

# ROSBACK COMPANY

*Manufacturers of Quality Handcrafted Bindery & Finishing Equipment since 1881.*

## **ROSBACK 203C SYSTEM BOOK SETUP PROCEDURE**

### **Start at 203C stitcher first:**

1. Assemble complete book and mark:
  - Trim marks
  - Center
  - Stitch placement
2. Move stitcher heads for proper placement of stitch.
3. Move clinchers in-line with stitcher heads.
4. String heads and set head compression for thickness of book, also adjust stitch length.
5. Set Caliper (in the OFF position)
6. Set book delivery fingers.
7. Set brush and book check pawl devices.
8. Set delivery stop (1/8" gap).
9. Set delivery rollers for thickness of book.

### **Next move to 706C feeder:**

1. Shut off unused pockets.\*
  - \*Note: If using all six pockets you must shut off pockets #1 and #2 for setup of #5 and #6.
2. Set feeder for book width, never going more than two lines at a time.
3. Start from the rear of the feeder for setup of pockets.
4. Clear flight rods from that pocket \*\*Always shut off machine after jogging.
5. Setup pocket for signature.
6. Load pocket with signatures.
7. Turn on vacuum pump.
8. Clear flight rods from next pocket and repeat procedure for pocket setup.
9. When all pockets are adjusted, advance complete book onto stitcher saddler and set book stop with 1/8" to 1/4" gap. Run 4 or 5 books onto stitcher delivery table.

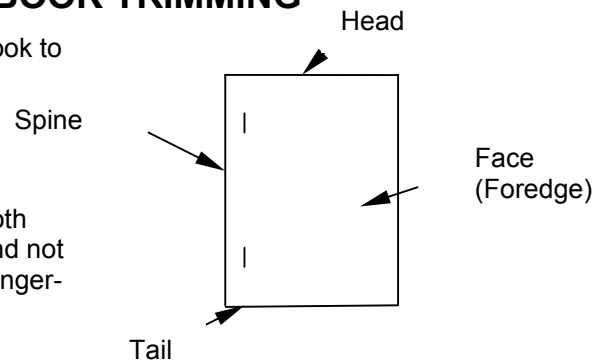
### **Next move to 250C Trimmer**

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## SETTING THE 250C TRIMMER FOR BOOK TRIMMING

1. Set the feed table guides for the book to be trimmed. Center of finished book to line up with center mark on feed table.
2. Rapid adjust the book stops for the face (foreedge) trim size.
3. Adjust the side knife position for the book head/tail trim.
4. Insert a book to be trimmed between the upper and lower tapes. Adjust both tracks to obtain an even grip. The amount of grip must not be too much and not too little. Generally, the book should be easily pulled with thumb and forefinger-grip through the upper and lower tapes.
5. Set the tape control to "SET UP".
6. Place a book onto the feed table and hand crank the machine to feed the book into the knives.
7. When the book spine contacts the face (foreedge) stops, stop cranking the machine and set the control to "RUN".
8. Continue cranking the machine until the face (foreedge) of the book is trimmed and the front knife just clears the book on the upward stroke.
9. Set the tape control to "SET UP". Continue cranking the machine until the face (foreedge) of the book is level with the front of the bottom side knife. Set the tape control to "RUN". Continue cranking the machine until the head/tail stops come up above the side knife bed casting.
10. Set the tape control to "SET UP". Continue cranking until the book spine contacts the head/tail stops.
11. Set the tape control to "RUN". Crank the machine until the side jogger cam followers are in the dwell of the cam.
12. Apply the hand brake.
13. Set the head/tail joggers to just make contact with the head & tail sides of the book.
14. Release the hand brake. Continue cranking the machine until the head & tail is trimmed and the book is ejected from the rear of the machine.
15. Check the size of the book and adjust accordingly.
16. Start the trimmer.
17. Eject one book from the stitcher onto the trimmer feed table.
18. Observe the book as it passes through the trimming stages.
19. If the book passed through the trimmer without any problems feed a minimum of five books through the machine automatically. Observe the face (foreedge) stops and adjust the "FOREEDGE" control so the spine just misses the stops. Immediately adjust the "FOREEDGE" control back until the spine just contacts the face (foreedge) stops.
20. Automatically feed another minimum of five books. Now, observe the head/tail stops. Adjust the "HEAD/TAIL" control until the spine just misses the head/tail stops. Immediately adjust the head/tail control back until the spine just contacts the head/tail stops.
21. Begin running the machine and check periodically the consistency of the trimming.



## TROUBLE SHOOTING:

1. If the book twists sideways when being transported between the tapes, there is probably uneven tape grip between the left and right tapes.
2. The tape drive should switch off immediately when the spine of the book has come in contact with the stops. If there is too much overrun the tapes could possibly mark the book cover.

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*Manufactured in the USA since 1881*