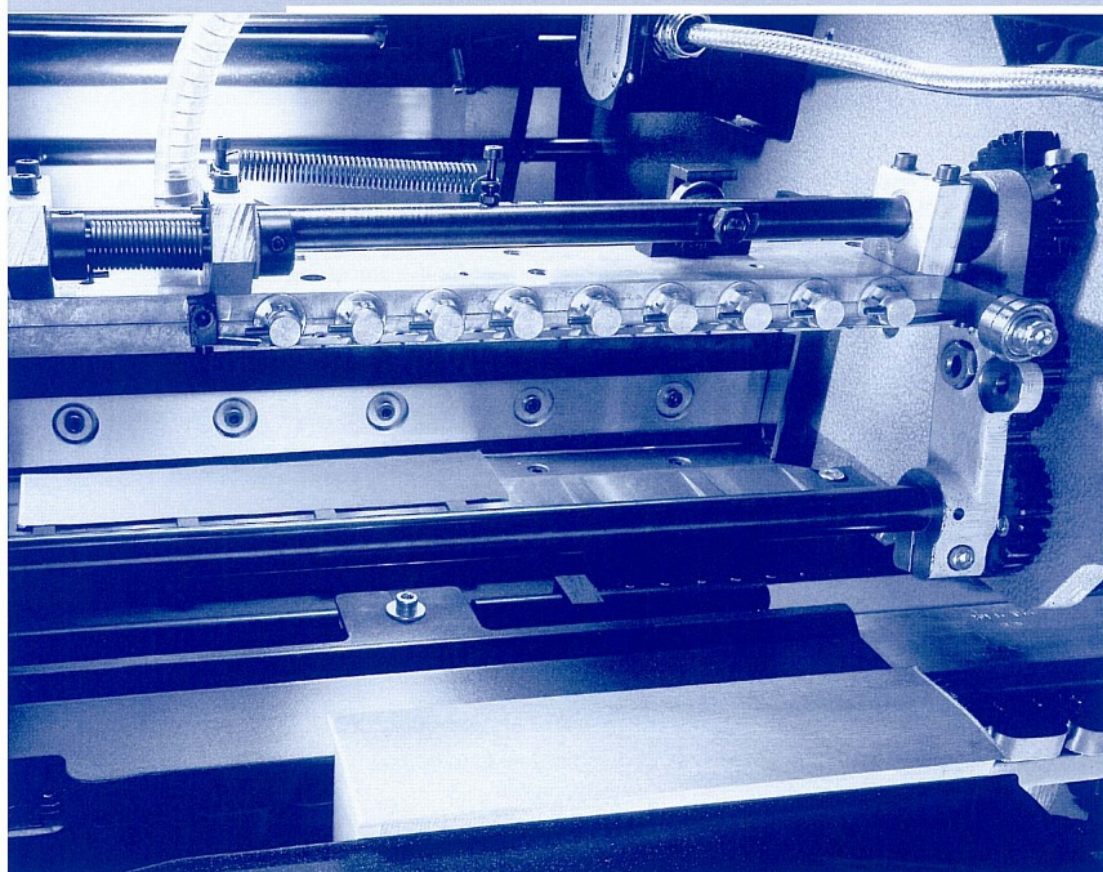


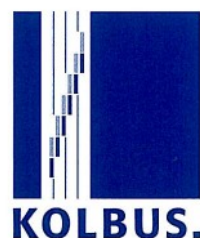
KOLBUS → Technical Data

Book production line

BF 527



For rounding, backing and casing-in of book blocks in hard, flexible or plastic cases. Alternative gluing, gauzing, backlining, and headbanding, depending on the equipment of the machine, is possible.

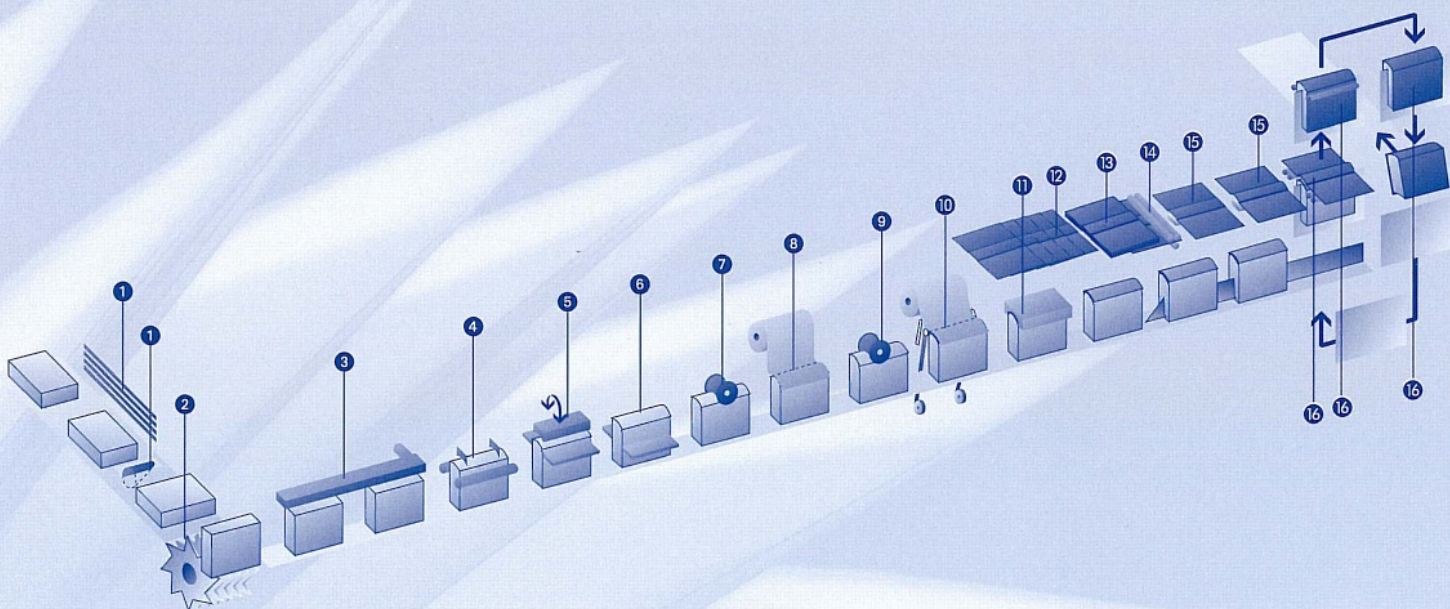


EQUIPMENT VARIATIONS

- ▲ Standard
● Alternative
■ Options
– Not available
S Special equipment

| | Number of HL-stations | | |
|--|--------------------------|---|----|
| | 3 | 5 | 7 |
| MISCELLANEOUS | | | |
| Copilot system with ›touch screen‹ monitor | ▲ | ▲ | ▲ |
| – Choice of production mode | | | |
| – Format memory | | | |
| – Operator guided changes of the production mode | | | |
| – Automatic format settings | | | |
| – Operating instructions | | | |
| – Fine adjustments via +/- keys during running production | | | |
| – Product counter (job, shift and start/stop counter) | | | |
| – Indication of machine and material flow malfunctions | | | |
| – Operator guided malfunction elimination | | | |
| PLC controls | ▲ | ▲ | ▲ |
| Infinitely variable frequency controlled drive | ▲ | ▲ | ▲ |
| Automatic central lubrication system | ▲ | ▲ | ▲ |
| Line control | ▲ | ▲ | ▲ |
| Safety standard according to CE directives and specifications | ▲ | ▲ | ▲ |
| Machine frame for 5 stations | ● | ● | – |
| Machine frame for 7 stations | – | ● | ●* |
| * + additional input unit in case of 6 working stations | – | – | ▲ |
| INFEED AREA | | | |
| Infrared heating with turning device | ■ | ■ | ■ |
| Infrared heating with cross conveyor | ■ | ■ | ■ |
| Telescopic infeed conveyor from the left, barrier and starfeeder (eight-fold star) | ▲ | ▲ | ▲ |
| Block spine heater for adhesive bound and hotmelt glued blocks (hot air-heating) | ▲ | ▲ | ▲ |
| Block position detection device (spine and front cut) with vacuum | ▲ | ▲ | ▲ |
| Block position detection device with mark reading unit* incl. case position detection device | S | S | S |
| *marking on the spine necessary | | | |
| AR-STATIONS | | | |
| Automatic block thickness control | ▲ | ▲ | ▲ |
| Rounding and backing station | ▲ | ▲ | ▲ |
| Infeed rails (radius and prism shaped) | ▲ | ▲ | ▲ |
| HL-STATIONS | | | |
| Timer for glue preheating | ▲ | ▲ | ▲ |
| Marking ribbon gluing device | ■ | ■ | ■ |
| Viscosity control device for automatic water supply to ensure constant glue viscosity (with pump and water tank/for manual filling) for 1 or 2 or 3 spine gluing units | ■ | ■ | ■ |
| 1ST STATION | | | |
| Spine gluing unit with circulation and premelter with automatic glue feeding | ■ | ● | ● |
| Spine gluing unit with circulation for the gluing of marking ribbons | ■ | ● | ● |
| 2ND STATION | | | |
| Gauzing station, gauze width: max. 350 mm | – | ● | ● |

| | Number of HL-stations | | |
|---|--------------------------|---|---|
| | 3 | 5 | 7 |
| 3RD STATION | | | |
| Spine gluing unit with circulation and premelter with automatic glue feeding | ● | ● | ● |
| 4TH STATION | | | |
| Backlining and headbanding station | ▲ | ▲ | ▲ |
| 5TH STATION | | | |
| Pressing station with teflon band and an integrated foam rubber rub-down element | ● | ● | ● |
| Pressing station with foam rubber cushion | ● | ● | ● |
| Spine gluing unit with circulation and premelter with automatic glue feeding | – | – | ■ |
| 6TH STATION | | | |
| Backlining and headbanding station | – | – | ■ |
| 7TH STATION | | | |
| Pressing station with teflon band and an integrated foam rubber rub-down element | – | – | ● |
| Pressing station with foam rubber cushion | – | – | ● |
| EMP-STATION | | | |
| CASE STATION | | | |
| Case prestacking conveyor | ▲ | ▲ | ▲ |
| Case bending machine | ▲ | ▲ | ▲ |
| Case forming station with counter holder | ▲ | ▲ | ▲ |
| Case magazine | ▲ | ▲ | ▲ |
| Special equipment for the processing of flexible cases with pre-scored flaps | ■ | ■ | ■ |
| <i>Block size</i> | | | |
| W x H x TH | | | |
| max. 220 x 300 x 50 mm | | | |
| min. 100 x 100 x 18 mm | | | |
| <i>Flap width</i> | | | |
| Width: 50 – 100 mm | | | |
| Mechanical speed: max. 50 cycles/min | | | |
| Note: All books are subject to a different delivery motion | | | |
| Double case control (for one-piece flexible cases) | ■ | ■ | ■ |
| CASING-IN STATION | | | |
| Pointed and bottom splitter for flimsy papers and gilt edge | ▲ | ▲ | ▲ |
| Rubbing-down unit and additional contact pressure station | ▲ | ▲ | ▲ |
| EMP glue pump monitoring | ▲ | ▲ | ▲ |
| HOTMELT NOZZLE GLUING UNIT FOR | | | |
| Spine gluing | ■ | ■ | ■ |
| Joint gluing | ■ | ■ | ■ |
| Spine and joint gluing | ■ | ■ | ■ |
| DELIVERY | | | |
| Delivery conveyor, length 1,280 mm | ▲ | ▲ | ▲ |
| Delivery conveyor, length 2,280 mm | S | S | S |
| Delivery conveyor, length 1,880 mm | S | S | S |
| VARIOUS ALTERNATIVE AND OPTIONAL EQUIPMENT | | | |
| Standard format dependent parts | ● | ● | ● |
| Special sets of format dependent parts for block, case and spine gluing (USA/Japan) | ● | ● | ● |
| Equipment for undersize formats | ■ | ■ | ■ |
| Equipment for remote diagnosis | | | |
| Coupling via telephone network | ■ | ■ | ■ |
| Equipment for remote diagnosis | | | |
| Coupling with the line remote diagnosis server, model AFS 701 | ■ | ■ | ■ |
| Coupling with the line data management system, model ADM 701 | ■ | ■ | ■ |



❶ Infrared heating with turning device

❷ Starfeeder

❸ Hot air heating

❹ Rounding station

❺ Backing station

❻ Correction station

❼ 1st gluing station

❽ Gauzing station

❾ 2nd gluing station

❿ Backlining and head-banding station

⓫ Pressing station

⓬ Case prestacking

⓭ Case magazine

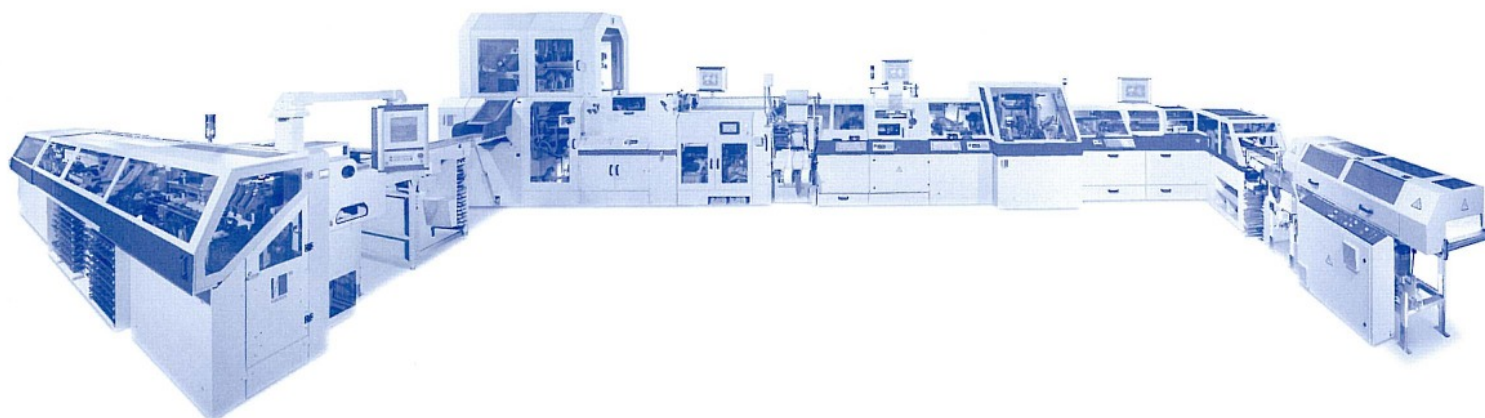
⓮ Case bending station

⓯ Case forming station

⓰ Casing-in station

Book production line

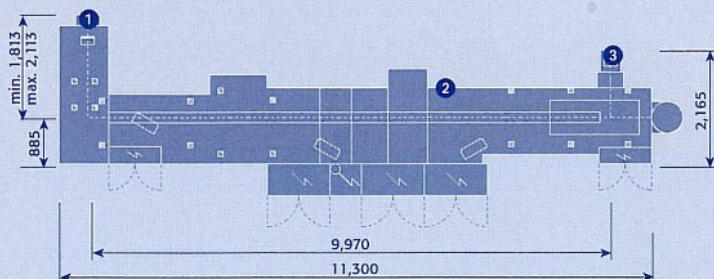
BF 527



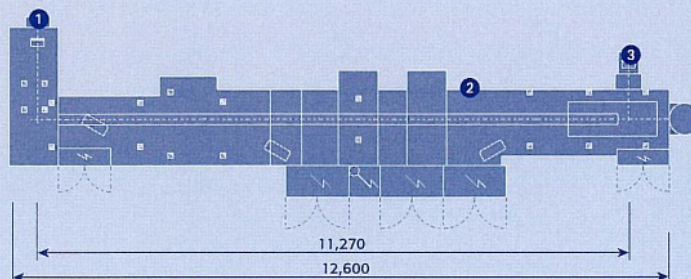
BF 527 - GROUND PLAN

- ① Infeed height ca. 900 mm
- ② Compressed air supply
- ③ Delivery height 1,125 mm

5 HL-STATIONS



7 HL-STATIONS



TECHNICAL DATA

SIZE RANGE BOOK BLOCK

| | |
|-----------------------|--------------------------|
| Width | min. 100 mm/max.* 305 mm |
| Height | min. 100 mm/max.* 375 mm |
| Thickness | min. 2 mm/max.* 80 mm |
| Small format (option) | 70 x 100 x 2 - 30 mm |

*With large and small formats there is an interdependence between the book sizes.

SIZE RANGE OPENED CASE

| | |
|-----------------------|-------------------|
| max. | 660 x 385 mm |
| min. | 210 x 105 mm |
| Small format (option) | min. 155 x 105 mm |

MECHANICAL SPEED

up to 60 cycles/min
Net production is subject to sizes, materials etc.

The customer has to provide:

COMPRESSED AIR REQUIREMENT

9 Nm³/h (Hardcover)
up to 14 Nm³/h (flexible cases)

FACTORY LINE PRESSURE

6 bar

COMPRESSED AIR SUPPLY

see extra sheet

MACHINE DIMENSIONS

| | |
|--------|---------------------------------|
| Length | 11,605/12,940 mm (5/7 stations) |
| Width | 3,520 mm |
| Height | 2,700 mm |

WEIGHT

17,130 kg (5 stations)

ELECTRICAL EQUIPMENT

3 phase, 400 volt/N/PE, 50 cycles

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