

# FS-532 FW20 (ENG) v1 210907

## 1. Introduction

### 1.1 Welcome

ENG-FW20-1-00

If you require navigation instructions, you can access the HELP menu at any point during the course.  
Click this box to open the HELP menu right away.

## FS-532

### Technical Training Course

**Supported devices:** C6100 series, C4080 series, C3080 series, C2070 series, C1100 series, C1070 series, 6136 series, 1250 series, 2250P, 1100, 2100, 951



Approx. completion time for full course: 1 hour  
Approx. completion time for newest changelog: 5 minutes

0.01

### 1.2 Course Overview

## Introduction

### Course Overview

This course will cover the following topics:

Introduction	What is the purpose of FS-532?
A. Installation <ul style="list-style-type: none"><li>Installation Order</li><li>Installation Precautions</li><li>Initial Adjustments for PK-522</li></ul>	What do I need to consider during installation?
B. Theory of Operation <ul style="list-style-type: none"><li>Unit Configuration</li><li>Paper Path</li></ul>	Which are the important components? How is paper conveyed?
C. Field Service <ul style="list-style-type: none"><li>Mechanical and Electrical Adjustments</li><li>Disassembly/Reassembly</li><li>Periodical Maintenance</li><li>Troubleshooting</li></ul>	Which adjustment can solve which issue? Where can I find information regarding maintenance and troubleshooting?

This course contains a list of product changes in the **CHANGELOG**. You access this menu at any time and jump to all changes of a product version directly.  
Click this box to open the **CHANGELOG** right away.

0.02

## 1.3 Helpful Materials

### Introduction

#### Helpful Materials

Many slides in this module identify where you can find additional information in the [service manual of AccurioPress C4080](#). If you are servicing another main body, please refer to the respective service manual.

The FS-532 can only be operated when connected to a compatible main body. Hence, there is no separate service manual for the FS-532.

Further details can be found in the [installation manuals and user's guides](#). All these manuals are provided by your regional HQ. We recommend to make sure that you have access to the manuals prior to starting this module.



A [printable version](#) of the course slides is available [here](#). You can use it to write down slide-related information while moving through the course, for example.

**NOTE:** The print version is only supplemental material. It does not replace the full information contained in the web-based training.

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## 1.4 Purpose of Option

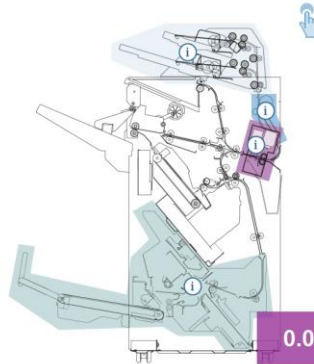
### Introduction

#### Purpose of Option

FS-532 is a finisher that sorts, groups and staples paper. It can be upgraded with the following options:

- MK-732 is a mounting kit which is required for the PI-502 to convey paper to the FS-532.
- PI-502 is a post inserter which feeds paper automatically or manually to the finisher.
- PK-522/PK-525 are built-in punch kits with a 2-hole (Japan), 2/3-hole (inch area), 2/4-hole (metric area) and 4-hole (Sweden) punch function.
- **For the C4080 series, only PK-525 is available.**
- SD-510 is a saddle stitching unit with a half- and tri-folding function.

Please refer to the [Product Specifications](#) [C](#) for more details regarding the functions of the options.



0.04

## 1.5 Supported Main Bodies

### Introduction

#### Supported Main Bodies

FS-532 supports the following main bodies:

##### AccurioPress

- C6100/C6085
- C4080/C4070/C4065
- C3080/C3070/C3080P/C3070P/ C83hc/C73hc
- C2070/C2060/C2070P

##### bizhub PRESS

- C1100/C1085
- C1070/C1060/C1070P/C71hc
- 6136/6120/6136P
- 1250/1052/1250P
- 2250P

##### bizhub PRO

- 1100
- 951

##### AccurioPrint

- 2100

Make sure that FS-532 is compatible to the installed firmware of the main body.



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## 2. Lesson A: Installation

### 2.1 Overview

#### Lesson A: Installation

Rev-2003

#### Overview

Your first step in handling the device is most likely the installation at your customer's location.

The step-by-step instructions are documented in the installation manuals for:

- FS-532
- FS-532 W\*6
- FS-532 + SD-510 + PK-522 (if SD-510 and PK-522 are not pre-installed)

Depending on the main body to which the FS-32 is installed as well as other options that have to be installed, the installation procedure differs.

The following slides give you a few practical tips on how to handle the installation procedure.

**FS-532 Installation Manual**

**CAUTION**

**1 Preparation Prior to Installation**

**2 Contents**

**3 Necessary parts**

A.01

### 2.2 Installation Order

#### Installation

#### Installation Order

When installing MK-732, PI-502, PK-522/PK-525 and/or SD-510 to FS-532, there is a certain installation order that needs to be followed.

If all options are installed, please refer to the installation order on the right side. If an option is not installed, skip the respective part.

FS-532 is only installed to the respective main body, if all options that are required have been installed to FS-532.

- 1 Install SD-510 to FS-532.
- 2 Install PK-522/PK-525 to FS-532.
- 3 Install MK-732 to FS-532.
- 4 Install PI-502 to FS-532.
- 5 Install FS-532 to the main body.

A.02

## 2.3 Installation Precautions

### Installation

#### Installation Precautions

When installing FS-532, consider the following precautions;

- Be careful about the connection of the [6-pin connector](#). If the 6-pin connector of FS-532 is mistakenly connected to the 8-pin connector of an upstream option, FS-532 will be damaged.
- Install the [guide sheet](#) to the entrance guide plate of the main body.
- Remove [screws and the conveyance guide/up](#) of the electric charge control unit of the main body to avoid a paper jam.



A.03

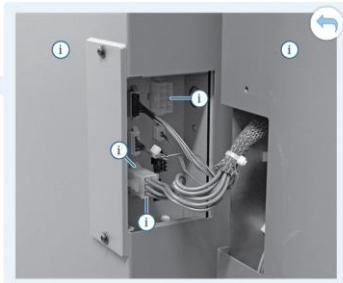
## 6-pin Connector (Slide Layer)

### Installation

#### Installation Precautions

When installing FS-532, consider the following precautions;

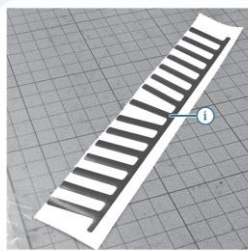
- Be careful about the connection of the [6-pin connector](#). If the 6-pin connector of FS-532 is mistakenly connected to the 8-pin connector of an upstream option, FS-532 will be damaged.
- Install the [guide sheet](#) to the entrance guide plate of the main body.
- Remove [screws and the conveyance guide/up](#) of the electric charge control unit of the main body to avoid a paper jam.



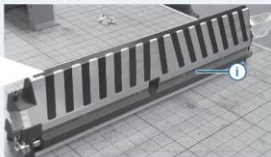
## Guide Sheet (Slide Layer)

### Installation

#### Installation Precautions



The guide sheet is affixed to the entrance guide plate of the main body.

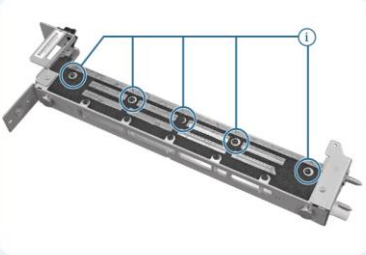


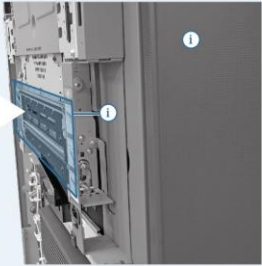
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## Guide Plate (Slide Layer)

### Installation

#### Installation Precautions





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ABC XYZ

## 2.4 Precautions Checklist

### Installation

#### Precautions Checklist

FS-532 +			
	1052, RU-509, RU-511, RU-518, IQ-501	C2070, C3080, C4080	1100, 2100, RU-510, PB-503, LS-505, LS-506, SD-513, FD-503
Does the upstream machine have an 8-pin connector?	Yes	No	No
Install the guide sheet	No	Yes	No
Remove the conveyance guide/up	No	Yes	No

A.04

## 2.5 Initial Adjustments for PK-522/PK-525

### Installation

#### Initial Adjustments for PK-522/PK-525

ABC XYZ

After installing PK-522/PK-525 to FS-532, the following initial adjustments have to be conducted to ensure that the punch function is working properly:

- Adjust the mounting position of the [punch unit adjustment plate](#) according to the punch unit adjustment mounting position adjustment [1.38.2](#).

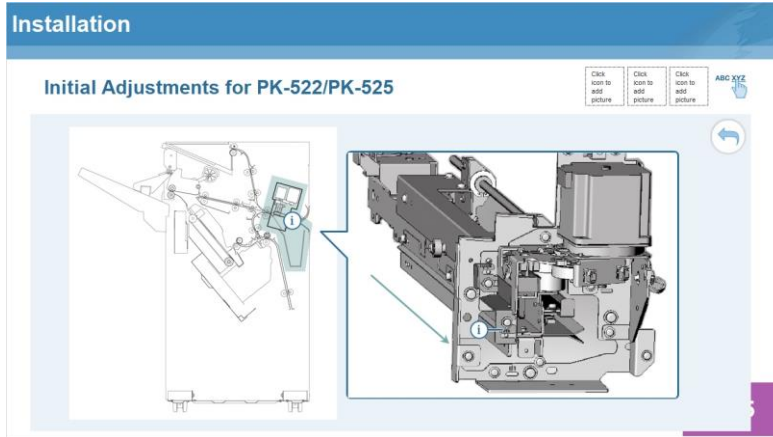
Conduct this adjustment as well when the installation location changes.

- Adjust the punch edge sensor in the Service Mode according to the [paper edge detect sensor adjustment 1.4.9.15](#).

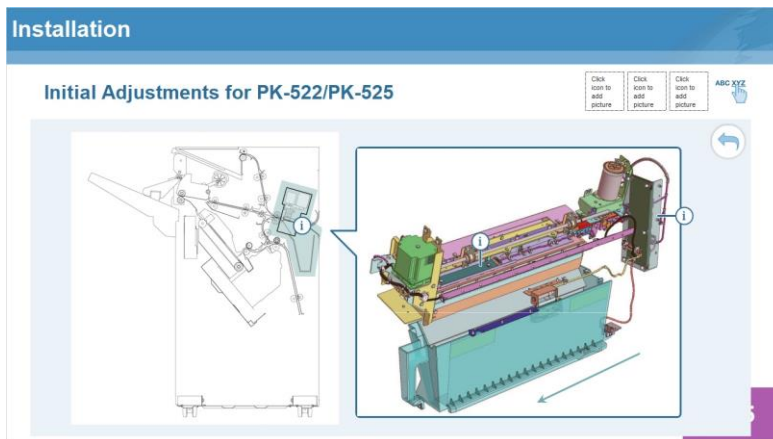
This adjustment is also necessary when the [punch control board \(PCB\)](#) or the [paper size sensor \(PS305\)](#) is replaced.

A.05

## punch unit adjustment plate (Slide Layer)



## PDB (Slide Layer)



## 3. Lesson B: Theory of Operation

### 3.1 Overview

**Lesson B: Theory of Operation**

**Overview**

This lesson explains the configuration of the FS-532 and of the options PI-502, MK-732, PK-522/PK-525 and SD-510.

Additionally, the different paper paths are illustrated to show which components are involved in which selected function.



**B.01**

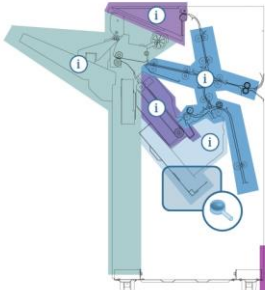
### 3.2 Unit Configuration of FS-532

**Lesson B: Theory of Operation**

**Unit Configuration of FS-532**

Click the buttons to learn more about the location and unit configuration of the options.

SD-510	PI-502
MK-732	PK-522/PK-525



**B.02**



## Staple Scraps Box (Slide Layer)

**Lesson B: Theory of Operation**

**Unit Configuration of FS-532**

Click the buttons to learn more about the location and unit configuration of the options.

SD-510	PI-502
MK-732	PK-522/PK-525



Click icon to add picture Click icon to add picture Click icon to add picture

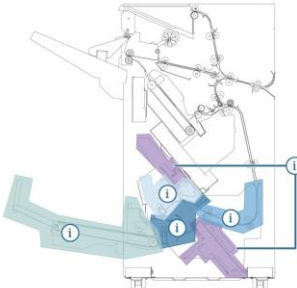
## SD-510 (Slide Layer)

**Lesson B: Theory of Operation**

**Unit Configuration of FS-532**

Click the buttons to learn more about the location and unit configuration of the options.

SD-510	PI-502
MK-732	PK-522/PK-525



Click icon to add picture Click icon to add picture Click icon to add picture

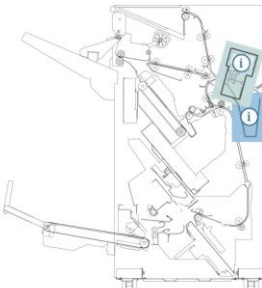
## PK-522\_PK-525 (Slide Layer)

**Lesson B: Theory of Operation**

**Unit Configuration of FS-532**

Click the buttons to learn more about the location and unit configuration of the options.

SD-510	PI-502
MK-732	PK-522/PK-525



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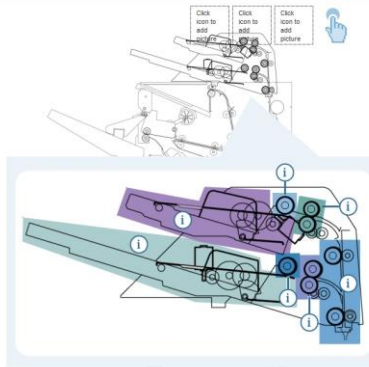
## PI-502 (Slide Layer)

### Lesson B: Theory of Operation

#### Unit Configuration of FS-532

Click the buttons to learn more about the location and unit configuration of the options.

SD-510	PI-502
MK-732	PK-522/PK-525



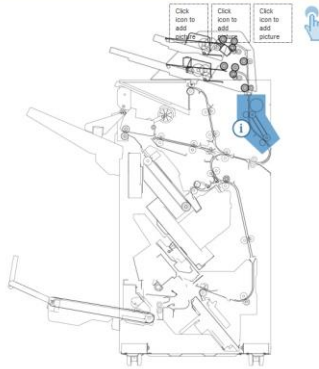
## MK-732 (Slide Layer)

### Lesson B: Theory of Operation

#### Unit Configuration of FS-532

Click the buttons to learn more about the location and unit configuration of the options.

SD-510	PI-502
MK-732	PK-522/PK-525



## 3.3 Paper Path

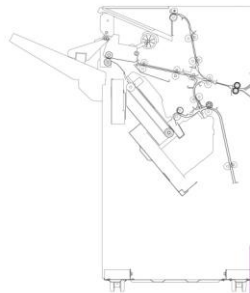
### Lesson B: Theory of Operation

#### Paper Path

Depending on the selected function, the paper path of FS-532 differs.

Click the functions to have a look at the different paper paths.

(Offset) Sort/group	Post insert
Staple	Punch
Half-fold/ Saddle-stitching	Tri-fold

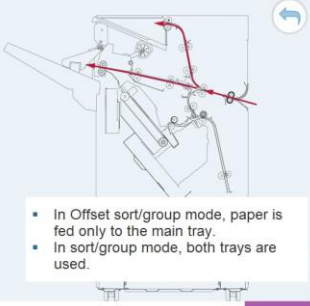
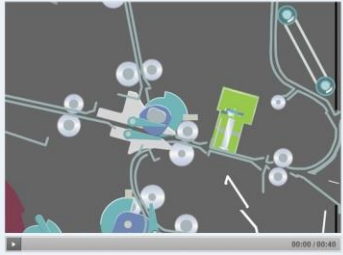


B.03

## Offset sort group mode (Slide Layer)

Lesson B: Theory of Operation

### Paper Path



Click icon to add picture   Click icon to add picture   Click icon to add picture

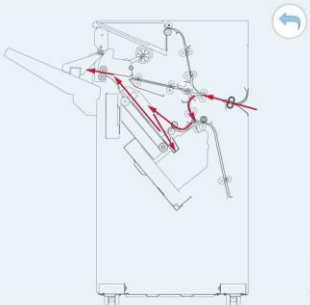
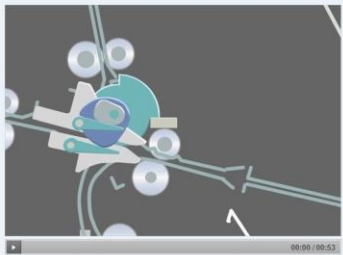
Click the play button to start the animation.

- In Offset sort/group mode, paper is fed only to the main tray.
- In sort/group mode, both trays are used.

## Offset staple staple mode (Slide Layer)

Lesson B: Theory of Operation

### Paper Path




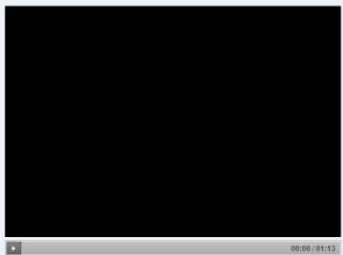
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Click the play button to start the animation.

## Half-fold/saddlestitching (Slide Layer)

Lesson B: Theory of Operation

### Paper Path



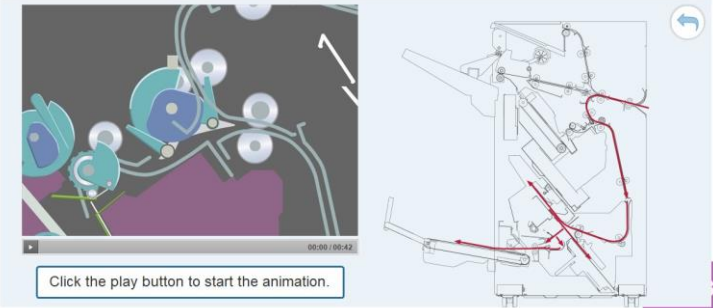
Click icon to add picture   Click icon to add picture   Click icon to add picture

Click the play button to start the animation.

## tri-fold (Slide Layer)

Lesson B: Theory of Operation

Paper Path



The 3D animation on the left shows a paper sheet being processed by a series of rollers and guides. A red line indicates the path of the paper. The 2D schematic on the right shows the same process from a top-down perspective, with a red line indicating the path of the paper. A play button is visible in the bottom right corner of the 3D animation.

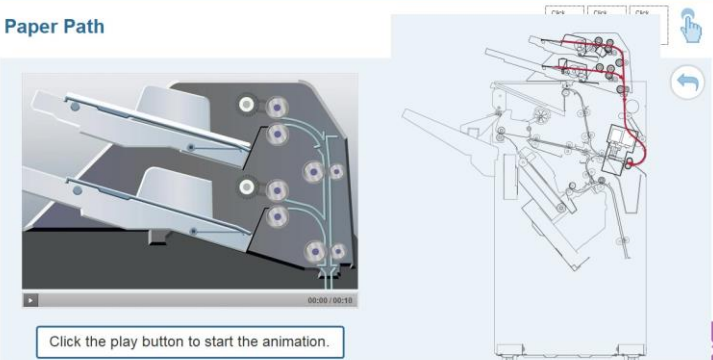
Click the play button to start the animation.

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## PI feeding (Slide Layer)

Lesson B: Theory of Operation

Paper Path



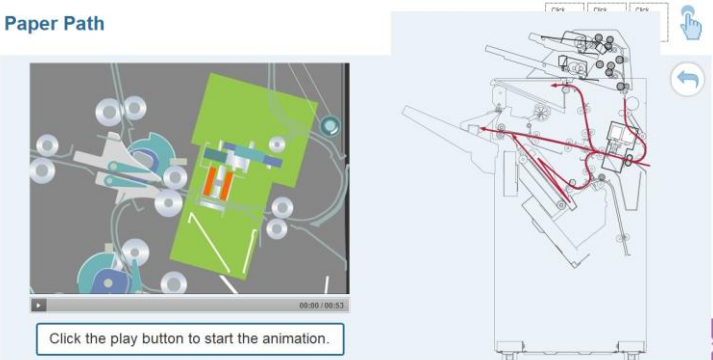
The 3D animation on the left shows a paper sheet being processed by a series of rollers and guides. A red line indicates the path of the paper. The 2D schematic on the right shows the same process from a top-down perspective, with a red line indicating the path of the paper. A play button is visible in the bottom right corner of the 3D animation.

Click the play button to start the animation.

## Punch function (Slide Layer)

Lesson B: Theory of Operation

Paper Path



The 3D animation on the left shows a paper sheet being processed by a series of rollers and guides. A red line indicates the path of the paper. The 2D schematic on the right shows the same process from a top-down perspective, with a red line indicating the path of the paper. A play button is visible in the bottom right corner of the 3D animation.

Click the play button to start the animation.

## 4. Lesson C: Field Service

### 4.1 Overview

Lesson C: Field Service

#### Overview

The following slides will give you practical advice for every day field service operations.

The following slides encompass:

- Mechanical and electrical adjustments
- Disassembly and reassembly
- Periodical maintenance
- Troubleshooting



C.01

### 4.2 Mechanical and Electrical Adjustments

Lesson C: Field Service


I.4.9,  
I.36-39 M

#### Mechanical and Electrical Adjustments

During the lifespan of the option, adjustments may be required.

The following slides give an overview about the most common issues regarding punching, stapling, folding and alignment. For each issue, mechanical and electrical adjustments are listed that can be conducted to solve the issue.

For further information, please refer to the step-by-step instructions in the service manual or in the user guide.



C.02

## 4.3 Skewed Punch Holes

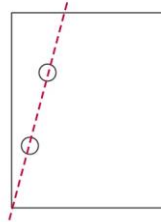
### Mechanical and Electrical Adjustments

#### Skewed Punch Holes

There are several reasons for skewed punch holes. Skewed punch holes may occur, if the punch unit is not adjusted properly or the registration loop amount is too short or large. To correct skewed punch holes, the following adjustments can be conducted:

- When PK-522/PK-525 is mounted:
  - ✓ [Punch hole position skew adjustment](#) [M I.38.1](#)
  - ✓ [Registration adjustment](#) [M I.4.9.16](#)
- When PI-502 is mounted additionally:
  - ✓ [PI tilt adjustment](#) [M I.39.1](#)
  - ✓ [PI registration adjustment](#) [M I.4.9.22](#)

To learn more about these adjustments, click the hyperlinks.



ABC XYZ

C.03

## Punch hole position skew adjustment (Slide Layer)

### Mechanical and Electrical Adjustments

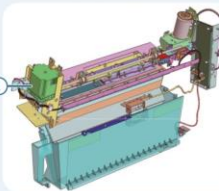
#### Skewed Punch Holes

There are several reasons for skewed punch holes. Skewed punch holes may occur, if the punch unit is not adjusted properly or the registration loop amount is too short or large. To correct skewed punch holes, the following adjustments can be conducted:

- When PK-522/PK-525 is mounted:
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  - ✓ [Registration adjustment](#) [M I.4.9.16](#)
- When PI-502 is mounted additionally:
  - ✓ [PI tilt adjustment](#) [M I.39.1](#)
  - ✓ [PI registration adjustment](#) [M I.4.9.22](#)

To learn more about these adjustments, click the hyperlinks.

To correct the skew, move the punch unit according to the calculated tilt amount.



ABC XYZ

C.03

## Registration adjustment (Slide Layer)

### Mechanical and Electrical Adjustments

#### Skewed Punch Holes

There are several reasons for skewed punch holes. Skewed punch holes may occur, if the punch unit is not adjusted properly or the registration loop amount is too short or large. To correct skewed punch holes, the following adjustments can be conducted:

- When PK-522/PK-525 is mounted:
  - ✓ [Punch hole position skew adjustment](#) [M I.38.1](#)
  - ✓ [Registration adjustment](#) [M I.4.9.16](#)
- When PI-502 is mounted additionally:
  - ✓ [PI tilt adjustment](#) [M I.39.1](#)
  - ✓ [PI registration adjustment](#) [M I.4.9.22](#)

To learn more about these adjustments, click the hyperlinks.

Change the paper loop amount of the registration roller of the PK-522 in the Registration Adjustment in the Service Mode.

ABC XYZ

C.03

## PI tilt adjustment (Slide Layer)

### Mechanical and Electrical Adjustments

#### Skewed Punch Holes

There are several reasons for skewed punch holes. Skewed punch holes may occur, if the punch unit is not adjusted properly or the registration loop amount is too short or large. To correct skewed punch holes, the following adjustments can be conducted:

- When PK-522/PK-525 is mounted:
  - ✓ [Punch hole position skew adjustment](#) [M 1.38.1](#)
  - ✓ [Registration adjustment](#) [M 1.4.9.16](#)
- When PI-502 is mounted additionally:
  - ✓ [PI tilt adjustment](#) [M 1.39.1](#)
  - ✓ [PI registration adjustment](#) [M 1.4.9.22](#)

To learn more about these adjustments, click the hyperlinks.

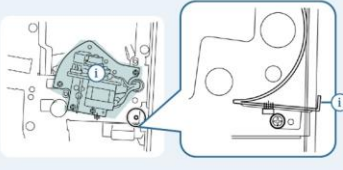
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Click icon to add picture

ABC XYZ

Check the tilt amount of the punch holes and move the guide plate of the punch unit according to the punch hole skew.



C.03

## PI registration adjustment (Slide Layer)

### Mechanical and Electrical Adjustments

#### Skewed Punch Holes

There are several reasons for skewed punch holes. Skewed punch holes may occur, if the punch unit is not adjusted properly or the registration loop amount is too short or large. To correct skewed punch holes, the following adjustments can be conducted:

- When PK-522/PK-525 is mounted:
  - ✓ [Punch hole position skew adjustment](#) [M 1.38.1](#)
  - ✓ [Registration adjustment](#) [M 1.4.9.16](#)
- When PI-502 is mounted additionally:
  - ✓ [PI tilt adjustment](#) [M 1.39.1](#)
  - ✓ [PI registration adjustment](#) [M 1.4.9.22](#)

To learn more about these adjustments, click the hyperlinks.

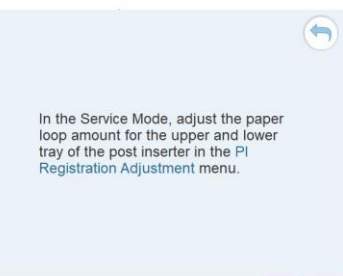
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Click icon to add picture

ABC XYZ

In the Service Mode, adjust the paper loop amount for the upper and lower tray of the post inserter in the PI Registration Adjustment menu.



C.03

## 4.4 Deviation in the Punch Hole Position

### Mechanical and Electrical Adjustments

#### Deviation in the Punch Hole Position

When the position of the punch holes differs from the standard value, conduct the following for

- the main scan direction:
  - ✓ [Vertical position adjustment](#) [M 1.4.9.18](#)
- the sub scan/paper feed direction:
  - ✓ [Horizontal position adjustment](#) [M 1.4.9.17](#)
- the main scan direction when paper is fed by the post inserter PI-502:
  - ✓ [PK punch position centering adjustment](#) [M 1.39.2](#)

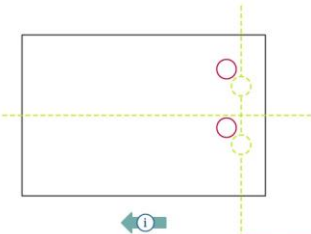
To learn more about these adjustments, click the hyperlinks.

Click icon to add picture

Click icon to add picture

Click icon to add picture

ABC XYZ



C.04






## Vertical position adjustment (Slide Layer)

### Mechanical and Electrical Adjustments

#### Deviation in the Punch Hole Position

When the position of the punch holes differs from the standard value, conduct the following for

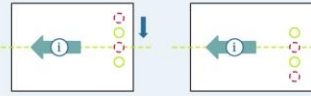

- the main scan direction:  
✓ [Vertical position adjustment](#)  I.4.9.18
- the sub scan/paper feed direction:  
✓ [Horizontal position adjustment](#)  I.4.9.17
- the main scan direction when paper is fed by the post inserter PI-502:  
✓ [PK punch position centering adjustment](#)  I.39.2

To learn more about these adjustments, click the hyperlinks.

Click icon to add picture

Click icon to add picture

ABC XYZ






When there is a deviation of the position of the punch holes in the main scan direction, change the punch position in the Service Mode.

## Horizontal position adjustment (Slide Layer)

### Mechanical and Electrical Adjustments

#### Deviation in the Punch Hole Position

When the position of the punch holes differs from the standard value, conduct the following for

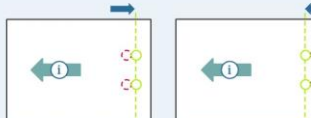

- the main scan direction:  
✓ [Vertical position adjustment](#)  I.4.9.18
- the sub scan/paper feed direction:  
✓ [Horizontal position adjustment](#)  I.4.9.17
- the main scan direction when paper is fed by the post inserter PI-502:  
✓ [PK punch position centering adjustment](#)  I.39.2

To learn more about these adjustments, click the hyperlinks.

Click icon to add picture

Click icon to add picture

ABC XYZ






When the position of the punch holes in the sub scan/paper feed direction is not within the standard value, change the punch position in the Service Mode.

## PK punch centering adjustment (Slide Layer)

### Mechanical and Electrical Adjustments

#### Deviation in the Punch Hole Position

When the position of the punch holes differs from the standard value, conduct the following for

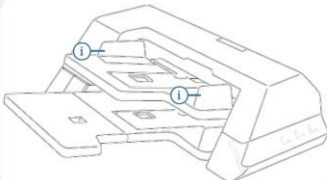

- the main scan direction:  
✓ [Vertical position adjustment](#)  I.4.9.18
- the sub scan/paper feed direction:  
✓ [Horizontal position adjustment](#)  I.4.9.17
- the main scan direction when paper is fed by the post inserter PI-502:  
✓ [PK punch position centering adjustment](#)  I.39.2

To learn more about these adjustments, click the hyperlinks.

Click icon to add picture

Click icon to add picture

ABC XYZ



When the position of the punch holes in the main scan direction is misaligned on paper that is fed from the PI, adjust the side guides of the post inserter.



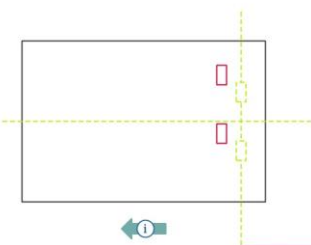
## 4.5 Deviation in the Staple Position

### Mechanical and Electrical Adjustments

#### Deviation in the Staple Position

To correct a deviation in the staple position, several adjustments can be conducted depending in which mode the issue occurs. If the deviation occurs

- on normal stapled paper:
  - ✓ Mechanical staple position adjustment [I.36.1](#)
  - ✓ Electrical staple position adjustment [I.4.9.5](#)
- in fold & staple mode when SD-510 is mounted:
  - ✓ Fold & staple pitch adjustment [I.4.9.8](#)
  - ✓ Fold & staple staple position adjustment [I.4.9.10](#)



C.05


## Staple position adjustment Mechanical (Slide Layer)

### Mechanical and Electrical Adjustments

#### Deviation in the Staple Position

What to do

- Move the staple unit assy in the stapler section to change the staple position in the sub scan/paper feed direction.



Note

When you change the position of the pitch staple position, please consider that the position of the corner staple changes as well.

The mechanical staple position adjustment must be conducted, after the following procedures:

- When the stapler unit has been replaced
- When the staple unit assy has been removed

## Staple position adjustment electrical (Slide Layer)

### Mechanical and Electrical Adjustments

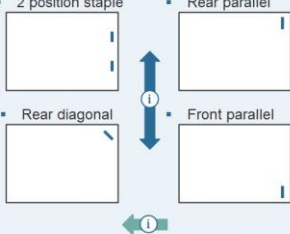
#### Deviation in the Staple Position

To correct a deviation in the staple position, several adjustments can be conducted depending in which mode the issue occurs. If the deviation occurs

- on normal stapled paper:
  - ✓ Mechanical staple position adjustment [I.36.1](#)
  - ✓ Electrical staple position adjustment [I.4.9.5](#)
- in fold & staple mode when SD-510 is mounted:
  - ✓ Fold & staple pitch adjustment [I.4.9.8](#)
  - ✓ Fold & staple staple position adjustment [I.4.9.10](#)

In the Service Mode, correct the staple position in the main scan direction for:

- 2 position staple
- Rear parallel
- Rear diagonal
- Front parallel



## F&S pitch adj (Slide Layer)


Mechanical and Electrical Adjustments

### Deviation in the Staple Position

To correct a deviation in the staple position, several adjustments can be conducted depending in which mode the issue occurs. If the deviation occurs

- on normal stapled paper:
  - ✓ [Mechanical staple position adjustment](#) [M](#) 1.36.1
  - ✓ [Electrical staple position adjustment](#) [M](#) 1.4.9.5
- in fold & staple mode when SD-510 is mounted:
  - ✓ [Fold & staple pitch adjustment](#) [M](#) 1.4.9.8
  - ✓ [Fold & staple position adjustment](#) [M](#) 1.4.9.10

When there is a deviation in the position of the staple pitch of a saddle-stitched printing product, change the staple-pitch adjustment in the **main scan direction** in the Service Mode.



C.05

## F&S staple pos adj (Slide Layer)

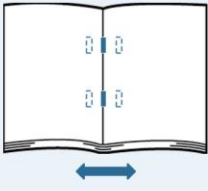
Mechanical and Electrical Adjustments

### Deviation in the Staple Position

To correct a deviation in the staple position, several adjustments can be conducted depending in which mode the issue occurs. If the deviation occurs

- on normal stapled paper:
  - ✓ [Mechanical staple position adjustment](#) [M](#) 1.36.1
  - ✓ [Electrical staple position adjustment](#) [M](#) 1.4.9.5
- in fold & staple mode when SD-510 is mounted:
  - ✓ [Fold & staple pitch adjustment](#) [M](#) 1.4.9.8
  - ✓ [Fold & staple position adjustment](#) [M](#) 1.4.9.10

Correct the staple position for the fold & staple mode in the **sub scan/paper feed direction**.



C.05


## 4.6 Clinched Stapled Paper

Mechanical and Electrical Adjustments


### Clinched Stapled Paper

If the bending height or floating of the staples differs from their standard values or if the staples are buckled, adjust the horizontal position of the clincher in the [✓ clincher section](#) of SD-510 according to the adjustment for staple clinch failure [M](#) 1.37.1.


This adjustment is only required if the issues occur during saddle-stitching.



Floating staple



Bending height



Buckled staple

C.06

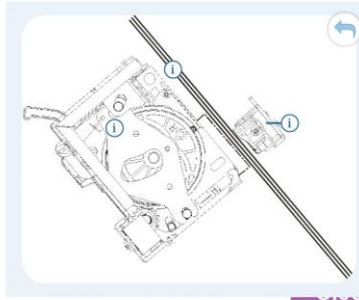
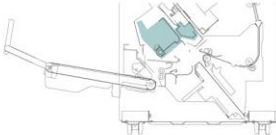
## Clincher section (Slide Layer)

### Mechanical and Electrical Adjustments

#### Clinched Stapled Paper

If the bending height or floating of the staples differs from their standard values or if the staples are buckled, adjust the horizontal position of the clincher in the [✓ clincher section](#) of SD-510 according to the adjustment for staple clinch failure [M 1.37.1](#).

This adjustment is only required if the issues occur during saddle-stitching.



## 4.7 Misaligned Paper Stacks

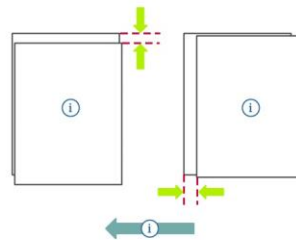
### Mechanical and Electrical Adjustments

#### Misaligned Paper Stacks

If stapled paper stacks are misaligned, conduct the following adjustments in the same order:

- 1) Staple paper width adjustment [M 1.4.9.3](#) to correct misalignments in the **main scan direction**
- 2) FD alignment plate adjustment [M 1.4.9.4](#) to correct misalignments in the **sub scan/paper feed direction**
- 3) Rewind paddle descent adjustment [M 1.4.9.6](#) to correct misalignments in the **sub scan/paper feed direction**

To correct an uneven paper stack in non-staple mode, conduct the exit guide unit paper width adjustment [M 1.4.9.2](#). This adjustment corrects misalignments in the **main scan direction**. Make sure that the paper width setting for stapled stacks is not smaller than the actual paper width. Otherwise the stack will curve.



C.07

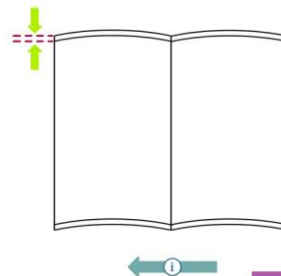
## 4.8 Misaligned Saddle-stitched Paper Stacks

### Mechanical and Electrical Adjustments

#### Misaligned Saddle-stitched Paper Stacks

When SD-510 is mounted, the fold & staple paper width adjustment [M 1.4.9.7](#) is available. It corrects misalignments that occur during saddle-stitching mode in the **main scan direction**.

Make sure that the paper width setting for stapled stacks is not smaller than the actual paper width. Otherwise the stack will curve.



C.07

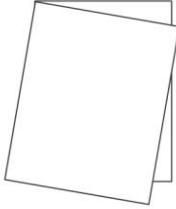
## 4.9 Skewed Fold

**Mechanical and Electrical Adjustments**

**Skewed Fold**

When the first fold is skewed, adjust the [rear stopper](#) in the alignment section of the saddle stitching unit SD-510 according to the 1st folding skew adjustment.

After conducting this adjustment, several electrical adjustments have to be conducted that correct the fold and staple position. For more information, please refer to chapter [1.37.2](#) in the service manual.



A diagram showing a rectangular sheet of paper being folded. The fold line is not perfectly horizontal, resulting in a skewed fold where the top and bottom edges are not parallel.

**C.08**

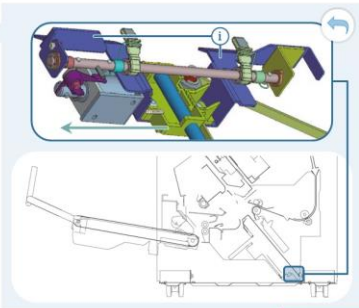
## Rear stopper (Slide Layer)

**Mechanical and Electrical Adjustments**

**Skewed Fold**

When the first fold is skewed, adjust the [rear stopper](#) in the alignment section of the saddle stitching unit SD-510 according to the 1st folding skew adjustment.

After conducting this adjustment, several electrical adjustments have to be conducted that correct the fold and staple position. For more information, please refer to chapter [1.37.2](#) in the service manual.



A detailed diagram of the rear stopper mechanism. The top part shows a 3D perspective view of the mechanical components, including a slide layer and various adjustment points. The bottom part shows a 2D cross-sectional view of the same mechanism. Arrows indicate the direction of movement for the slide layer.

**C.08**

## 4.10 Deviation in Folding Position

**Mechanical and Electrical Adjustments**

**Deviation in Folding Position**

If the folding position differs from the standard value, several adjustments can be conducted from the Service Mode:

- Conduct the [Fold & staple fold position adjustment](#) [1.4.9.9](#) to correct the [fold position](#) of a half-folded and stapled product.
- Conduct the [half-fold position adjustment](#) [1.4.9.11](#) if you need to correct the [fold position](#) of a half-folded product.
- With the [tri-fold position adjustment](#) [1.4.9.12](#) the [position of the 1st and 2nd fold](#) in a tri-folded brochure is adjusted.

**C.09**

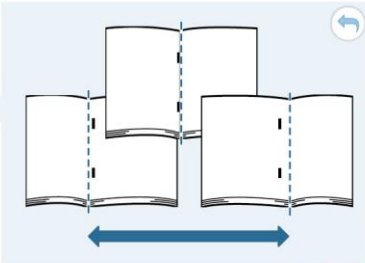
## fold&staple (Slide Layer)

### Mechanical and Electrical Adjustments

#### Deviation in Folding Position

If the folding position differs from the standard value, several adjustments can be conducted from the Service Mode:

- Conduct the Fold & staple fold position adjustment [1.4.9.9](#) to correct the [fold position](#) of a half-folded and stapled product.
- Conduct the half-fold position adjustment [1.4.9.11](#) if you need to correct the [fold position](#) of a half-folded product.
- With the tri-fold position adjustment [1.4.9.12](#) the [position of the 1st and 2nd fold](#) in a tri-folded brochure is adjusted.



C.09

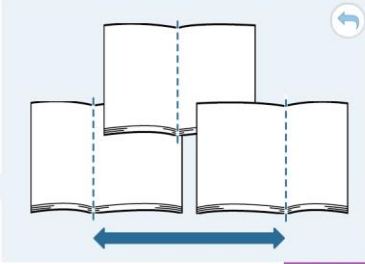
## half-fold (Slide Layer)

### Mechanical and Electrical Adjustments

#### Deviation in Folding Position

If the folding position differs from the standard value, several adjustments can be conducted from the Service Mode:

- Conduct the Fold & staple fold position adjustment [1.4.9.9](#) to correct the [fold position](#) of a half-folded and stapled product.
- Conduct the half-fold position adjustment [1.4.9.11](#) if you need to correct the [fold position](#) of a half-folded product.
- With the tri-fold position adjustment [1.4.9.12](#) the [position of the 1st and 2nd fold](#) in a tri-folded brochure is adjusted.



C.09

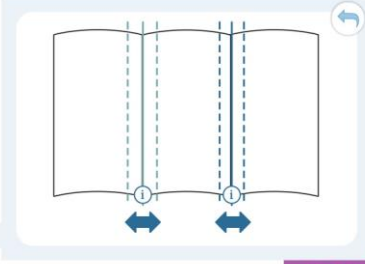
## tri-fold (Slide Layer)

### Mechanical and Electrical Adjustments

#### Deviation in Folding Position

If the folding position differs from the standard value, several adjustments can be conducted from the Service Mode:

- Conduct the Fold & staple fold position adjustment [1.4.9.9](#) to correct the [fold position](#) of a half-folded and stapled product.
- Conduct the half-fold position adjustment [1.4.9.11](#) if you need to correct the [fold position](#) of a half-folded product.
- With the tri-fold position adjustment [1.4.9.12](#) the [position of the 1st and 2nd fold](#) in a tri-folded brochure is adjusted.



C.09

## 4.11 Wide Shift or Box Folding in a Tri-folded Brochure

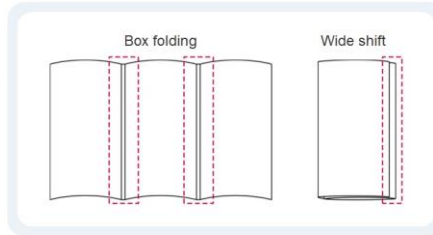
### Mechanical and Electrical Adjustments

#### Wide Shift or Box Folding in a Tri-folded Brochure

When you change the paper type for tri-folding, it might be that a box-folding or wide-shift effect occurs.

When this happens, change the degree of how much the 2nd folding knife is pushed in the fold with the double fold plate adjustment [I.4.9.13](#).

Less pressure reduces the box folding effect. More pressure reduces the wide shift effect.



C.10

## 4.12 Strengthen the Book Fold

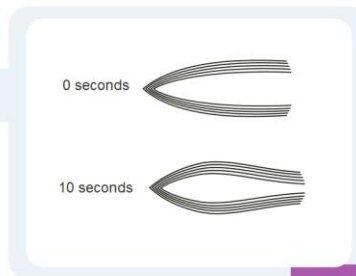
### Mechanical and Electrical Adjustments

#### Strengthen the Book Fold

To adjust the time to depress the booklet folding line, conduct the half-fold strength adjustment [I.4.9.14](#) in the Service Mode.

Strengthen the book fold by defining the pressing time from 0 to 10 seconds.

Making the pressure time longer increases strength to fold booklets, yet decreases productivity.



C.11

## 4.13 Skewed Main Tray

### Mechanical and Electrical Adjustments

#### Skewed Main Tray

When the height of the main tray of the FS-532 differs between the front and rear side, adjust the belt near both sides of the FS-532 according to the main tray horizontal adjustment [I.36.2](#).



C.12



## 4.14 Disassembly and Reassembly

### Lesson C: Field Service

G M

#### Disassembly and Reassembly

Device disassembly and reassembly should always follow the correct instructions [G.39](#) (FS-532), [G.40](#) (SD-510), [G.41](#) (PK-522), [G.42](#) (PI-502).

These instructions contain precautions and warnings as well as detailed descriptions of the different procedures.



C.13

## 4.15 Periodical Maintenance

### Lesson C: Field Service

E, F M

#### Periodical Maintenance

The first reference for periodical maintenance is the information given in the service manual.

It lists

- Maintenance Items and maintenance intervals [F.1.40](#) - [F.1.44](#),
- Periodical Maintenance Procedures [F.35](#) - [F.39](#), and the required Service Materials, Jigs and Tools [E.1.1](#)–[1.3](#).



C.14

## 4.16 Troubleshooting

### Lesson C: Field Service

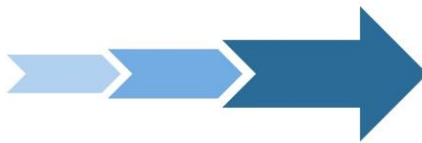
I, K M

#### Troubleshooting

First reference for troubleshooting is the service manual:

- I/O codes [I.4.7.11](#)
- Jam codes [K.1.5](#) - [K.1.10](#)
- Malfunction codes [K.2](#)
- Checklists for other trouble [K.3.4.12](#)
- ICP lists [K.5.2.26](#) - [K.5.2.29](#)

Dip switches [I.4.5.2](#) - [I.4.5.7](#) can help to isolate the cause for a particular output trouble.



C.15



## 4.17 Wrap-up...

### Lesson C: Field Service

#### Wrap-up...



You have almost reached the end of this course!  
The last few slides feature a quiz that will help you  
test your knowledge about this course.

We recommend that you take a break before  
attempting the quiz.

If you are ready to continue, click the [NEXT >](#) button.

C.16

## 5. Goodbye



**Congratulations!**

You have finished the FS-532 technical training course.

- ✓ Introduction
- ✓ Installation
  - Installation Order
  - Installation Precautions
  - Initial Adjustments for PK-522/PK-525
- ✓ Theory of Operation
  - Unit Configuration
  - Paper Path
- ✓ Field Service
  - Mechanical and Electrical Adjustments
  - Disassembly/Reassembly
  - Periodical Maintenance
  - Troubleshooting

## 6. Changelog

### 6.1 Changelog

#### Course Updates

##### Changelog



Click on the device name to view significant changes and access the changed slides directly. When you open a changelog, you also activate highlighting for these changes throughout in the course. You can restart the course without highlighting via the button on the lower left.


- ✓ [Revisions \(2020-03\)](#)
- ✓ [Changes Version B0 → 11 \(2020-10\)](#)

**Remove all highlighting**  
WARNING: Restarts course


### lyr\_changelog-Rev2003 (Slide Layer)

#### Course Updates

##### Changelog



**Significant changes in Revision 2020-03:**


- The W\*6 of FS-532 can now be connected to
  - AccurioPress C83hc and C73hc and
  - AccurioPress 6136, 6136P, 6120.
- Therefore, a new => [installation manual](#) is available.
- The symbols of the electrical parts replacement list have been changed ( K.1). Therefore, you should check the symbols when referring to the parts guide manual.

**Remove all highlighting**  
WARNING: Restarts course

## lyr\_changelog-Ver11 (Slide Layer)

### Course Updates

#### Changelog



Remove all highlighting  
WARNING: Restarts course

Click icon to add picture

Click icon to add picture

ABC XYZ

Click icon to add picture

#### Significant changes in Version 11:

- The W\*6 of FS-532 can now be connected to the AccurioPress C4080 series.
- When connecting the FS-532 to the C4080 series, the [PK-525](#) can be connected as an optional punch unit (instead of the PK-522). The PK-525 is common with the FS-541.
- The [exterior design](#) has been changed.
- Some parts (motors and photo sensors) have been replaced by the respective parts from the FS-541 since their production is going to be stopped. Therefore, the electric parts codes (for example "M101" and "PS101") used in the service manual have been changed to match the parts codes of the FS-541 [MP](#) > FS-532

## 6.2 Exterior Design

### Changes in FW-532 Version 11

#### Exterior Design



For C3080 series



For C4080 series