

# C.P. Bourg<sup>®</sup> Booklet Maker Enhanced (BMEx)

with Optional Sheet Rotator (BSR), Square Edge  
Module (SQEDG), and Bleed Crease Module (BCMEx)

## Finishing Solutions Planning Guide

### Supported Printers

Xerox iGen3<sup>®</sup> Digital Production Press  
Xerox iGen4<sup>®</sup> Digital Production Press  
Xerox iGen<sup>™</sup> 220 Digital Production Press  
Xerox iGen<sup>™</sup> 150 Digital Production Press  
Xerox Nuvera<sup>®</sup> 100/120/144/157 EA Production System  
Xerox Nuvera<sup>®</sup> 200/288/314 EA Perfecting Production System  
Xerox Color<sup>®</sup> 8250 Production Printer



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# Introduction

This Solutions Planning Guide contains information on how to prepare for the installation of the C.P. Bourg Booklet Maker (BMEx) with:

- Xerox iGen3 Digital Production Press
- Xerox iGen4 Digital Production Press
- Xerox iGen150 Digital Production Press
- Xerox 220 Digital Production Press
- Xerox Nuvera 100/120/144/157 and 200/288/314 Production System
- Xerox Color 8250 Production Printer

## About this Guide

This guide provides the Analyst and the coordinating Customer with common BMEx specifications and specific pre-installation tasks based on the actual Xerox printer model attached to the BMEx.

## Contents

This section lists the contents of this guide:

- Introduction - provides information about the use of this guide.
- Product Overview - provides Installation Planning, including Space, Electrical, Environmental requirements, Installation Time and Operating Supplies.
- Xerox iGen - provides information about Limitations, System Dependencies, and a Configuration Guide.
- Xerox Nuvera - provides information about Limitations, System Dependencies, and a Configuration Guide.
- Xerox Color 8250 Production Printer - provides information about Limitations, System Dependencies, and a Configuration Guide.
- Customer Agreement - contains the Customer Agreement form.
- Appendix A – contains the Floor Loading Certification form.

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# Product Overview

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The C.P. Bourg Booklet Maker Enhanced (BMEx) is a booklet maker that connects inline with iGen and Nuvera printers. The C.P. Bourg BMEx is unique in its ability to produce extra large format booklets. It can produce booklets with a finished size as large as 11.5" x 14.33". The BMEx can stitch fold and trim 2 to 30 sheets (75gsm). The BMEx also corner and top stitches, and stacks.

The Bourg Sheet Rotator (BSR) (not shown) enables maximum small Booklet productivity on Xerox printers that are not equipped with an internal rotator.

The Bourg Bleed Crease Module (BCMEx) (not shown) takes traditional stitch-fold, face-trimmed booklets and transforms them into three-sided, bleed-trimmed booklets with creased covers and inside sheets that lay flat, stack easily, and help eliminate cracking on printed cover stock. The BCMEx can crease only the cover or the cover and body pages for a better finished booklet.

The Square Edge Module (SQEDG) (not shown) further expands BMEx capability by offering an optional square edge spine to produce the look and feel of a perfect bound book. However, normal, or non-square edge, saddle-stitched booklets can still be produced.

# Install Planning

This guide will help you prepare for the installation of the C.P. Bourg BMEx.

## Device Configurations

The BMEx components are:

- Booklet Maker Stitcher/Folder
- Conveyor

Optional components include:

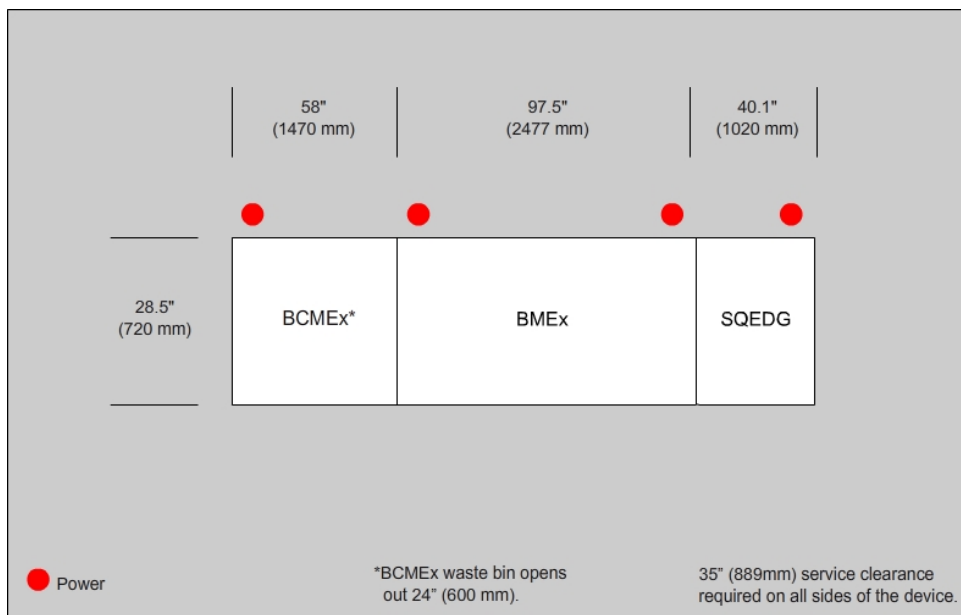
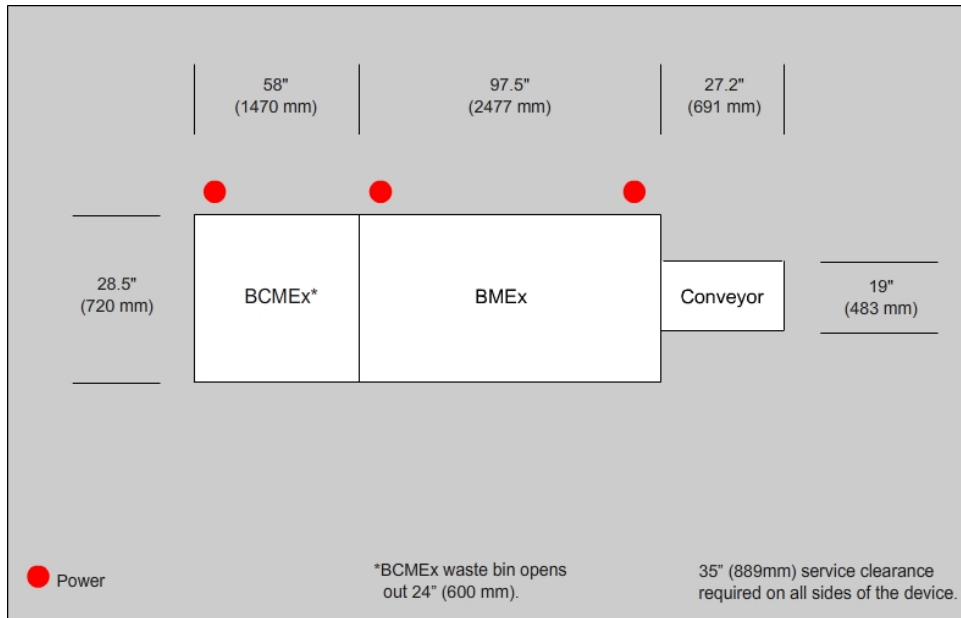
- Bourg Sheet Rotator (BSR)
- Bourg Bleed Crease Module (BCMEx)
- Square Edge (SQEDG)
- Bourg Box



## Space Requirements

The space requirements illustration provides the machine footprint as well as the overall operating and maintenance area.

In addition to the diagram below, there should be a minimum of 82 inches (2083 mm) clearance from the floor to the nearest overhead obstruction.



### NOTE:

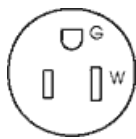
The space requirements diagram for the C.P. Bourg BMEx is a representation only and not drawn to scale.

## Component Dimensions

Dimensions	BCMEx (Optional)	BMEEx	SQEDG
Width x Depth x Height	58" x 28.5" x 47" (1473x720x1194mm)	97.5" x 28.5" x 56" (2469x720x1422mm)	40.1"x28.5"x49" (1020x720x1242mm)
Weight	649lbs (294kg)	1300lbs (590 kg)	291 lbs (131kg)
Shipping Weight	1100lbs (498kg)	1650lbs (748kg)	420 lbs (190kg)
Operator Clearance	Minimum 24" (609.6mm) in front of the device	Minimum 30" (763mm) in front of the device	Minimum 24" (609.6mm) in front of the device
Service Clearance	Minimum 30" (763mm) on all sides of the device	Minimum 35" (889mm) on all sides of the device	Minimum 35" (889mm) on all sides of the device

## Electrical Requirements

NEMA # for all the devices listed below: 5-15P



Plug configuration

Device Power	North America	Europe
BMEEx	120 VAC (+/- 10 %), 60 Hz, 10A	230 VAC (+/- 10 %), 50 Hz, 7A
BCMEx	120 VAC (+/- 10 %), 60 Hz, 6A	230 VAC (+/- 10 %), 50 Hz, 4A
BMEEx Trimmer	120 VAC (+/- 10 %), 60 Hz, 6A	230 VAC (+/- 10 %), 50 Hz, 4A
SQEDG	120 VAC (+/- 10 %), 60 Hz, 5A	230 VAC (+/- 10 %), 50 Hz, 3A

## Power Cords

- BMEEx – approximately 6' (1829mm) long
- BMEEx Trimmer - approximately 8' (2438mm) long
- BCMEx - approximately 12' (3658mm) long
- SQEDG - approximately 8' (2438mm) long

## Environmental Requirements

Environment	BMEx, BCMEx, SQEDG
Temperature	50 - 90° F (10 - 35°C)
Humidity	40 - 85 % RH
Heat Emission	5700 btu/hr Run
Sound Emission	Run 70 db
Altitude	0 - 8840 ft (3000m)

## Install and Customer Training

The Bourg BMEx install is performed by a C.P. Bourg service technician after the iGen has been installed and takes one day. Customer training takes an additional two days.

## Operating Supplies

The Bourg BMEx is shipped with one stitch cartridge or stitch roll for each stitch head.

Staple Cartridge (ISP) - Part number 9158017

Staple Spool (Hohner) - Part number 9158018

Staple-Spool Kit (Hohner) normal stitching to loop stitching - Part number 9158037

40,000 stitches for each spool or cassette

The following parts are consumables and are not covered under the service contract:

- Stitcher Wire - 9158017 and 9158018
- Trimmer Blades - 9232510 and 9231391

Contacts for part orders in North America:

C.P. Bourg

Customer Service

Phone: 1-508-998-2171

E-mail: <http://www.cpbourg.com>

Contacts for part orders in Europe

C.P. Bourg

Export Department

Phone: +32 10 622-211

## Floor Load

Module	Uniform Load
<b>BMEx</b>	
Front casters	185lbs/caster
Rear casters	278lbs/caster
<b>Trimmer and Conveyor</b>	
Front casters	100lbs/caster
Rear casters	137.5lbs/caster
<b>BCMEx</b>	30 lbs/sq ft (148 kg/sq m)
<b>SQEDG</b>	44 lbs/sq ft (212 kg/sq m)

## Floor Level

The floor must be level to within one (1) degree.

# Xerox® iGen Digital Production Press

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## Performance Specifications

Listed below are the performance specifications for the BMEx.

Stapling/Folding	Specifications	
Paper Type/Weight	Min: 60gsm Max: 160gsm Coated and uncoated 80 to 250 gsm Covers (up to 350 gsm if cover is creased) SQEDG Uncoated stock 16-110 lbs (60 – 200gsm)	
Paper Size Input	Min: 7" x 8" (178mm x 203mm) SEF Max: 14.33" x 22.5" (364mm x 572mm) SEF	
Paper Size Output	Min: 7" x 3.5" (178mm x 89mm) Max: 14.33" x 11.75" (364mm x 299mm)	
Input Height	33.86" (860mm)	
Stitch Heads	1, 2, or 4 stitch heads. Each BMEx is delivered with two stitch heads. The number of stitch heads must be selected at time of order as they cannot be upgraded in the field.	
Staple Type	Cartridge	40,000 stitches per
	Roll	40,000 stitches per
Stitch Configurations	Center, Corner, Top, Side, or Bypass	
Stitcher Capacity	50 sheets max (80 gsm)	4.8mm thickness max
Folding Capacity	2 to 30 sheets max (75gsm)	2.9 mm thickness max
Folding Capacity (No staple)	5 sheets max (75gsm) without stapling	
Trimmer Position (Face)	4.5mm Nominal Max: 25mm Min: 0.5mm	
Trimmer Capacity	30 sheets max (75gsm) 2 sheets min (60gsm)	
BCMEx - Input Paper Size	Max: 14.33" x 22.5" (364 x 572mm) SEF Before trimming Min: 7" x 8" (178 x 203mm) SEF	
BCMEx - Output Paper Size	Max: 14" x 22.5" (356 x 572mm) SEF Min: 5" x 8" (127 x 203mm) SEF	

## Limitations

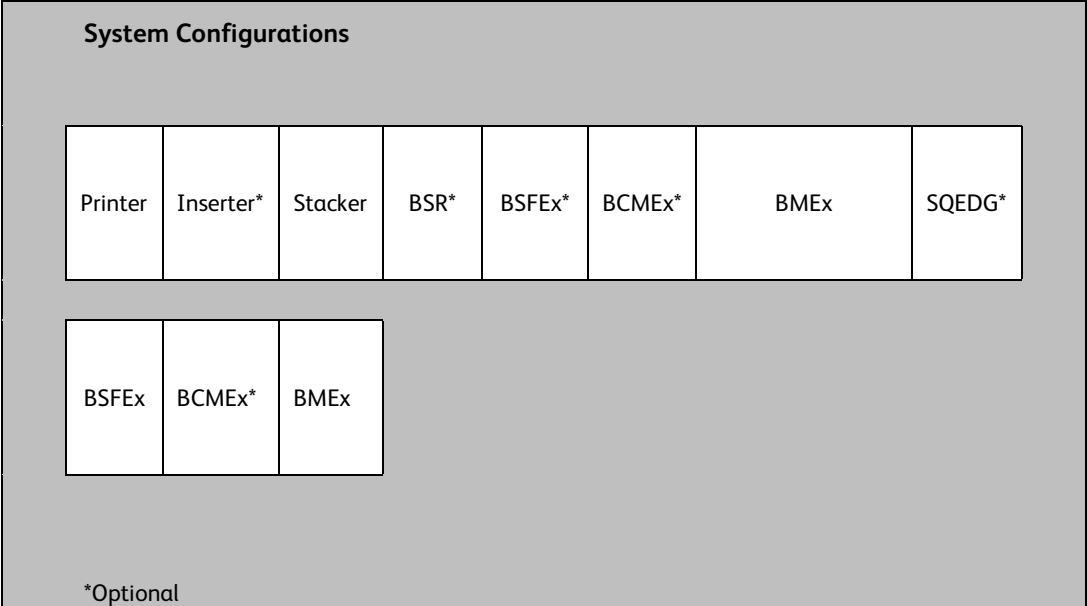
- If the BMEx is inline with a BCMEx, the maximum sheet size is 14" (356mm) wide due to sheet size limitations of the BCMEx.
- Maximum number of folded and stitched sheets; 2-30 sheets (75gsm) total gsm 2250, or a thickness of 2.9 mm maximum.
- Books 11.8" (300mm) or longer can only be saddle stitched.
- The number of stitch heads must be selected at time of order as they cannot be upgraded in the field.
- Use of short grain paper is highly recommended for 11 x 17"/A3 sized paper.
- The cover page of the booklet must be sent as the last page in the set.
- Job programming at the BCMEx does not automatically flow to the BMEx and requires some operator setup at the booklet maker user interface.
- If maximum bleed trim is used, the waste bin can become full in as little as 60 minutes. With 4 to 6mm bleed trim, the runtime can be as long as 240 minutes.
- There is a physical limitation of 13.78" in terms of width on the SQEDG.

## System Dependencies and Prerequisites

- If installing a new BMEx on an existing iGen installation, a Xerox iGen Finishing Interface Kit (iG3FIN) must be ordered.
- On the iGen4 and iGen150, the anti-static components are part of the Finishing Interface Kit.

## Configuration Guide

This section contains diagrams of the finishing solutions that are currently supported.



## Productivity Guide

iGen3, iGen4, iGen150, iGen220 All sheets fed SEF, folded, and stitched.

Paper Size	Sheets per Book	Books per Hour
<b>8.5" x 11" (A4)</b>	2	1636
	5	818
	10	439
	15	300
<b>11" x 17" (A3)</b>	2	900
	5	360
	10	180
	15	120
<b>8.5" x 14"</b>	2	1200
	5	600
	10	327
	15	225
<b>14.33" x 20.5"</b>	2	750
	5	300
	10	150
	15	100

Maximum booklet size guide (including a cover sheet)

Paper Weight	Bond (lbs)	Max number of uncoated sheets per book
<b>75 gsm</b>	20	30
<b>80 gsm</b>	22	29
<b>90 gsm</b>	24	24
<b>105 gsm</b>	28	20
<b>120 gsm</b>	32	19



The data shown below was generated on a Xerox iGen 150 Digital Production Press with an in-line BSFEx/BCMEx/BMEx.

<b>Sheets per Set</b>	<b>Booklets per Hour (9x12 SEF)</b>	<b>Booklets per Hour (11x17 SEF)</b>	<b>Booklets per Hour (12x18 SEF)</b>
2	2309	1849	1802
3	1857	1428	1386
4	1553	1163	1126
5	1335	982	949
6	1170	849	819
7	1042	748	721
8	938	668	644
9	854	604	581
10	783	551	530
11	724	506	487
12	672	469	451
13	628	436	419
14	589	408	392
15	554	383	368
16	524	361	347
17	496	341	328
18	472	324	311
19	449	308	296
20	429	293	282
21	411	280	269
22	393	268	258
23	378	257	247
24	363	247	237
25	350	238	228
26	337	229	220
27	326	221	212
28	315	214	205
29	305	207	198
30	316	209	200

The measurements above are based on booklet-to-booklet performance and do not include cycle-up and cycle-down at the start or end of the job. Using a Bourg Square Edge Module may also effect book-to-book production on small set sizes.

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# Xerox Nuvera® 100/120/144/157 and 200/288/314 Production Systems

## Performance Specifications

Listed below are the performance specifications for the BMEx.

Stapling/Folding	Specifications	
Paper Type/Weight	Min: 60gsm (coated or uncoated) Max: 350gsm (coated or uncoated)	
Paper Size Input	Min: 5.8" x 8" (147mm x 203mm) Max: 12.6" x 19.3" (320mm x 490mm)	
Input Height	33.86" (860mm)	
Stitch Heads	1, 2, or 4 stitch heads. Each BMEx is delivered with two stitch heads. The number of stitch heads must be selected at time of order as they cannot be upgraded in the field.	
Staple Type	Cartridge	40,000 stitches per
	Roll	40,000 stitches per
Stitch Configurations	Center, Corner, Top, Side, or Bypass	
Stitcher Capacity	50 sheets max (80 gsm)	4.8mm thickness max
Folding Capacity	2 to 30 sheets max (75gsm)	2.9 mm thickness max
Folding Capacity (No staple)	5 sheets max (75gsm) without stapling	
Trimmer Position (Face)	4.5mm Nominal Max: 20mm Min: 0.5mm	
Trimmer Capacity	30 sheets max (75gsm) 2 sheets min (60gsm)	
BCMEx - Input Paper Size	Max: 12.6" x 19.3" (320 x 490mm)SEF Min: 5.8" x 8" (147 x 203mm) SEF	

## Limitations

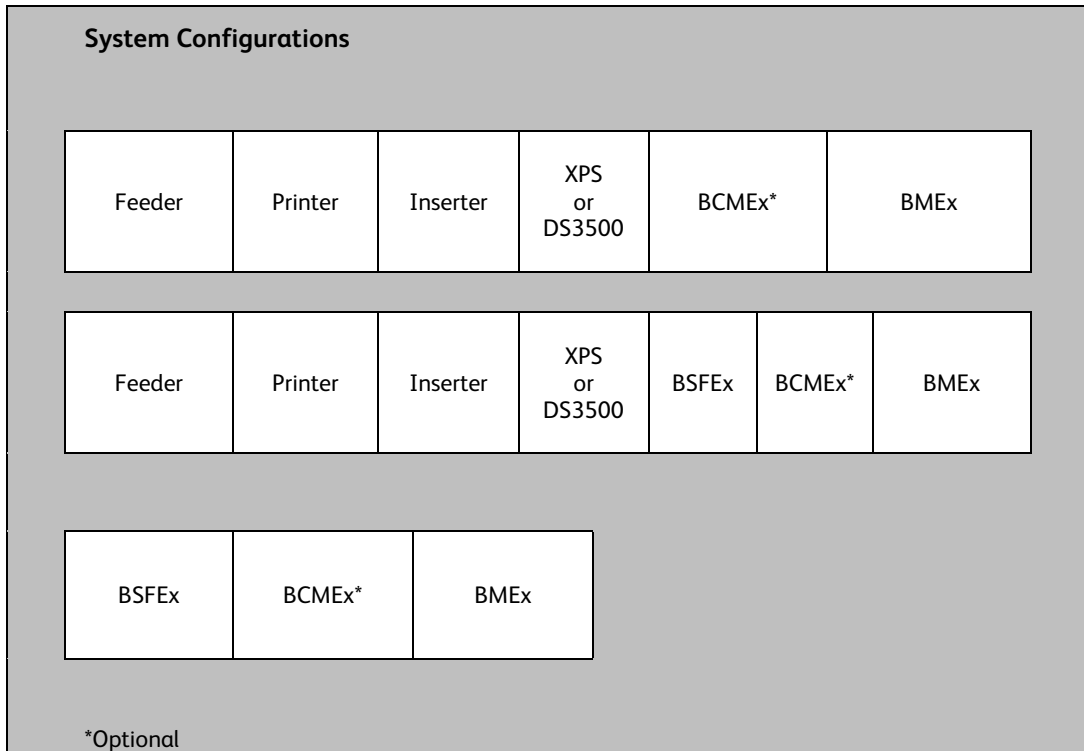
- Maximum number of folded and stitched sheets; 2-30 sheets (75gsm) total gsm 2250, or a thickness of 2.9 mm maximum.
- Books 11.8" (300mm) or longer can only be saddle stitched.
- The number of stitch heads must be selected at time of order as they cannot be upgraded in the field.
- Use of short grain paper is highly recommended for 11 x 17"/A3 sized paper.
- The cover page of the booklet must be sent as the last page in the set.
- If maximum bleed trim is used, the waste bin can become full in as little as 60 minutes. With 4 to 6mm bleed trim, the runtime can be as long as 240 minutes.
- C.P. Bourg is currently investigating a BMEx firmware upgrade in order to correct a false missing staple error.
- Stray trimmings may cause occasional shutdowns.
- The Booklet Stacker has a capacity of 50 booklets (depending on the number of sheets in each booklet). The Stacker can be unloaded while the machine is running.

## System Dependencies and Prerequisites

- Job programming at the BCMEx does not automatically flow to the BMEx and requires some operator setup at the booklet maker user interface.

## Configuration Guide

This section contains diagrams of the finishing solutions that are currently supported.



## Booklet Size Guide

Maximum booklet size guideline (including a cover sheet)

Paper Weight	Bond (lbs)	Max number of uncoated sheets per book
75 gsm	20	30
80 gsm	22	29
90 gsm	24	24
105 gsm	28	20
120 gsm	32	19

## Productivity Guide

Data shown below was generated on a Xerox Nuvera 157 Production System.

Paper Size	Sheets per Book	Rotate?	Body GSM	Folded?	Stapled?	Books per Hour
8.5" x 11" LEF	1	Yes	75	Yes	Yes	-
8.5" x 11" LEF	2	Yes	75	Yes	Yes	1967
8.5" x 11" LEF	5	Yes	75	Yes	Yes	786
8.5" x 11" LEF	10	Yes	75	Yes	Yes	449
8.5" x 11" LEF	15	Yes	75	Yes	Yes	305
8.5" x 11" LEF	25	Yes	75	Yes	Yes	185
8.5" x 11" SEF	1	No	75	Yes	Yes	-
8.5" x 11" SEF	2	No	75	Yes	Yes	1434
8.5" x 11" SEF	5	No	75	Yes	Yes	630
8.5" x 11" SEF	10	No	75	Yes	Yes	315
8.5" x 11" SEF	15	No	75	Yes	Yes	210
8.5" x 11" SEF	25	No	75	Yes	Yes	126
8.5" x 14" SEF	1	No	75	Yes	Yes	-
8.5" x 14" SEF	2	No	75	Yes	Yes	1204
8.5" x 14" SEF	5	No	75	Yes	Yes	451
8.5" x 14" SEF	10	No	75	Yes	Yes	236
8.5" x 14" SEF	15	No	75	Yes	Yes	153
8.5" x 14" SEF	25	No	75	Yes	Yes	95
11" x 17" SEF	1	No	75	Yes	Yes	-
11" x 17" SEF	2	No	75	Yes	Yes	1165
11" x 17" SEF	5	No	75	Yes	Yes	450
11" x 17" SEF	10	No	75	Yes	Yes	235
11" x 17" SEF	15	No	75	Yes	Yes	151
11" x 17" SEF	25	No	75	Yes	Yes	95
12" x 18" SEF	1	No	75	Yes	Yes	-
12" x 18" SEF	2	No	75	Yes	Yes	630
12" x 18" SEF	5	No	75	Yes	Yes	286
12" x 18" SEF	10	No	75	Yes	Yes	157
12" x 18" SEF	15	No	75	Yes	Yes	105
12" x 18" SEF	25	No	75	Yes	Yes	68

# Xerox® Color 8250 Production Printer

# 5

## Performance Specifications

Listed below are the performance specifications for the BMEEx.

Stapling/Folding	Specifications	
Paper Type/Weight	Min: 60gsm Max: 160gsm Coated and uncoated 80 to 250 gsm Covers (up to 350 gsm if cover is creased) SQEDG Uncoated stock 16-110 lbs (60 – 200gsm)	
Paper Size Input	Min: 7" x 8" (178mm x 203mm) SEF Max: 14.33" x 22.5" (364mm x 572mm) SEF	
Paper Size Output	Min: 7" x 3.5" (178mm x 89mm) Max: 14.33" x 11.75" (364mm x 299mm)	
Input Height	33.86" (860mm)	
Stitch Heads	1, 2, or 4 stitch heads. Each BMEEx is delivered with two stitch heads. The number of stitch heads must be selected at time of order as they cannot be upgraded in the field.	
Staple Type	Cartridge	40,000 stitches per
	Roll	40,000 stitches per
Stitch Configurations	Center, Corner, Top, Side, or Bypass	
Stitcher Capacity	50 sheets max (80 gsm)	4.8mm thickness max
Folding Capacity	2 to 30 sheets max (75gsm)	2.9 mm thickness max
Folding Capacity (No staple)	5 sheets max (75gsm) without stapling	
Trimmer Position (Face)	4.5mm Nominal Max: 25mm Min: 0.5mm	
Trimmer Capacity	30 sheets max (75gsm) 2 sheets min (60gsm)	
BCMEEx - Input Paper Size	Max: 14.33" x 22.5" (364 x 572mm) SEF Before trimming Min: 7" x 8" (178 x 203mm) SEF	
BCMEEx - Output Paper Size	Max: 14" x 22.5" (356 x 572mm) SEF Min: 5" x 8" (127 x 203mm) SEF	

## Limitations

- If the BMEx is inline with a BCMEx, the maximum sheet size is 14" (356mm) wide due to sheet size limitations of the BCMEx.
- Maximum number of folded and stitched sheets; 2-30 sheets (75gsm) total gsm 2250, or a thickness of 2.9 mm maximum.
- Books 11.8" (300mm) or longer can only be saddle stitched.
- The number of stitch heads must be selected at time of order as they cannot be upgraded in the field.
- Use of short grain paper is highly recommended for 11 x 17"/A3 sized paper.
- The cover page of the booklet must be sent as the last page in the set.
- Job programming at the BCMEx does not automatically flow to the BMEx and requires some operator setup at the booklet maker user interface.
- If maximum bleed trim is used, the waste bin can become full in as little as 60 minutes. With 4 to 6mm bleed trim, the runtime can be as long as 240 minutes.
- There is a physical limitation of 13.78" in terms of width on the SQEDG.

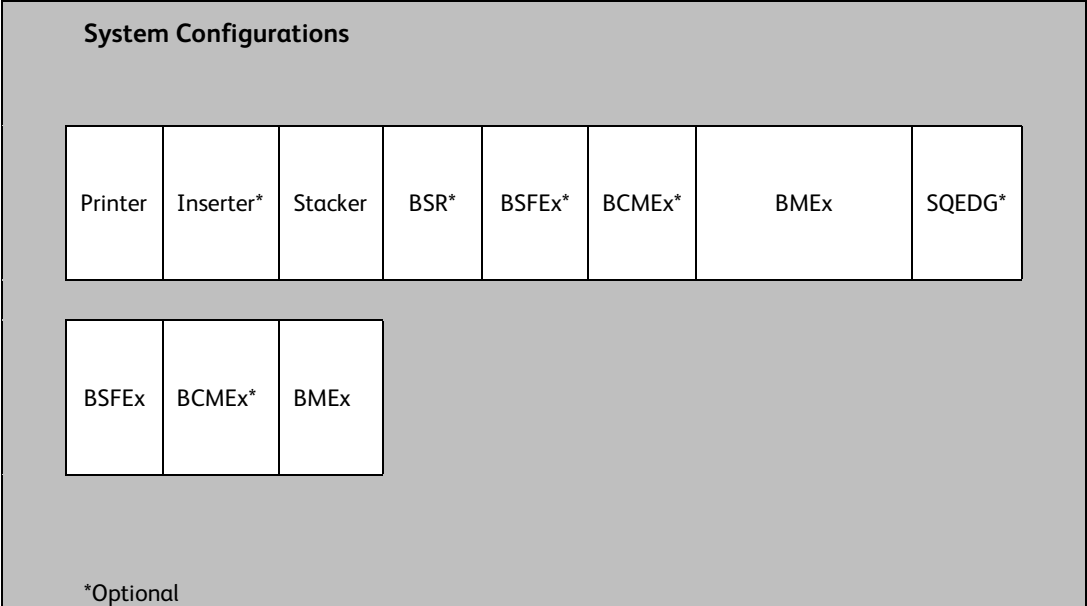
## System Dependencies and Prerequisites

- If installing a new BMEx on an existing installation, a Xerox Finishing Interface Kit (iG3FIN) must be ordered.
- The anti-static components are part of the Finishing Interface Kit.



## Configuration Guide

This section contains diagrams of the finishing solutions that are currently supported.



## Productivity Guide

All sheets fed SEF, folded, and stitched.

Paper Size	Sheets per Book	Books per Hour
<b>8.5" x 11" (A4)</b>	2	1636
	5	818
	10	439
	15	300
<b>11" x 17" (A3)</b>	2	900
	5	360
	10	180
	15	120
<b>8.5" x 14"</b>	2	1200
	5	600
	10	327
	15	225
<b>14.33" x 20.5"</b>	2	750
	5	300
	10	150
	15	100

Maximum booklet size guide (including a cover sheet)

Paper Weight	Bond (lbs)	Max number of uncoated sheets per book
<b>75 gsm</b>	20	30
<b>80 gsm</b>	22	29
<b>90 gsm</b>	24	24
<b>105 gsm</b>	28	20
<b>120 gsm</b>	32	19

The data shown below was generated with an in-line BSFEx/BCMEx/BMEx.

Sheets per Set	Booklets per Hour (9x12 SEF)	Booklets per Hour (11x17 SEF)	Booklets per Hour (12x18 SEF)
2	2309	1849	1802
3	1857	1428	1386
4	1553	1163	1126
5	1335	982	949
6	1170	849	819
7	1042	748	721
8	938	668	644
9	854	604	581
10	783	551	530
11	724	506	487
12	672	469	451
13	628	436	419
14	589	408	392
15	554	383	368
16	524	361	347
17	496	341	328
18	472	324	311
19	449	308	296
20	429	293	282
21	411	280	269
22	393	268	258
23	378	257	247
24	363	247	237
25	350	238	228
26	337	229	220
27	326	221	212
28	315	214	205
29	305	207	198
30	316	209	200

The measurements above are based on booklet-to-booklet performance and do not include cycle-up and cycle-down at the start or end of the job. Using a Bourg Square Edge Module may also effect book-to-book production on small set sizes.

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# Customer Agreement

# 6

As a final step in the install planning you must complete the Customer Agreement form.

## Devices

Check off the modules that will be part of this install:

- BMEx Stitcher/Folder \_\_\_\_\_
- Conveyor \_\_\_\_\_
- BSR (Optional) \_\_\_\_\_
- BCMEx (Optional) \_\_\_\_\_
- BSFEx (Optional) \_\_\_\_\_
- SQEDG (Optional) \_\_\_\_\_
- Bourg Box (Optional) \_\_\_\_\_

I have reviewed the solution expectations and understand the specifications and limitations for each of the modules that will be installed: (***Signature and Date***)

Customer: \_\_\_\_\_

Company Name: \_\_\_\_\_ Date: \_\_\_\_\_

For installations made in the US and Canada, a copy of the signed Customer Agreement must be attached to the XOA/Customer purchase order and faxed to SPA: 1-800-407-8430.

## Primary Customer Applications

Record the primary customer applications:

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## Special Considerations/Limitations

Record any special considerations and/or limitations identified by Xerox and agreed to by the customer:

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# Appendix A Floor Loading Certification

## Floor loading certification and authorization for delivery

Dear Customer, It is critical that the installation site and delivery route within the customer building are capable of supporting the weight of the Xerox iGen press and any additional feeders, stackers and Xerox or third party inline finishers that will be attached to the press. Refer to the *Solutions Planning Guide* supplied by your local Xerox Sales Analyst for the weight and size specifications of those inline finishing devices included with the Xerox iGen press. For the floor loading specifications of the individual iGen press modules, refer to Table B-1, Module Floor Loading, in Appendix B of the Installation Planning Guide. Xerox strongly suggests a structural engineer conduct an on-site inspection to certify that the floor load bearing range will safely support the Xerox iGen press, its modules, and any inline finishing devices (both the delivery route and the installation site.) In addition, we require the owner of the building in which the Xerox iGen installation will occur to sign this document in order to signify that the disclaimer of liability set forth below is acceptable to such building owner. **Disclaimer of Liability;** Xerox Corporation and/or parties associated with the delivery and installation of the Xerox iGen press, shall not be liable and do not assume any responsibility for any type of damage to tangible property occurring during the delivery or installation of the Xerox iGen system which is caused by the inability of your floors to support the weight of such equipment.

Customer Company Name <b>(Print)</b> -	
Customer Contact Name <b>(Print)</b> -	
Customer Contact Phone No.	
Building Owner Name <b>(Print)</b> -	
Disclaimer of Liability is acceptable to Owner: <b>Signature of Owner Required</b> -	
Building Owner Address-	
Building Owner Phone Number-	
Name of CBU Analyst <b>(Print)</b>	
Signature of CBU Analyst -	

