

Spine Creaser # SC-OS-02 for Osaka Cover Feeder Installation and Instructions



Technical Support:

techsupport@technifoldusa.com

Order replacement matrix online: <http://store.technifoldusa.com> or
call 973-383-7920

www.TechnifoldUSA.com

***** IMPORTANT *****

Handle With Care When Installing!

Yes, these precision tools are heavy duty but it IS possible to ding the edges of the device and ruin the female creasing channel/rib holder. Take your time when doing the installation.

If you have any questions or are not getting the results you expect email techsupport@technifoldusa.com

or take a look at the FAQ and Tech Support page:

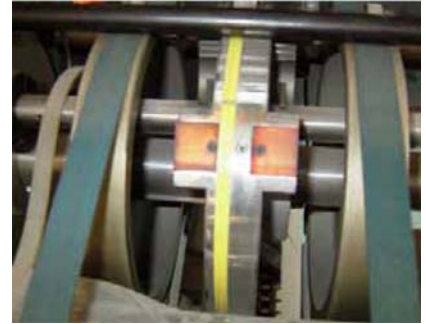
<http://www.technifoldusa.com/faqs-support/>

Our products do not work like conventional tools, so what you may be accustomed to doing may not be right for this product. So please, ask away! We provide unlimited free tech support and will work to overcome any obstacle or problem.

Tech Support: email techsupport@technifoldusa.com and we'll get back to you as soon as possible, usually within a few hours or less, the same business day.

Step One – Clean the Drum

- Turn off power to the machine and disengage the cover feeder so it can be rotated in manual mode, if available.
- Remove inserts from the drum (if any.)
- Wipe away dust and dirt from the drum using a mineral spirit or other cleaning agent that will not leave a residue. Pay special attention to cleaning out the scoring groove thoroughly.



Step 2 – Apply Roll Tape to Drum

- Rotate the drum so the gripper pad area is accessible (shown in photo, upper right.)
- Now take the narrow roll of 8mm 2-sided tape (supplied) and apply a length around the full circumference of the drum, centered over the scoring groove. If your matrix is pre-taped, skip this step and go to Step 3 below.
- Cut the tape and butt the ends together in the area of the gripper pads.
- Press the tape firmly onto the drum.

Step 3 - Apply the Creasing Matrix

- Peel away the backing from the tape. OR if matrix is pre-taped, select the matrix and peel off backing, exposing adhesive.
- Select one of the 3 rubber creasing matrix to suit the stock being run.
 - Orange (light) for 100-135 gsm (100# text – 80# Cover)
 - White (medium) for 135-250 gsm (60 -100# Cover)
 - Yellow (heavy) for 250gsm + (100# cover and up)
- Align one end of the rubber matrix at the midpoint of the gripper pad area. The matrix has two sides; the rounded side is for creasing and the opposite V-shaped side is for alignment in the drum.
- While a second person rotates the drum, gradually stretch the matrix and push down into the scoring groove. As the drum completes a full rotation, both ends of the matrix should meet at your original starting point.
- Rotate the drum and examine matrix visually to be sure it lies flat and is perfectly straight.
- If you're not happy with the installation simply pull the matrix and repeat.



Step 4 – Install the Spine Creaser Female

- Remove the OEM scoring wheel and set aside the bolt. Insert the Spine Creaser female wheel using the same bolt that held the OEM wheel. If needed, use the enclosed washers to ensure a snug fit. The female wheel should have no side-to-side play or wobble.
- Select one of the two female channels and carefully center the channel over the matrix by moving the bracket side to side as needed. You can do this visually, perhaps using a flashlight to illuminate the area. If desired, run a few sheets through and check the score manually to be sure it looks 'centered' as shown in the photo. A proper crease will have a smooth, evenly rounded bead on the inside, with no tearing.



- Once you're satisfied that it's centered, move to the next step.
- Next, attach one of the horseshoe stop blocks snugly next to the bracket opposite the channel you are working with. This is your centered position for that channel. Now repeat the centering process for the other side, finishing up with a stop block mounted adjacent to the bracket.
 - From now on, whenever you switch female channels, all you have to do in order to center it is loosen the bracket holding the female wheel, slide to the stop block, and lock in position.

Creasing Tips with the Spine Creaser

- Use the absolute minimum pressure necessary. A deeper crease is not necessarily a better crease. Excess pressure will also wear the matrix prematurely.
- Take time to experiment with different creases to see what works best for the stocks that you run, especially when you are new to running the Spine Creaser on your Osaka. There is no right or wrong crease setting. Find what works best, then make a note in the Crease Setting Log for the operator to refer to when you return to that job.
- If you switch back and forth between various weights of paper stocks, allow a few minutes extra setup time on the stitcher. Yes it might take a few minutes longer than a conventional set up, but remember, those few extra minutes are saving an entire separate operation or an expensive outsourced job!
- Email techsupport@technifoldusa.com if you have any questions. We'll get back to you as soon as possible, usually the same business day.

Frequently Asked Questions for the Spine Creaser to fit Osako

What if I still get fiber cracking?

Be sure to experiment with different crease settings. For instance, an 80# cover from one mill might require a different setting than an 80# cover from another mill. Also check that the female component is centered correctly.

How long should the creasing matrix last?

The creasing matrix should last 1/2 million to 1.5 million sheets or more, depending on the weight of paper.

How much pressure should I use?

Use the minimum pressure necessary to get a good crease. A deeper crease is not necessarily better for eliminating fiber cracking. It is usually better to go to a different creasing rib rather than apply excessive pressure.

When do I have to re-center the female components?

If the stop blocks are installed correctly, you should only have to move the female wheel against the block to automatically center the female channel. If in doubt, double check to ensure the blocks do indeed stop the female at a centered position.

What range of papers can I crease?

In general, the Spine-Hinge Creaser should work on stocks from about 60# cover up through 16pt. Paper varies substantially so feel free to experiment no matter what type of paper stock you are running.

For Technical Support

email: TechSupport@technifoldusa.com

or visit <http://www.technifoldusa.com/faqs-support/>

To Order Replacement Parts:

Call the Sales Office 973-383-7920 M-F 10-4 eastern

or online <http://store.technifoldusa.com/>

Crease Setting Log

Email Tech Support

Print This Form



Your Name:

Machine:

Technifold USA

Sales Office: 973-383-7920

www.technifoldusa.com

Date	Job Number or Name	Male Rib Used	Female Channel	Type of Stock

Notes