

**724 Feeder Problem Solving Tips-n-Hints**

Problem	What to look for...	What should you do...
Signature rolling off crease	<ul style="list-style-type: none"> <li>a. Vacuum pump or pocket valve off.</li> <li>b. Bottom support at station too far back.</li> <li>c. Signatures too soft and/or flimsy.</li> <li>d. Signature not pulled down by suction cups.</li> <li>e. Plate not far enough into signature when released.</li> </ul>	<ul style="list-style-type: none"> <li>a. Turn vacuum pump/pocket valve on and/or verify that it is on.</li> <li>b. Move bottom support forward in station.</li> <li>c. Recheck all setup steps and setup to close tolerances. Consider using brushes on front of vacuum cover plates at station.</li> <li>d. See next problem and solution.</li> <li>e. Adjust vacuum release point cam.</li> </ul>
Signatures not pulled down by vacuum cups	<ul style="list-style-type: none"> <li>a. Heavy weight signatures or vacuum too low.</li> <li>b. Unused vacuum cups not plugged, low vacuum.</li> <li>c. Signatures held too tight in pocket.</li> <li>d. Too many signatures in station.</li> <li>e. Backstop not against pile.</li> </ul>	<ul style="list-style-type: none"> <li>a. Adjust regulator to provide slight increase in vacuum level.</li> <li>b. Install plugs into unused (open) vacuum cups.</li> <li>c. Move station back slightly for about 1/32" clearance along width of signature and make sure you have some side-to-side play.</li> <li>d. Remove some signatures from station.</li> <li>e. Release and slide backstop onto pile.</li> </ul>
Problem feeding signatures after jam is cleared	<ul style="list-style-type: none"> <li>a. Signature plates are out of position, out-of-time.</li> <li>b. Picker fingers bent.</li> </ul>	<ul style="list-style-type: none"> <li>a. Reset clutch and/or retime feeder.</li> <li>b. Replace and/or adjust.</li> </ul>
Signatures missed or torn, not opening for plates	<ul style="list-style-type: none"> <li>a. Signature upside down in pocket.</li> <li>b. Air not turned down to unused stations, air jet too low.</li> <li>c. Air tube clogged.</li> <li>d. Signature not folded correctly.</li> <li>e. Lip support too far out, lower leg catching on it.</li> <li>f. (Only with openers) fingers may not be returning home.</li> <li>g. (Only with openers) fingers are too far out. Possibly beyond leading edge of lip support.</li> </ul>	<ul style="list-style-type: none"> <li>a. Check all signatures in stack and reposition as needed, long leg up, crown facing front station.</li> <li>b. Turn down air to unused stations, reduce vacuum.</li> <li>c. Clean air tube exit port on pocket table. Do not to enlarge opening.</li> <li>d. Remove incorrectly folded signature from stock.</li> <li>e. Readjust as needed. Typically the lip support should extend about 1/16" less than the short leg of signature.</li> <li>f. Check and/or adjust as indicated in section 5., SERVICE, PICKER ASSEMBLY.</li> <li>g. Readjust picker assembly so fingers are about 1/16" from lip support.</li> </ul>
Signatures not placed correctly on saddle.	<ul style="list-style-type: none"> <li>a. Feeders too far away from saddle, out of time with stitcher or overload clutch not reset correctly.</li> </ul>	<ul style="list-style-type: none"> <li>a. Follow instructions in section 6, TROUBLESHOOTING and section 5., SERVICE.</li> </ul>
Sneakers, additional signatures pulled off crown springs.	<ul style="list-style-type: none"> <li>a. Too much space between crown spring skis and signatures.</li> <li>b. Stock pile weight too heavy.</li> <li>c. Station bottom support springs out of position or more required.</li> <li>d. Paper porous, more than one signature sucked down.</li> <li>e. Crown springs weak or broken.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust station back to reduce space.</li> <li>b. Excessive weight causes the signatures to push extras past crown springs. If this occurs, remove some signatures to reduce weight.</li> <li>c. Move station bottom supports upward or use additional springs.</li> <li>d. Replace standard vacuum cup S-1481 with smaller cup S-1482 or reduce vacuum. Maybe raise table slightly.</li> <li>e. Replace defective crown springs.</li> </ul>