Instructions, Operating Tips and FAQ's for Spine-Hinge Creasers

SHC-ADJ-04-FP 35mm MBO & Stahl
SHC-ADJ-MF-30-FP 30mm MBO
SHC-ADJ-03-FP 36mm Speedcreaser

For Technical Support:
email: info@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 slitter 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 info@technifoldusa.com. Also be sure to review the FAQ's in this booklet.

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 info@technifoldusa.com and we'll get back to you as soon as possible, usually the same business day.

Instructions and Tips
Adjustable Spine-Hinge Creaser for Folders

The Spine Hinge Creaser is designed to produce up to 4 simultaneous creases as found on perfect bound book covers or other specialty applications.

The set consists of:

Color Coded Creasing Ribs

Orange # M-29 for light to medium stocks 100-200gsm (approx. 90# text through 80# Cover)

Blue #M-17 for medium stocks 200-270gsm (approx 80# - 100# Cover, or 7-10 pt)

Yellow #M-16 for heavy stocks 250-350gsm (approx 100# cover or 9 pt and up)

Color Coded Female Channels

Orange Dot (use with orange ribs, this is the narrowest channel) 100-170gsm

Orange + Blue Dot (use with either orange OR blue rib) 150-200gsm

Blue + Yellow Dot (use with either blue OR yellow rib) 200-275gsm

Yellow Dot (use with yellow rib) 250-350gsm

Spacers

Spacers are 2 widths.
Black = 2mm thick.
Red = 1mm thick.
Use these to set spine to hinge width.

** Important ** Always use the same arrangement of spacers on each component. For

instance if you have 3 black and 2 red spacers between the rib and the female channel as shown in the photo at right, then be sure all 4 components are set up in identical fashion.

Also important—the complete set of 5 red and 3 black spacers should all be on each component at all times. This ensures that the retaining collar applies sufficient pressure when tightened.

The only thing that changes is where the spacers are located on the component.

Setup Procedure

1. Select your creasing ribs according to guidelines above. Initially you will probably need to experiment to find the best setting for the stocks you run. It's a good idea to keep a log of the settings used (rib + female channel combination). When you return to that job or that paper, you know which rib + female channel combination to use.

2. Select spacers needed to set spine-to-hinge width. Excess spacers should always be left ON each component so that the ribs and female channel can be properly locked into position.

3. Assemble rib holder, spacers, female channel and secure by tightening the threaded collar (the one with the dimples.) Tighten securely by hand.

4. Slide the retaining collar on (the one with the set screw) next to the threaded collar and align the set screw with access hole.

5. Slide 2 components on the upper shaft and 2 on the lower shaft and position either the top 2 collars, or the bottom 2 collars, whichever is easier. Now lock these 2 into position with the set screws.

[Once you get each component on the folding machine you can, if you feel it necessary, snug the retaining collar up a little using a spanner wrench. If you've got a strong grip during assembly you can probably skip this step. Should you decide to snug them up, do this before you line all the components up.]

6. Pop open the gap on the slitter shaft and carefully move the other 2 collars into position. If you're careless and the shaft isn't opened wide enough, you can nick the creasing ribs.

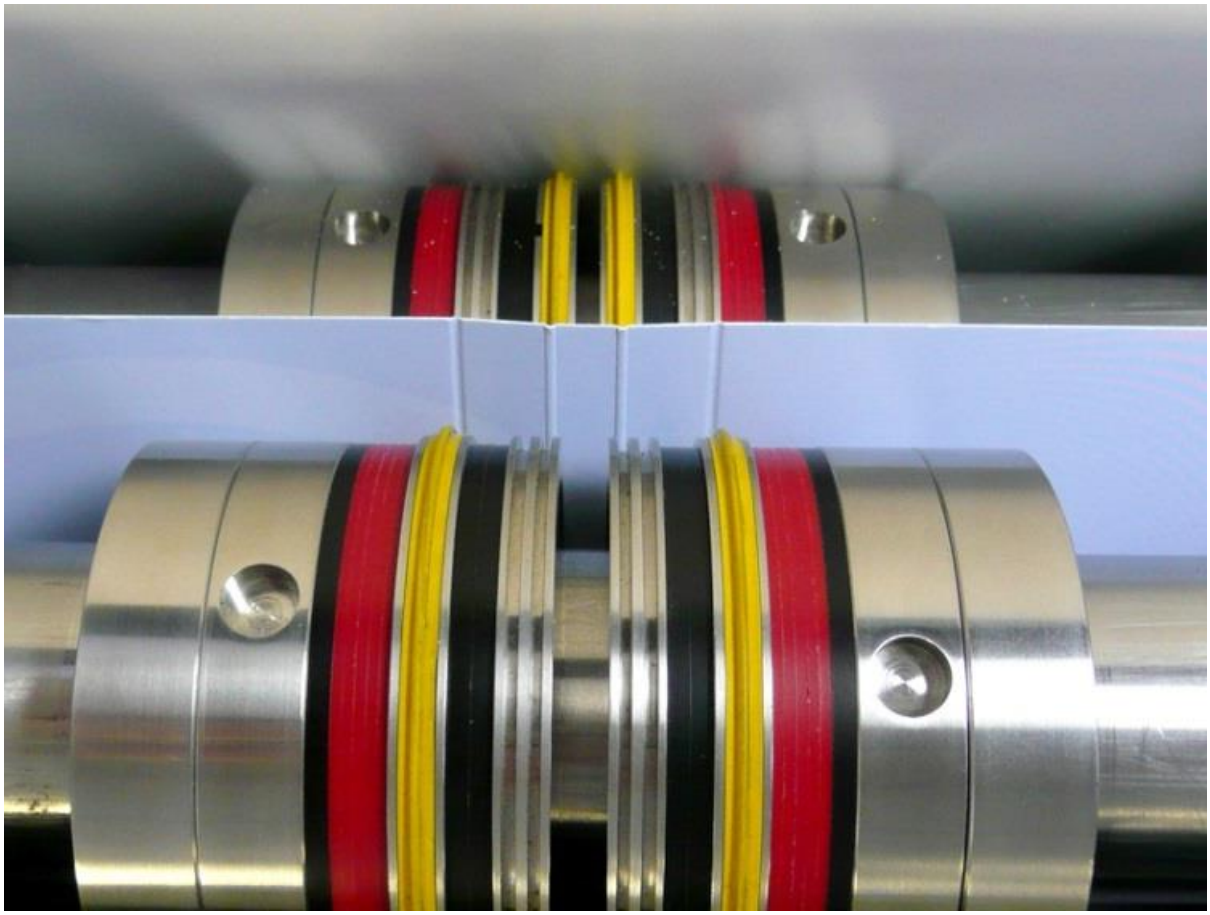
Be sure bottom 2 collars are lined up correctly (still loose on the shaft) with the creasing rib in the correct channel.

7. Now hand crank a sheet through so that the creasing units rotate at least one or two revolutions. This will center the female channels on the 2 units that are loose on the shaft.

8. While the sheet of paper is still gripped by the device, lock the set screws on the 2 loose units.

9. Run one sheet through the folder and check the creases. There should be no cracking, and the inside of the crease (the “bead”) should be slightly rounded and even along the length of the crease. Re-center the tools if you don’t have a nice even bead as shown. You may also have to adjust pressure to get a good crease.

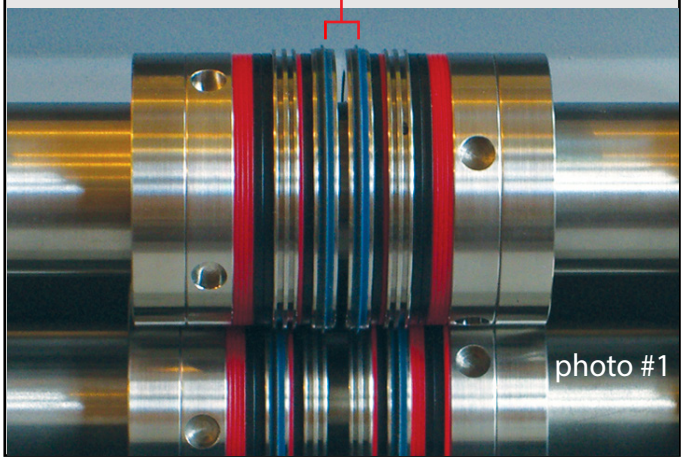
The photo below shows 4 units fully assembled and positioned using the yellow ribs.



Spine-Hinge Creaser for Folding Machines

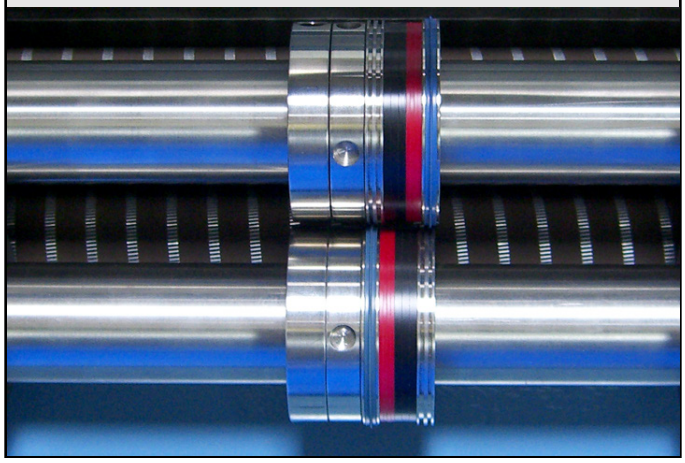
Minimum & Maximum Dimensions for Various Configurations

Minimum Spine Width - all 4 creasing ribs: 5mm (3/16")
Maximum Spine Width: infinitely variable, no max.



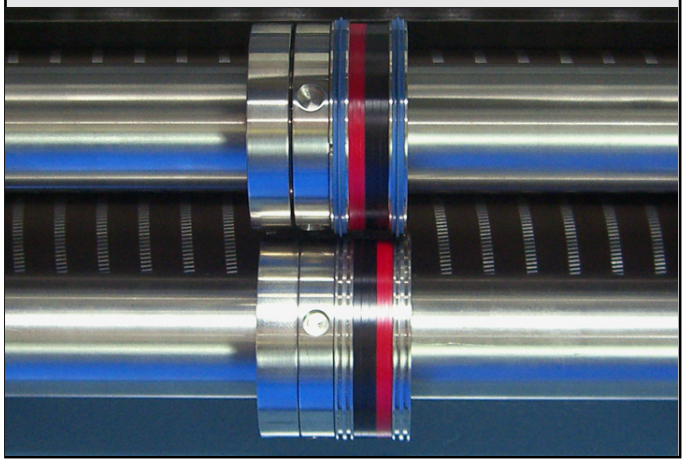
Two creases on top, two on bottom, photo 1
All four creases on the same side, photo 2

Maximum creasing width within each unit
with ribs on opposite sides: 17mm (about 11/16")

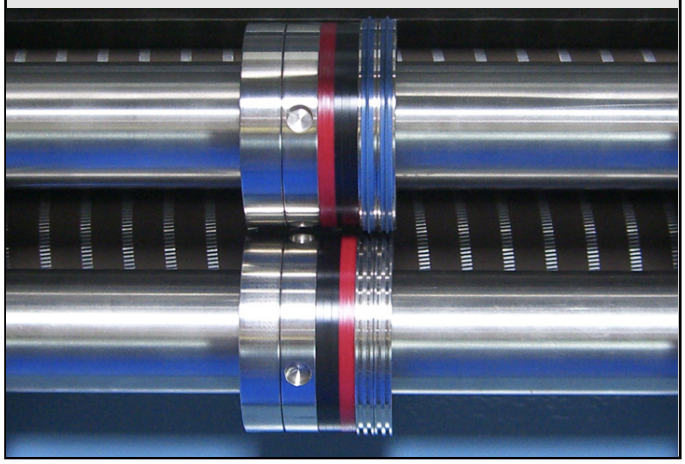


Minimum creasing width within each unit
with ribs on opposite sides: 4mm (5/32")

Maximum creasing width within each unit
with ribs on the same side: 15mm (19/32")



Minimum creasing width within each unit
with ribs on the same side: 5mm (about 3/16")



Frequently Asked Questions

for the Spine-Hinge Creaser to fit 30, 35, and 35mm Shafts

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 creasing ribs and different female channels. 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 creasing ribs should last 1/2 million to 1 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.

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. **Don't forget this important step!**

What range of papers can I crease?

In general, the Spine-Hinge Creaser should work on stocks from about 50- 60# cover up through 14-16pt. Paper varies substantially so feel free to experiment no matter what type of paper stock you are running.

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. Adjust the slitter shaft gap (pressure) as needed to get this result. Avoid tearing or wrinkling.

Crease Setting Log

Email Tech Support | Print This Form

Technifold USA
Sales Office: 973-383-7920
www.technifoldusa.com

Your Name: _____

Machine: _____

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

Notes