

### 706 Feeder Problem Solving Tips-n-Hints

Problem	What to look for...	What should you do...
Feeder does not run	<ul style="list-style-type: none"> <li>a. Stitcher not reset.</li> <li>b. Overload clutch disengaged at feeder.</li> <li>c. Flexible cable to drive shaft securing screws loose or shaft sheared.</li> </ul>	<ul style="list-style-type: none"> <li>a. Reset stitcher.</li> <li>b. Find and correct cause of overload then reset overload clutch.</li> <li>c. Make sure securing setscrews are tight at both ends of cable and that flexible shaft is in good condition.</li> </ul>
Signature pickup erratic	<ul style="list-style-type: none"> <li>a. Setup procedures wrong.</li> <li>b. Airflow valve (s) open at stations not in use.</li> <li>c. Nozzle in pipe at air manifold plugged.</li> <li>d. Pump defective, vanes worn.</li> <li>e. Sucker cups damaged or defective.</li> </ul>	<ul style="list-style-type: none"> <li>a. Setup job as recommended in manual.</li> <li>b. Close air valves to stations not in use.</li> <li>c. Clean nozzle in pipe of manifold so airflow is not restricted.</li> <li>d. Repair or replace pump.</li> <li>e. Replace cracked or damaged sucker cups.</li> </ul>
Signatures not deposited on stitcher saddle correctly falling off saddle	<ul style="list-style-type: none"> <li>a. Feeder too close or too far from saddle.</li> <li>b. Book width setting incorrect.</li> <li>c. Secondary flight rods out of position.</li> </ul>	<ul style="list-style-type: none"> <li>a. Position feeder as indicated in manual.</li> <li>b. Adjust book width.</li> <li>c. The first secondary flight rod should be 1/16" (1.6mm) in back of primary flight rod. If a jam occurred, the secondary flight rod may be out of position in 1/2" (12.7mm) increments. See manual for this adjustment.</li> </ul>
Signatures not deposited on saddle correctly feed finger hits signature before flight rod clears	<p>Feeder and stitcher out of time. If problem occurs again then check:</p> <ul style="list-style-type: none"> <li>a. Main drive chain tension tool loose.</li> <li>b. Flexible shaft loose or damaged.</li> <li>c. Wrong tension on flight rod chains.</li> </ul>	<p>To retime, see operators manual.</p> <ul style="list-style-type: none"> <li>a. Adjust idler tension.</li> <li>b. Retighten or replace.</li> <li>c. Adjust tension.</li> </ul>
Flight rods miss or tear signatures lower fold of signature not opening every time	<ul style="list-style-type: none"> <li>a. One or more signatures upside down in station.</li> <li>b. One or more signatures folded incorrectly.</li> <li>c. Signature openers (picker fingers) not returning all the way.</li> <li>d. Picker fingers (opener) too high.</li> <li>e. Picker fingers (opener) too far forward.</li> <li>f. Station bottoms too far back.</li> <li>g. Air flow too low.</li> <li>h. Up-curl in covers stock or heavy material.</li> <li>i. Signatures sticking.</li> </ul>	<ul style="list-style-type: none"> <li>a. Check stack and relocate correctly.</li> <li>b. Remove incorrectly folded signatures from stack.</li> <li>c. Fingers prevent lower leg of signature from falling. Make sure opener springs have enough tension wind as needed.</li> <li>d. Opener (picker fingers) stopped by sagging signature on backstroke. Readjust opener (picker finger assembly).</li> <li>e. Fingers are beyond leading edge of lip support. Readjust location of opener (picker finger assembly).</li> <li>f. Move station bottoms away from station back or even remove one or more station bottoms.</li> <li>g. Readjust airflow to station.</li> <li>h. Remove and roll stock in opposite direction.</li> <li>i. Fan signatures in stack before returning to pocket. If problem remains, consider readjusting individual picker fingers until they just touch lower leg of signature.</li> </ul>
Signatures roll off flight rod after pickup	<ul style="list-style-type: none"> <li>a. Vacuum release too late or too early wrong setting.</li> <li>b. Vacuum valve sticking.</li> <li>c. Signature not pulled off crown springs.</li> </ul>	<ul style="list-style-type: none"> <li>a. Readjust vacuum stroke.</li> <li>b. Clean valve stems and lubricate.</li> <li>c. Setup problem. See manual</li> </ul>
Primary flight rods may be hitting vacuum cups	<ul style="list-style-type: none"> <li>a. Tension too loose on main drive chain.</li> <li>b. Tension on flight rod chains incorrect.</li> </ul>	<ul style="list-style-type: none"> <li>a. Adjust idler tension.</li> <li>b. Adjust tension.</li> </ul>
Small or tightly folded signatures catch in feed finger slot on stitcher saddle	<ul style="list-style-type: none"> <li>a. Deflector needed at Stitcher.</li> </ul>	<ul style="list-style-type: none"> <li>a. Install deflector #706-041 on Stitcher when feeding small signatures.</li> </ul>