10 Technical Specification

Inserter head

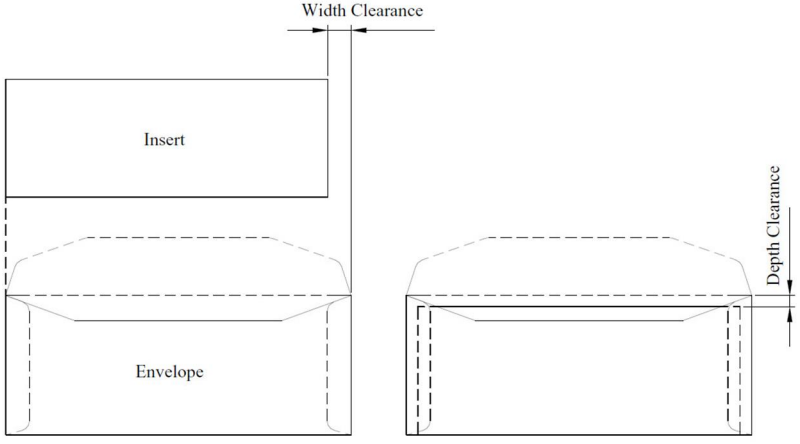
Pack thickness	Maximum pack thickness is defined as the internal dimension of a rigid opening that a filled envelope will fall through under its own weight. All envelopes sizes: up to 10mm (25/64”)

Pack clearance

The minimum clearances required between the inserts and envelopes are dependent on insert pack thickness.

Clearance is the total clearance and is defined as the difference between the largest overall dimensions of the pack and the internal dimensions of the envelope (see below). The required clearances are summarised as follows:

- Pack <3mm: Depth 6mm (¼”) Width 16mm (5/8”)
- Pack >3mm <6mm: Depth 12mm (½”) Width 19mm (¾”)



Monthly volume

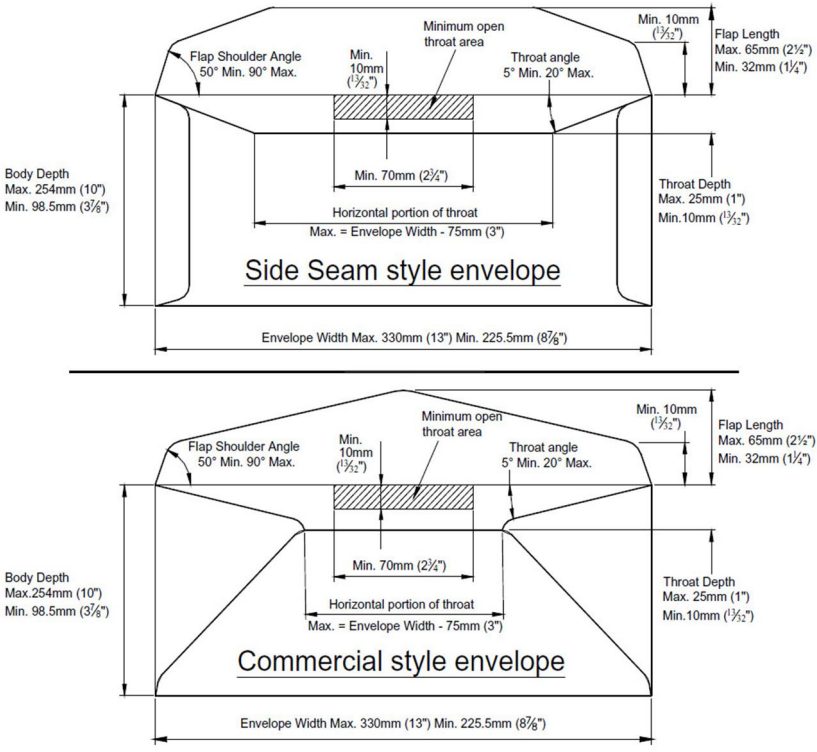
Up to 300,000 filled envelopes per month.

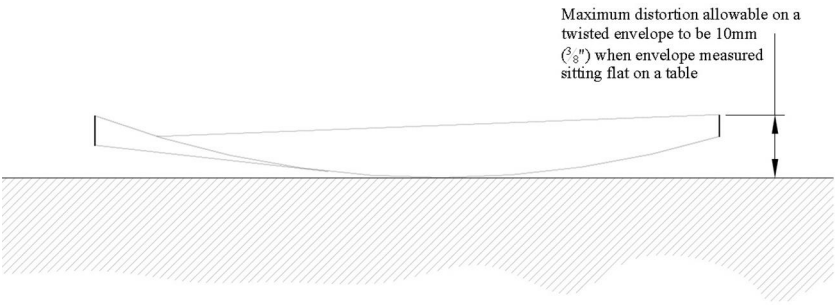
Cycling speed

MAILPIECE	SPEED
Max. speed per hour/Max doc speed per hour	6,000
Accumulation speed (A4)	12,000
C 65 (114mm), 1 x A4/Letter in C-fold via Accumulator	6,000
C 65 (114mm), 2 x A4 in C-fold via Accumulator	6,000
C 65 (114mm), 4 x A4 in C-fold	3,150
C 65 (114mm), 1 x A4 in C-fold + BRE	5,300
Nr#10 (105mm), 1 x Letter in C-Fold via Accumulator	6,000
Nr#10 (105mm), 2 x Letter in C-Fold via Accumulator	6,000
Nr#10 (105mm), 4 x Letter-20 in C-Fold	3,350
C5 (162mm), 1 x A4 single fold via Accumulator	5,200
C5 (162mm), 2 x A4 single fold via Accumulator	5,200
C5 (162mm), 4 x A4 single fold	3,150
C4 (324mm), 1 x A4 unfolded	4,700
C4 (324mm), 8 x A4 unfolded	1,500
C4 (324mm), 10 x A4 unfolded	1,200
C4 (324mm), 15 x A4 unfolded	800

Envelope Hopper capacity	C5 or below - up to 800 of 90gsm (24lbs bond) C4 (flat type) - up to 500 of 100gsm (28lbs bond) Loading whilst running - Yes
Envelope weight	Minimum: C5 or below - 70gsm (18lbs bond) Minimum: Above C5 - 90gsm (24lbs bond) Maximum: 110gsm (28lbs bond)
General envelope requirements	• Envelope to be good quality machine-fill type. Dimensions and quality to be consistent across manufactured batches. • Side seams must be securely glued to the top of the seam. • Flap crease must be pre-scored to enable the envelope flap to open flat. **Note that flap length >48mm reduces machine speed.** • No glue seepage must be evident on interior or exterior of envelope.
Receiving tray capacity (optional)	C5/6: 215 filled envelopes* C4: 300 filled envelopes* *assumes 1 document inserted.

Envelope details





Envelope sealing fluid	Built-in wetter tank, automatically pump-fed by 10-litre wetter container located in stand. Optional low-level float switch available.

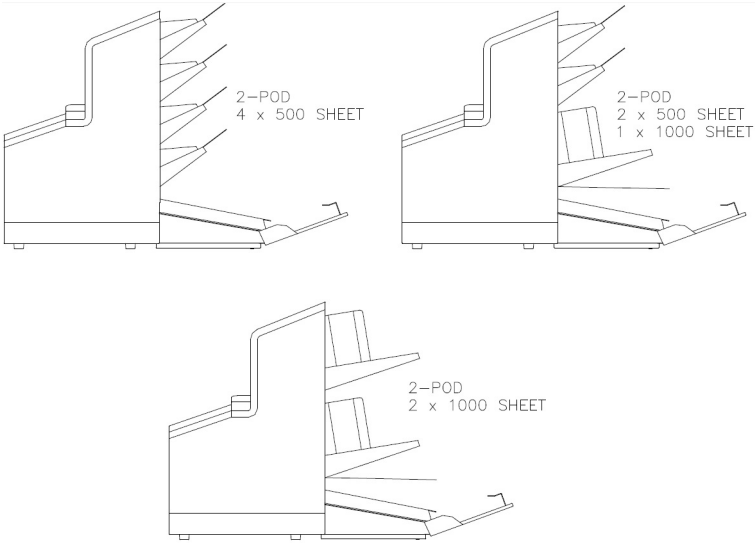
Flex tower

Paper Size	Minimum width: 148mm (5¾")* Maximum width: 305mm (12")† Minimum length: 93mm (3 5/8") (140mm (5½") when reading and using acumulator) Maximum length: 406mm (16") *For individual items. Min. pack width: 210mm (8¼") †Maximum width when folding: 229mm (9") **Note:** The maximum suggested width difference between inserts is 32mm (1¼"): this may be increased subject to test. If this difference is exceeded, the insertion fingers will not cover the edges of the narrow insert and may cause insertion problems. Sandwiching a narrow insert between two wider ones may resolve this.
Paper weight	Minimum 70gsm (18lbs bond) Maximum 120gsm (32lbs bond) for folded documents Maximum 2mm thick for unfolded inserts (subject to test) Maximum 2.5mm thick for Daily Mail (subject to test)
Folding capacity	C, Z or V-fold: 8 sheets 80gsm (20lbs bond)* Double-forward fold: 4 sheets 80gsm (20lbs bond)* * Multiple folded sets dependent upon pack thickness.
Fold lengths	Fold Plate 1: 237mm Max, 50mm Min. Fold Plate 2: 232mm Max, 85mm Min. Fold Plate 3: 135mm Max, 50mm Min.

Hopper capacity

Tower is fitted with 2 pods, each fitted with 1 or 2 hoppers as follows:

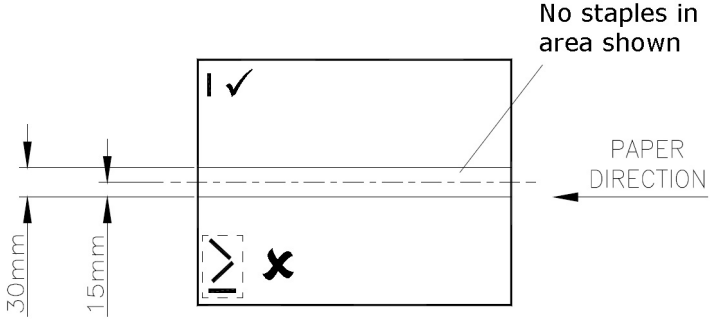
- 2 x 500 sheets of 80gsm (20lbs bond)
- 1 x 1000 sheets of 80gsm (20lbs bond)



Examples shown above are for illustration only. Other configurations are available.

Daily mail

Up to 8 sheets of 80gsm (20lbs bond) for C, Z or V fold, up to 4 sheets of 80gsm (20lbs bond) for double forward fold, up to 25 sheets of 80gsm (20lbs bond) unfolded. May be stapled or not. Max. thickness of staple 3mm. Allowable staple positions are shown below.

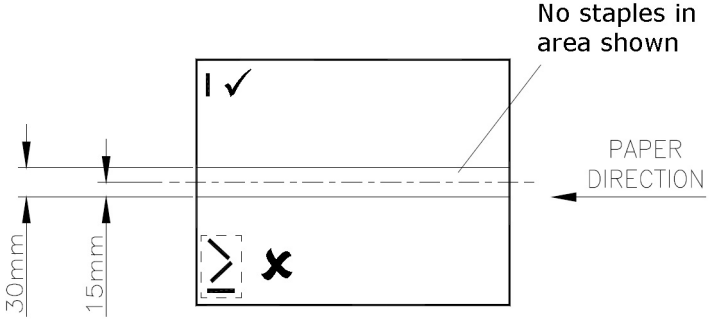


Versatile feeder

Enclosure Size	Minimum width: 148mm (5¾")* Maximum width: 305mm (12") Minimum length: • 76mm (3") for non-reading unit • 93mm (3 5/8") for reading unit Maximum length: 216mm (8½") *For individual items, min. pack width is 210mm (8¼") **Note:** The maximum suggested width difference between inserts is 32mm (1¼"): this may be increased subject to test. If this difference is exceeded, the insertion fingers will not cover the edges of the narrow insert and may cause insertion problems. Sandwiching a narrow insert between two wider ones may resolve this.
Enclosure weight	Minimum 70gsm (20lbs bond) Maximum 6mm (¼") thickness
Hopper capacity	1000 sheets of A4 80gsm (20lbs bond) 500 sheets of A4 Z-folded 80gsm (20lbs bond) 250 x 2.4mm booklets 500 x C65 envelopes **Note:** Quantities shown above are maximal. Depending upon other conditions, actual quantities may be lower than those shown.
Requirements	Enclosures must be flexible enough to suit path constraints. Some enclosures may require special tyres.

Daily mail

Up to 25 sheets of 80gsm (20lbs bond) unfolded. May be stapled or not. Max. thickness of staple 3mm. Allowable staple positions are shown below.



Mechanical & Electrical

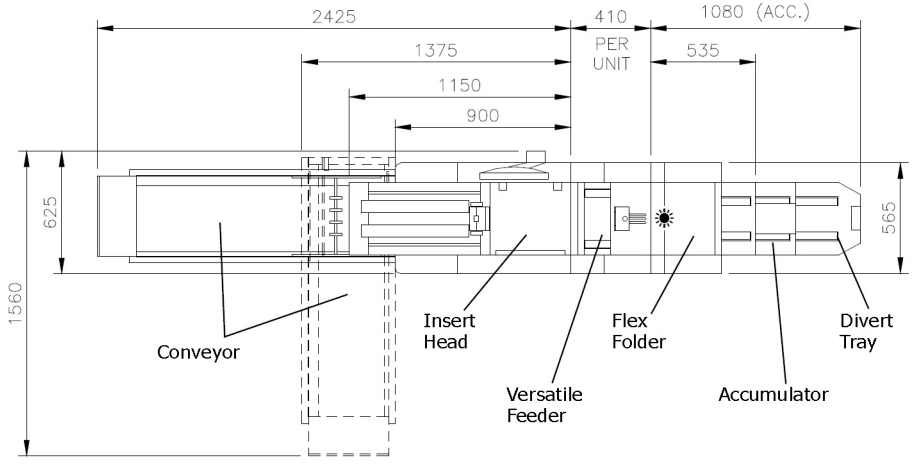
<table>
<tr><td>Noise level</td><td>75dbA (3 x Versatile feeders, 1 x Flex tower, measured at 1.6m height, 1m from nearest cover).</td></tr>
<tr><td>Heat Output (BTU/Hour)</td><td>Rated current x rated volts x 3.412 (eg. 2464 BTU/Hour for typical configuration of 3 x versa feeders + flex tower folder).</td></tr>
<tr><td>Heat Output (Watts)</td><td>Rated current x rated volts (eg. 722W for typical configuration of 3 x Versatile feeders + Flex tower folder).</td></tr>
<tr><td>Electrical</td><td>
<table>
<tr><td></td><td>230VAC</td><td>115VAC</td></tr>
<tr><td>Frequency</td><td>50Hz</td><td>60Hz</td></tr>
<tr><td>Input Current</td><td>Head: 0.85A
Versa Feeder: 0.58A
CIS Feeder: 0.58A
Flex Tower: 0.55A
PC & Monitor: 1.2A</td><td>Head: 1.6A
Versa Feeder: 1A
CIS Feeder: 1A
Flex Tower: 1.4A
PC & Monitor: 2.4A</td></tr>
<tr><td>Fuse Rating (Insert Head)</td><td>T6.3A</td><td>T10A</td></tr>
</table>
</td></tr>
<tr><td>Operating Temperature</td><td>18 - 28 deg C (64 - 82 deg F)</td></tr>
<tr><td>Operating humidity</td><td>30 - 80% RH</td></tr>
</table>

Weights

	Unpackaged	Packaged
Inserter Head	101Kg	119Kg
Versatile Feeder	62Kg	76Kg
Flex Tower*	114Kg	130Kg
Conveyor	36Kg	42Kg
Furniture Units	23Kg 34Kg 44Kg	24Kg (short) 36Kg (long) 46Kg (conveyor)
PC, Arm & Fluid	31Kg	34Kg

* 2-pod version (each with 2 x 500 sheet-trays), and including accumulator with diverter tray.

Sizes:



Heights (incl. furniture):

Inserter head	1200
Versatile Feeder	1400
Flex Folder*	1500

* Fitted with 4 x 500-sheet trays

Ambient light:

Although the machine may operate in sunlight, it is not designed for use in direct sunlight, or where sunlight is exposed to the machine through windows or skylights. The light-sensitive sensors can be affected in these conditions. It is therefore recommended to:

a) Locate the machine out of direct sunlight
b) Protect the machine from direct sunlight using blinds or similar blocking devices.

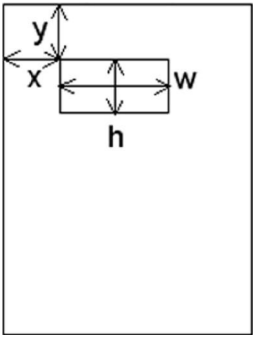
If the machine can only be located where it may be exposed to direct sunlight, then please contact Technical Support department, who may be able to advise on the use of blocking material on the inside of the Perspex cover where necessary.

Important Notes:

1. All stationery should be allowed to acclimatise near the machine for at least 24 hours before use to prevent rapid absorption of moisture in the material, or condensation forming on the machine. Failure to acclimatise the material may cause pre-gumming of envelopes or otherwise impair machine performance.
2. The machine will function with humidity levels lower than 30% RH, but high levels of static may be generated, impairing machine performance.
3. The machine will function with humidity levels higher than 80% RH, but moisture absorption into the material may impair machine performance.
4. Condensation must not be present under any circumstances.
5. The machine will function at temperature levels above 28 deg C (82 deg F) and below 18 deg C (64 deg F). However, temperature levels outside these limits may impair the machine performance.
6. Material processed directly from laser printers may have high levels of static causing material to stick together. If double feeding occurs, then Hi-Grip separators may be required - contact IPSS department.

11 Glossary of Terms

Glossary of Terms

Term	Description
Address carrier	The address carrier is the document that carries the address of the person for who the mail set is meant. The address carrier can consist of one or more sheets, from which at least the first sheet must contain the address. The address must remain visible while enclosures are added and the document set is folded. The fold type and selected envelope must ensure that the address is visible behind the window in the envelope. For personalized mailings there is always an address carrier present as long as envelope printing is not supported. Normally there is one address carrier.
Address position	 Position of the address on the address carrier, measured from the upper left corner. The address position consists of a horizontal x coordinate, a vertical y coordinate, a horizontal width w and a vertical height h.
Automatic	The feature of an inserting system to automatically determine its job settings by measuring the sizes of documents and envelope. From all feeders that are loaded one sheet will be taken. Based on the maximum document length (which is also the length of the document set) and the length of the envelope the fold type is determined.
Automatic job	A job that is created with the Automatic job functionality.
Barcode Reading (BCR)	Barcode Reading is intended for reading and interpreting printed barcodes. The codes give information to the inserting system about how to build-up and handle a set.