



Instruction Guide

Spine-Hinge Creaser

to fit

Harris UB Binders

QC-DEL-UB/6-FP

For Technical Support:
email: 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

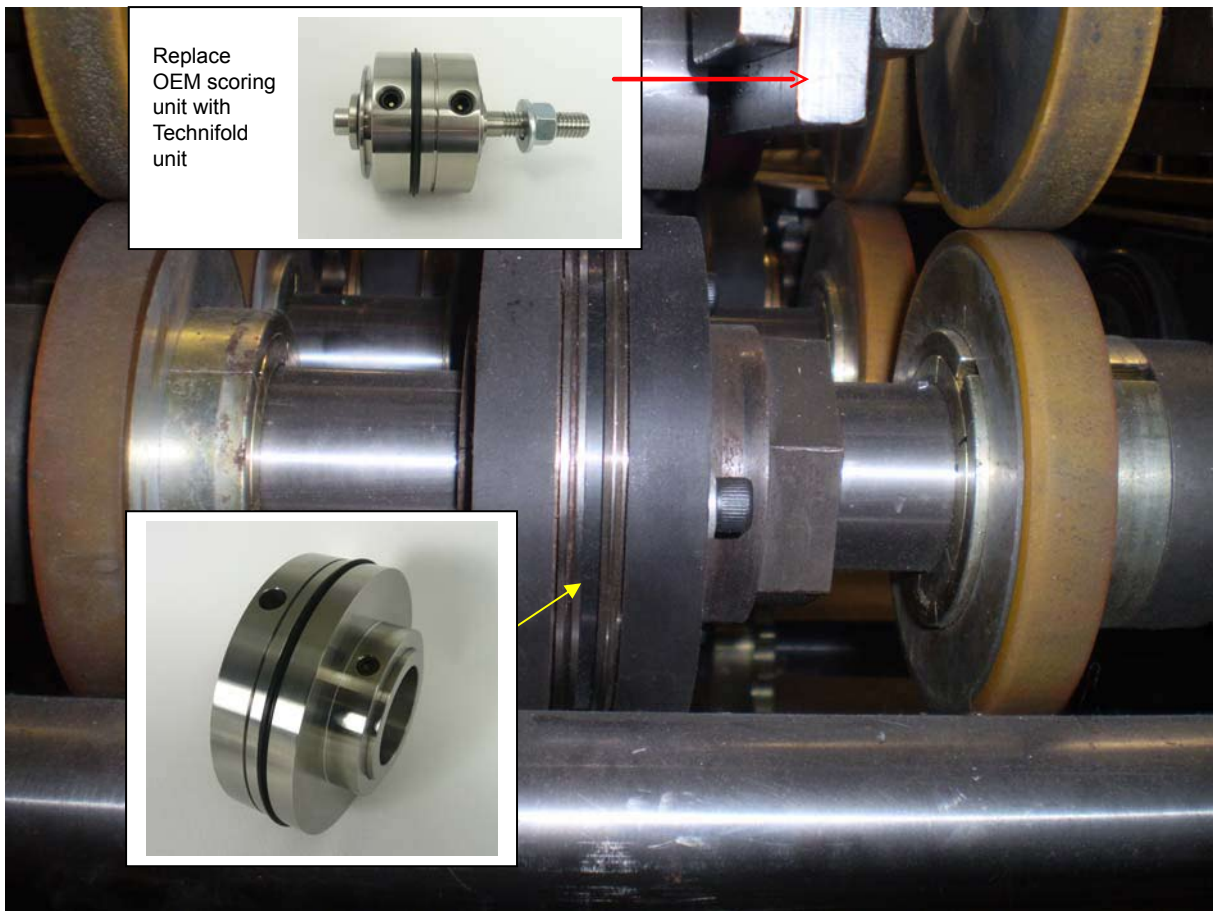
or take a look at the FAQ and Tech Support page:

<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.

UB BINDER INSTUCTIONS



Replace OEM scoring unit with Technifold unit

Top Creasing Unit

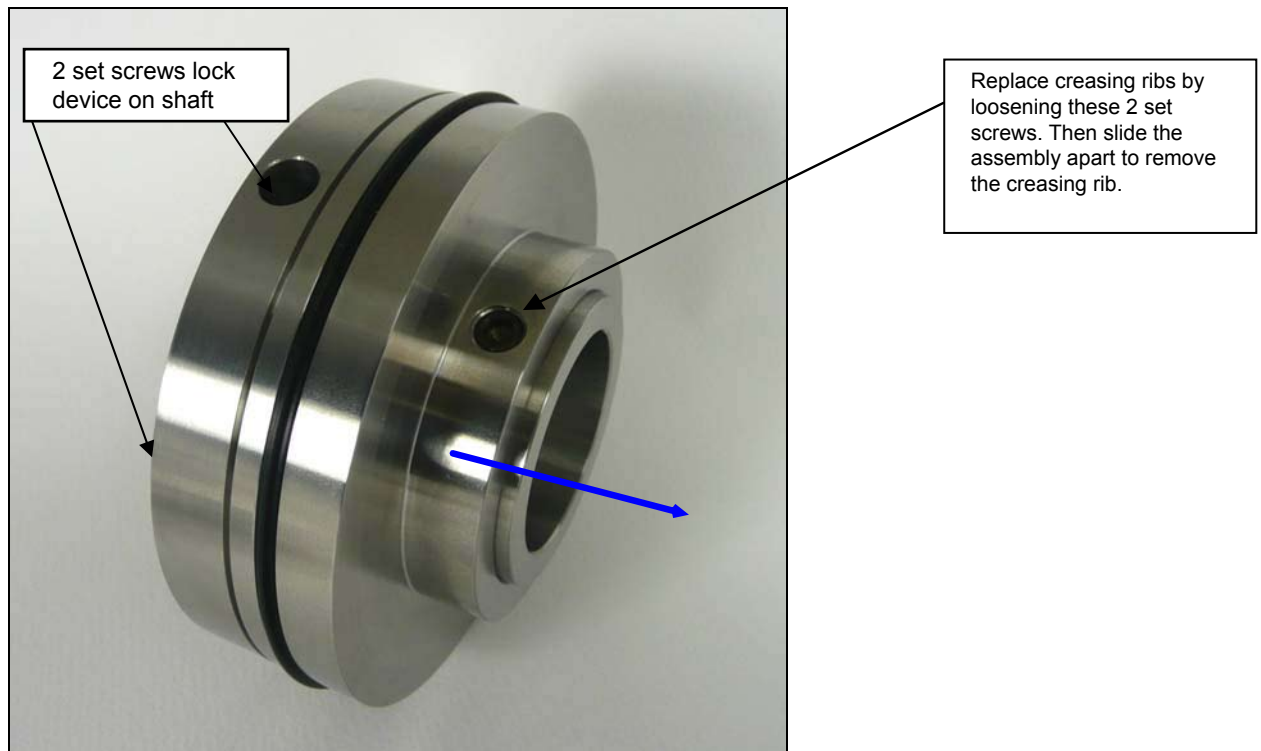
SAFETY STOP
Prevents creasing unit from sliding off shaft.

CREASING RIB REMOVAL
Loosen this set screw and slide retaining collar open. Replace the rib, slide the retaining collar back in to position snugly against the rib, then re-tighten set screw.

MOVING THE CREASING UNIT
To make minor adjustments to the position of the creasing unit, loosen this set screw. Move into the desired position, then follow the procedure for centering the creasing rib in the female channel. (See the following pages for instructions.)

IMPORTANT
You must always re-center the creasing units when you change position!

Bottom Creasing Unit



Centering the creasing rib and female channel

When installing the **Bottom creasing unit** for the first time it is important to align the bottom creasing unit inline with the edge of the clamps. Once this has been correctly aligned the bottom creasing unit should never have to be moved again. Replacement the creasing rib as shown above.

How to center the creasing ribs in the channel:

- 1) Position the upper unit directly above the lower unit, with the 2 creasing ribs inside the opposite female channels. Do NOT lock the upper unit. Leave it loose so it can easily move from side to side.
- 2) Run a sheet of cover stock through the cover feeder so that the upper units rotate at least one or two revolutions. This will automatically center the upper unit.
- 3) Now, with the cover sheet still gripped between the units, lock the upper unit in position.
- 4) Check visually to ensure the rib is centered and repeat if needed. Run a few sheets to check the quality of the crease.

Alternative Modification for Upper Scoring Units

Creasing requires a substantial amount of compression on the sheet. We've found that some of the older Harris UB Binders, depending on the design, may have weak springs on the upper scoring unit holders. Generally speaking, if you can raise the upper units with light to moderate finger pressure, they are too weak. If so, you'll have difficulty getting good crease formation no matter which creasing rib you use.

There are some simple fixes to the problem.

1. Replace the springs with heavier ones that will increase and maintain pressure.
2. Remove the springs completely and modify the unit so that the upper creases can be raised and lowered manually to the desired position. (This could be similar to pressure adjustments found on scoring machines or folding machines, where the correct pressure can be 'dialed in'.)
3. Replace the original unit with an air-actuated system as shown in the photo below. The operator with this installation says that about 60psi provides plenty of pressure for all their jobs.

Note: we don't currently have components available for such modifications. Any good binder mechanic, or perhaps your own maintenance department, will be able to fabricate what you need with readily available parts.



Tips on Selecting the Right Creasing Rib

For best results 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.

Sometimes customers prefer a conventional score line, with the male hitting the inside of the folded cover, so the bead folds to the outside.

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 or the crease is too heavy. Relax the pressure or go to a thinner crease.

The outside of the crease should also be smooth and free of cracking or tearing.

Experiment with Various Creases

The Pink M-41 and Black M-85 rubber creasing ribs are used together as a set. They have the same profile and are intended to be used with most stocks up through about 100# cover or 12pt. For heavier stocks use the hard nylon creasing ribs, QC-DEL-MPB/PC-B and QC-DEL-UB-6/PC.

It's important to try both creasing ribs and then make a note of the creasing rib combo that works best for each job or for a particular stock. Generally the rubber ribs are better at eliminating fiber cracking than the hard nylon ribs.

The nylon ribs will last longer, so if fiber cracking is not an issue, you will want to try them if the stock is heavy enough. Again, at first it is important to experiment a bit with both ribs.



For Technical Support

email: TechSupport@technifoldusa.com

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

Frequently Asked Questions

for the Spine-Hinge Creaser to fit UB Binders

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 nylon creasing ribs on your UB Binder Spine-Hinge Creaser should last 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.

What range of papers can I crease?

In general, the Spine-Hinge Creaser should work on stocks from about 60# cover (5-6 pt) 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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To Order Replacement Parts:

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Spine & Hinge (Quad) Creaser

To fit UB Binder

Stock Code: **QC- DEL-UB/6-FP**

Shaft Size: **1½" Exit Shafts**
Outer Diameter: **4"**

SETTINGS



Additional Information

The distance between the spine and the hinge is fixed at ¼ inch

Contents of Package

2x Top shaft spindle fixing assemblies

Spindle assemblies that bolt onto the existing crease unit holders

2x Top shaft creasing Male/Female

Components:

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

2x Bottom shaft creasing Male/Female

Components:

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

1 x 5mm Hexagon Key

4 x Creasing Rib Perfect Binder Pink M-41

4 x Creasing Rib Perfect Binder Black M- 85

Nylon creasing ribs

For creasing laminated & heavy covers 280gsm and above

2 x small black nylon creasing ribs

QC-DEL-MPB/PC-B

2 x Large black nylon creasing ribs

QC- DEL-UB 6 /PC



Tech 362 Tech 128 (top crease units only)

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