



Instruction Guide
Spine-Hinge Creaser
to fit
Muller Pantera
QC-MU-PAN-FP-6

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.

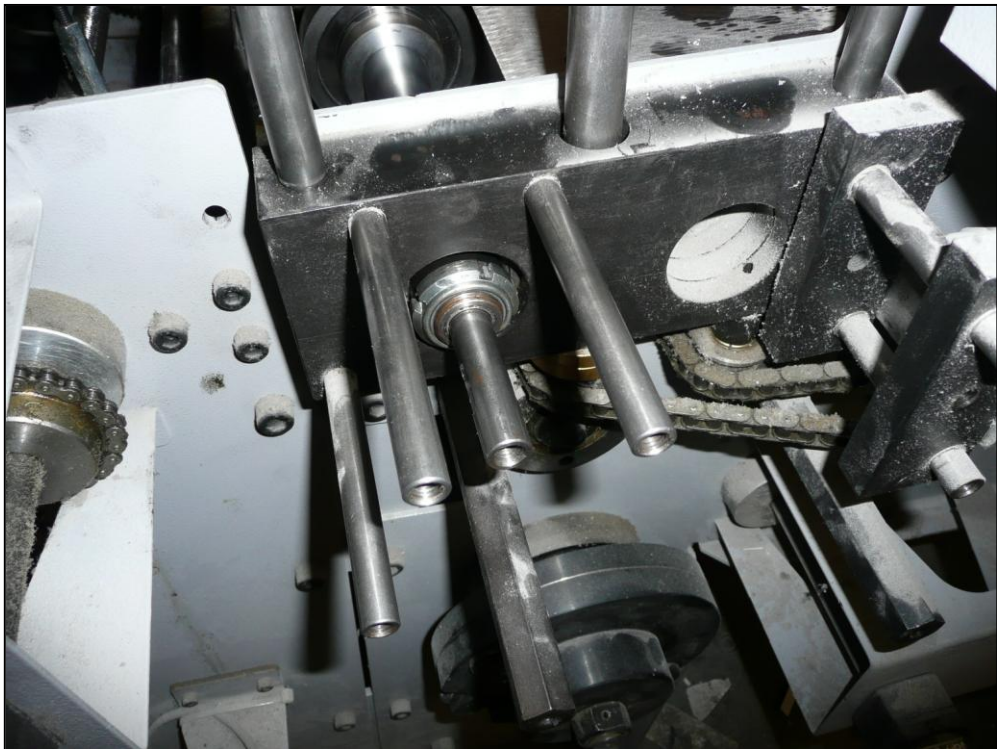
Tech Support: email techsupport@technifoldusa.com and we'll get back to you as soon as possible, usually the same business day.

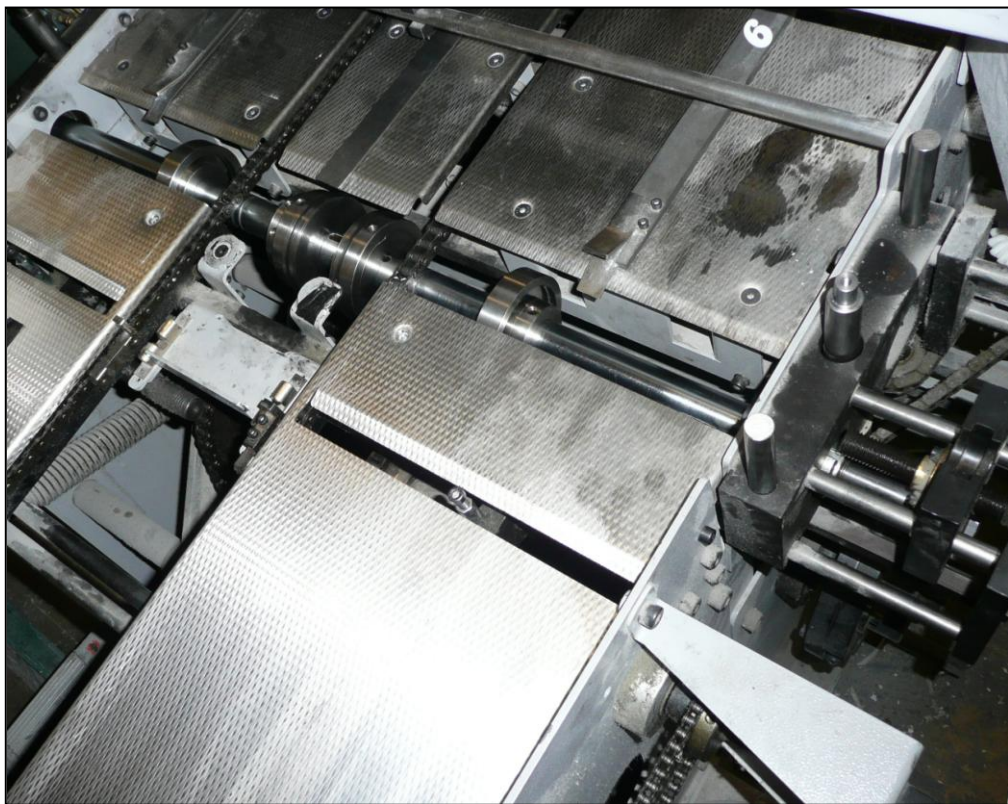
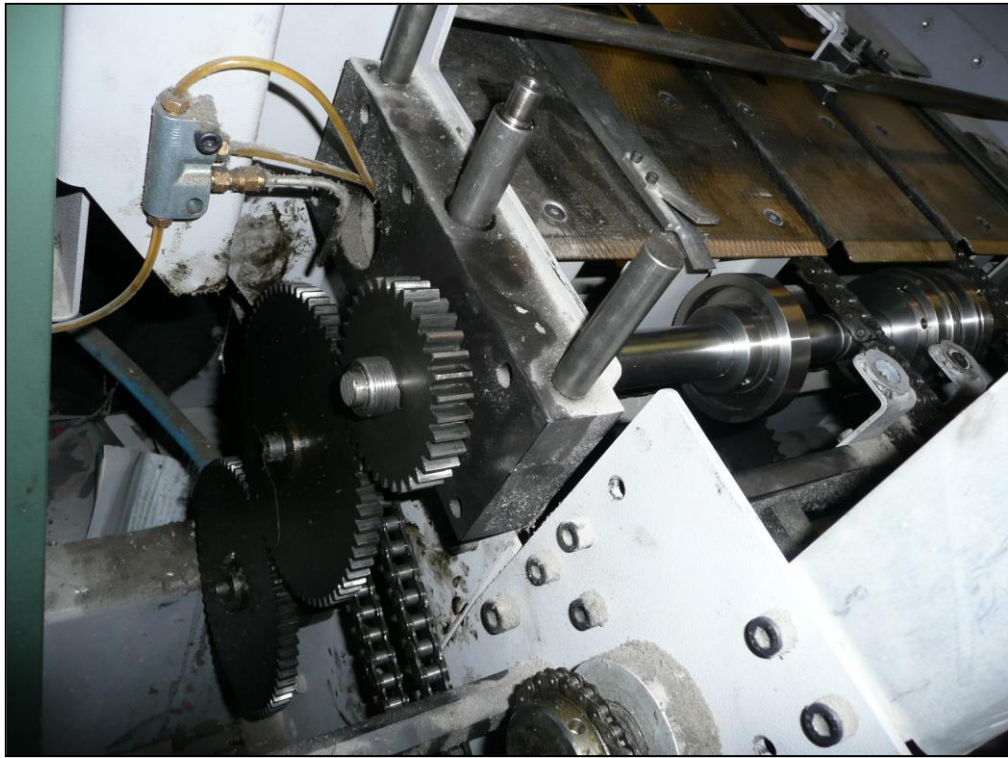
Bottom shaft
Left side



Bottom shaft
Right side





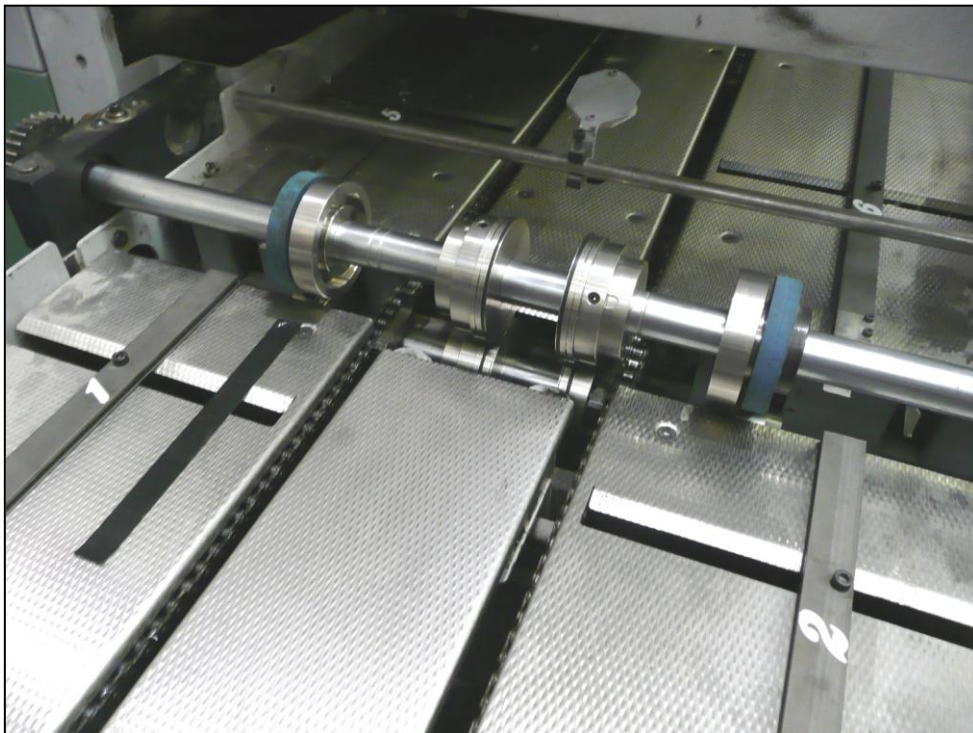




Top shaft
Left side



Top Shaft
Right side



Installation tips for the Muller Pantera



Top Shaft Unit

2 x Extra security
shaft locking screws



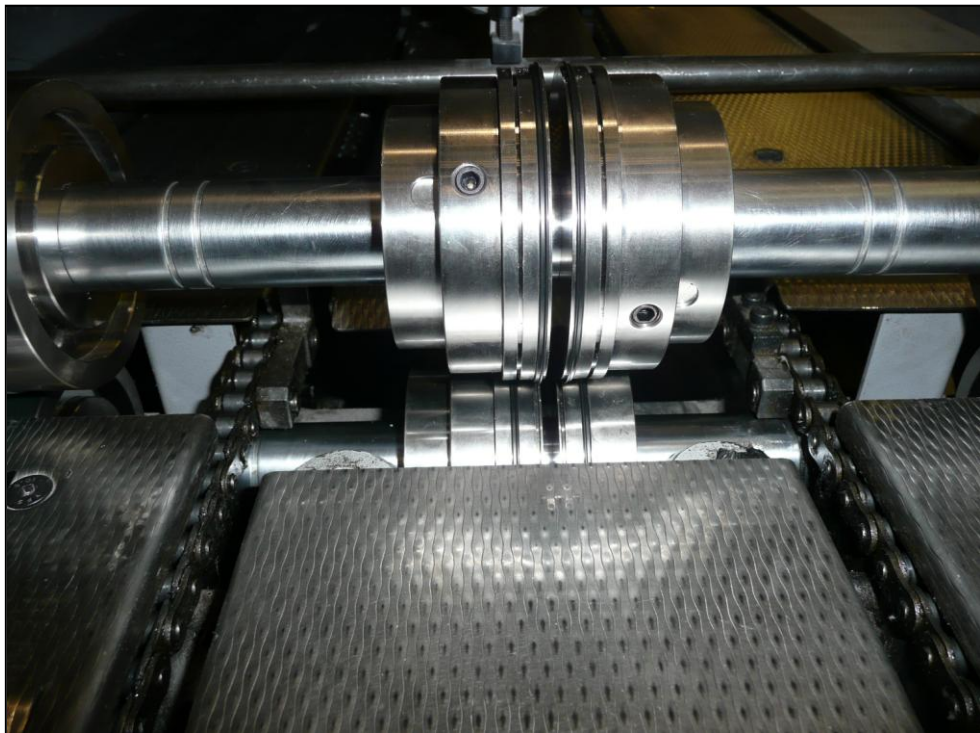
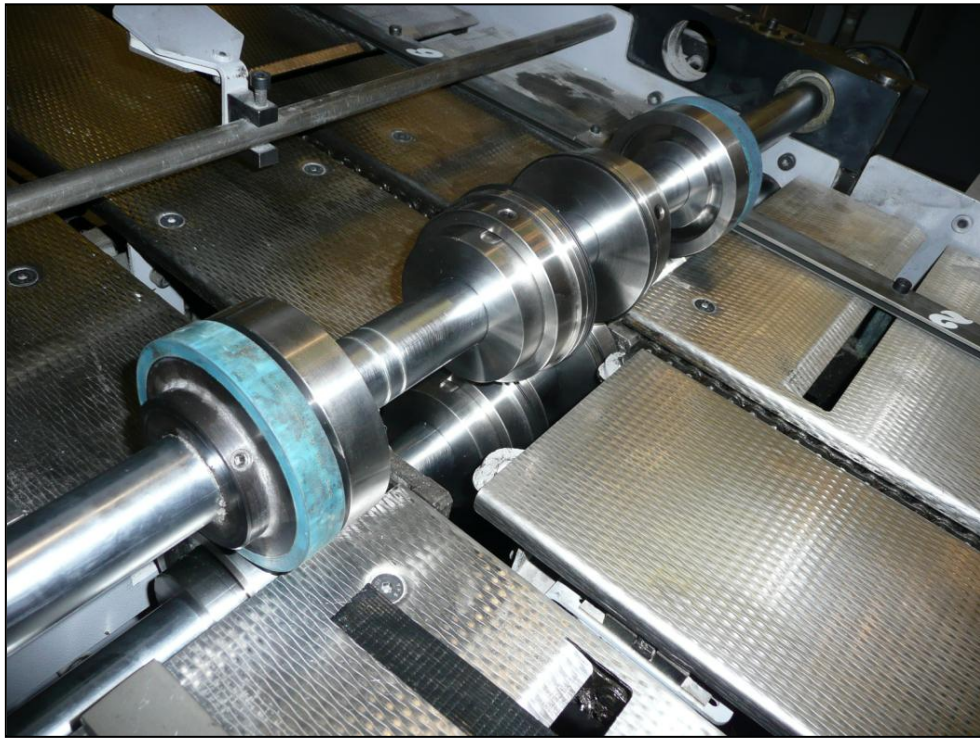
Original inner
shaft fixing
screws required.

Muller Martini
parts code
1580.2072.4

**To prevent damage to the nylon creasing ribs please remove
the ribs before installation!**



Bottom right side shaft
unit



Setting the Shaft Gap (or Pressure)



1 - Push the rubber gripper rollers off to the side.

2 - Align the Technifold gripper rollers (metal) so the upper metal roller is directly over the lower metal roller.

3 - Initially, place a sheet of 100gsm (about 5-6pt) paper between the collars on each side.

4 - Lower the upper shaft until there is a light grip on the paper from the metal rollers. This basically calibrates the gap to a good starting point.

5 - Now slide the upper metal rollers away and re-position the rubber gripper rollers directly over the lower metal rollers. You should now be ready for running most jobs.

6 - When changing stocks which vary in thickness, simply repeat this procedure with the stock you plan to run. This will in most cases give you the proper gap (pressure) for a correct crease. Of course, you can fine tune as needed.

How to Center the Crease



1 - Lock the nylon creasing ribs snugly in all upper and lower creasing tools.

2 - Align the lower units with the rear of the clamp.

3 - Lock the shaft set screws on the lower creasing units.

4 - Position each upper unit directly over the lower unit, with the male ribs opposite the female channels. DO NOT LOCK the upper units.

5 - Run a sheet of cover stock so the units go through at least one full revolution and the set screws are visible. This will automatically center the upper units over the lower units.

6 - Now, with the cover stock still gripped between the units, lock the upper units in position with the shaft set screws.

7 - Check visually (if possible) and repeat if needed. Be sure shafts are free of dust and dirt when performing this procedure so the units can move freely.

8 - Run a few cover sheets and check the crease quality. Adjust position and/or pressure as needed.

Tips on Selecting the Right Creasing Rib

Although there is only 1 female channel width available on this creasing tool, there are two male creasing ribs, each with different profiles. These can be used to alter the performance of your spine and hinge creases. Here are some brief suggestions.

Blue nylon creasing ribs should be used with stocks from 6-12 pt or so. Use the black nylon ribs for heavier stocks.

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

It's important to try both creasing ribs on various stocks and then make a note of the creasing rib that works best for each job or for a particular stock.

Use the enclosed Crease Setting Log to make notes and then refer back to it when re-visiting a particular job or a particular stock.



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 the Muller Pantera

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 Spine-Hinge Creaser should last about 1.5 to 2 million sheets or more, depending on the weight of paper. It can vary substantially. **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. This is critical!! It creates the proper crease and also maximizes life expectancy of the creasing ribs.

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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Spine & Hinge (Quad) Creaser

To fit Muller Martini Pantera Binder

Stock Code: **QC-MU/PAN-FP-6**

Shaft Size: **30mm Exit Shafts**

Outer Diameter: **85mm**

SETTINGS



Additional Information

The distance between the spine and the hinge has a 6mm fixed size

Top Shaft Crease Unit



Bottom Shaft Crease Unit



Contents of Package

4x Male/Female Components:

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

4x **Blue** Nylon Crease Ribs

Code: QC-MU/PC-B 100-280gsm

4x Black Nylon Crease Ribs

Code: QC-MU-PAN/PC 250-350gsm

4x Support Collars

Helps grip & guide the sheets while creasing



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

Crease Setting Log

Email Tech Support

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