

# 6 Tips for High Yield Folding

*by the staff of Tech-ni-fold*  
Global Leaders in  
Print Finishing Solutions

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**The beautiful thing about folding machines is that it's possible to do many things to the sheet as it passes through the machine.**

For years however, some things...though possible...were simply not done.

For instance, trimming cover stock on the folder was discouraged, so covers were always run 1-up. If the cover needed scoring, it was done anywhere except the folder, typically on press, letterpress or diecutter.

Or consider the 4/C job on text weight paper. In order to be slit on the folder 2 or

3-up, it had to be considered throwaway quality because the edges were always fuzzy and after a short amount of run-time on the cutting knives, a bit ragged.

A premium job was always run one-up. With the advent of new creasing and cutting tools, it now pays to re-visit some of these 'possibilities' that may have been removed from your arsenal of production techniques. They're all very simple to execute and for the longer runs will give you huge boosts in productivity, in some cases doubling the yield or better.

We put together some of the more popular layouts we are seeing used as well as some more unusual ones—6 in total.

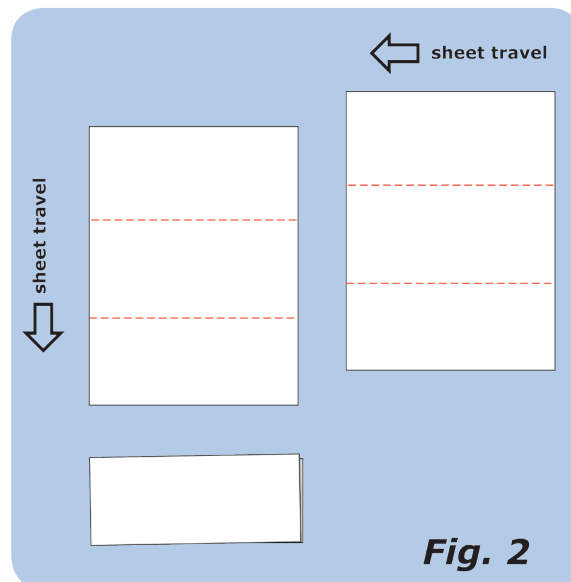
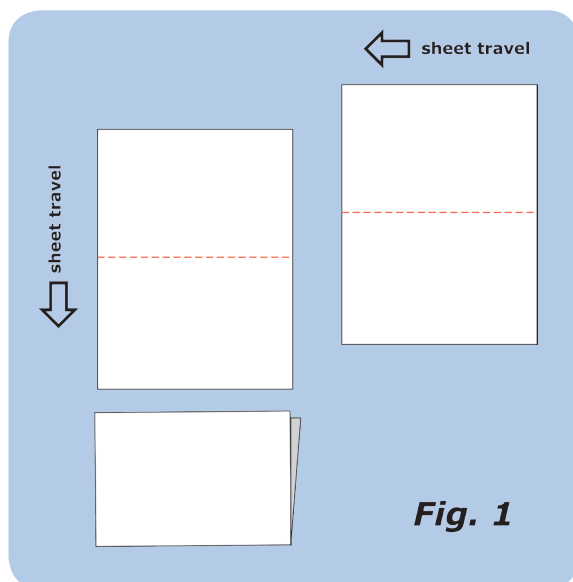


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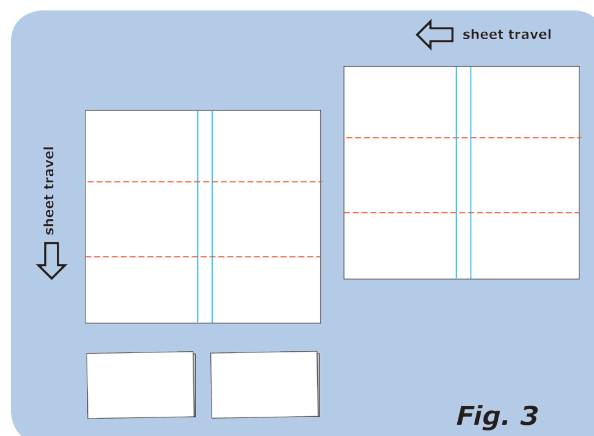
One of the great things about bindery work is that there is no end to the creativity that I see applied to finishing a print job, especially on folding machines. Depending on the trim size, number of folds and weight of the paper there might be half a dozen ways to process the same job.

Here are some common ways to use Technifold products with various layouts to dramatically boost your production.

**Figures 1 and 2** illustrates the most common uses of a high end creasing system, such as the Tri-Creaser, on the folding machine. In the main parallel section one or two (or more) Tri-Creasers do the creasing and then the piece is folded in the right angle section. You get letterpress quality creasing at folding machine speeds, using as many Tri-Creasers as needed to match the number of folds. **This eliminates outsourcing or separate creasing (scoring) operations.**



**Figure 3** shows one of the most popular ways to get a big increase in folding machine yield. Here you run a **letter-fold or 6-panel job 2-up**. Apply 2 creases in the first section (no folding.) In the right angle section, fold 2 times, then take a trim out of the middle using a premium cutting tool such as Technifold's Multi Tool to yield 2 pieces. With the Multi Tool, you can even do this on cover stocks since you are getting guillotine quality cutting.



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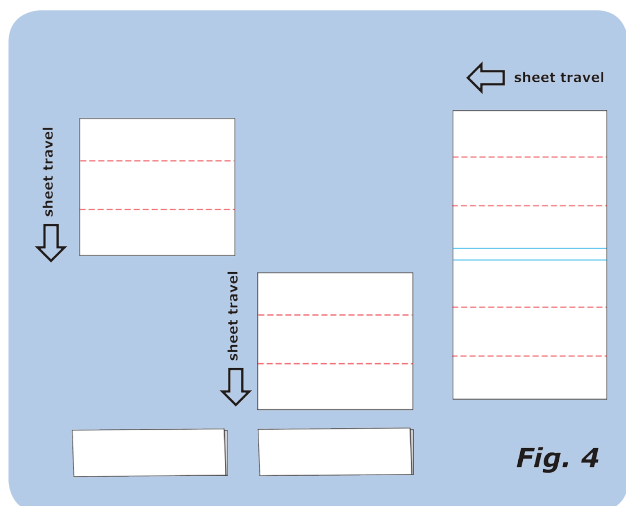


Fig. 4

**Figure 4** illustrates a **technique for running a 2-up job**. Typically (but not always) this requires a split guide on the right angle section. If you do any long runs and a split guide attachment is available, it's well worth the investment since production increases can be huge.

Here we illustrate 2 creases applied to each unit in the main parallel section (4 Tri-Creasers total) with a double-trim taken out of the middle with the Multi Tool. The newly trimmed sheet then folds 2x in the right angle section.

You can also add 2 Multi Tools to the right angle section to make this a 4-up job, depending on the size and layout.

**A note on the split guide:** if you have enough room on the sheet, you can run jobs like this **without a split guide**. It simply requires a larger double-trim to build in a gap between the sheets as they travel the cross carrier.

**Figure 5** shows another popular use with the Multi Tools—**run any parallel fold job 2, 3 or more up** and then slit or double-trim to yield the final piece. With the Multi Tool you can trim stocks up to a combined thickness of about .040" whether it's cover stock or text, and it will have a guillotine edge.

With this type of layout, we routinely see operators easily getting 2 to 3 times the normal yield. For instance, folding a 4pp cover at 20,000/hour will yield nearly 60,000/hour at the same machine speed when running 3-up. Even if you reduce run speed to 18,000/hour to compensate for an oblong format, that's still a hefty 270% increase in your yield! (54,000/hour vs. 20,000/hour.)

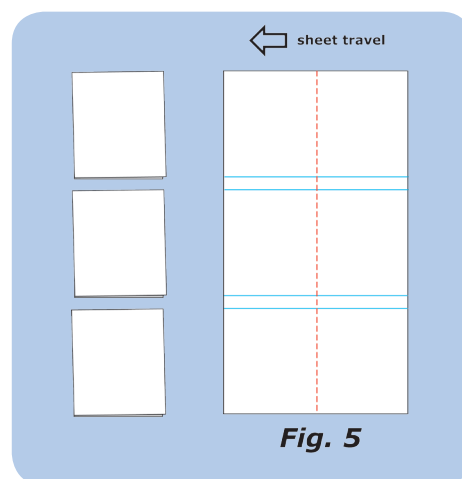


Fig. 5

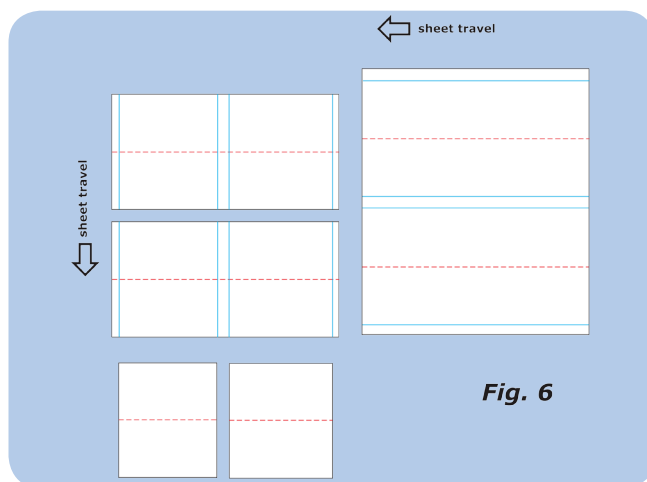


Fig. 6

**Figure 6** demonstrates another inventive use of multiple Technifold tools to get a huge increase in yield. **Here a 4-up 11.5 x 15.5" sheet is taken directly from the press (no trimming,) creased, trimmed and delivered flat.**

In the parallel section they apply 2 creases, trim both edges and double-trim the middle. The 2 newly trimmed pieces then pass through the right-angle unfolded with both edges trimmed and another double-trim taken from the center. This delivers 4 flat sheets about 5.25 x 7.25" with one crease down the middle.

**The net result:** the job runs at 8,500 sheets/hour x 4, yielding 34,000/hour of finished, scored, batch-counted pieces ready to be shipped. Job requires 6 Multi Tools for cutting and 2 Tri-Creasers.



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