



# Instruction & Installation Guide

## Spine-Hinge Creaser *to fit*

### Wohlenberg Perfect Binders QC-DEL-WO/98-FP-6

For Technical Support:  
email: [techsupport@technifoldusa.com](mailto:techsupport@technifoldusa.com)

To order parts online:  
<http://store.technifoldusa.com>  
or Call 973-383-7920 M-F 10-4 eastern

## **\*\*\* 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.

Be sure the cover feeder shafts are clean and free of burrs, and **never, ever force anything! Everything should be moved with a finger touch**—if not, there is something wrong!

**If you have any questions or are not getting the results you expect email [techsupport@technifoldusa.com](mailto:techsupport@technifoldusa.com)**

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

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

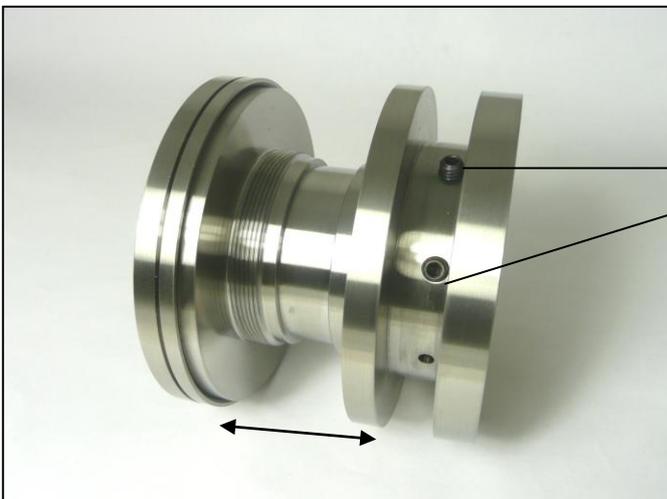
Our products do not work like conventional tools, so what you may be accustomed to doing may not be right for this product. So please, ask away! We provide unlimited free tech support and will work to overcome any obstacle or problem.

**Tech Support:** email [techsupport@technifoldusa.com](mailto:techsupport@technifoldusa.com) and we'll get back to you as soon as possible, usually the same business day.

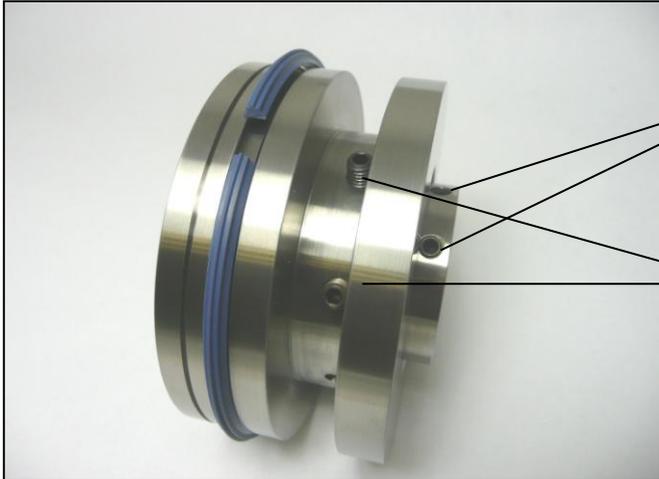
# Installation instructions

## Wohlenberg binder

30mm shaft & 98mm outer diameter  
with a fixed 6mm hinge

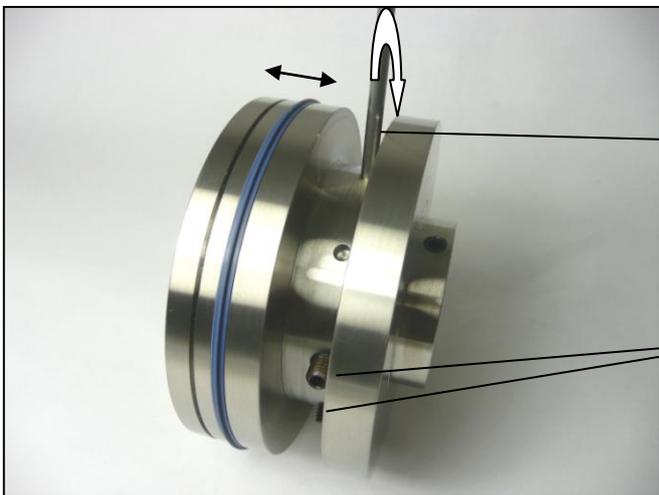


Unscrewing the 2 x  
6mm screws will allow  
the parts to be  
separated



Tighten the 2x6mm screws firmly to the shaft

With the 2 x 6mm inside screws loosened unscrew the 2 crease rib holders until the gap is large enough to remove the crease rib.



Hand screw the holders together.

Place the small bar in any of the small 6mm holes and tighten the holders firmly together.

Tighten the 2 x 6mm screws to hold the clamped devices firmly together.

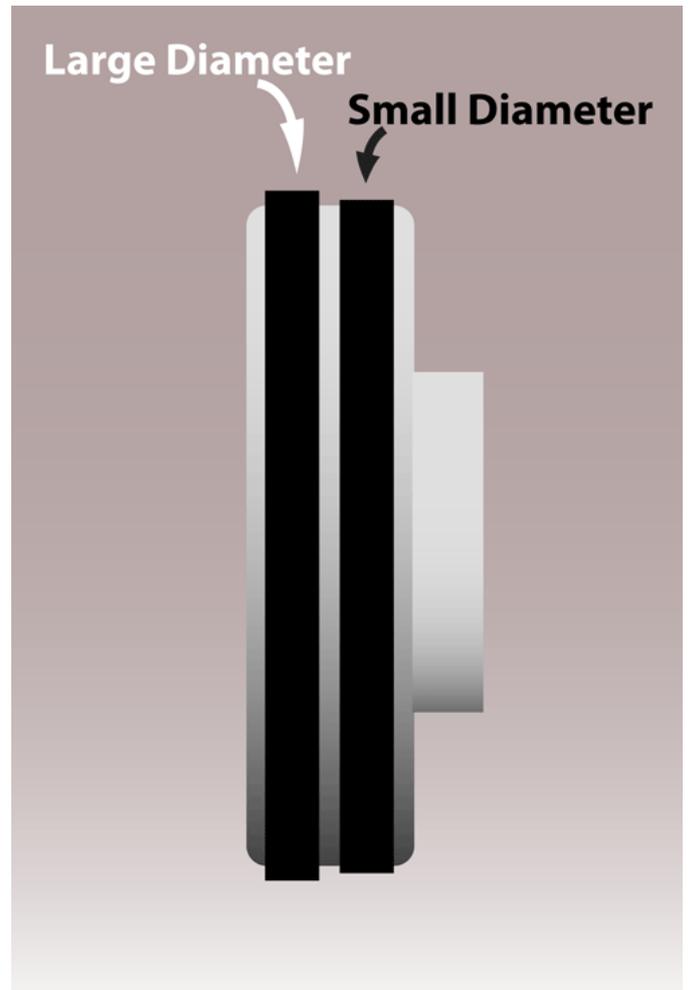


## Crease Ribs

**Orange** light crease  
**Blue** medium crease  
**Yellow** heavy

## Nylon Crease Ribs

**Black** heavy



The 4 TOP Gripper rollers we supply have 2 different outside diameters.

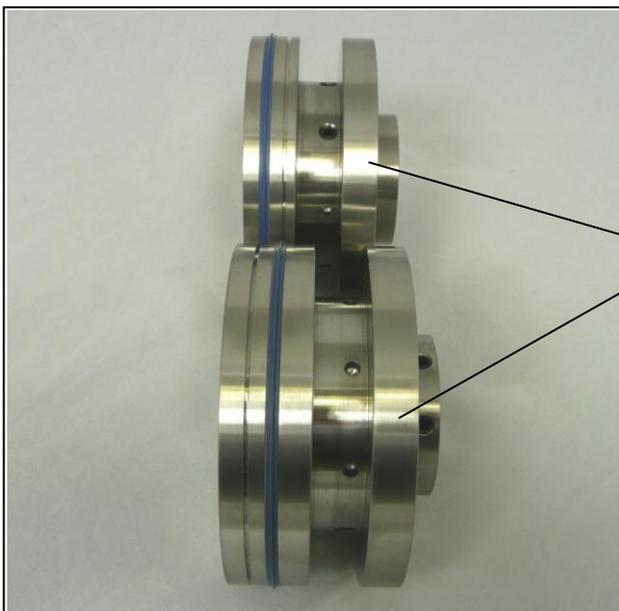
(Same gripper band, different recesses.)

Use these with your OEM, all steel bottom support collars.

Heavy stocks will need the larger OD to maintain a proper grip on the sheet.

Medium to light stocks will use the small diameter.

Simply position the appropriate diameter gripper on top of the lower steel collar.



The metal collars here are for supporting the sheet and should not be used to grip the cover stock.

(Use your OEM lower gripper rollers as described above.)



Photo showing the assembly of the crease units before installation  
Top shafts use the gripper support collars  
To stop damage please remove crease ribs before installation

## Installing the bottom shaft parts

Select the correct colour coded split crease ribs and attach them on to the holder.

Align a bottom crease unit with the edge of the book clamp and tighten the fixing screws. Align the remaining bottom crease unit into the desired position and tighten the fixing screw.

## Installing the top shaft parts

It is important to use the Technifold top gripper support collars and the original plain metal bottom support collars.

Once the crease units are on the shafts insert the split crease ribs into the units.

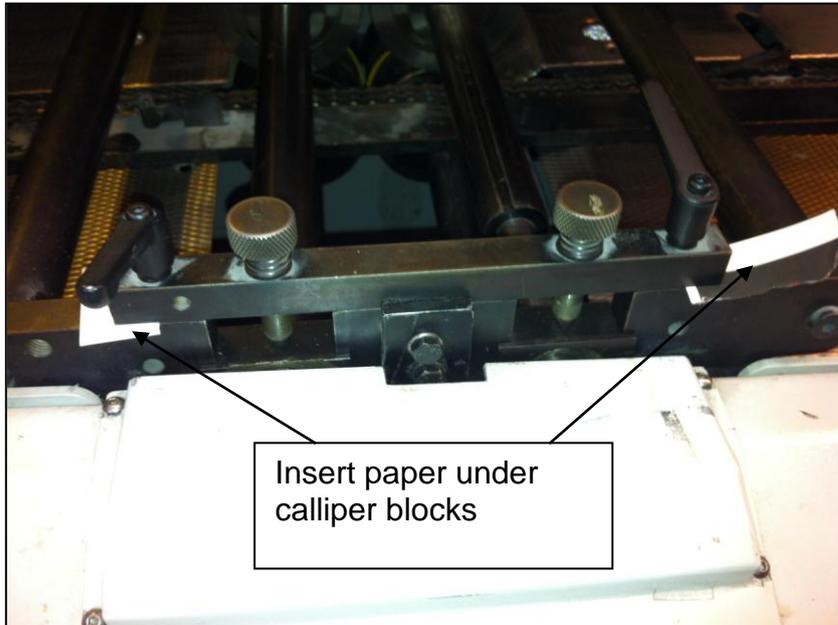
To achieve the correct grip between the support collars, align the top and bottom collars together. Equal gentle pressure should be achieved on each collar.

As the top shaft is being lowered, slide the male rib protrusions into the corresponding female channels.

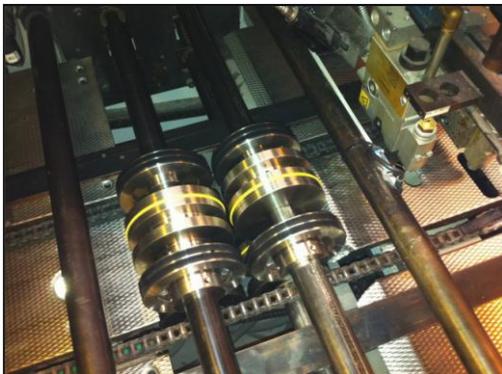
Slowly run a sheet of cover stock between the crease units. As the cover stock rotates through the crease units the loose top crease units automatically

centralise to the optimum crease position. Tighten down the fixings screws when the crease unit fixing screws come into view.

To achieve the optimum crease position the crease ribs must locate into the centre of the female channels.



To finely set the calliper pressure for the first time, it may be advantageous to insert 80gsm paper between the blocks as shown above. When setting for different weights of stock simply insert the correct stock into the 4 calliper blocks and the setting will automatically be set to the correct pressure.





## Tips on Selecting the Right Creasing Rib

Think of your new Spine & Hinge Creaser as a device that gives you the ultimate in control over how your perfect bound book covers will look and perform. There are 4 crease ribs to work with so with a little experimentation early on, you will find crease settings that are perfect for each of the jobs you run. Here are some brief suggestions.

**If fiber cracking is not a problem with the stock you are running**, and it's 250gsm (about .010) or heavier, start with the black nylon creasing ribs. (You'll have to experiment!) The nylon ribs will last longer than the rubber ribs. Always be sure to center the devices as explained in another part of this manual. An off-center tool will wear out the ribs prematurely. For lighter stocks, you'll probably need to use one of the 3 colored creasing ribs.

**If you expect fiber cracking to be a problem**, then start with one of the 3 types of rubber creasing ribs included with your new kit. Always be sure to re-center the devices whenever you re-position any tool. This applies to both rubber and nylon ribs.

Always be sure to crease with the male creasing rib hitting the face (outside) of the piece to produce a crease that will eliminate fiber cracking. There could be exceptions to this 'rule' but in most cases this will give the best result.

### **What Does a Good Crease Look Like?**

The inside bead of the crease should be smoothly rounded as shown in photo at right. If visible tears start to appear, you probably have too much pressure. The outside of the crease should also be smooth and free of cracking or tearing.



### **Experiment with Various Creases**

Use the enclosed Crease Setting Log as an operator reference. Try various creasing ribs and then make a note of the creasing rib that works best for each job or for a particular stock.

If you run a wide range of paper stocks, initially this will take a little work but it's well worth it the long run.

Refer to your Crease Setting Log when you return to that job or that particular stock. This will save you LOTS of setup time!

### **For Technical Support**

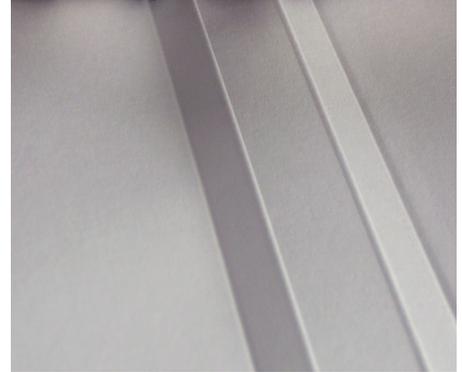
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or visit <http://www.technifoldusa.com/faqs-support/>

# Frequently Asked Questions for the Spine-Hinge Creaser to fit Kolbus

## *Which side of the sheet do I crease?*

Technically, the correct way to score the sheet in order to eliminate fiber cracking is the same as with a die score—the male should be hitting the outside (face) of the cover, so that the fold is going away from the male. So the spines should be scored from one side, the hinges from the other side. (photo right)



However, sometimes customer preference dictates how you crease (score) a particular sheet. **A Tip:** experiment with various crease settings to find out what works best for the jobs that you run. Then use the enclosed Crease Setting Log to keep a record of what setting works best.

## *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 components are centered correctly.

## *How long should the creasing ribs last?*

The rubber creasing ribs should last 1/2 million to 1.5 million sheets or more, depending on the weight of paper. Use the minimum pressure necessary to get a good crease. A deeper crease is not necessarily better for eliminating fiber cracking. It might be better to go to a different creasing rib rather than apply excessive pressure. The nylon creasing rib will last even longer.

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

Whenever you move any component to a new position you need to re-center that male/female pair.

## *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.

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# Quad Creaser

To fit Wohlenberg Perfect Binder with 6mm Fixed Hinge

Stock Code: **QC-DEL-WO/98-FP-6**

Shaft Size: **30mm Exit Shaft**

Outer Diameter: **98mm**

## SETTINGS



## Contents of Package

### 4x Male/ Female Components:

contains both the split creasing rib and the fixed 6mm female channel hinge

### 4x Orange Gripper Crease (M-169):

split creasing ribs will crease 100- 150gsm

### 4x Blue Gripper Crease (M-167):

split creasing ribs will crease 150- 280gsm

### 4x Yellow Gripper Crease (M-170):

split creasing ribs will crease 280- 350gsm

### 4x Black Nylon Crease Ribs

**QC-DEL-WO-98/PC**

split creasing ribs will crease 250-350gsm

### Optional Nylon Ribs

#### Orange Dot Black Nylon Crease Ribs

**QC-DEL-WO-98/PC-O**

split creasing ribs will crease 100- 170gsm

### Black Blanking Spacers

allows quick adjustment when setting up books with 2 x spine creases only (no hinge)

**QC-WO-SP**

## Wohlenberg

4 crease shafts

### Champion

City E

Golf

Phoenix



Each black gripper gives a separate pressure setting

### 4x Top Support Collars:

With 2 x grip pressure settings helps support the sheet during creasing

### 8 x M-88 Gripper bands

located in support collars

### 1 x 3mm T handle hexagon key

1 x removal tool / tension bar

