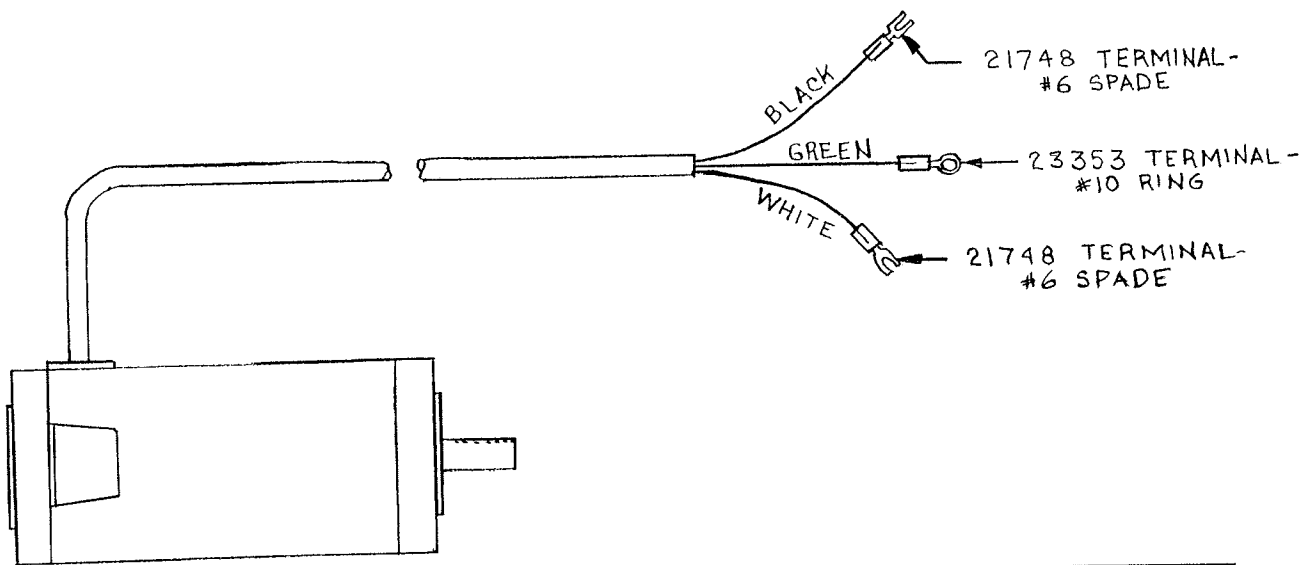
DO NOT CONNECT GROUND WIRE



**WIRING DIAGRAM
56195-001**



WIRING DIAGRAM
56195-001 page 2



DASH NO.	MOTOR	PROCUREMENT
-001	22970-020	143-100
-002	30526	143-200

**WIRING DIAGRAM
53230**

Baumfolder has authorized sales and service representatives located throughout the United States, supplemented by a dealer network.

Call toll free, 800/543-6107, for parts or the number of your nearest sales/service representative or authorized dealer.

BAUMFOLDER
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