

# Atelier (FBB1) Fold & Crease recommendation

- Pre-crease width/thickness based on 2 point didot ie 0,71 millimeters as superior results are obtained if the creasing bulge faces inwards
- Best practice should be on a flatbed principle (Bobst) or second option a HB-Cylinder
- Highly recommended above pre crease rolls eg in-line industrial folding-binding machines
- Pressure pre-crease knife as much as possible
- Channel width can be calculated as:  $2 \times \text{paper thickness} + \text{knife width}$
- Channel depth roughly 1- 1,5x paper thickness
- Folding direction: inside crease is outside fold
- Room condition RH ca 50 % humidity
- Knife in the center of the channel
- Preferable not to crease in the lacquers

## Best practice crease configuration based on thickness

Basis weight	Channel width (mm)	Channel depth (mm)	Crease knife width (mm)
220	1.30 – 1.50	0.30 – 0,40	0.71
240	1.40 – 1.60	0.35 – 0.45	0.71
260	1.45 – 1.65	0,40 – 0.50	0.71
280	1.50 – 1.70	0,45 – 0.55	0.71
300	1.60 – 1.80	0.50 – 0.60	0.71
320	1.70 – 1.90	0.55 – 0.65	0.71
350	1.80 – 2.00	0.60 – 0,70	0.71

## Calculations

- Channel width:**  $0,71 + (2 \times \text{paper thickness} \pm 0.1 \text{ mm})$   
**Channel depth:** Paper thickness still maximum 1.5 x thickness  
**Crease pressure:** Maximum possible

