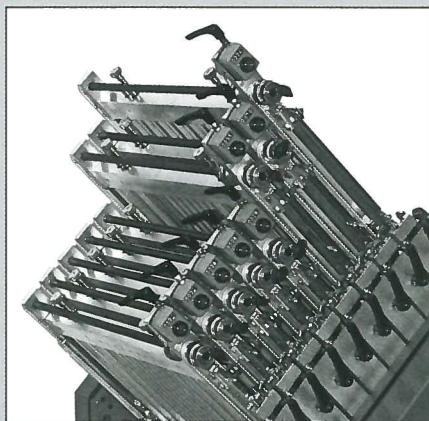


# ■ Profitable Folding

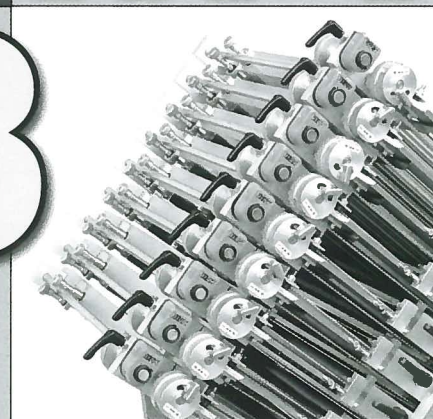


Folding unit

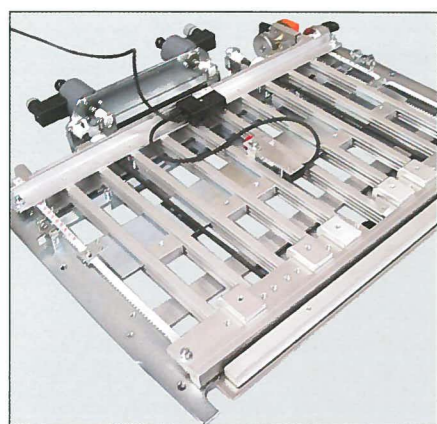
# M 7

# M 8

Folding unit



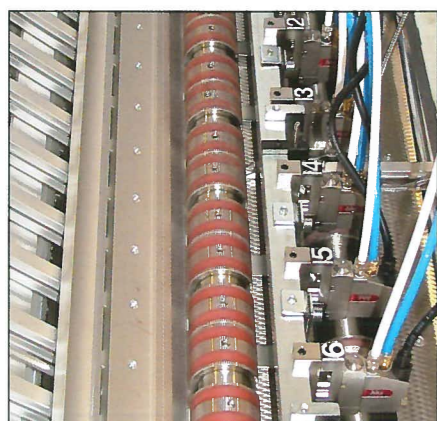
# Folding pockets for any reason



Gate fold pocket (electro magnetic).



Segmented upper pocket mouth for hotmelt gluing in the folding machine.



Segmented folding rollers with cold glue nozzles at the feed.



M8.40 18 – The first 18 pocket folding machine.

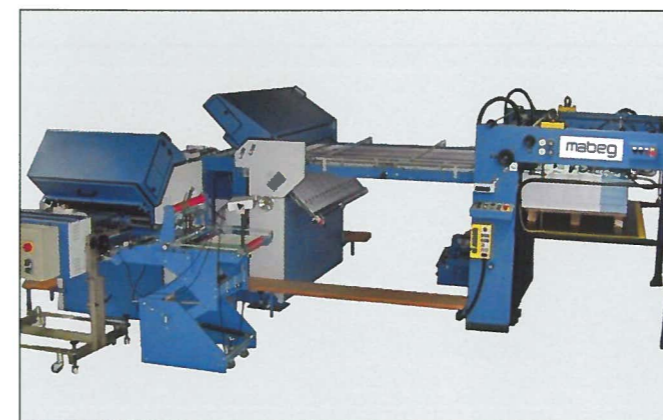


① Cold glue nozzle  
② Hotmelt nozzle

A high number of folding pockets for the pharmaceutical industry is absolutely necessary. The quantity of information on the inserts/outserts calls for large unfolded sheet sizes and regarding the medicine boxes, small final sizes are required. Multiple foldings with the M7 (up to 16 pockets) or the M8.40 (up to 18 pockets) will realize your product. Regarding the relative high product thicknesses, you will also find optimized outsert versions of our folding units.

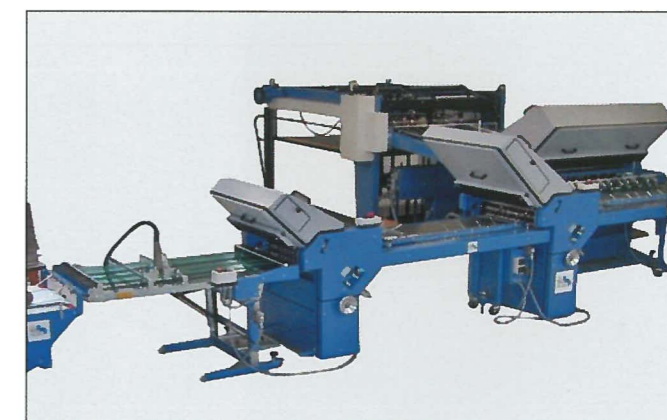


# Applications for the M 7 & Co.



## Map folding machine

Multiple folding in first or second unit allows the folding of maps in any style.



## Poster folding machine

Folding of large formats of posters with optimized folding roller diameters and working widths.

## Booklet applications

The M 7 multiple pocket folder allows the production of glued or stitched booklets with a high number of pages. With or without separate cover, glued or stitched, booklet labels with a closing tab or without – it is realizable. Punching the booklets at the end of the line generates excellent cutting of the edges of your booklets. Also in multiple-ups.



## 2 x 32-page Signature folding

Working widths up to 165 cm for large format folding allow the production of 32-page signatures in 2-up. A high output and economic production is guaranteed.

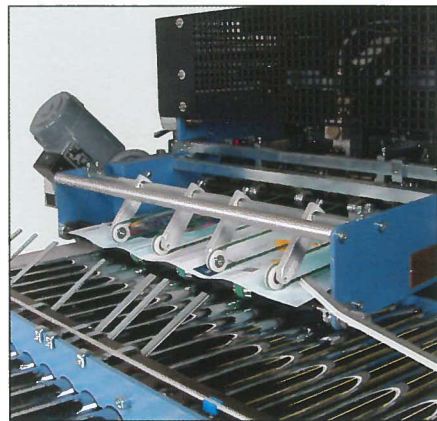


# Additional Equipment



Every configuration with cross-fold application should include a transfer unit.

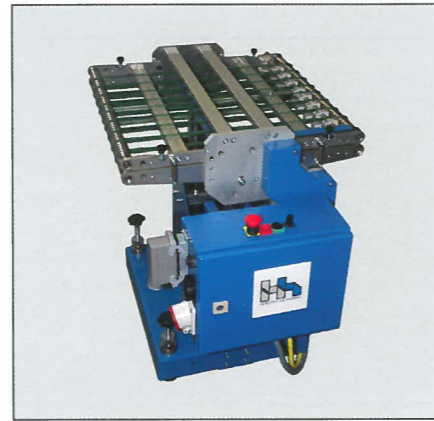
Advantage:  
Higher production security and higher performance.



Hingable transfer unit.



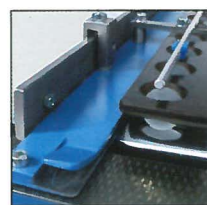
Mobile, height adjustable transfer unit type 850 with movable outrun.



Additional unit: Marking device type 865 for counting and alternating delivery.



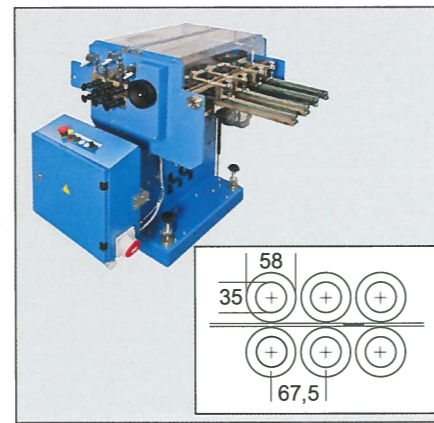
Right-angle side-lay with marbles on the roller table.



Side-lay on roller table.



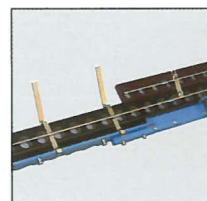
High-Speed-Guides with clip-on side-lay.



Additional unit: Mobile cutting unit for small products with belt-guiding.



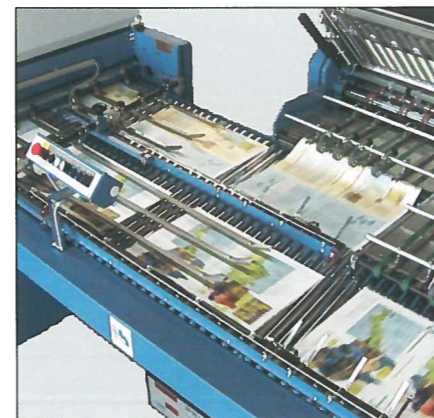
Belt register table with side-lay for the alignment of low paper grammages.



Combined right angle-side-lay for right angle receipt of the product and exact alignment inside following side-lay.

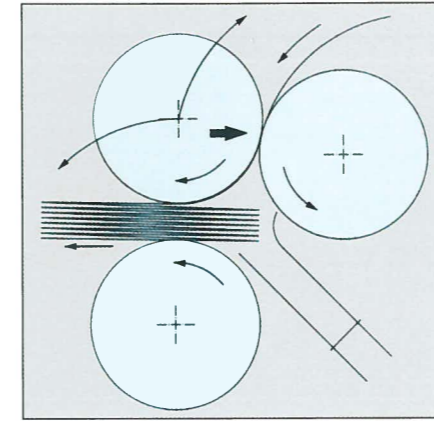


Table rollers with 20 or 32 mm diameter and small distance for smooth paper transport.

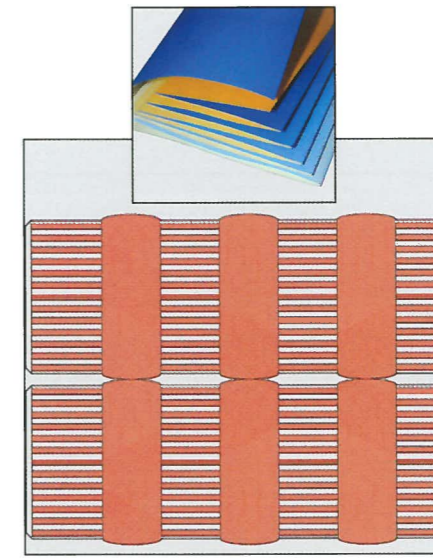


Double stream production.

# Technology, which speaks for itself: High performance, Long-lasting, Innovative



Radial folding roller adjustment.

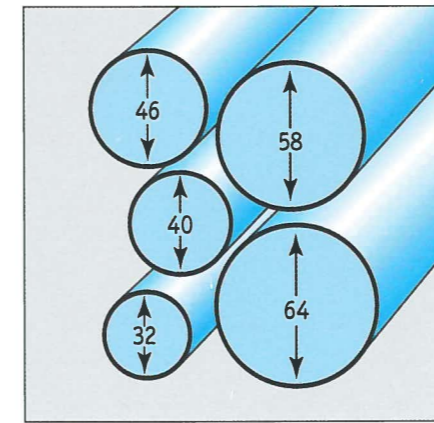


High Grip / Less static roller cover.

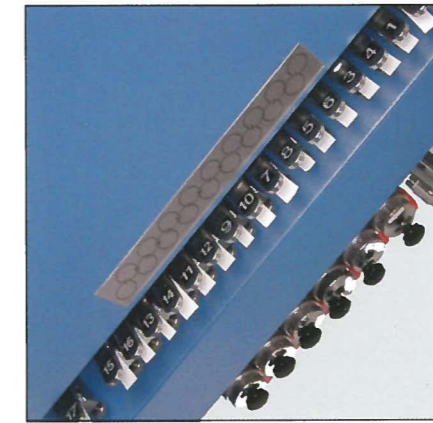
## Radial folding roller adjustment

If the gap between the upper movable roller and the fixed roller underneath, becomes bigger regarding the many paper layers, the upper movable roller moves around the bottom roller in a radial way.

The material is guided during the whole process. Also with a high number of pockets and high speeds, an excellent folding quality will be realized. This is standard equipment of all of our folding machines, independent from the folding roller diameter you chose.



Available folding roller diameters (mm).

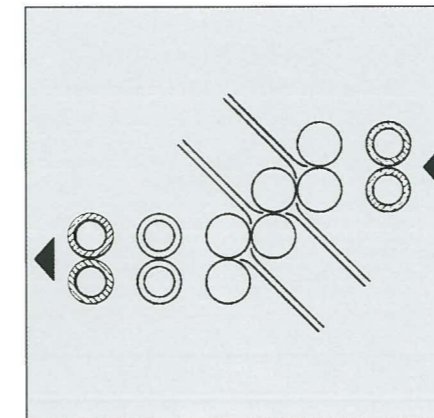


Central roller setup with paper inserting device for short preparation time.

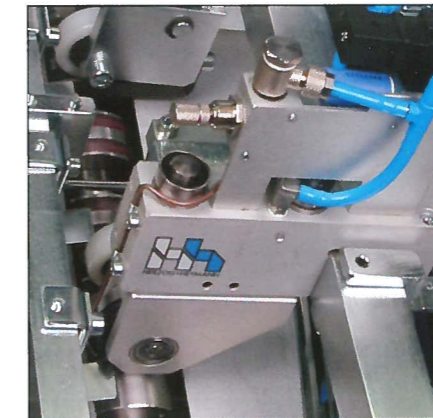
## Roller cover

Along the whole width of the roller, the paper is grabbed by the special Less-Static roller cover inside the notches of the metal and the slightly higher rubber segments. Advantage: less roller pressure for thin papers and protection of the material and the machine.

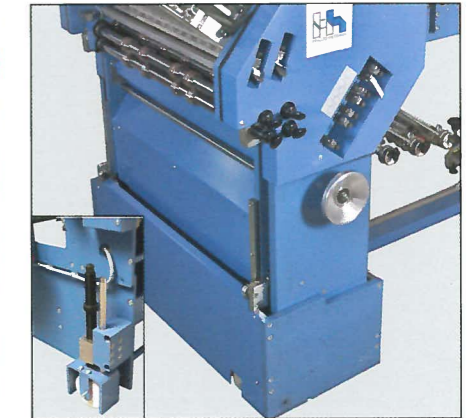
This property allows complicated folding like e.g. the profitable pyramid-roll fold.



Available pre-cutter and second pair of rear cutter shafts.



Timed-cutting, -perforation, -creasing. The pre-cutter shaft is necessary.



Motorized height adjustment of 25 cm. Manually versions also available.

# The flexible model kit offers you a lot of possibilities

## Flexibility in all areas

The individual model kit of the M7 folding units allows you to choose like you prefer.

Regarding your products, you can choose the number of pockets, working widths and the diameters of the folding rollers and produce your product in best quality.

The quantity of folds, the required minimal folding length, different paper grammages are only a few reasons, which require a balanced concept of your folding machine.

All folding units are modular and available with different types of feeding systems.

Also many delivery systems, which are optimized for the kind of product you like to produce, are available.



Flat track delivery type 702 with movable infeed for ergonomic working.



Vertical delivery type 177 for products with small formats.



Line with mobile flat pile feeder.

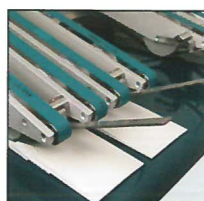
## Mailing equipment of a folding unit

For the mailing production flexible folding units are necessary. Due to constant changing of the configuration of the mailing line, the folding units must be mobile and height adjustable, so anytime they can take place at a new position.

An additional pair of cutter shafts at the infeed allows timed- or permanent cutting, perforating and creasing. A second pair of rear cutter shafts raises the cutting quality of your products.



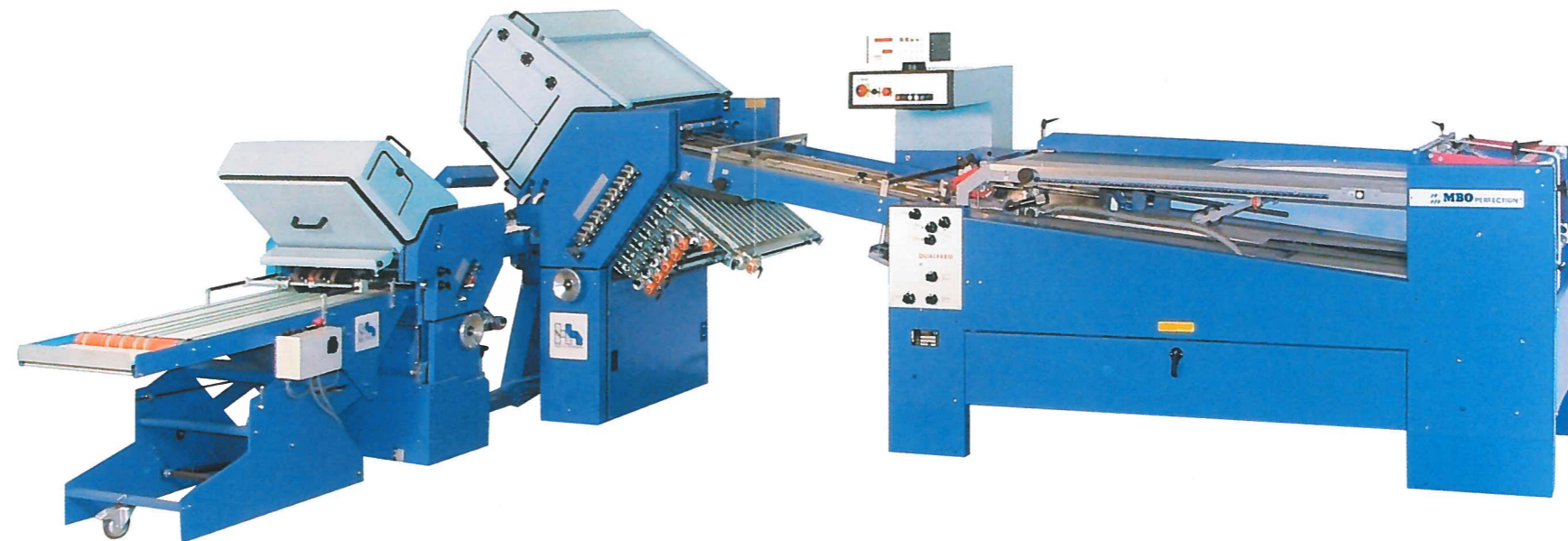
Flat track delivery type 703 with flat belt for products with small formats.



Driven upper belts for fast and safe fixing of the products. Available for all flat track deliveries.



Vertical delivery type 271, for 2-up production and kicker device.



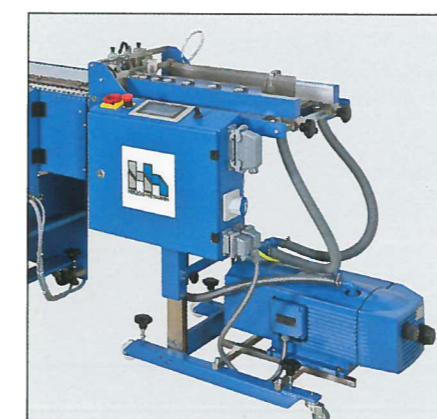
## Feeding systems

Sheet-fed or web-fed or directly from the digital printing machine, large or small size sheets, feeding from the pallet or repacking on a flat- or round pile feeder. A lot is possible.

The paper can be fed efficiently and economically to the folding machine M 7 on many ways, according to the job volume and the formats.

Mobile folding units allow the operation with mobile feeders. The range of production possibilities will be extended by combinations of separate components, so that a single investment can be used multiply.

This makes the model kit due to its modularity and flexibility of the Herzog+Heymann folding machines economic and profitable.



Mobile stream suction feeder.



Fix installed flat pile feeder.

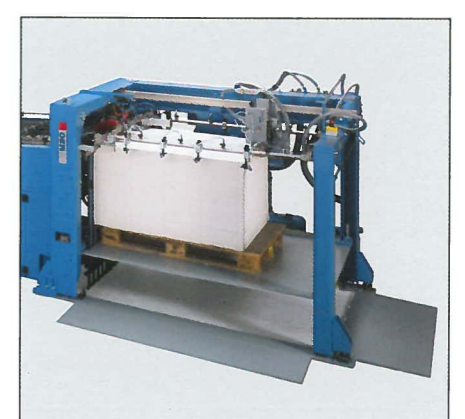


## Sheet control

The product run will be controlled by photo cells, so that incorrect checked products will be ejected. This avoids paper jams and protects the machine and reduces complaints.



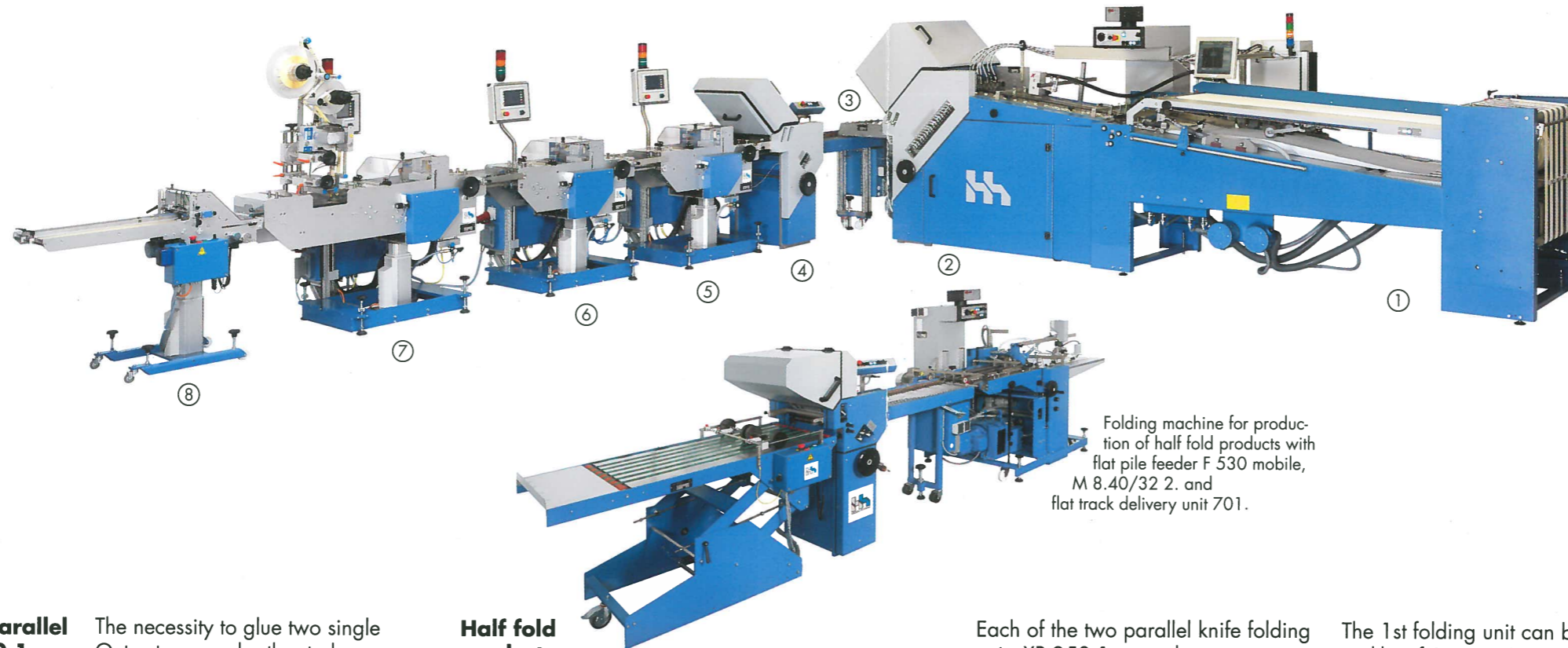
Web processing with MBO Digital.



Pallet feeder fixed to the folding unit or with self-drive.

# Maxi Outserts with up to 304 panels

# World's first folding machine with 18 pockets



The pictured system contains:

- ① Round pile feeder R 76. High prepile volume of approx. 520 cm, feeding table SBT 52 long for installation of the hhs QS-Systems with cameras and waterscoring.
- ② 1st folding unit M 8.40/52 18. with 18 folding pockets.
- ③ Transfer unit 250 with ejection.
- ④ Pocket folding unit M 8.40/32 2.
- ⑤ 1st parallel knife folding unit XP 250.1.
- ⑥ 2nd parallel knife folding unit XP 250.1.
- ⑦ Labeller XL-100 for closing products.
- ⑧ Vertical delivery unit XP-D 250.

## Configuration variants parallel knife folding unit XP 250.1

- XP 250.1: with ejection
- XP 250.1 ECO: without ejection (ejection retrofittable)
- Glue control (retrofittable)

## Inline production of Maxi Outserts

- Herzog + Heymann enable:
- 304 panels
  - inline production
  - closing with labels.

The necessity to glue two single Outserts on each other to have very thick Outserts belongs to the past.

18 folding pockets inside the new first pocket folding unit M 8.40/52/72, a second pocket folding unit M 8.40/32 with two pockets and two parallel knife folding units XP 250.1 in tandem position, and the new Herzog + Heymann labeller XL-100 for closing products permit labelled Outserts with up to 304 panels.

## Half fold products

Half fold products are produced inside packing systems. Before dispensing into the packaging, they will be folded as required by the covering box.

Because the units of the Outsert system are mobile from the second folding unit, this second unit also can be used with an additional mobile feeder for half fold products.

For the blank production, a second pair of rear cutter shafts should be used in the folding unit for smooth blank stripping.

Delivery occurs by a flat track delivery unit 701.

The trend is towards Outserts, because the expensive packing systems run trouble-free and therefore, expensive dead-time can be avoided.

Folding machine for production of half fold products with flat pile feeder F 530 mobile, M 8.40/32 2. and flat track delivery unit 701.

Each of the two parallel knife folding units XP 250.1 in tandem position does one fold. So the 2nd pocket folding unit M 8.40 OUT only needs to be equipped with two folding pockets. This procedure allows very thick folded end-products.

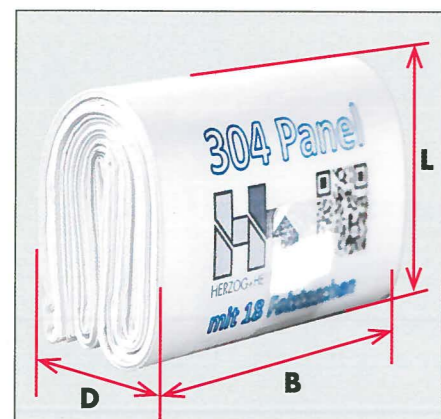
If only one parallel knife folding unit XP 250.1 shall be used, the 2nd pocket folding unit must be equipped with 4 folding pockets.

The 1st folding unit can be used with widths of 35 cm, 45 cm and 52 cm from series KL 112.1. The KL 112.1 is available with up to 16 folding pockets.

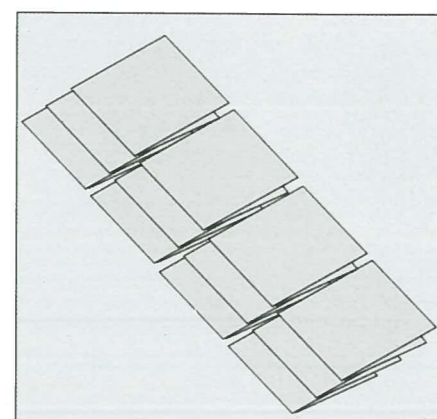
The requirement for more folding pockets achieves the new folding machine M 8.40 with up to 18 folding pockets.

## Feeding table SBT long

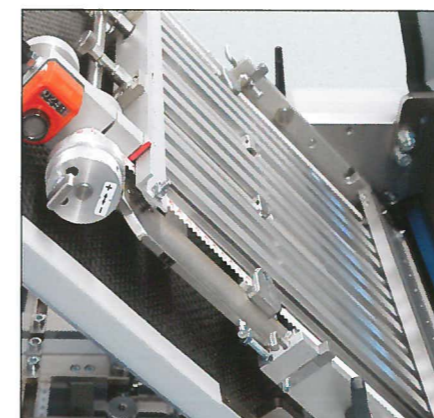
The length of 1.400 mm of the feeding table is necessary, if the hhs camera system Xtend<sup>2</sup> shall be used. The approx. 1000 mm long sheet requires enough time for accurate alignment at the side-lay, before code reading. Inaccurate alignment would cause faulty measurements.



Labelled Maxi Outsert product with 304 panels.



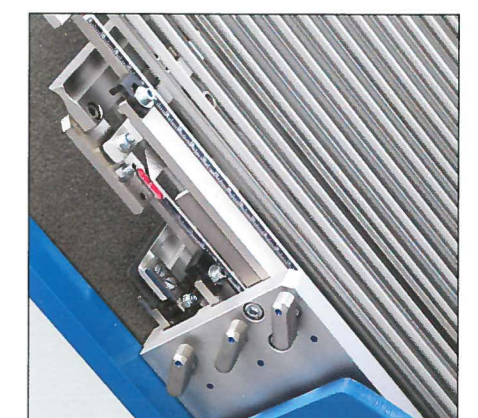
4-up half fold products.



④ 2nd folding unit M 8.40 OUT with two folding pockets. The sheet deflector is turned upwards for folding.



② 1st folding unit KL 112.1 with 16 folding pockets. The folding pockets are located in position.



Folding pockets of KL 112.1 in position for folding and sheet deflecting.

# Technical data M 7 and M 8



Scan the QR-Code and enjoy our movies.

	Max. mm	Min. mm
<b>Stream suction feeder FBS 272</b>		
Mobile	520 x 720	90 x 90
<b>Flat pile feeder F 535</b>		
Stationary	520 x 1000	80 x 105
– register table standard	900	
– register table SBT 52 long	1400	
Mobile (F530)	520 x 1000	80 x 105
<b>Flat pile feeder F 76</b>		
Stationary	720 x 1120	150 x 200
Solo Version	720 x 1040	150 x 250
<b>Round pile feeder R 530</b>		
Stationary	520x1000	150x180
– register table standard	900	
– register table SBT 52 long	1400	
Mobile	520 x 1000	150 x 180
Loading capacity	3250	
<b>Round pile feeder DUALFEED, stationary</b>		
R 700	720 x 1040	150 x 200
R 800	820 x 1200	170 x 180
Loading capacity	5200	
<b>Round pile feeder SAR, mobile</b>		
SAR 72	720 x 1040	150 x 200
SAR 82	820 x 1200	170 x 180
Loading capacity	5200	
<b>Pallet feeder</b>		
FP 720/820	720/820 x 1200	170 x 250
FP 1020	1020 x 1450	300 x 250
<b>MABEG Pallet feeder</b>		
Available width	1320, 1420, 1620	

**All mobile feeders are equipped with self-control, self-drive and an installed alignment table (except FBS). All mobile feeding systems are movable, especially the Solo Versions. These are stationary stand-alone feeding systems.**

## Folding unit M 7

Working width	320 – 1650 mm
Number of pockets	2 – 16
Ø Folding rollers	32, 40, 46, 58, 64 mm
Minimal folding length	
32 mm rollers	32 mm
(with short-fold pockets)	25 mm
40 mm rollers	42 mm
(with short-fold pockets)	35 mm
46 mm rollers	65 mm
(with short-fold pockets)	50 mm
58 mm rollers	75 mm
64 mm rollers	80 mm
Motorized height adjustment	250 mm
Manual height adjustment	200 mm
Speed	40–160 m/min.
Optional	180 m/min.
Power	230/400 V, 50 Hz, 3 Phasen

## Folding unit M 8

Working width	320 – 720 mm
Number of pockets	2 – 18
Ø Folding rollers	40 mm
Minimal folding length	32 mm
Motorized height adjustment	250 mm
Manual height adjustment	200 mm
Speed	40–160 m/min.
Optional	180 m/min.
Power	230/400 V, 50 Hz, 3 Phasen