



Web Spine-Hinge Creaser Instructions

Product Code TRI-WEB-05



www.TechnifoldUSA.com

Online store: <http://store.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. Until they are safely installed on the holders, leave them in the foam lined boxes in a safe work area.

Take your time when doing the installation.

Be sure the holder shafts are clean and free of burrs, and **never, ever force anything!** Everything should install with hand pressure only.

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 the same business day.

Spine-Hinge Creaser for Web Presses

Your web press Spine-Hinge Creaser can be used two ways:

1. To produce 2 or 4 simultaneous creases for perfect bound book covers or other similar jobs requiring multiple creases or scores
2. To run individual creases

Running 4 creases

When running 4 creases, hinge width is fixed at 6mm (.25") and spine width is infinitely variable.

The 4 units of the web spine-hinge creaser are identical. When installed, the opposing unit must be flipped so its channels run in the opposite direction (see photos following on the following pages.)

There are 4 spine-hinge crease settings which are fixed in 1/4" pairs as shown in the photos on the following pages. Although each setting is designed for an approximate range of paper densities, it's best to think of these as recommended starting points.

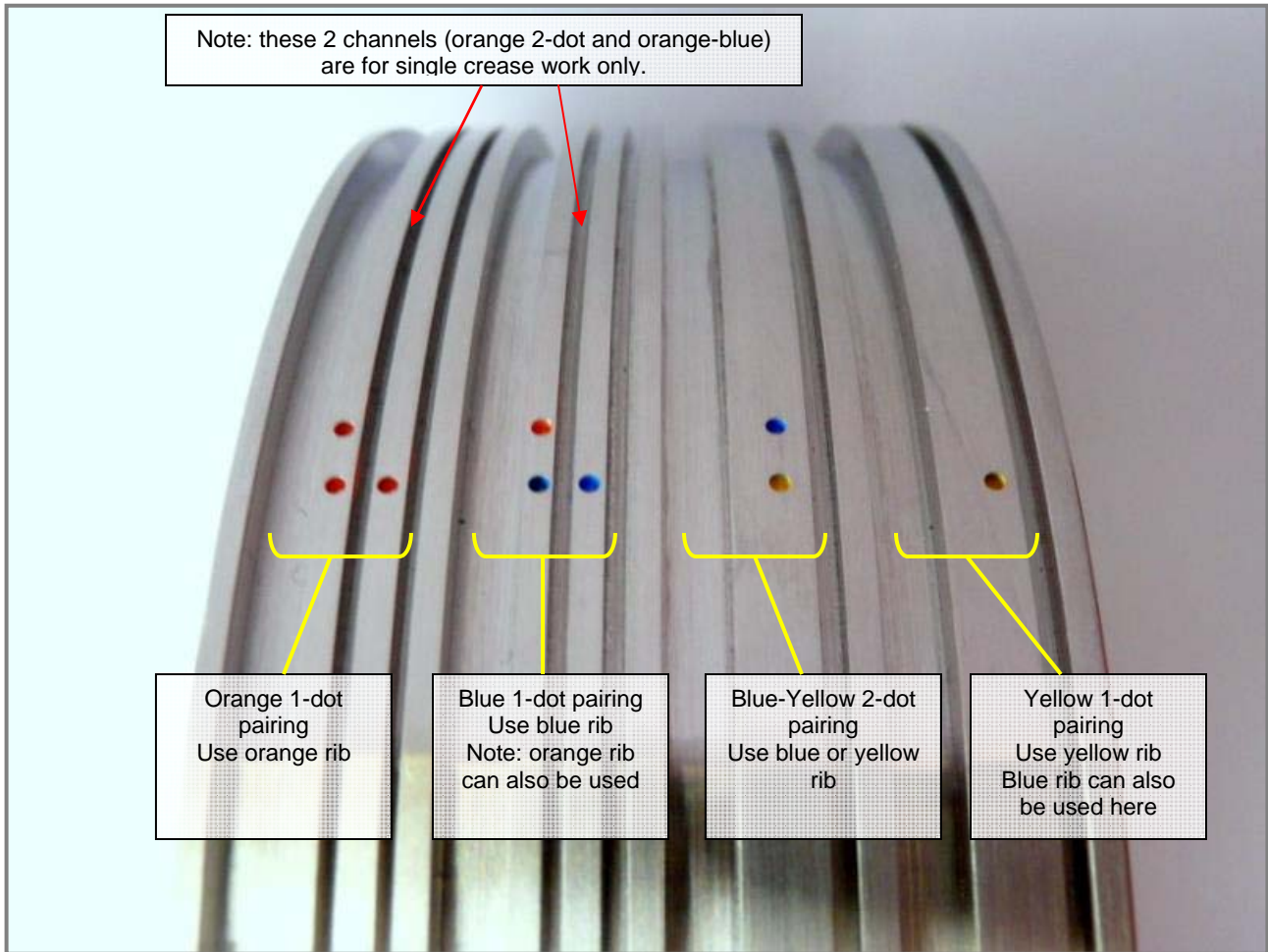
It's important to experiment to see what works best with the stocks you run. Once you find a setting that you like, make a note of it for future reference. We've included a crease setting log for your convenience.

Running single creases

There are 6 female channels available for single creasing. The dots adjacent to the female channels indicate which ribs can be used in that channel. For instance, a blue and a yellow dot mean you can run either a blue rib or a yellow rib in that channel. Note: as mentioned before these are recommended starting points based on our experience of what works best with various weights of stock. You are by no means limited to that recommendation. You can for instance, run an orange rib in any blue channel, or a blue rib in the widest yellow channel.

The male rib can be positioned in any of the four available rib slots, whichever is most convenient.





Example: to use the Orange 1-dot setting, install an orange rib in the channel indicated on all 4 units (left side of the pairing in the photo). Since each set of creasing units are facing each other in the opposite direction, you get 2 creases, 6mm apart X 2 = 4 creases in total. You get 2 creases on each side of the sheet.

For Single Crease Work

Simply install the creasing rib you desire in any of the 4 rib slots, whichever is most convenient. Then center the opposite unit over the appropriate channel.

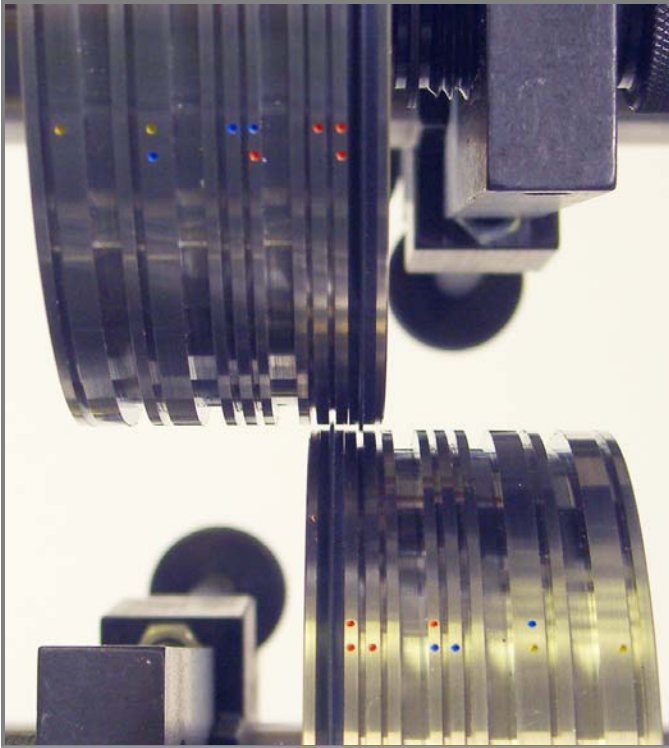
There are a total of 6 female channels available. Each has a slightly different width.

The Orange 2-dot and the orange-blue dot channels are extra channels provided for single-crease work and do not get used in 4-crease work.

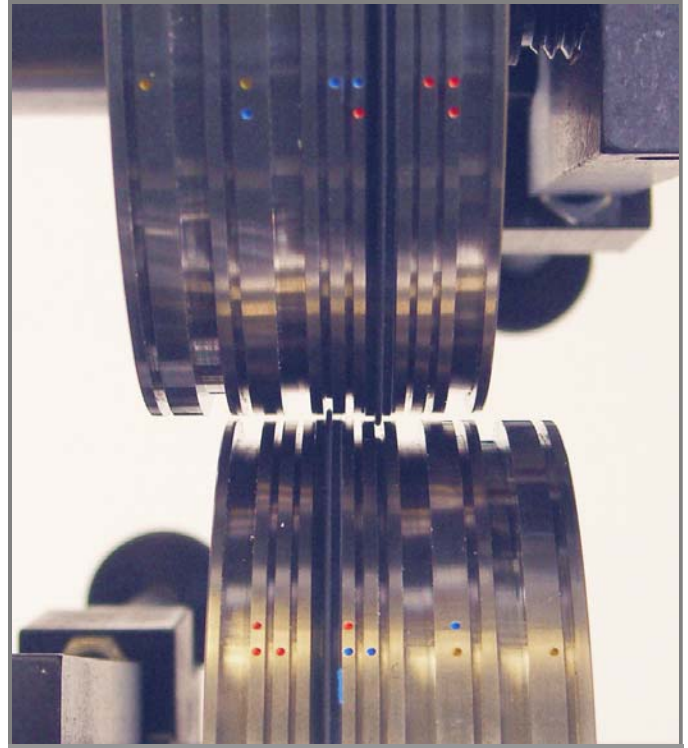
Crease Setting Ranges (approximate)

Orange Rib (# M-33A)	70-160 gsm text up through 60# cover .004"—.007"
Blue Rib (#M-34)	100-250 gsm text up through 100# cover .006"—.010"
Yellow Rib (#M-33)	250-350 gsm 80# cover and heavier .010"—.018"

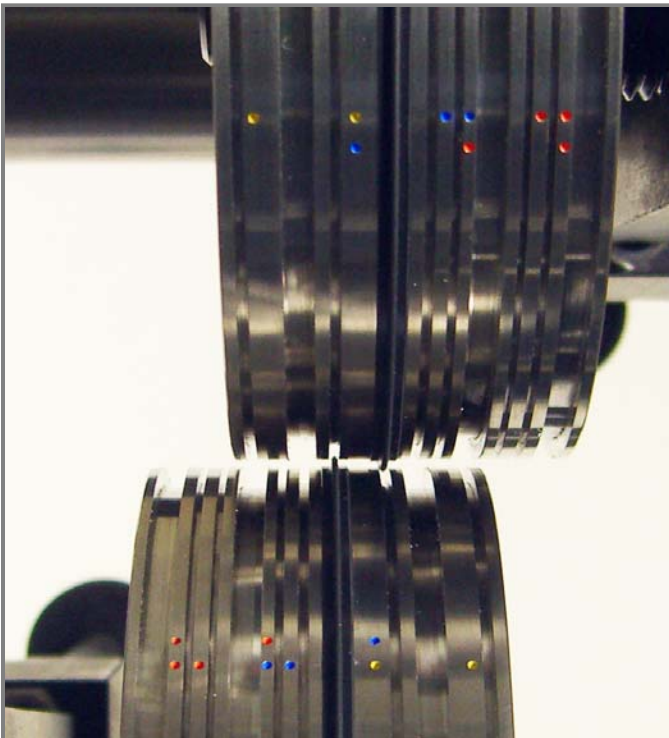
Creasing Rib + Channel Pairings Illustrated



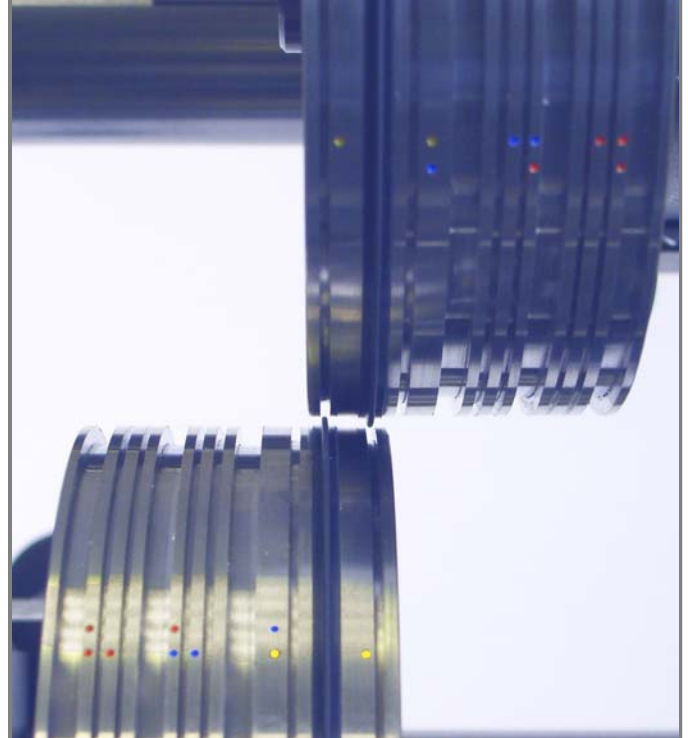
Orange 1-Dot Pairing
Lightest (thinnest) crease
Use M-33A orange rib



Blue 1-Dot Pairing
Light to medium crease
Use M-34 blue and can also use M-33A Orange



Blue/Yellow Pairing
Medium to heavy crease
Use M-34 Blue and can also use M-33 Yellow



Yellow 1-Dot Pairing
Heaviest crease
Use M-33 Yellow primarily; will also accept M-34



To remove or change position of a creasing rib, slide the extraction tool under the rib at the cutout. Gently pry up the rib and slide the tool under the rib and/or use your fingers to remove the rib.



Tips on Selecting the Right Creasing Rib

Your new Spine & Hinge Creaser gives you the ability to control how your perfect bound book covers will look and perform. There are several crease combinations available and 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.

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

Always be sure to center the crease. The rib should be precisely in the middle of the female channel. Use the micro side-lay adjustment on the holders for fine adjustments. Depending on your installation, shine a light or hold a sheet of white paper behind the creasers to visually line them up.

An off-center crease will be deformed and may not perform properly when it gets to the binding line. It will also prematurely wear the rubber creasing ribs.



Test first. Once you select your crease setting and before you fire up the press, test some sheets. Engage the air actuator and set the depth. Take a small sheet and run it through the creasers by hand. It won't be straight but it's good enough to give you feedback on the quality of the crease. Make any adjustments and re-test as needed until you are satisfied with the quality of the crease.

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.

If the inside bead is wrinkled, you can try two things:

- Move to a thinner channel
- Try the next wider rib in the same channel

The outside of the crease should also be smooth and free of cracking or tearing. Adjust the gap (pressure) as needed to get this result.

Use Minimum Pressure

More pressure does not necessarily make a better crease and it often makes it worse. If added pressure starts to tear the inside of the sheet, back off the pressure and try another setting.

Experiment with Various Creases

Use the enclosed Crease Setting Log as an operator reference. It also helps to enter it in your internal job information system. 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!

Frequently Asked Questions

for the Spine-Hinge Creaser to fit Web Presses

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. 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 1.5 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.

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 Web Spine-Hinge Creaser can be used on almost any stock that is run on web presses, especially if it is used as a scoring aid to improve folding quality. For the purposes of eliminating fiber cracking, you'll probably see best results on stocks in the .005" to .016" range.

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/>

