Xerox

# PowerSquare™ 224
Finishing Solutions Planning Guide

Supported Printers

Xerox® iGen3™ Digital Press
Xerox® iGen4™ Digital Press
Xerox® iGen4™ Diamond Edition Digital Press
Xerox® iGen™ 150 Digital Press
Xerox® Color 8250 Production Printer
Xerox Nuvera® 100/120/144/157 EA Production System
Xerox Nuvera® 200/288/314 EA Perfecting Production System
Xerox® Color 800/1000 Press
Xerox® DocuColor™ 8080 Digital Press

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Introduction

The purpose of this document is to describe the features and operation of the PowerSquare 224 when used in-line with validated Xerox printers. It also provides information to be used when planning the installation of this solution.

About this Guide

This guide will provide the Analyst and the Customer with common PowerSquare 224 specifications and pre-installation tasks.

Contents

This section lists the contents of this guide:

- Introduction - provides information about the use of this guide.
- Product Overview - provides Performance Specifications and Installation Planning including Space, Electrical, Environmental requirements, Installation Time, and Operating Supplies.
- Xerox Nuvera 100/120/144/157 EA Production Systems and 200/288/314 EA Perfection Production System - provides information about Limitations, System Dependencies, and Configuration Guide.
- Xerox® iGen3 / iGen4 / iGen150 Press - provides information about Limitations, System Dependencies, Configuration, and Productivity.
- Xerox® Color 8250 Production Printer - provides information about Limitations, System Dependencies, Configuration, and Productivity.
- Xerox Color 800/1000 Press - provides information about Limitations, System Dependencies, Configuration, and Productivity.
- Xerox Color DocuColor 8080 Digital Color Press - provides information about Limitations, System Dependencies, Configuration, and Productivity.
- Xerox Dual-Mode Sheet Feeder (BSFEx) - provides information about Limitations, System Dependencies, Configuration, and Productivity.
- Customer Agreement - contains the Customer Agreement form.

Professional Support Services

Xerox offers a rich set of value-added services designed to help you plan, implement, and operate your solution, migrate and build your key applications, and analyze and redesign your workflow. Your local sales representative and analyst can show you how these billable services can make your business more effective.

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Product Overview

The PowerSquare 224

The PowerSquare 224 is a complete booklet making solution for digital printers. It will produce stitched, SquareBack books up to 224 pages thick.

The PowerSquare 224 is available in three configurations: off-line, in-line, and dual mode. It connects to a wide range of digital printers, including both center- and side-registered systems. Optional accessories include a high capacity book stacker and a full-bleed trimmer for color documents.This model includes a larger online sheet size (365x500mm), an increased book thickness (10.4mm) and a higher average monthly production volume (50,000 books). The paper path through the machine has been enhanced to optimize performance with the high quality papers used in color digital print applications.

The machine also features a new dynamic auto-adjustment system that ensures quality performance regardless of book thickness, allowing uninterrupted running when streaming jobs, or when printing variable content documents that have different page-counts. The PowerSquare 224 produces a perfect stitch regardless of whether the book has 2 pages or 224 pages, without operator intervention.

The optional PowerSquare Book Stacker is available as an accessory to the PowerSquare 224. The PowerSquare Book Stacker has a capacity of 930mm, which means that it can run for up to an hour without operator intervention. The stacker accommodates different sized books without adjustment and can be unloaded on-the-run to provide uninterrupted production.

The PowerSquare Book Stacker

The optional Full Bleed Trimmer completes the booklet making process by trimming the top and bottom edge of the book. It provides a professional solution for full-bleed printed work.

The Full Bleed Trimmer

The PowerSquare 224, the PowerSquare Book Stacker, and the Full Bleed trimmer are designed and manufactured by Watkiss Automation (UK). In North America, C. P. Bourg Inc. markets the products to Xerox customers and provides nationwide sales and support.

Install Planning

This Solutions Planning Guide will help you prepare for the installation of the PowerSquare 224.

Device Configurations

The PowerSquare 224 components are:

* PowerSquare
* Connecting Bridge
* Bridge Covers
* PowerSquare Full Bleed Trimmer (option)
* PowerSquare Book Stacker (option)

Space Requirements

The space requirements illustration provides the machine footprint as well as the overall operating and maintenance area. In addition to the diagram, there should be a minimum of 78 inches (1,981mm) clearance from the floor to the nearest overhead obstruction.

With Trimmer

With Trimmer and PBS Book Stacker
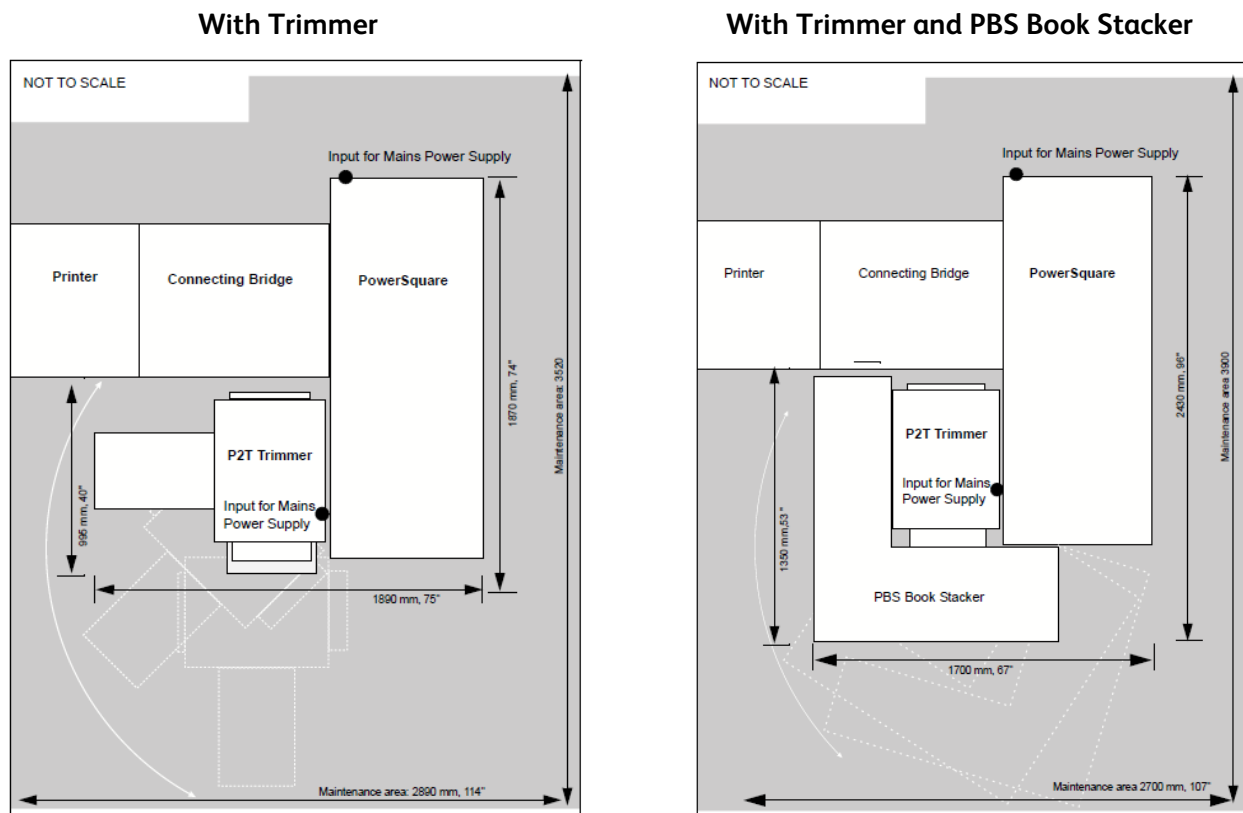
NOTE
The diagrams above are representations only and not drawn to scale.

Space Requirements, continued…

With Stacker	**With PBS Book Stacker**

NOT TO SCALE

Input for Mains Power Supply

Printer

Connecting Bridge

PowerSquare

Stacker

1870 mm, 74"

2870 mm, 113"

1675 mm, 66"

2175mm, 86"

NOT TO SCALE

Input for Mains Power Supply

Printer

Connecting Bridge

PowerSquare

PBS Book Stacker

1350 mm, 54"

2420 mm, 96"

500 mm, 20"

3580 mm, 141"

1250 mm, 50"

1770 mm, 70"

Maintenance area: 2220 mm, 88"
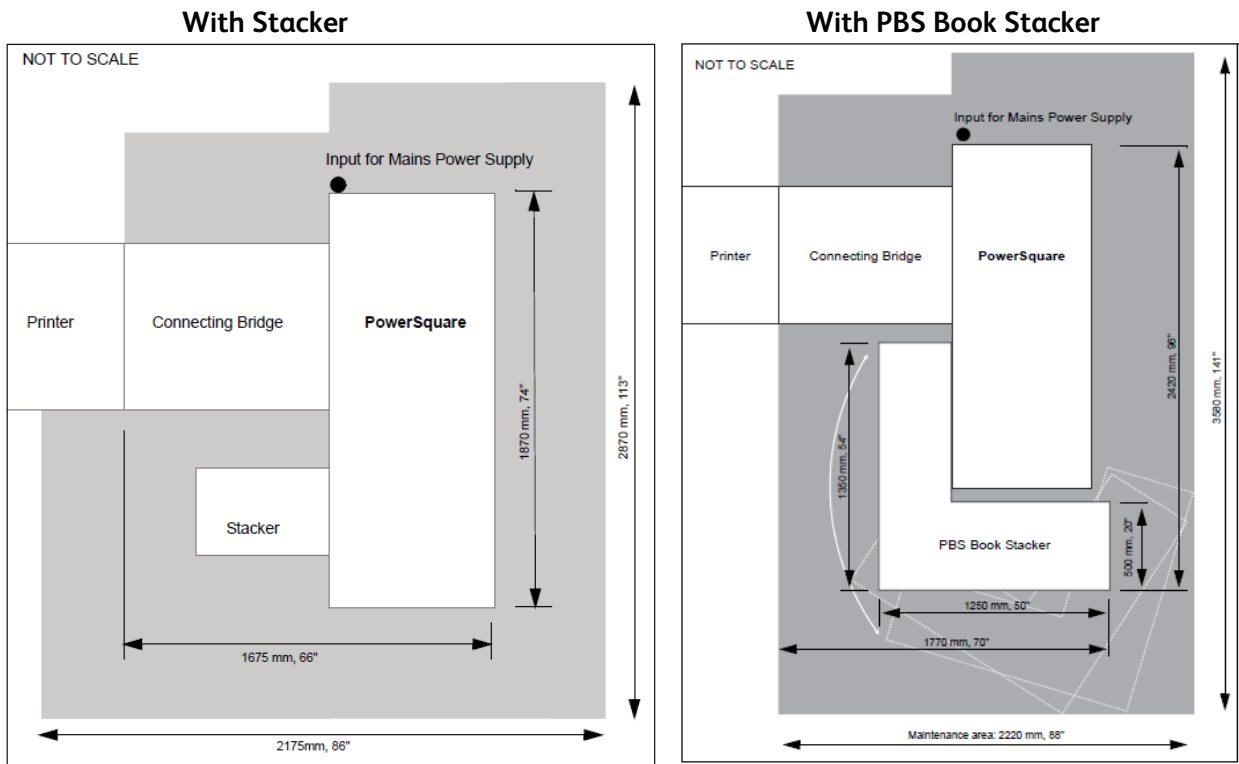
NOTE
The diagrams above are representations only and not drawn to scale.

Machine Dimensions and Weight

Machine	Width	Depth	Height	Weight
PowerSquare 224 with Stacker and Connecting Bridge	66" (1675 mm)	74" (1870 mm)	52" (1330 mm)	1190 lb. (540 kg)*
PowerSquare 224 with PowerSquare Book Stacker and Connecting Bridge	70" (1770 mm)	96" (2420 mm)	52" (1330 mm)	1520 lb. (690 kg)*
PowerSquare 224 with Full Bleed Trimmer and Connecting Bridge	75" (1890 mm)	74" (1870 mm)	52" (1330 mm)	1850 lb. (840 kg)*
PowerSquare 224 with Full Bleed Trimmer, PowerSquare Book Stacker and Connecting Bridge	67" (1700 mm)	96" (2430 mm)	52" (1330 mm)	2180 lb. (990 kg)*

 * includes stitch wire

Shipping Dimensions and Weight

Device	Length	Width	Height	Weight
PowerSquare 224	83" (2090 mm)	37" (940 mm)	59" (1480 mm)	1180 lb. (535 kg)
Connecting Bridge	74" (1880 mm)	30" (750 mm)	24" (590 mm)	210 lb. (95 kg)
Bridge Covers	44" (1120 mm)	36" (900 mm)	54" (1350 mm)	320 lb. (145 kg)
PowerSquare Book Stacker	63" (1590 mm)	43" (1070 mm)	49" (1240 mm)	500 lb. (225 kg)
PowerSquare Full Bleed Trimmer	48" (1200 mm)	40" (1000 mm)	47" (1175 mm)	795 lb. (360 kg)

Electrical Requirements

Device	North America	Europe
PowerSquare 224	200 - 240VAC, 50/60 Hz, 4A Power cord: 8 ft. (2,500 mm)	200 - 240VAC, 50/60 Hz, 4A Power cord: 8 ft. (2,500 mm)
PowerSquare BookStacker	Powered by the PowerSquare 224. A separate power supply is not needed.	
PowerSquare Full Bleed Trimmer	220 – 240VAC, 50/60 Hz, 5A Power cord: 8 ft. (2,500 mm) 190V to 240V Auxiliary transformer kit is required for installations in North America and other low voltage locations (below 225V).	

Nema #6 -15R (North America)
IEC 83 'Shuko' (Europe)
BS1363 (UK)

Environmental Requirements

Device	PowerSquare 224	PowerSquare Book Stacker	PowerSquare Full Bleed Trimmer
Temperature	50 - 95° F (10 - 35°C)		
Humidity	35 – 85 % (Non-condensing)		
Heat Emission	80 btu/hr. (Standby mode) 520 btu/hr. (Operating mode)	15 btu/hr. (Standby mode) 55 btu/hr. (Operating mode)	10 btu/hr. (Standby mode) 210 btu/hr. (Operating mode)
Sound Emission	Standby: 66 dB Running: 87 dB peak	Standby: 60 dB Running: 72 dB peak	Standby: 65 dB Running: 79dB peak
Altitude	0 – 6,500 ft. (0 – 2,000 m) Above Mean Sea Level (AMSL)		

Install and Customer Training

In North America, C.P. Bourg installs the PowerSquare 224 and the estimated installation time is one day. Customer training is also one day.

In Europe, Watkiss Automation installs the PowerSquare 224 and the estimated installation time is one day. Customer training is also one day.

Contact information:

- **North America**: C.P. Bourg Inc. (508) 998-2171
- **Europe**: Watkiss Automation Ltd. +44 (0)1767 685700

Operating Supplies

Each PowerSquare 224 is delivered with:

Quantity	Part Number	Part Name
1	812-038	PSQ Stitch Wire Powerbind 0.6mm 15kg
1	952-017	Rule 24"
1	952-436	Air Duster
1	952-435	Digital Caliper 6" (150mm)
2	951-308	LR44 Battery for digital caliper
1	951-095	Kluber Isoflex NBU15 Grease 50G
8	951-710	Alcohol Cleaning Wipe
1	951-884	Disposable Gloves, 2 pairs

The following PowerSquare 224 consumables are not covered by the service contract:

Consumable	Part Number	Approximate Cost
Stitch Heads	WA812031	Contact C.P. Bourg Inc. for pricing.
Clinchers	WA812034	$1600.00
Trimmer Blades& Anvil Set	WA914132	$2650.00
Stitcher Wire	WA812038	$355.00

The following PowerSquare Full Bleed Trimmer consumables are not covered by the service contract:

Consumable	Part Number	Approximate Cost
Trimmer Blades& Anvil Set	WA914594	TBD

Spare parts and supplies can be ordered as follows.

- **North America**: C.P. Bourg Inc. (508) 998-2171

- **Europe**: Watkiss Automation Ltd., Blaydon Rd., Sandy Bedfordshire, SG19 1RZ UK, +44 (0)1767 685700, Attn: Zoe Mortimer

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Xerox Nuvera® 100/120/144/157 EA Production System and 200/288/314 EA Perfecting Production System

Limitations

- When connected to Nuvera, a Sheet Enhancement Module (SEM) is required.
- On books with more than 40 sheets (160 pages), a self-cover may not produce satisfactory quality and heavier cover stock may be required.
- For the PowerSquare Book Stacker to stack correctly, the spine of the book must be equal to or longer than the book width.
- For FreeFlow Print Server, all finishers downstream of the stacker must be set up at the finisher; the downstream finishers cannot be set up using the print driver.

System Dependencies and Prerequisites

Listed below are the dependencies and prerequisites for installing the PowerSquare 224.

- A Xerox Production Stacker, DS-3500 Stacker, or a BFM-Direct Connect (BFM-DC) is required for inline connectivity to the printer

- If the PowerSquare is inline after a Basic Finisher Module - Direct Connect (BFM-DC), SPAR 9.0.33 is required. This software kit will be shipped with each PowerSquare. Nuvera 9.0.31 machine software is required to enable this SPAR. If 9.0.31 software is not in the machine, order an RV9.0 kit from MAPS. Field upgrades without a Xerox Tape Binder (XTB) or 19.33 Sheet Feed Module (SFM) will require installing additional memory before the upgrade. Nuvera EA requires one 606K16520 kit and one 606K16510 kit. Nuvera 288 requires two 606K16510 kits.

- If the PowerSquare 224 is installed with a PowerSquare Book Stacker or a PowerSquare Full Bleed Trimmer, the following kit is required:
    - 072-335 PBS/P2T Interface Kit for PSQ

- If the PowerSquare 224 is installed with *both* a PowerSquare Book Stacker and a PowerSquare Full Bleed Trimmer, the following kits are recommended:
    - 072-325 Trimmings Conveyor Kit (carries the trimmings from the Full Bleed Trimmer to a waste box in the Book Stacker to enable continuous operation).
    - If the trimmings conveyor kit is not ordered, part 940-180 is required.
    - 072-345 GUI Pivot Arm Kit (moves the user interface to a more convenient location)

- If the PowerSquare Full Bleed Trimmer is installed in North America or other low voltage locations, the following part must be ordered:
    - 072-306 Auxiliary Transformer Kit, 190V to 240V

NOTE
In case the floor at the customer site is very uneven, it is recommended that the Nuvera printer is installed and leveled with a Caster Leveling Kit (Kit number 498K13720).

Configuration Guide

The Configuration Guide contains diagrams of the various Finishing Solutions currently supported.

In-Line

SFM	SFM*	Printer/ Duplex Printer	SEM	Inserter*	BFM Plus*	DS3500 or BFMDC	XTB*	PowerSquare 224

SFM	SFM*	Printer/ Duplex Printer	SEM	Inserter*	XPS	XTB*	PowerSquare 224

SFM	SFM*	Printer/ Duplex Printer	SEM	Inserter*	DS3500 or XPS	BSFEx*	PowerSquare 224

*Optional

Off-Line

BSFEx	PowerSquare 224

Please reference the Xerox Nuvera 100/120/144/157 Duplex Customer Expectations Document (CED) for Basic Finishing Module (BFM) and (BFM Plus) specifications. Xerox Sales Representatives can access the CED at http://xww.thefic.xerox.com/dsweb/View/Collection-92487.

Performance Specifications

Listed below are the Performance Specifications for the PowerSquare 224.

PowerSquare 224	Specifications
Paper Size/Weight	Min Input : 7.9" x 7.9" (200 x 200mm) Max Input : 14.4" x 19.6" (365 x 500mm) Min Rotation: 8.2" x 7.9" (207x200mm) Max Rotation: 12.5" x 8.9" (320x227mm) 16 lbs. (60 gsm) – 32 lbs. index (250gsm)
Output Tray Capacity	35 books (20 sheets of 80gsm bond paper with 2 stitches)
Book Thickness	Min Set: 1 sheet (80 gsm) Max Set: 56 sheets 80gsm 0.2" (5mm) Max Book: 224 pages 80gsm 0.4" (10mm)
Input Height	34" (860mm)

PowerSquare Book Stacker	Specifications
Stacker Capacity	930mm

PowerSquare Full Bleed Trimmer	Specifications
Trimming	Minimum trim width: 4.7" (120mm) Maximum trim width: 14.9" (378mm) Maximum side trim: 1.5" (40mm) each side Minimum side trim: 0.04" (1mm) each side

Productivity Guide

The productivity information shown below applies to PowerSquare 224 release 4.1.

The serial number cut-in for PowerSquare 224 is as follows:

North, Central, and South America		Europe	
Watkiss	WA/PSQ/0800	Watkiss	WA/PSQ/0800
Xerox	TBD	Xerox	2804651015

Nuvera 157 EA Production System

Number of Sheets	Books per Hour (Letter/A4)	Books per Hour (Ledger/A3)	Books per Hour (12"x18"/SRA3)
2	720	692	580
5	720	450	300
10	375	237	148
15	230	155	101
20	230	115	75
30	127	78	50
40	115	60	38
50	76	48	30

Nuvera 288 EA Perfecting Production System*

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	25	35	50
Books/Hour	878	878	720	514	321	216	160
11" x 17" (A3) 2 Staples	2	5	10	15	25	35	50
Books/Hour	720	720	390	273	166	116	83
12" x 18" 2 Staples	2	5	10	15	25	35	50
Books/Hour	720	480	272	184	111	80	56

*Productivity rates for the Nuvera 144 will be approximately 50 % of the rates shown for the Nuvera 288.

The table below shows the productivity for coated stocks.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	25	30	40	50
Time(seconds)/10 Books	46	72	132	192	251	311	373	502	620
Impressions/Minute	52	83	90	93	95	96	96	95	96
Books/Hour	782	500	272	187	143	115	96	71	58
11" x 17" (A3) 2 Staples	2	5	10	15	20	25	30	40	50
Time(seconds)/10 Books	48	120	240	360	480	600	720	970	1210
Impressions/Minute	50	50	50	50	50	50	50	49	49
Books/Hour	750	300	150	100	75	60	50	37	29

The table below shows the productivity when running in *Auto Book Thickness* mode for variable sets, using the profile 'Auto Mode ≤3.4mm'. For books above 34 sheets, productivity will be as the same as the table on the top of this page.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	30
Books/Hour	720	720	610	473	360	257
11" x 17" (A3) 2 Staples	2	5	10	15	20	30
Books/Hour	643	643	360	257	200	136
12" x 18" (SRA3) 2 Staples	2	5	10	15	20	30
Books/Hour	588	588	261	182	140	95

**Nuvera 288 with System Productivity in Auto Mode
using ≥3.5mm profile (for books of 1 to 50 sheets)**

NOTE
For books above 3.4mm thick, productivity will be shown earlier in this section.

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	460	450	414
5	460	450	409
10	444	360	261
15	440	257	182
20	346	198	140
30	250	136	95

**Nuvera 288 with System Productivity in Auto Mode
using ≤3.4mm profile (for books of 1 to 34 sheets)**

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	720	643	588
5	720	643	588
10	610	360	261
15	473	257	182
20	360	200	140
30	257	136	95

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Xerox® iGen3 / iGen4 / iGen150 Press

Limitations

- On books with more than 40 sheets (160 pages), a self-cover may not produce satisfactory quality and heavier cover stock may be required.
- For the PowerSquare Book Stacker to stack correctly, the spine of the book must be equal to or longer than the book width.
- For some substrates and high area coverage, the thickness (before folding) may be reduced to a maximum of 4mm (40 sheets of 80 gsm). On some coated stocks this may be reduced even further.

System Dependencies and Prerequisites

- If the PowerSquare 224 is installed with a PowerSquare Book Stacker or a PowerSquare Full Bleed Trimmer, the following kit is required:
  - 072-335 PBS/P2T Interface Kit for PSQ
- If the PowerSquare 224 is installed with *both* a PowerSquare Book Stacker and a PowerSquare Full Bleed Trimmer, the following kits are recommended:
  - 072-325 Trimmings Conveyor Kit (carries the trimmings from the Full Bleed Trimmer to a waste box in the Book Stacker to enable continuous operation).
  - If the trimmings conveyor kit is not ordered, part 940-180 is required.
  - 072-345 GUI Pivot Arm Kit (moves the user interface to a more convenient location)
- If the PowerSquare Full Bleed Trimmer is installed in North America or other low voltage locations, the following part must be ordered:
  - 072-306 Auxiliary Transformer Kit, 190V to 240V

Configuration Guide

The Configuration Guide contains diagrams of the various Finishing Solutions currently supported.

System Configuration

In-Line

Feeder	Feeder	Printer	Output Module	BSFEx*	PowerSquare 224

*Optional

Off-Line

BSFEx	PowerSquare 224

NOTE
The configuration diagrams are representations only and not drawn to scale.

Performance Specifications

Listed below are the Performance Specifications for the PowerSquare 224.

PowerSquare 224	Specifications
Paper Size/Weight	Min Input : 7.9" x 7.9" (200 x 200mm) Max Input : 14.4" x 19.6" (365 x 500mm) Min Rotation: 8.2" x 7.9" (207x200mm) Max Rotation: 12.5" x 8.9" (320x227mm) 18 lbs. (70 gsm) – 32 lbs. index (250gsm)
Output Tray Capacity	35 books (20 sheets of 80gsm bond paper with 2 stitches)
Book Thickness	Min Set: 1 sheet (80gsm) Max Set: 56 sheets 80gsm 0.2" (5mm) Max Book: 224 pages 80gsm 0.4" (10mm)
Input Height	34" (860mm)

PowerSquare Book Stacker	Specifications
Stacker Capacity	930mm

PowerSquare Full Bleed Trimmer	Specifications
Trimming	Minimum trim width: 4.7" (120mm) Maximum trim width: 14.9" (378mm) Maximum side trim: 1.5" (40mm) each side Minimum side trim: 0.04" (1mm) each side

Productivity

The productivity information shown below applies to PowerSquare 224 release 4.1.

The serial number cut-in for PowerSquare 224 is as follows:

North, Central, and South America		Europe	
Watkiss	WA/PSQ/0800	**Watkiss**	WA/PSQ/0800
Xerox	TBD	**Xerox**	2804651015

iGen4

The table below shows the productivity for coated stocks on iGen4.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	30	40	50
Time(seconds)/# Books	95/20	112/20	146/13	164/10	216/10	152/5	195/5	276/5
Impressions/Minute	50	107	107	110	110	110	110	110
Books/Hour	758	643	320	220	166	118	92	65
11" x 17" (A3) 2 Staples	2	5	10	15	20	30	40	50
Time(seconds)/# Books	94/20	200/20	203/10	300/10	204/5	300/5	400/5	500/5
Impressions/Minute	51	60	60	60	60	60	60	60
Books/Hour	764	360	177	120	88	60	45	36
12" x 18" (SRA3) 2 Staples	2	5	10	15	20	30	40	50
Time(seconds)/# Books	115/20	235/20	235/10	360/10	240/5	360/5	480/5	600/5
Impressions/Minute	42	50	50	50	50	50	50	50
Books/Hour	626	306	153	100	75	50	37	30

The table below shows the productivity when running in *Auto Book Thickness* mode for variable sets on iGen4 using the profile 'Auto Mode ≤3.4mm'. For books above 34 sheets, productivity will be as the same as the first table.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	30
Books/Hour	734	562	310	220	167	110
11" x 17" (A3) 2 Staples	2	5	10	15	20	30
Books/Hour	679	340	180	120	92	60
12" x 18" (SRA3) 2 Staples	2	5	10	15	20	30
Books/Hour	600	306	153	100	75	50

iGen 4 with System Productivity in Auto Mode
using ≥3.5mm profile (for books of 1 to 50 sheets)

NOTE
For books above 3.4mm thick, productivity will be equal to non-Auto Mode.

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	440	450	428
5	450	333	272
10	300	178	151
15	214	120	100
20	87	92	75
30	61	60	50

iGen4 with System Productivity in Auto Mode
using ≤3.4mm profile (for books of 1 to 34 sheets)

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	734	679	600
5	562	340	306
10	310	180	153
15	220	120	100
20	167	92	75
30	110	60	50

iGen150

The table below shows the productivity for coated stocks on iGen150.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	30	40	50
Time(seconds)/# Books	96/20	100/20	96/10	136/10	174/10	128/5	178/5	225/5
Impressions/Minute	50	120	125	132	134	134	134	134
Books/Hour	750	720	375	265	207	140	101	80
11" x 17" (A3) 2 Staples	2	5	10	15	20	30	40	50
Time(seconds)/# Books	98/20	158/20	160/10	240/10	164/5	240/5	320/5	400/5
Impressions/Minute	49	75	75	75	75	75	75	75
Books/Hour	734	456	225	150	110	75	56	45
12" x 18" (SRA3) 2 Staples	2	5	10	15	20	30	40	50
Time(seconds)/# Books	147/20	210/20	192/10	288/10	194/5	288/5	380/5	480/5
Impressions/Minute	32	57	62.5	62.5	62.5	62.5	62.5	62.5
Books/Hour	490	342	187	125	93	62	48	38

The table below shows the productivity when running in *Auto Book Thickness* mode for variable sets on iGen150, using the profile 'Auto Mode ≤3.4mm'. For books above 34 sheets, productivity will be as the same as the first table.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	30
Books/Hour	734	643	409	268	203	140
11" x 17" (A3) 2 Staples	2	5	10	15	20	30
Books/Hour	679	375	214	148	114	73
12" x 18" (SRA3) 2 Staples	2	5	10	15	20	30
Books/Hour	676	339	189	126	90	64

**iGen150 with System Productivity in Auto Mode
using ≥3.5mm profile (for books of 1 to 50 sheets)**

NOTE
For books above 3.4mm thick, productivity will be equal to non-Auto Mode.

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	440	440	343
5	504	375	304
10	350	214	185
15	256	148	125
20	196	110	90
30	132	72	64

**iGen150 with System Productivity in Auto Mode
using ≤3.4mm profile (for books of 1 to 34 sheets)**

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	734	679	676
5	643	375	339
10	409	214	189
15	268	148	126
20	203	114	90
30	140	73	64

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Xerox® Color 8250 Production Printer

Limitations

- On books with more than 40 sheets (160 pages), a self-cover may not produce satisfactory quality and heavier cover stock may be required.
- For the PowerSquare Book Stacker to stack correctly, the spine of the book must be equal to or longer than the book width.
- For some substrates and high area coverage, the thickness (before folding) may be reduced to a maximum of 4mm (40 sheets of 80 gsm). On some coated stocks this may be reduced even further.

System Dependencies and Prerequisites

- If the PowerSquare 224 is installed with a PowerSquare Book Stacker or a PowerSquare Full Bleed Trimmer, the following kit is required:
  - 072-335 PBS/P2T Interface Kit for PSQ
- If the PowerSquare 224 is installed with *both* a PowerSquare Book Stacker and a PowerSquare Full Bleed Trimmer, the following kits are recommended:
  - 072-325 Trimmings Conveyor Kit (carries the trimmings from the Full Bleed Trimmer to a waste box in the Book Stacker to enable continuous operation).
  - If the trimmings conveyor kit is not ordered, part 940-180 is required.
  - 072-345 GUI Pivot Arm Kit (moves the user interface to a more convenient location)
- If the PowerSquare Full Bleed Trimmer is installed in North America or other low voltage locations, the following part must be ordered:
  - 072-306 Auxiliary Transformer Kit, 190V to 240V

Configuration Guide

The Configuration Guide contains diagrams of the various Finishing Solutions currently supported.

System Configuration

In-Line

Feeder	Feeder	Printer	Output Module	BSFEx*	PowerSquare 224

*Optional

Off-Line

BSFEx	PowerSquare 224

NOTE

The configuration diagrams are representations only and not drawn to scale.

Performance Specifications

Listed below are the Performance Specifications for the PowerSquare 224.

PowerSquare 224	Specifications
Paper Size/Weight	Min Input : 7.9" x 7.9" (200 x 200mm) Max Input : 14.4" x 19.6" (365 x 500mm) Min Rotation: 8.2" x 7.9" (207x200mm) Max Rotation: 12.5" x 8.9" (320x227mm) 18 lbs. (70 gsm) – 32 lbs. index (250gsm)
Output Tray Capacity	35 books (20 sheets of 80gsm bond paper with 2 stitches)
Book Thickness	Min Set: 1 sheet (80gsm) Max Set: 56 sheets 80gsm 0.2" (5mm) Max Book: 224 pages 80gsm 0.4" (10mm)
Input Height	34" (860mm)

PowerSquare Book Stacker	Specifications
Stacker Capacity	930mm

PowerSquare Full Bleed Trimmer	Specifications
Trimming	Minimum trim width: 4.7" (120mm) Maximum trim width: 14.9" (378mm) Maximum side trim: 1.5" (40mm) each side Minimum side trim: 0.04" (1mm) each side

Productivity

The productivity information shown below applies to PowerSquare 224 release 4.1.

The serial number cut-in for PowerSquare 224 is as follows:

North, Central, and South America		Europe	
Watkiss	WA/PSQ/0800	**Watkiss**	WA/PSQ/0800
Xerox	TBD	**Xerox**	2804651015

The table below shows the productivity for coated stocks on the Xerox Color 8250 Production Printer.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	30	40	50
Time(seconds)/# Books	96/20	100/20	96/10	136/10	174/10	128/5	178/5	225/5
Impressions/Minute	50	120	125	132	134	134	134	134
Books/Hour	750	720	375	265	207	140	101	80
11" x 17" (A3) 2 Staples	2	5	10	15	20	30	40	50
Time(seconds)/# Books	98/20	158/20	160/10	240/10	164/5	240/5	320/5	400/5
Impressions/Minute	49	75	75	75	75	75	75	75
Books/Hour	734	456	225	150	110	75	56	45
12" x 18" (SRA3) 2 Staples	2	5	10	15	20	30	40	50
Time(seconds)/# Books	147/20	210/20	192/10	288/10	194/5	288/5	380/5	480/5
Impressions/Minute	32	57	62.5	62.5	62.5	62.5	62.5	62.5
Books/Hour	490	342	187	125	93	62	48	38

The table below shows the productivity when running in *Auto Book Thickness* mode for variable sets on the Xerox 8250 Production Printer, using the profile 'Auto Mode ≤3.4mm'. For books above 34 sheets, productivity will be as the same as the first table.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	30
Books/Hour	734	643	409	268	203	140
11" x 17" (A3) 2 Staples	2	5	10	15	20	30
Books/Hour	679	375	214	148	114	73
12" x 18" (SRA3) 2 Staples	2	5	10	15	20	30
Books/Hour	676	339	189	126	90	64

Color 8250 with System Productivity in Auto Mode
using ≥3.5mm profile (for books of 1 to 50 sheets)

NOTE
For books above 3.4mm thick, productivity will be equal to non-Auto Mode.

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	440	440	343
5	504	375	304
10	350	214	185
15	256	148	125
20	196	110	90
30	132	72	64

Color 8250 with System Productivity in Auto Mode
using ≤3.4mm profile (for books of 1 to 34 sheets)

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	734	679	676
5	643	375	339
10	409	214	189
15	268	148	126
20	203	114	90
30	140	73	64

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Xerox® DocuColor™ 8080 Digital Color Press

Limitations

- On books with more than 40 sheets (160 pages), a self-cover may not produce satisfactory quality and heavier cover stock may be required.
- For the PowerSquare Book Stacker to stack correctly, the spine of the book must be equal to or longer than the book width.
- For some substrates and high area coverage, the thickness (before folding) may be reduced to a maximum of 4mm (40 sheets of 80 gsm). On some coated stocks this may be reduced even further.

System Dependencies and Prerequisites

- If the PowerSquare 224 is installed with a PowerSquare Book Stacker or a PowerSquare Full Bleed Trimmer, the following kit is required:
  - 072-335 PBS/P2T Interface Kit for PSQ
- If the PowerSquare 224 is installed with *both* a PowerSquare Book Stacker and a PowerSquare Full Bleed Trimmer, the following kits are recommended:
  - 072-325 Trimmings Conveyor Kit (carries the trimmings from the Full Bleed Trimmer to a waste box in the Book Stacker to enable continuous operation).
  - If the trimmings conveyor kit is not ordered, part 940-180 is required.
  - 072-345 GUI Pivot Arm Kit (moves the user interface to a more convenient location)
- If the PowerSquare Full Bleed Trimmer is installed in North America or other low voltage locations, the following part must be ordered:
  - 072-306 Auxiliary Transformer Kit, 190V to 240V

Configuration Guide

The Configuration Guide contains diagrams of the various Finishing Solutions currently supported.

System Configuration

In-Line

Printer	Interface Module	High Capacity Stacker	PowerSquare 224

Off-Line

BSFEx	PowerSquare 224

NOTE
The configuration diagrams are representations only and not drawn to scale.

Performance Specifications

Listed below are the Performance Specifications for the PowerSquare 224.

PowerSquare 224	Specifications
Paper Size/Weight	Min Input : 7.9" x 7.9" (200 x 200mm) Max Input : 14.4" x 19.6" (365 x 500mm) Min Rotation: 8.2" x 7.9" (207x200mm) Max Rotation: 12.5" x 8.9" (320x227mm) 16 lbs (60 gsm) – 32 lbs index (250gsm)
Output Tray Capacity	35 books (20 sheets of 80gsm bond paper with 2 stitches)
Book Thickness	Min Set: 1 sheet (80 gsm) Max Set: 56 sheets 80gsm 0.2" (5mm) Max Book: 224 pages 80gsm 0.4" (10mm)
Input Height	34" (860mm)

PowerSquare Book Stacker	Specifications
Stacker Capacity	930mm

PowerSquare Full Bleed Trimmer	Specifications
Trimming	Minimum trim width: 4.7" (120mm) Maximum trim width: 14.9" (378mm) Maximum side trim: 1.5" (40mm) each side Minimum side trim: 0.04" (1mm) each side

Productivity

The productivity information shown below applies to PowerSquare 224 release 4.1.

The serial number cut-in for PowerSquare 224 is as follows:

North, Central, and South America		Europe	
Watkiss	WA/PSQ/0800	**Watkiss**	WA/PSQ/0800
Xerox	TBD	**Xerox**	2804651015

Most book sizes will have no impact on the productivity. The following table shows minimum book sizes for full productivity.

NOTE
If operating in *Auto Thickness Mode*, increase the minimum book size by one sheet for each case in the table below.

Sheet Size	Number of Sheets			
	<2 Staples	**<3 Staples**	**<4 Staples**	**<6 Staples**
8.5" x 11" A4 Rotate	3	3	4	5
8.5" x 11" A4 No Rotate	3	4	5	6
11" x 17" A3	2	2	2	3
12" x 18" SRA3	2	2	2	3

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Xerox® Color 800/1000 Press

Limitations

- On books with more than 40 sheets (160 pages), a self-cover may not produce satisfactory quality and heavier cover stock may be required.

- For the PowerSquare Book Stacker to stack correctly, the spine of the book must be equal to or longer than the book width.

- For some substrates and high area coverage, the thickness (before folding) may be reduced to a maximum of 4mm (40 sheets of 80 gsm). On some coated stocks this may be reduced even further.

System Dependencies and Prerequisites

- If the PowerSquare 224 is installed with a PowerSquare Book Stacker or a PowerSquare Full Bleed Trimmer, the following kit is required:
  - 072-335 PBS/P2T Interface Kit for PSQ

- If the PowerSquare 224 is installed with *both* a PowerSquare Book Stacker and a PowerSquare Full Bleed Trimmer, the following kits are recommended:
  - 072-325 Trimmings Conveyor Kit (carries the trimmings from the Full Bleed Trimmer to a waste box in the Book Stacker to enable continuous operation).
  - If the trimmings conveyor kit is not ordered, part 940-180 is required.
  - 072-345 GUI Pivot Arm Kit (moves the user interface to a more convenient location)

- If the PowerSquare Full Bleed Trimmer is installed in North America or other low voltage locations, the following part must be ordered:
  - 072-306 Auxiliary Transformer Kit, 190V to 240V

Configuration Guide

The Configuration Guide contains diagrams of the various Finishing Solutions currently supported.

System Configuration

In-Line

Printer	Interface Module	High Capacity Stacker *	Perfect-Binder *	Standard Finisher Plus	PowerSquare 224

*Optional

Off-Line

BSFEx	PowerSquare 224

NOTE
The configuration diagrams are representations only and not drawn to scale.

Performance Specifications

Listed below are the Performance Specifications for the PowerSquare 224.

PowerSquare 224	Specifications
Paper Size/Weight	Min Input : 7.9" x 7.9" (200 x 200mm) Max Input : 14.4" x 19.6" (365 x 500mm) Min Rotation: 8.2" x 7.9" (207x200mm) Max Rotation: 12.5" x 8.9" (320x227mm) 18 lbs (70 gsm) – 32 lbs index (250gsm)
Output Tray Capacity	35 books (20 sheets of 80gsm bond paper with 2 stitches)
Book Thickness	Min Set: 1 sheet (80gsm) Max Set: 56 sheets 80gsm 0.2" (5mm) Max Book: 224 pages 80gsm 0.4" (10mm)
Input Height	34" (860mm)

PowerSquare Book Stacker	Specifications
Stacker Capacity	930mm

PowerSquare Full Bleed Trimmer	Specifications
Trimming	Minimum trim width: 4.7" (120mm) Maximum trim width: 14.9" (378mm) Maximum side trim: 1.5" (40mm) each side Minimum side trim: 0.04" (1mm) each side

Productivity

The productivity information shown below applies to PowerSquare 224 release 4.1.

The serial number cut-in for PowerSquare 224 is as follows:

North, Central, and South America		Europe	
Watkiss	WA/PSQ/0800	**Watkiss**	WA/PSQ/0800
Xerox	TBD	**Xerox**	2804651015

The table below shows the productivity for coated stocks.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	25	30	40	50
Time(seconds)/10 Books	46	72	132	192	251	311	373	502	620
Impressions/Minute	52	83	90	93	95	96	96	95	96
Books/Hour	782	500	272	187	143	115	96	71	58
11" x 17" (A3) 2 Staples	2	5	10	15	20	25	30	40	50
Time(seconds)/10 Books	48	120	240	360	480	600	720	970	1210
Impressions/Minute	50	50	50	50	50	50	50	49	49
Books/Hour	750	300	150	100	75	60	50	37	29

The table below shows the productivity when running in *Auto Book Thickness* mode for variable sets, using the profile 'Auto Mode ≤3.4mm'. For books above 34 sheets, productivity will be as the same as the first table.

Set Size	Sheets	Sheets	Sheets	Sheets	Sheets	Sheets
8.5" x 11" (A4) 2 Staples	2	5	10	15	20	30
Books/Hour	750	514	281	186	144	102
11" x 17" (A3) 2 Staples	2	5	10	15	20	30
Books/Hour	750	310	138	96	72	48
12" x 18" (SRA3) 2 Staples	2	5	10	15	20	30
Books/Hour	600	300	150	100	72	48

Xerox Color 800/1000 with System Productivity in Auto Mode using ≥3.5mm profile (for books of 1 to 50 sheets)

NOTE

For books above 3.4mm thick, productivity will be equal to non-Auto Mode.

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	418	349	428
5	428	257	250
10	250	138	135
15	180	96	78
20	138	72	72
30	102	48	48

Xerox Color 800/1000 with System Productivity in Auto Mode using ≤3.4mm profile (for books of 1 to 34 sheets)

Number of Sheets	Books/Hour (Letter/A4)	Books/Hour (Ledger/A3)	Books/hour (12"x18"/SRA3)
2	750	750	600
5	514	310	300
10	281	138	150
15	186	96	100
20	144	72	72
30	102	48	48

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Xerox® Dual-Mode Sheet Feeder (BSFEx)

Limitations

- On books with more than 40 sheets (160 pages), a self-cover may not produce satisfactory quality and heavier cover stock may be required.
- For the PowerSquare Book Stacker to stack correctly, the spine of the book must be equal to or longer than the book width.
- For some substrates and high area coverage, the thickness (before folding) may be reduced to a maximum of 4mm (40 sheets of 80 gsm). On some coated stocks this may be reduced even further.

System Dependencies and Prerequisites

- If the PowerSquare 224 is installed with a PowerSquare Book Stacker or a PowerSquare Full Bleed Trimmer, the following kit is required:
  - 072-335 PBS/P2T Interface Kit for PSQ
- If the PowerSquare 224 is installed with *both* a PowerSquare Book Stacker and a PowerSquare Full Bleed Trimmer, the following kits are recommended:
  - 072-325 Trimmings Conveyor Kit (carries the trimmings from the Full Bleed Trimmer to a waste box in the Book Stacker to enable continuous operation).
  - If the trimmings conveyor kit is not ordered, part 940-180 is required.
  - 072-345 GUI Pivot Arm Kit (moves the user interface to a more convenient location)
- If the PowerSquare Full Bleed Trimmer is installed in North America or other low voltage locations, the following part must be ordered:
  - 072-306 Auxiliary Transformer Kit, 190V to 240V

Configuration Guide

The Configuration Guide contains diagrams of the various Finishing Solutions currently supported.

System Configuration

BSFEx	PowerSquare 224

NOTE
The configuration diagrams are representations only and not drawn to scale.

Performance Specifications

Listed below are the Performance Specifications for the PowerSquare 224.

PowerSquare 224	Specifications
Paper Size/Weight	Min Input : 7.9" x 7.9" (200 x 200mm) Max Input : 14.4" x 19.6" (365 x 500mm) Min Rotation: 8.2" x 7.9" (207x200mm) Max Rotation: 12.5" x 8.9" (320x227mm) 18 lbs (70 gsm) – 32 lbs index (250gsm)
Output Tray Capacity	35 books (20 sheets of 80gsm bond paper with 2 stitches)
Book Thickness	Min Set: 1 sheet (80gsm) Max Set: 56 sheets 80gsm 0.2" (5mm) Max Book: 224 pages 80gsm 0.4" (10mm)
Input Height	34" (860mm)

PowerSquare Book Stacker	Specifications
Stacker Capacity	930mm

PowerSquare Full Bleed Trimmer	Specifications
Trimming	Minimum trim width: 4.7" (120mm) Maximum trim width: 14.9" (378mm) Maximum side trim: 1.5" (40mm) each side Minimum side trim: 0.04" (1mm) each side

Productivity

Letter / A4 / 2 Staples

Number of Sheets	Seconds/Number of Books	Books per hour
2	101/20	712
5	101/20	712
10	52/10	692
15	73/10	495
20	106/11	373
30	68/5	264
40	96/5	187
50	118/5	152

Ledger / A3 / 2 Staples

Number of Sheets	Seconds/Number of Books	Books per hour
2	96/20	748
5	50/10	720
10	61/10	590
15	79/9	410
20	57/5	316
30	88/5	217
40	115/5	156
50	142/5	127

12" x 18" /SRA3

Number of Sheets	Seconds/Number of Books	Books per hour
2	101/20	712
5	96/17	637
10	64/10	562
15	92/10	391
20	60/5	300
30	88/5	204
40	120/5	150
50	148/5	122

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Customer Agreement

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

Devices

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

- PowerSquare 224 _____
- Full Bleed Trimmer _____
- Power Book Stacker _____
- Dual-Mode Sheet Feeder (BSFEx) _____

Primary Customer Applications

Record the primary customer applications:

_____

_____

Special Considerations/Limitations

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

_____

_____

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.