

### Trimmer Problem Solving Tips-n-Hints

Problem	What to look for...	What should you do...
When starting Stitcher/Trimmer, books are delivered onto trimmer table out of time with feed fingers	<ul style="list-style-type: none"> <li>a. If switch is on manual.</li> <li>b. Timing of trimmer feed fingers.</li> </ul>	<ul style="list-style-type: none"> <li>a. Switch to automatic.</li> <li>b. Set timing of feed fingers as described in section 4.</li> </ul>
Book ejects onto trimmer feed table crooked	<ul style="list-style-type: none"> <li>a. Check Stitcher ejector rolls.</li> <li>b. Trimmer feed table guides.</li> <li>c. Check if tucker blade is parallel to saddle ridge.</li> </ul>	<ul style="list-style-type: none"> <li>a. Ejector rolls may require adjustments as described in Stitcher manual section 4.</li> <li>b. Trimmer feed table guides should be adjusted the same at books entering point.</li> <li>c. Adjust tucker blade so that it is parallel to saddle ridge.</li> </ul>
Books have tendency to go under book position guides	<ul style="list-style-type: none"> <li>a. Are guides aligned properly.</li> <li>b. Stitcher feed finger setting.</li> <li>c. Stitcher delivery stops position.</li> </ul>	<ul style="list-style-type: none"> <li>a. Adjust guides as described in section 4.</li> <li>b. Adjust setting of stitcher feed finger.</li> <li>c. Adjust position of stitcher delivery stop.</li> </ul>
Book hits lower front knife	<ul style="list-style-type: none"> <li>a. Check height of feed table guides.</li> </ul>	<ul style="list-style-type: none"> <li>a. Lower trimmer feed table guides.</li> </ul>
Books have tendency of jamming at front knife or in that immediate area	<ul style="list-style-type: none"> <li>a. Trimmer feed fingers timing.</li> <li>b. Setting of primary feed roll lobe cam.</li> <li>c. Trimmer feed table guides.</li> <li>d. books proper register or heading.</li> <li>e. Any interference to the passage of the book.</li> </ul>	<ul style="list-style-type: none"> <li>a. Retime trimmer feed fingers.</li> <li>b. Reset primary feed roll lobe cam position.</li> <li>c. Readjust trimmer feed table guides.</li> <li>d. Adjust book guides.</li> <li>e. Clear stock from trimmer.</li> </ul>
Book fails to come up to first stops for front cut	<ul style="list-style-type: none"> <li>a. Adjustment setting of primary feed rolls.</li> <li>b. Height setting of secondary feed rolls.</li> <li>c. Trimmer feed finger timing.</li> <li>d. Are drive tapes tight and free of grease on underside.</li> <li>e. Lobe cam position.</li> <li>f. Side clamps rise.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust setting of primary feed rolls.</li> <li>b. Reset height of secondary feed rolls.</li> <li>c. Retime the trimmer feed fingers.</li> <li>d. Clean tapes with fast evaporating solvent to free any grease or grime.</li> <li>e. Reposition lobe cam.</li> <li>f. Readjust side clamps.</li> </ul>
Book does not leave front or first cut position	<ul style="list-style-type: none"> <li>a. Primary feed roll adjustment.</li> <li>b. First secondary feed roll tension.</li> <li>c. Drive tapes loose.</li> <li>d. Any book travel interference.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust setting of primary feed rolls.</li> <li>b. Readjust tension of first secondary feed roll directly behind primary feed rolls.</li> <li>c. Tighten drive tapes.</li> <li>d. Clear stock from trimmer.</li> </ul>
Book fails to come up to second stop for side cuts	<ul style="list-style-type: none"> <li>a. Primary feed rolls setting.</li> <li>b. Readjust secondary feed rolls as described in this manual under secondary feed rolls.</li> <li>c. Check drive tapes to see that they are tight and free of grease on underside.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust primary feed rolls.</li> <li>b. Readjust secondary feed rolls as described in this manual under secondary feed rolls.</li> <li>c. Clean tapes with fast evaporating solvent to free any grease or grime.</li> </ul>
Book fails to come up to second stop for side cuts	<ul style="list-style-type: none"> <li>a. Primary feed rolls setting.</li> <li>b. Readjust secondary feed rolls as described in this manual under secondary feed rolls.</li> <li>c. Check drive tapes to see that they are tight and free of grease on underside.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust primary feed rolls.</li> <li>b. Readjust secondary feed rolls as described in this manual under secondary feed rolls.</li> <li>c. Clean tapes with fast evaporating solvent to free any grease or grime.</li> </ul>
Front cut not parallel to crown of book.	<ul style="list-style-type: none"> <li>a. Stops.</li> <li>b. primary feed rolls setting.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust stops.</li> <li>b. Readjust primary feed rolls.</li> </ul>
Head and tail cuts not square with crown of book.	<ul style="list-style-type: none"> <li>a. Stops.</li> <li>b. More pressure on one set of secondary rolls than on the other.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust stops.</li> <li>b. Readjust secondary feed rolls as described in this manual.</li> </ul>
Head and tail cuts not parallel to each other	<ul style="list-style-type: none"> <li>a. Side packers set in too far.</li> <li>b. Book sagging between knives.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust side packers.</li> <li>b. Use book support casting supplied.</li> </ul>
After head and tail cuts, book will not move into the delivery properly	<ul style="list-style-type: none"> <li>a. Setting height and tension of secondary feed rolls.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust height or tension of secondary feed rolls.</li> </ul>
Marking of books	<ul style="list-style-type: none"> <li>a. All tapes, rollers that come in contact with book.</li> </ul>	<ul style="list-style-type: none"> <li>a. Clean tapes with fast evaporating solvent to free any grease or grime.</li> </ul>
Dull Knives	<ul style="list-style-type: none"> <li>a. Books not cutting clean.</li> </ul>	<ul style="list-style-type: none"> <li>a. Sharpen Knives. <a href="#">See Instruction Sheet.</a></li> </ul> <p><b>WARNING: Use Extreme Caution! DO NOT</b> handle dull knives with bare hands. Dull knives are still extremely sharp.</p>