



Instruction Guide Spine-Hinge Creaser *to fit*

Stahl 25mm or CreaseStream Mini
CSM-SHC-25

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 slitter 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

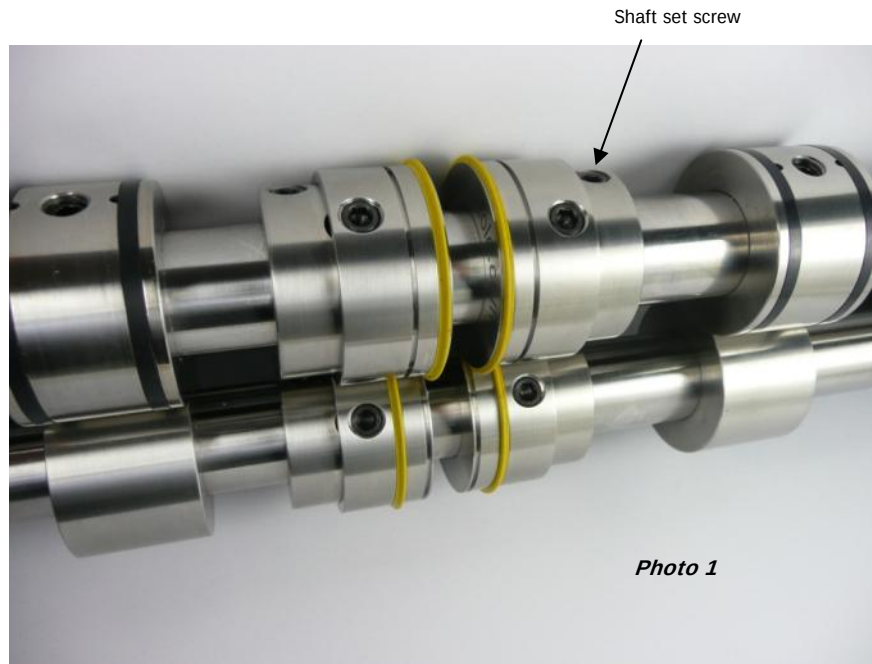
or take a look at the FAQ and Tech Support page:

<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.

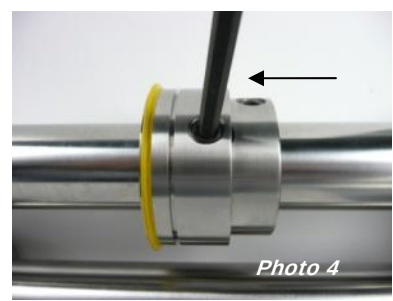
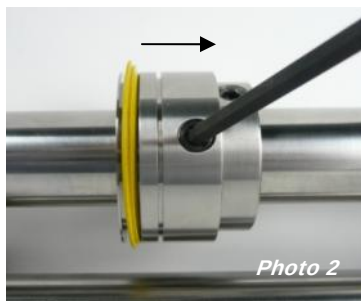
Tech Support: email techsupport@technifoldusa.com and we'll get back to you as soon as possible, usually the same business day.

25mm Spine & Hinge Creaser - Instructions



Each of the 4 crease units should be positioned on the slitter shafts as shown above.

1.1 Setting the Spine & Hinge creaser



To move the crease rib holder along the shafts, unlock the **shaft set screw** shown in Photo 1 above for each component. Lift the slitter shaft caliper so that the top shaft is pulled upward. The creasing rib holders will now slide freely along the shaft to be positioned where you need them. You want to take care so as not to nick the ribs against the opposite component when changing the position on the shaft.

When changing from one stock weight to another you may need to change to another creasing rib. To change ribs, first, use the 4mm Allen key to loosen the **retaining collar set screw** on the creasing rib holder (*see Photo 2 above*).

Slide the retaining collar away and remove the rib. (*Photo 3*)

Replace with the desired rib.

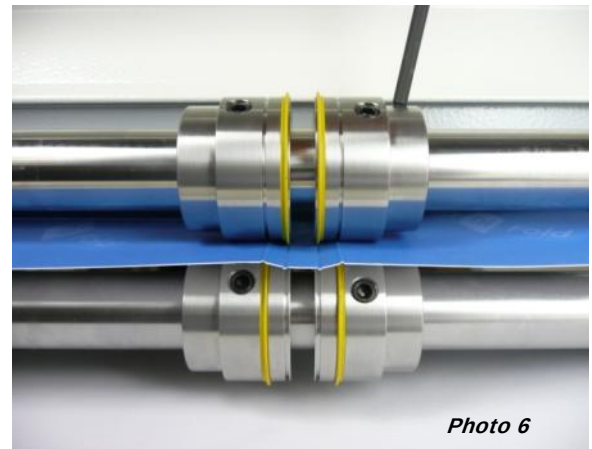
Snug the retaining collar against the rib and re-tighten the set screw. (*Photo 4*)

Repeat for all 4 components.

Note: for the sake of clarity, the photos show us changing the rib on a component that is moved away from the other components. Although it's somewhat easier to change the rib in this manner, it's not necessary. You can leave all 4 components in position and still change the ribs.

Once all 4 ribs are replaced, be sure to set the slitter shaft caliper with the stock you plan to run.

If the creasing units need to be re-positioned top to bottom, lift the slitter shaft calipers and slide the upper component into position over the lower. Gently lower the shaft ensuring the creasing ribs are located in the female channel. (*photo 5*)



Next, Position each upper/lower set where needed.

Now...lock the **shaft set screw** on the bottom components only, leaving the top units loose on the shaft.

Advance a sheet of cover stock through the machine until the sheet has rotated the creasing units at least one full revolution and the retaining ring set screws are visible. This will center the creasing ribs in the female channels.

While the sheet is still trapped between the components tighten the top shaft set screws on the two upper components. (Photo 6) Run a sheet through the machine. Check position and crease depth.

If no other adjustments are needed, you should be ready to run.

Tips on Selecting the Right Creasing Rib

Think of your new Spine & Hinge Creaser as a device that gives you the ability to control how your perfect bound book covers will look and perform. There are several crease combinations but with a little experimentation early on, you will find crease settings that are perfect for each of the jobs you run. Here are some brief suggestions.

If fiber cracking is not a problem with the stock you are running, and you are running stocks from 10 pt and heavier, start with the black 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.

In general though, use the blue creasing ribs for stocks up to about 10 pt or 100# cover. Use the Yellow creasing ribs from 8pt or 80# cover and heavier. Experiment to see what works best. 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. Adjust the slit shaft gap (pressure) as needed to get this result. Avoid tearing or wrinkling.

Experiment with Various Creases

Use the enclosed Crease Setting Log as an operator reference. Try various creasing ribs and then make a note of the creasing rib that works best for each job or for a particular stock.

If you run a wide range of paper stocks, initially this will take a little work but it's well worth it the long run.

Refer to your Crease Setting Log when you return to that job or that particular stock. This will save you LOTS of setup time!



Frequently Asked Questions

for the Spine-Hinge Creaser to fit 25mm Stahl Shafts

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 creasing ribs. 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 creasing ribs should last 1/2 million to 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. Don't forget this important step!

What range of papers can I crease?

In general, the Spine-Hinge Creaser should work on stocks from about 60# cover up through 114pt. Paper varies substantially so feel free to experiment no matter what type of paper stock you are running.

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Spine & Hinge Creaser (to fit CreaseStream Mini) – with fixed 6mm hinge



Order Code: CSM-SHC-25

Contents of Package

- 4 x Male / Female components contains both the split creasing rib and the fixed female channel
- 4 x **RIB012-B** – Blue split creasing ribs used to crease 150-170gsm
- 4 x **RIB013-Y** – Yellow split creasing ribs used to crease 160-270gsm
- 4 x **RIB019-BK** – Black nylon split creasing ribs used to crease 270-350gsm

Optional Consumables

Creasing Ribs

RIB012-B – Blue for stock of 150-170gsm

RIB013-Y – Yellow for stock of 160-270gsm

RIB019-BK – Black for heavy & laminate crease 270-350gsm

Additional Information

This tool incorporates a 6mm fixed hinge



Technical Specification

Shaft Size: 25mm

Outer diameter: 44mm

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Product code	
-PE	Pear
-AC	Maple

Codes shown in blue
delivery is within