Instruction Guide
Spine-Hinge Creaser
to fit
Muller Panda
QC-MU-PA-FP-6-01

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.

Installation of Spine Hinge Creaser to fit Muller Panda

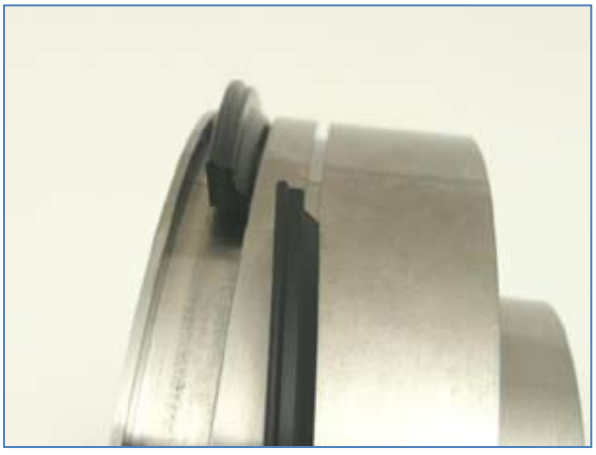
30 mm shafts with 80mm Outside Diameter

Top shaft

Bottom shaft

Top shaft

Uses the single-wedge crease in which the creasing profile is offset to one side.



Bottom shaft

Uses the double-wedge crease in which the creasing profile is centered.

Top shaft component with single-wedge creasing rib installed

Bottom shaft component with double-wedge creasing rib installed

2 ea. Top Shaft Gripper Rollers

Used to grip the sheets as they run through the cover feeder creasing unit

How to Center the Creasing Units

1 - Be sure all four creasing ribs are locked into place. Now align the 2 bottom creasing components in the correct position (usually aligned with the edge of the clamp.) Lock the shaft set screws so the bottom units are fixed in position. Also, be sure that all shafts are free of dust, dirt or grease. This ensures that the creasing units can move freely when needed.

2 - Postion the upper units in place directly over the lower units. The gap on the shafts should be opened so that you can move the upper units into position without damaging the creasing ribs! DO NOT TIGHTEN the shaft set screws on the upper units yet...leave them loose so the units can slide freely on the shafts!

3 - Postion the Technifold gripper rollers directly over the lower gripper rollers.

4 - Place a sheet of the paper you plan to run between the gripper rollers on each side. Adjust the gap as need so there is a light drag on the gripper rollers.

5 - Slowly run a sheet of cover stock through the feeder so that the creasing units move through at least one full revolution, and so that the shaft locking set screw is accessible. The rotation will automatically center the upper units.

6 - Now, with the cover stock still gripped by the creasing units, tighten the locking set screws on the upper units. Check visually (if possible) to be sure the units are centered. Run a few sheets and check the crease by hand. Repeat the centering procedure if needed.

7 - When changing to a different thickness of stock, simply repeat the gap set 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.

8 - **Important:** Whenever you move the creasing units OR change the ribs, you MUST re-center the crease!

Tips on Selecting the Right Creasing Rib

Although there is only 1 female channel width available on this creasing tool, there are several 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.

If fiber cracking is not a problem with the stock you are running, start with one of the nylon creasing ribs (You'll have to experiment!) The nylon ribs will last longer than the rubber ribs. Always be sure to center the devices as explained in another part of this manual. An off-center tool will wear out the ribs prematurely. Remember too that on this Panda device, the upper and lower ribs have different shapes. (This is what helps the tools to get down to the minimum 5/32" spine.)

If you expect fiber cracking to be a problem, then start with the rubber creasing ribs. Always be sure to re-center the devices whenever you re-position any tool. This applies to both rubber and nylon ribs.

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

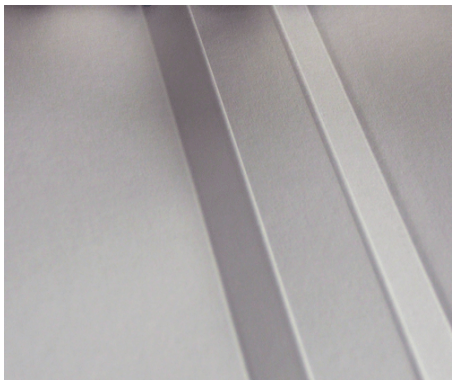
It's important to try all creasing ribs on various stocks and then make a note of the creasing rib that works best for each job or for a particular stock. There is no single right or wrong crease setting.

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
email: TechSupport@technifoldusa.com
or visit http://www.technifoldusa.com/faqs-support/

Frequently Asked Questions
for the Spine-Hinge Creaser to fit the Muller Panda

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. Rubber ribs typically last 500,000-1 million sheets or more depending on the stock, coatings and varnishes.

When do I have to re-center the female components?

Whenever you move any component to a new position you need to re-center each 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 2 Shaft Panda Binder with a 6mm Fixed Hinge

Stock Code: **QC- MU/PA-FP-6-01**

Top shaft **30mm**
Outer Diameter: **80mm**

Bottom Shaft Size: **30mm Exit Shaft**
Outer Diameter: **80mm**

SETTINGS

Additional Information

This creaser system uses a
6 mm fixed hinge

Contents of Package

2x Top Shaft Male/ Female Components:
contains both the narrow type of slit nylon creasing rib and the fixed female channel

2x Bottom Shaft Male/ Female Components:
contains the wide creasing rib and the fixed female channel

2x Top shaft Gripper Boss Support Rollers
used to grip the cover on the top shafts during the creasing process

4x Black Gripper Bands (M-59):
inserted into the Gripper Support Collars helps feeding sheet through device

4x M-174 Creasing Ribs - Top Shaft

4x M-82 Creasing Ribs - Bottom Shaft

Nylon crease ribs

TOP SHAFT

2 x orange Creasing Ribs:
QC-MU-PA01/PC-O-T
2 x blue Creasing Ribs:
QC-MU-PA01/PC-B-T
2 x yellow Creasing Ribs:
QC-MU-PA01/PC-Y –T

BOTTOM SHAFT

2 x orange Creasing Ribs:
QC-MU-PA01/PC-O-B
2 x blue Creasing Ribs:
QC-MU-PA01/PC-B-B
2 x yellow Creasing Ribs:
QC-MU-PA01/PC-Y-B

Tech 406 & Tech 376 (bottom crease units)

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 | Print This Form

Your Name: _____

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