ACCUCREASER

6-2010
Version 1.1

Serial Number _____

Date _____

INTRO LETTER

Congratulations,

You have purchased the most versatile automatic creasing machine on the market today. Designed to accommodate the demands of finishing digitally produced media, the AccuCreaser efficiently applies a rotary actuated compression crease, leaving a crisp, sharp score with no cracking of the image after the fold, on both the outside and inside creased edge.
Counts trademarked RAC System assures a consistent, controlled compression that is easily adjustable to the demands of any sensitive media.
The AccuCreaser with its microprocessor driven transport promises many years of profitable operation.

Your AccuCreaser was manufactured at Count's headquarters in Escondido, California. We are proud to build quality equipment and stand behind our machines knowing that the quality of our product is exceeded only by the staff which supports it.

Thank you for choosing Count.

Sincerely,

David M. Gilbert

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ELECTRICAL SPECIFICATIONS

Power Requirement:	110v, 60 HZ, AC, or International 230v, 50/60HZ, AC
	20 amp line required for models with pump
Circuit Protection:	Motor/Transformer.....3 AMP Circuit Breaker
	Microprocessor.....1/4 AMP Slo-Blow
	Pulse Board.....3 AMP Slo-Blow

NOTE: Older buildings, overloaded lines, and bad grounds can affect the operation of your AccuCreaser. A regulated dedicated line is recommended.

OPERATING SPEEDS

MODE	TRANSPORT SPEED (Feet per Sec.)	11X17 Sheet(est)	5 ½" Sheet(est)
Perf Mode	2.5	8500	12500
Crease Mode	2.0	2500	4400

△SPECIFICATIONS

Net Weight:	ACCUCREASER.....350 lbs
Overall Dimensions:	.....32"Lx27"Wx26"D
Boxed Dimensions:	.....36"Lx36"Wx48"H
Min. Sheet Size:	.....3"x5"
Max. Sheet Size:	.....18"x20"

NOTE: The AccuCreaser is capable of handling many types of applications above and beyond the standard specifications. It is possible to feed quite a variety of jobs, from 30" sheets to die cut stocks. However, the performance of the AccuCreaser on these special applications is directly related to the experience of the operator.

SAFETY PROCEDURES

BEFORE USE:

- Read through the owner's manual. Follow instructions CAREFULLY.
- NEVER use a wet area. Electric shock could occur.
- Use a GROUNDED outlet and a GROUNDED circuit. Do no use ungrounded equipment on the same circuit.
- Always use a dedicated line. DO NOT use with line splitting surge protector.

DURING USE:

- Keep fingers and hands away from creasing bar, perf blades, and rubber rollers.
- Keep cords clear of moving parts.

AFTER USE:

- Turn off machine at the rear panel, then unplug the main power cord. This will prevent damage to your machine by power/voltage spikes.
- To unplug cords, always grasp the plug body, never pull on cords to disconnect. Wire fatigue and possible shock could result from improper disconnect procedures.

BE ALERT! BE CAREFUL!

CARE AND MAINTENANCE

The ACCUCREASER is a precision machine. It is very important to keep it free of excessive dust, dirt and foreign matter. We recommend that you keep the machine **covered** when not in use.

BEARINGS/BUSHNGS: The bearings are sealed roller bearings and are designed to be self lubricating, however dirt and dust can get into them causing clogging and dirt build up. It is recommended to oil them daily under heavy use or monthly under light use. The Bushings are Bronze are do require lubrication more frequently. Oil these once a week under heavy use.

STRIKE DIE: The groove in the lower die should be cleaned periodically using a toothbrush to remove any dirt or build up.

SENSOR EYE: Clean the upper and lower sensor with a Q-tip (avoid moving the sensor to clean). Clean when necessary.

REMOVEABLE SCREWS: When these show signs of wear or stripping, replace as soon as possible. If these strip or hollow out they can be costly to remove. If you do keep your AccuCreaser clean and in top condition, it will give you years of service.

COMPONENT IDENTIFICATION

REFERENCES

WARRANTY

Count Machinery Company warrants each Accucreaser AFT Machine against defective parts or workmanship under normal use and service for a period of one year on electrical and all other parts from the date of purchase. During this time COUNT will either repair or replace any COUNT unit returned (shipping prepaid) which, after examination by us, is determined to be defective. **All freight charges for equipment sent in for warranty service are the responsibility of the purchaser and must be prepaid.** Count will not be held responsible for any shipping charges. You may request your desired shipping method. If no method is stated, COUNT will send the item UPS ground. This warranty shall not apply to products that have been repaired or altered by anyone except for COUNT, or which has been subjected to misuse, negligence, or accident. Under no circumstances will COUNT be liable for consequential damages. The user shall determine the suitability of the product for the intended use and the user assumes all risk and liability whatsoever in connection herewith. For service, return the machine prepaid with written explanation of services needed to:

Count Machinery Company
2128 Auto Park Way Escondido, CA 92029
Tel: 760-489-1400 Fax: 760-489-1543
E-mail: info@countmachinery.com

Notice:

The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied but the operator.

We strive for continued improvements in our equipment line. Therefore, we reserve the right to change specifications without notice or liability to existing count equipment in the field.

Please complete the following information for your future reference.

Serial no. :_____

Purchased by : _____
Date purchased: _____
Count invoice no. :_____

ACCUCREASER
MICROPROCESSOR CONTROLLER

THE MICRO-CONTROLLER CONSISTS OF FOUR SECTIONS:

1. Controller Display
2. Operate Controls
3. Programming Controls
4. Data Pad

Controller Display

The LCD displays programming information, prompts response, and verifies entered data or commands. The LCD also conducts a self-diagnosis test whenever power is turned on. A countdown sequence from 9 to 0 will appear. If a number is missing from the sequence this indicates a failure in a component. If this occurs, contact the Count service department for further details. At the display of “EZ Creaser” the microprocessor is clear and ready to accept the entries. The micro-controller is also equipped with volatile memory so when power is turned off the AccuCreaser will retain the last programmed entry.

TRANSPORT OPERATION

- A document may be slowly advanced through the transport by pushing and holding this button.

  EXAMPLE:  

  The motor should advance transport at slow speed and stop whenever finger is lifted.
- Controls on-off function of motor.

  EXAMPLE:  

  Machine will run at mode and speed previously selected. If no mode has been selected, it will automatically run in perf mode at low speed.
- Machine will stop.  

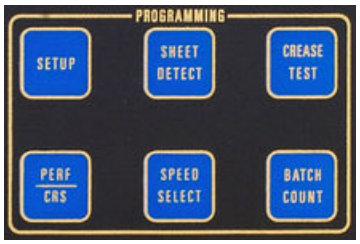
NOTE: If the ACCUCREASER is stopped while a sheet is under the sensor, the display will flash “sensor blocked”

DATA PAD

- **Data Keys 0-9:** Allows entry of numeric data required for distances and crease designation.
- **Enter/Yes:** Stores input information from data keys and answers display prompted questions.
- **Clear/No:** Erases errors entered and prompts for clearing total count. Answers “no” to display prompted questions.

PROGRAMMING CONTROLS(Mode Selection)

Speed Select: Pushing this will select speed, low, medium or high and show the speed selected on the display.
Mode Select: PERF/CRS Pushing this will Change the mode your machine runs in. By Default and every time your machine is powered off the machine will start in PERF mode. Press the PERF/CRS mode button twice to enter into Crease Mode.



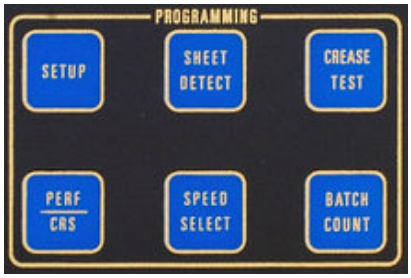
EXAMPLE:	DISPLAY READS:
	CRS Mode Low Speed
	CRS Mode Med Speed
	CRS Mode High Speed

These may be pressed until the desired mode is selected, then: 

Pressing 

will now run transport at selected mode.

PROGRAMMING FOR CREASING



•**Set-Up**: Pressing this will present a request for the selection of a distance where the location of the number is requested in hundredths of an inch from the lead edge of the sheet.
•**Crease Test:** Pressing this button will fire the crease bar one time.

SETTING UP CREASING

Crease Mode: Press the PERF/CRS button twice this will put the machine in crease mode then hit enter and follow the steps below.

EXAMPLE:

DISPLAY READS:

Dist 1 = 0.00

You can now enter the desired location for your crease, from .1 to 20 inches.

Dist 1 = 1.50

Sel Crease Bar = 0

You can now select the crease bar you have selected for the job.

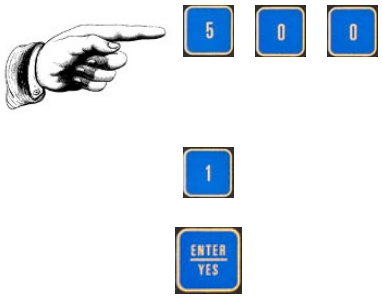
Sel Crease Bar = 1

End Program? Y/N

Answering yes will complete the programming sequence. Answering no will prompt the next location for a crease (see next page) the ACCUCREASER will accept up to 8 locations to crease.

EXAMPLE:

DISPLAY READS:



Dist 2 = 0.00

Dist 2 = 5.00

Sel Crease Bar = 0

Sel Crease Bar = 1

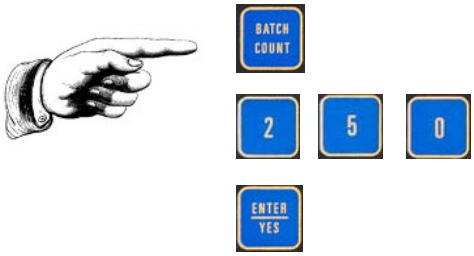
End Program Y/N Program Complete

You have now programmed your ACCUCREASER to crease in two locations. Press run and place 1 sheet on the feed table. The sheet should feed through stopping twice to crease. If this does not occur, check your mode and make sure your selections have been accepted. Remember, the speed and mode can be changed at any time, and will not affect the program.

BATCH COUNTER

EXAMPLE:

DISPLAY READS:



Batch Count = 0

Batch Count = 250

EZ Creaser

This will allow 250 sheets to pass the sensor then stop transport automatically. Pressing run will batch another group of 250 sheets. You can set the batch counter up to 9999.0 the feature is convenient for chip boarding small groups to be padded, or wrapping larger jobs in predetermined packages.

CLEAR BATCH COUNT:

DISPLAY READS:

Batch Count = 250

Batch Count - 0

EZ Creaser

TOTAL COUNTER

The micro-controller automatically counts any paper being run through the transport. This count is displayed as the ACCUCREASER is operating and when it is stopped. To clear the counter:

DISPLAY READS

Clr Tot Cnt = Y/N

Total Count = 0

SETTING THE DOUBLE SHEET DETECTOR

Note: Sheet detector works on the basis of measurement comparison using the length of the sheet to verify more than one sheet.

To turn on:

1.  

=Display will read (measuring length)
Machine will automatically start to advance

2. Place sheet of job to be run in machine

3. After paper runs through the machine will stop and a dashed line will appear in the bottom of left corner of display, thus indicating that the sheet detector is activated.

To turn off:

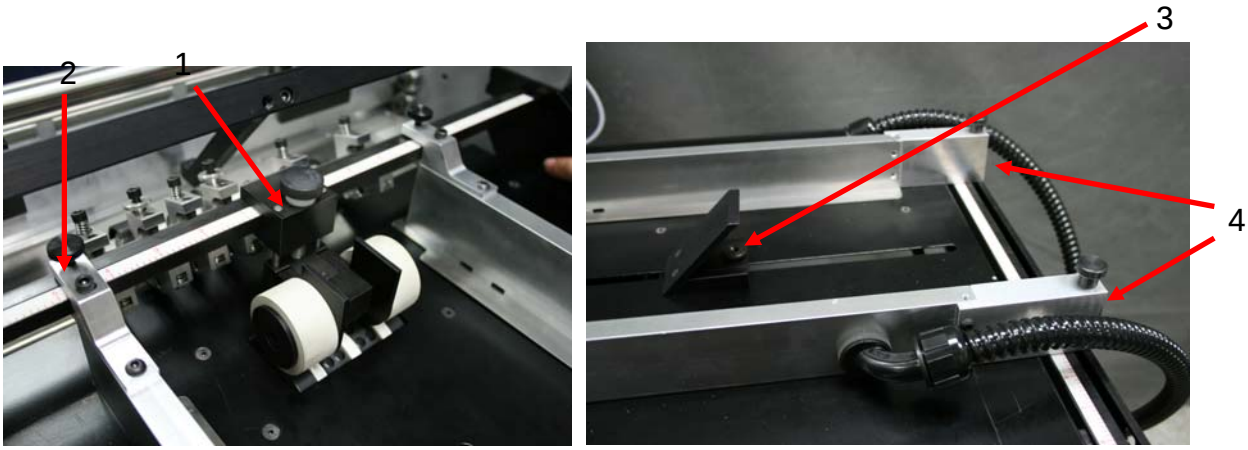
1.  

=Dashed line on display will vanish from display, thus indicating that the sheet detector is off.

PROGRAMMING NOTES

- The micro controller is capable of positioning creases from 1/2 of an inch from the lead edge to ½ inch from the tail edge and up to 26 inches from the lead edge.
- The crease bar can be programmed to strike single or multiple locations with a capacity of 10 locations.
- When programming multiple locations to crease, the distances must be entered in an ascending order. For example, if 1.5 is the first location, the controller will not accept an entry of 1.2 after this. If this is attempted, the display will read “crease out of range”
- If the incorrect key is pushed while programming, a beep will occur and the display will flash “keyboard sequence error”. Wait 3 seconds then respond as prompted.

FEED TABLE ASSEMBLY



1. Height Adjustment Knob
2. Feed Rail Lock Knob Front
3. Paper Guide Slide Assembly
4. Feed Rail Lock Knob Rear

DELIVERY TRAY ASSEMBLY

INSTALLING THE DELIVERY TRAY

Position the tray to slide it under the 2 dowel pins and rest it on the lower dowel pins.

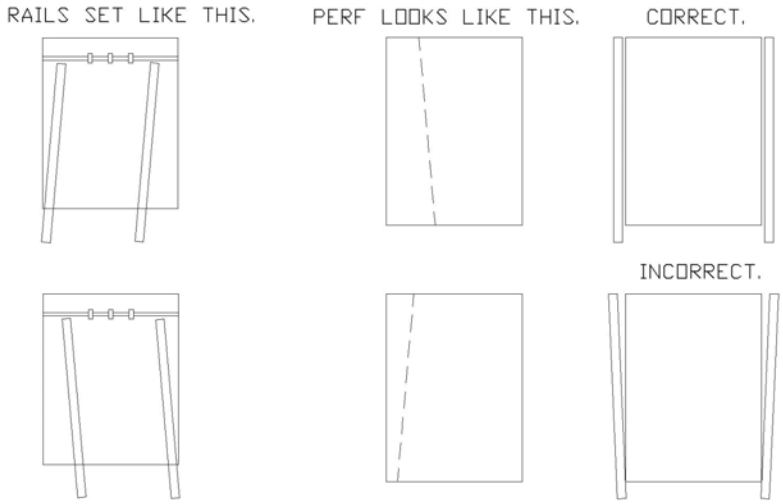
Dowel Pins Used to
Hold Delivery Tray

ADJUSTING THE FEED RAILS

The feed rails on your ACCUCREASER are designed to adjust easily in case of a problem with crooked feeding. By loosening the feed rail alignment lock knobs you can move each rail independently to square them to your stock. To maintain an accurate perf or score, it is important to get the rails as aligned and snug to the sheet as possible without “squeezing” the sheet, as this will create drag and cause the sheets to hang up in the rails.
To adjust this correctly, use one rail as your reference, the left (operator side). Place your stock squarely against it then bring your right rail in and tighten, looking down it from the rear. Adjust the rail with the skew adjustment knob so it is squared to the sheet. Then tighten the lock knob, and place your ACCUCREASER in perf mode. Set a sheet in the feeder, and under the feed wheels, then press run.
Check perf by folding over and aligning the perfed edge.

Perf holes should line up within a blade’s width. If they do not line up, adjust rails accordingly, moving your left rail first and then adjusting the right rail to square the sheet. This may take a few attempts, but this adjustment is important to produce quality perf and score jobs.

EXAMPLE:



SQUARING THE FEED RAILS

The constant fine tuning of the rails will make it necessary to bring the rails back to true “square”. To do this, take a sheet of 8 1/2 x 11” cover stock and place it in the feed table against the operator side guide. Pressing the sheet against the rail, slide the rail over so that the front edge of the stock lines up to the front edge of the feed table. Loosen the feed rail adjustment lock knob, and use the skew adjustment knob to adjust the rail so that the sheet is aligned with the left to right with the edge. Once this is done, slide the opposite side guide into position and adjust it to the edge of the sheet. Your rails should now feed the sheet perfectly aligned providing a straight perf or score.

SETTING THE AUTOMATIC FEEDER

For efficient Auto-feeding, the setting of the caliper to the vacuum wheel is very important.
Use a piece of the stock to be run as a “feeler gauge”. Place a sheet under the feed wheels, turn the feed wheel adjustment screw (Counterclockwise to raise, clockwise to lower) so that the paper can slip freely under the wheels. The feed wheels should be barely touching the stock. If during the feeding you begin to get doubles, lower the feed wheels just enough to stop the double sheeting. The paper between the friction plate and the auto feed wheel must move freely and should not be gripped. (fig.?)

FEED DRIVE BOX

The feed drive box is the little black box located directly below the feed table. This drive box consists of shafts, gears, pulleys, rubber rollers and o-ring belts.

1.
2.
3.
4.
5.
6. Vacuum drive rubber rollers F-2166

When installing the feed drive box stretch the oring belt over the drive pully.

LOADING THE FEEDER

Take the paper and load the feed tray. The leading edge of the bottom sheet is slightly forward of the stack and so on throughout the stack. Lift the stack and tuck the slide assembly under the rear edge of the sheet just slightly.
The feed wheels should be spaced evenly across the lead edge of the job to be run. These wheels are designed to easily slide on the shaft to the position necessary.
Note: do not allow the machine to run with the feed wheels in contact with the **friction plate.** This will cause the feed wheels to wear too quickly.

FEEDING NOTES

- When set properly, the feed is very efficient and flexible. When neglected it can become very frustrating to run even the simplest job. The adjustments previously discussed are very important.
- The EZ CREASER is capable of running 20lb. single sheets, 4 part forms and 100 lb cover. It is also very capable of handling gloss, coated, and even laminated stocks. Its flexibility is directly related to the operator's experience.
- All carbonless sets are fed into the EZ CREASER with as little pressure from the feed wheels as possible. Use just enough pressure to eliminate double feeding.
- To clean the feed wheels, use only water on a clean cloth. Wipe the rollers in the direction of the ribbing while turning them by hand.

REPLACING THE RUBBER VACUUM BANDS

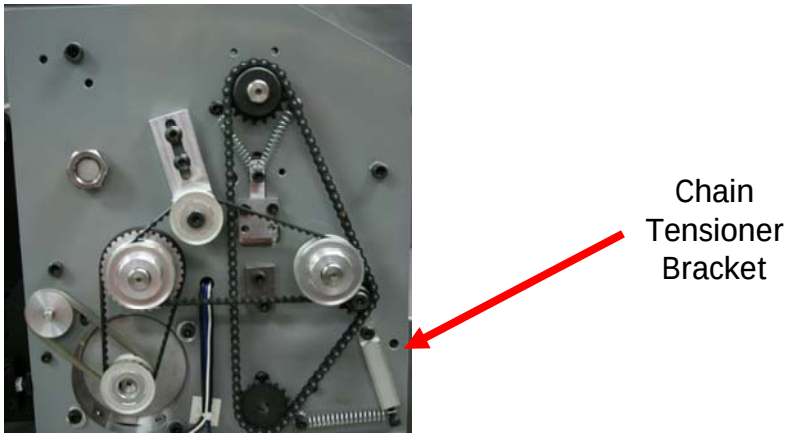
A top feed Disconnect the air vacuum hoses from the feeder. Loosen the Locks from the top of the feeder frames. Lift out and remove the feeder from the machine. Remove the manifolds from the feeder. Remove six flat head screws on the feeder table(two on each side of the feeder drum and two on the right side of the table). Turn the feeder over to expose the underside. Remove the flat head screw securing adjustment lever to the adjustment shaft. Remove the drum assembly from the feeder. Remove the inner drum from the feeder. Remove the old vacuum bands. Insert the band installation tool on the end of the outer drum. Lightly lubricate the tool with petroleum jelly. Slide the first band over the installation tool and into the first groove on the drum repeat for the second and third. NOTE: Do not over stretch these bands or they may break. Reverse the procedure to re-assemble the feeder.

CHECKING THE SENSORS

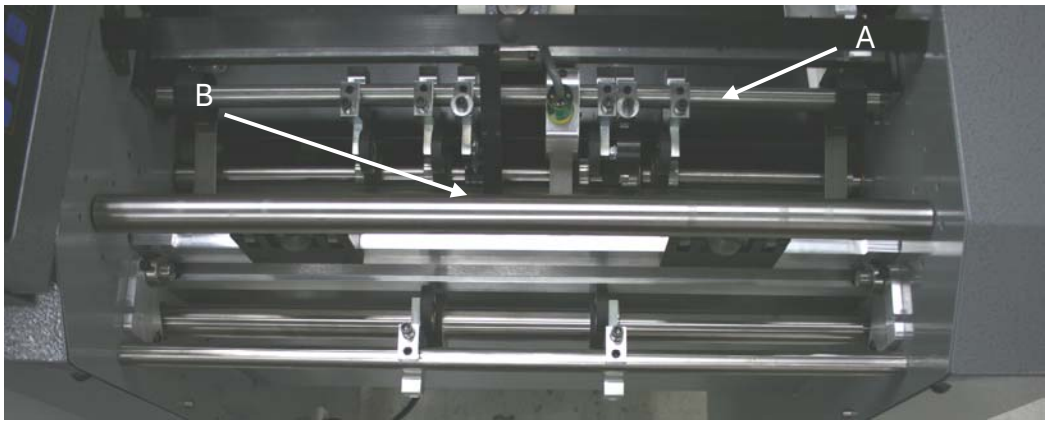
1. Turn machine power on and allow startup count down mode to complete
2. At this time your display on your control board should read “ACCUCREASER”
3. By placing a sheet or paper between the sensors your control board should read “Sensor Blocked”.
4. By removing paper between sensors display should return to “ACCUCREASER”
5. If all above steps work correctly sensor is working properly, if not, contact the Count Machinery Company service department.

DRIVE CHAIN TENSION

The chain that drives the upper crease die in time will stretch. This is a common occurrence in chains. The spring tensioner bracket will automatically adjust the tension. It is important that this chain remain taught and free of any play. It is recommended to check this periodically. If there is play in the chain drive, make sure the adjustment spring is in the correct location.



PERF SHAFT & STRIKE PLATE

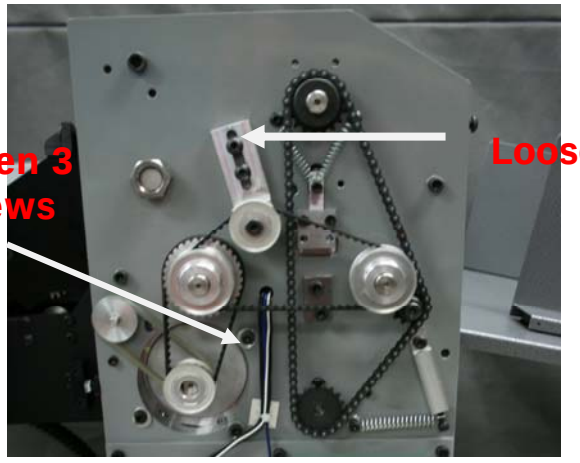


A – Support Bar – F-0232 This is the shaft that the roller wheels and perf score are mounted on.

B – Lower Sensor Eye Assy. – S-AAM-0230 Located in the strike plate, directly below the upper sensor. These two must align.

REMOVING THE PERF SHAFT

Loosen the operator side cover. Locate and remove the perf shaft lock collar.
Next, remove the non-operator side cover. Loosen both of the belt tensioner idler pully's. You do not need to remove these as loosening them will allow enough movement to free the pully's of the perf shaft. Slide the perf shaft out the pulley side.
It is only necessary to slide the shaft out about 6 to 8 inches. With the shaft slid to the side, you can access the lower hubs and reconfigure them as needed to complete any job. After you have configured the lower shaft, replace the shaft into its bearing and secure the shaft collar. The shaft should not be able to move side to side. With both drive belts in Position, re-tension the belt idlers and tighten while applying constant firm pressure on the belts by pushing down on the tops of the brackets with the large T-handle wrench supplied. Replace covers. Align upper assemblies accordingly.



PERFORATING AND SCORING ASSEMBLIES

For removing and old blade and attaching a new blade to the pressure adjust mounting bracket, remove the (1) button head cap screw. **BE SURE TO TIGHTEN THE SET SCREW SECURELY TO THE BAR.** Once you have the upper and lower perf assemblies in place, you can tighten the half dog screw.

Complete: #S-APP-0129

Complete: #S-APP-0139

Part No.	Description
H-0215	Screw-10-32x1/2" button head socket
H-0250	Screw-10-32x 1 1/2"socket cap
H-0270	Screw-1/4"-20x1/4" socket set
H-0275	Screw-1/4-20x1/4" socket set
H-0278	Screw-1/4-20x1/4" socket half dog
H-0456	Washer – flat .20
H-0580	Compression spring 1 ½"
F-0403	315-s40 silicone gripper wheel
F-0425	Forward roller mount ap-app
F-0430	Forward roller (rubber only)
S-APP-0116	Roller wheel assembly
S-APP-0131	Score blade assembly
S-APP-0141	Perf blade assembly
S-APP-0132	Lower score hub assy.Hub ap
S-APP-0142	Lower perf assy. Hub app
S-APP-0622	Bracket-perf/score pres,adj. assy

GRIPPER WHEEL PERF-SCORE MOUNTING

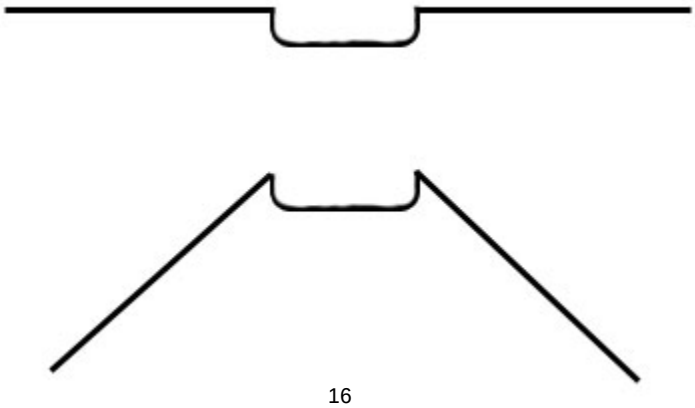
Rubber Grip Wheel Position

Score Wheel

Position your score blade as desired. Scores should be made so that the blade runs on the side of the sheet that will be on the inside of the finished fold. Scores may be made on the EZ CREASER in three different ways using the different grooves on the lower score assembly.

FOLDING DIRECTION OF PAPER

There is a correct and incorrect way to fold a creased paper. Following the diagram below will show you the correct direction the paper should be folded.



RAC System (Rotary Actuated Creasing) Assembly

Component ID

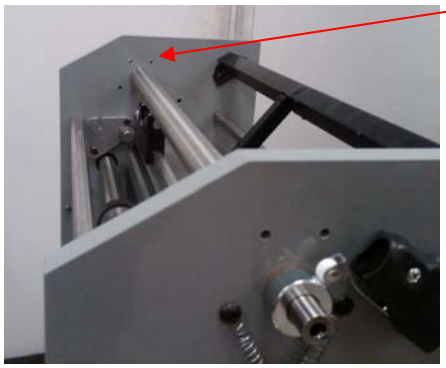
A. RAC drive motor
B. Eccentric Drive Shaft
C. Upper crease die
D. Pressure Adjust bearing blocks (RAC Rollers)
E. Lower crease die
F. Drive chain & tensioner SEE DRIVE CHAIN TENSIONER ON PAGE 13
G. Return springs SEE SERVICE DIAGRAM A ON PAGE 21
H. Compression bracket RAC locknut F-2640
I. Compression Bracket Adjust Screw Assy

ADJUSTING THE RAC ROLLERS

The RAC rollers are set from the factory and it is **NOT** recommended to make any adjustments to this without consulting with Count's tech-support department.
Should an adjustment be necessary, please follow the steps below.
Loosen the small bearing block lock screws. This allows very slight adjustments of the bearing block to be made by loosening the thumb lock and turning the height adjustment screw in the middle of the bearing block. This is a very fine thread and is capable of making very slight adjustments. Turning the adjustment screw clockwise will increase the bar pressure, as counterclockwise will decrease the pressure. Once the adjustment to the bar has been made, slightly tighten the thumb lock and re set the block set-screws.

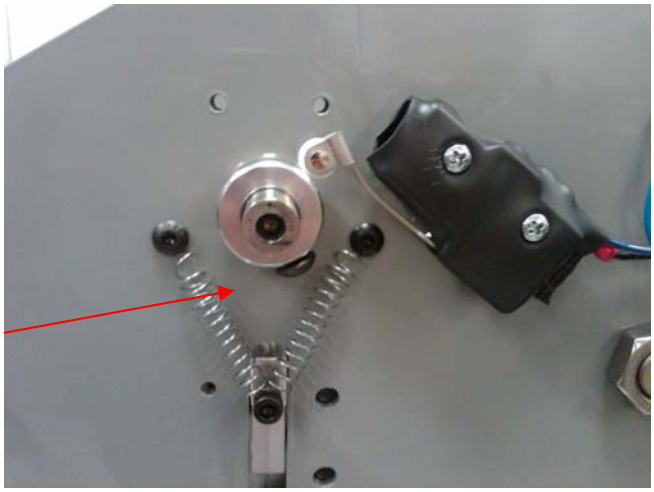
ADJUSTING RAC TOP DEAD CENTER

The top dead center of the RAC will need to be adjusted from time to time. To do this turn the machine off, remove the operator side cover, and manually rotate the eccentric shaft to the top dead center. Then locate the adjusting shaft collar on the end of the eccentric on the operators side and take a 5/32 allen wrench and loosen the button head screw and rotate it to the 5 o'clock position. This will ensure proper alignment of the crease bar.



Use the button head adjustment screw to the 5 o'clock position.

To ensure proper adjustment make sure the eccentric drive shaft is at top dead center.



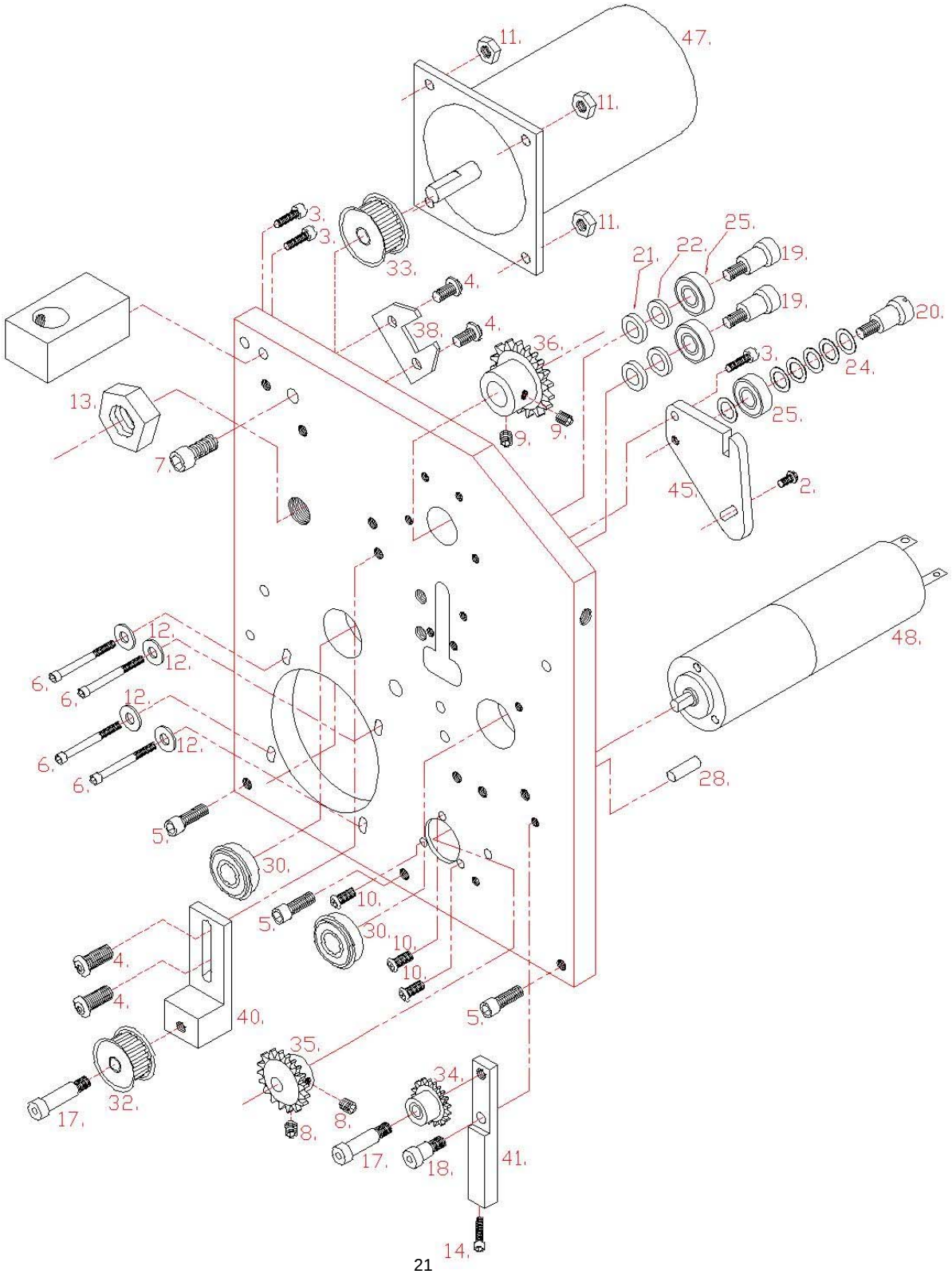
CHANGING THE LOWER CREASE DIE

The Lower crease die can easily be changed to accommodate thicker stocks by removing the non-operator side cover, slide the bar out and flip it over to use the wider die channel. Please note, custom die's are available upon request.

TROUBLE SHOOTING

- **POWER DOES NOT TURN ON**
    1. Check circuit breaker on rear panel.
    2. Check outlet for power.
- **POWER TURNS ON (FAN ON) BUT MICROPROCESSOR DOES NOT LIGHT UP**
    1. Check ¼ amp & 3 amp fuse on rear panel.
    2. Check connector from control board to machine.
- **MICROPROCESSOR COMES ON BUT DISPLAY IS SCRAMBLED**
    1. Poor Connection on or to control board.
    2. Turn power off then turn back on. If display remains scrambled, contact Count Service Department.
- **TRANSPORT "LOCKS UP" AFTER CREASING**
    1. Check pulleys to make sure they are securely tightened on shafts.
    2. Check to see that the transport turns freely (oil when necessary).
    3. Possible damage to microprocessor.
- **FEED TABLE NOT FEEDING CORRECTLY**
    1. Clean feed wheel rollers.
    2. Feed wheels do not have equal pressure on them, check adjustment.
    3. Contact strip is worn and will not gap the stack.
- **SHEETS NOT FEEDING STRAIGHT**
    1. Unequal feed wheel pressure.
    2. Align feed rails "check for squareness". This can be checked by the lead edge of the paper feeding into the machine should line up with the front edge of the feed plate.
    3. Not enough pressure on forwarding rollers.
    4. Clean ALL rubber rollers.
- **PERF IS NOT STRAIGHT**
    1. Check for equal pressure on all grip wheels and that none are hanging up.
    2. Recheck all steps under (SHEET NOT FEEDING STRAIGHT)
- **PERFORATION IS NOT CLEAN OR CUTS SHEETS**
    1. Not enough pressure on perf wheel.
    2. Perf blade is worn.
- **CREASE NOT REGISTERING ON SHEET**
    1. Clean all Rubber Rollers
    2. Check pressure on grip wheels. If these are not down firmly, your registration will be off.
    3. Check all pulleys to make sure they are securely tensioned on shafts.
    4. Check to see that machine transport turns freely.
- **CREASE APPEARS WEAK**
    1. Crease bar not level.
    2. Not enough pressure, adjust RAC rollers with height adjustment screw.
    3. Too much pressure, motor cannot make full stroke.
    4. Crease bar not tightened properly on bracket.
- **CREASE BAR DOES NOT ROTATE**
    1. Crease bar set too low, cannot make full stroke.
    2. Crease bar is dirty. Clean with damp cloth and wipe clean.
    3. May need to send crease bar in to headquarters for service.

SERVICE DIAGRAM A
ACCUCREASER SIDE FRAME LEFT (NON OPERATOR)

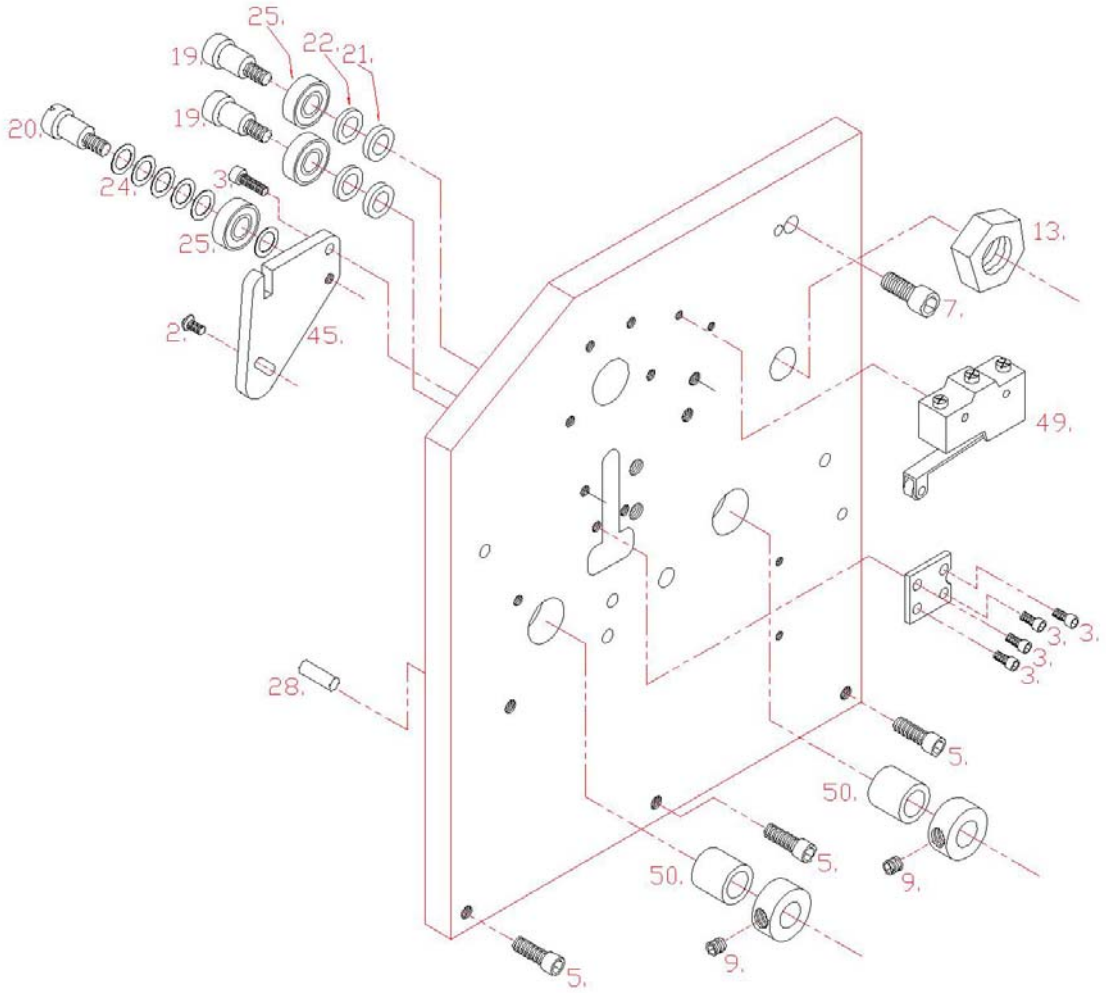


SERVICE DIAGRAM A

Parts Description List

ITEM NUMBER	PART NUMBER	DESCRIPTION
2	H-0215	SCREW, 10-32X1/2" BUTTON HEAD CAP SCREW
3	H-0235	SCREW, 10-32 X 5/8" SOCKET CAP
4	H-0285	SCREW, 1/4-20X1/2" BTN HD SOC CAP
5	H-0315	SCREW, 1/4-20X3/4" SOCKET CAP
6	H-0250	SCREW, 10-32X1-1/2" SOCKET CAP
7	H-0361	SCREW, 5/16-18X3/4" SOCKET CAP
8	H-0204	SCREW, 10-32 X 3/16" SOCKET SET
9	H-0270	SCREW, 1/4-20 X 1/4" SOCKET SET
10	H-0199	SCREW, 10-16 X 1/2" PHIL PAND HEAD - BLK.
11	H-0410	HEX NUT 10-32 LOCK-KEPNUT
12	H-0455	WASHER #10 FLAT
13	H-0425	NUT, 5/8" HEX
14	H-0245	SCREW, 10-32 X 1" SOCKET CAP
17	H-0380	SCREW, 5/16X3/4" SHOULDER SOCKET CAP
18	H-0375	SCREW, 1/4X1/4" SHOULDER SOCKET CAP
19	H-0386	SCREW, 3/8 X 1/2" SHOULDER SCS.
20	H-1668	SCREW, 3/3 X 3/8 SHOULDER SLOT
21	H-1669	WASHER, 3/8 ID X .125 THICK
22	H-1670	WASHER, 3/8 ID X .095 THICK
24	H-0480	WASHER, FLAT BURR WHEEL
25	H-0669	BEARING, ROLLER .375ID X .875OD X .280W.
28	H-1672	DOWEL PIN .252 RECEIVING TRAY SUPPORT
30	H-0679	BEARING, ROLLER 1/2"I.D. FLANGED
32	S-APP-0646	IDLER PULLEY ASSY 16T.
33	H-0706	PULLEY TIMMING 1/5 PITCH 18 TOOTH
34	S-CRZ-0009	SPROCKET, #25 12T.
35	HF-0798	MOTOR SPROCKET 17T. #25 W/ METRIC BORE
36	H-0802	ECCENTRIC SHAFT SPROCKET #25 18T.
38	FS-315	TIE BAR LOCK
40	F-0541	BRACKET, IDLER 1" - APP
41	F-2654	BRACKET, CHAIN TENSIONER
45	F-2649	BEARING ADJUST BRACKET - CREASER
47	E-1227	MOTOR STEPPER
48	E-1241	MOTOR CREASER - DRIVE BAR

SERVICE DIAGRAM B
ACCU CREASER SIDE FRAME RIGHT (OPERATOR)



ITEM NUMBER	PART NUMBER	DESCRIPTION
3	H-0235	SCREW, 10-32 X 5/8" SOCKET CAP
5	H-0315	SCREW, 1/4-20X3/4" SOCKET CAP
7	H-0361	SCREW, 5/16-18X3/4" SOCKET CAP
9	H-0270	SCREW, 1/4-20 X 1/4" SOCKET SET
13	H-0425	NUT, 5/8" HEX
19	H-0386	SCREW, 3/8 X 1/2" SHOULDER SCS.
20	H-1668	SCREW, 3/3 X 3/8 SHOULDER SLOT
21	H-1669	WASHER, 3/8 ID X .125 THICK
22	H-1670	WASHER, 3/8 ID X .095 THICK
24	H-0480	WASHER, FLAT BURR WHEEL
25	H-0669	BEARING, ROLLER .375ID X .875OD X .280W.
28	H-1672	DOWEL PIN .252 RECEIVING TRAY SUPPORT
45	F-2649	BEARING ADJUST BRACKET – CREASER
49	S-CRZ-0018	SWITCH, - ASSY
50	H-0645	BRONZE BUSHING