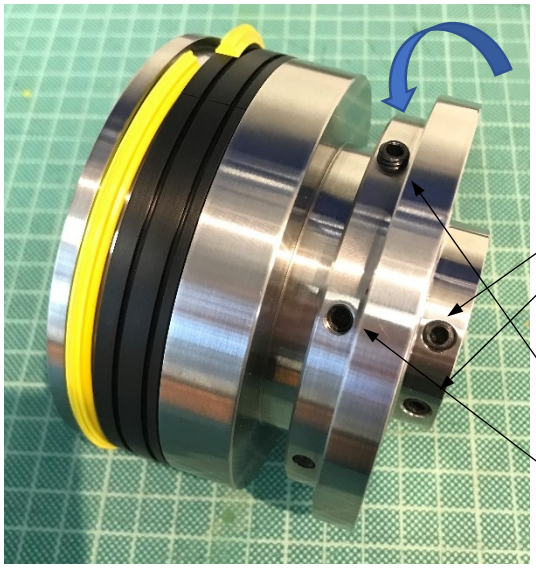
Installation Instructions Wohlenberg Quad-Creaser with Adjustable 6-Creaser Capacity

30mm Shaft & 98mm Outer Diameter with Adjustable Hinges

**Some of the tooling shown in this Instruction Guide may be different to what has been supplied in with this kit – all instructions are still valid*

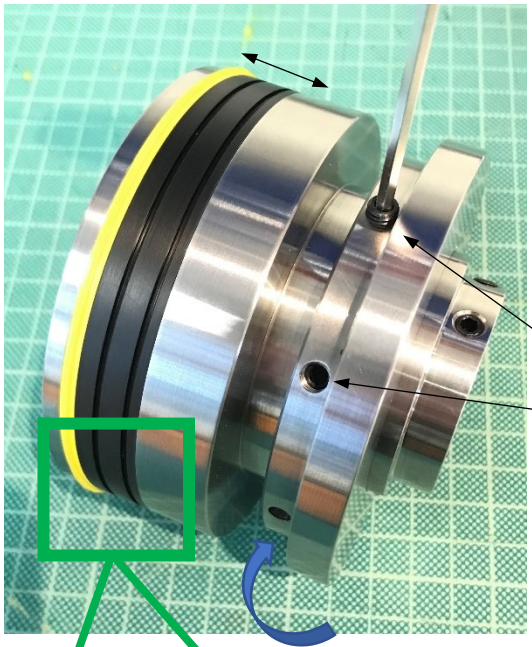
REMOVING AND REPLACING THE ACCESSORIES



Tighten the 2x 6mm shaft locking screws to secure creasing unit into position.

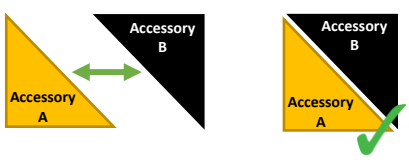
With the 2x 6mm inside screws loosened, unscrew the mandrel anti-clockwise apart until the gap is large enough to remove the creasing rib entirely.

Each accessory is split in design enabling easy insertion and removal from the tooling components without needing to remove the tools from the machine shafts.



Hand screw the collar and mandrel parts clockwise together and tighten by placing the supplied allen key into any of the 6mm holes and tighten the two components together.

Tighten the 2x 6mm inside screws to hold and fix the two parts firmly together.



When loading accessories to the components, and before tightening the collar, and mandrel parts together **ENSURE THE BEVELLED EDGES ON THE ACCESSORIES FIT PROPERLY BETWEEN EACH CORRESPONDING PART.**
FAILURE TO DO SO WILL RESULT IN DAMAGE.

INSERTS & ACCESSORIES

Male Creasing Rib Options

Orange – to crease thin cover stocks
Blue – to crease medium cover stocks
Yellow – to crease heavy cover stocks

Plastic Creasing Rib Options

Black – to crease heavy or laminate cover stocks where fibre-cracking is not an issue

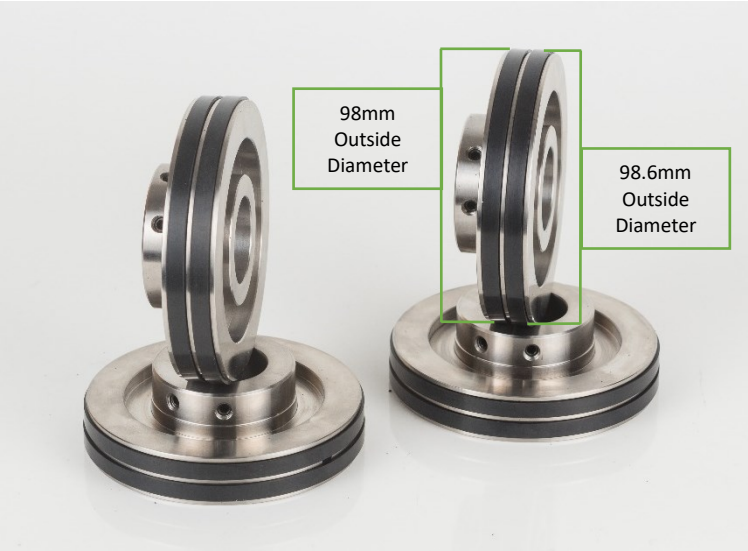
Female Hinge Spacer Options

Yellow – 10mm Hinge Spacer (Top & Bottom)
Blue – 6mm Hinge Spacer (Top & Bottom)
White – 5mm Hinge Spacer (Top & Bottom)
Black – 4mm Hinge Spacer (Top & Bottom)

Blanking Spacer (Double-Bevelled)

Item Code: **QC-WO-SP-02**
2 of these items are included in with the tooling pack.
These parts are for **use when converting the tool to the traditional Quad-Creaser (or 4 crease Spine & Hinge Creaser) configuration.**

TECH-NI-FOLD'S GRIPPER BOSS SUPPORT ROLLERS



Tech-ni-Fold's Gripper Boss Support Rollers supplied in your tool pack are to be installed on the machine's top shafts.

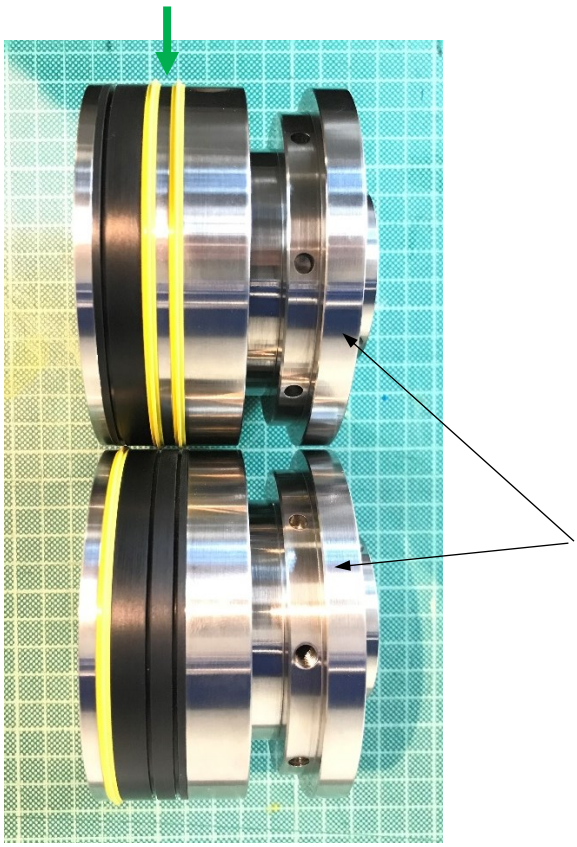
They are to be used in conjunction with the original plain metal support rollers which are to be situated on to the bottom shafts.

The 4x Tech-ni-Fold Support Rollers have 2 outer diameter sizes built into one roller (as shown).

Two different grip amounts can be achieved by using each gripper band separately.

TOP AND BOTTOM COMPONENT CONFIGURATION

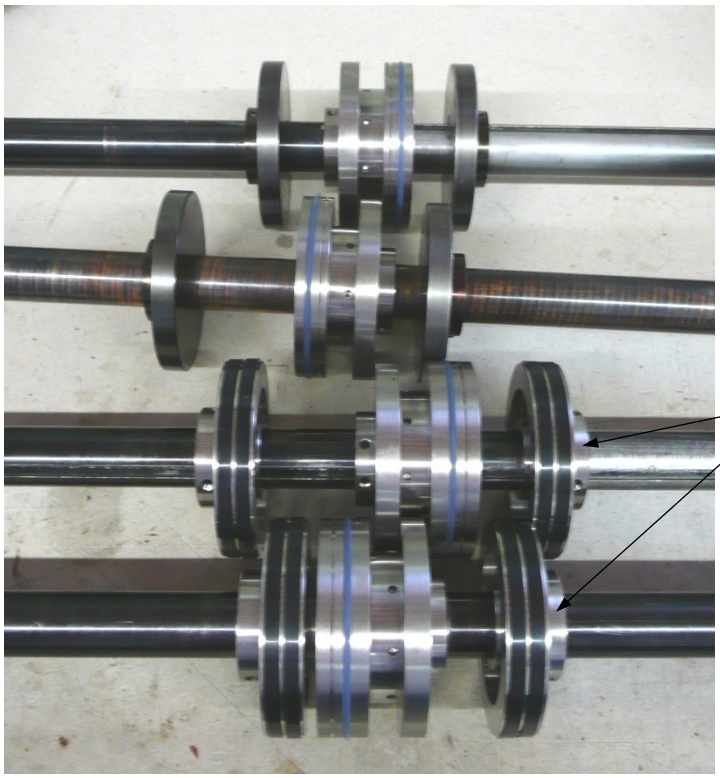
This Metal Divider MUST always remain loaded on the top components.



When installed within the machine, the top and bottom components will be configured as shown, with the male creasing ribs and corresponding female channels aligned. The same top and bottom configuration must be applied to the front and back machine shafts.

Please note: the metal diameter located on the mandrels is designed to help guide the cover stock through the device during the creasing process. They are **not** designed to grip the cover stock.

INSTALLING THE COMPONENTS TO THE SHAFTS



This photograph shows the assembly of the crease units before installation into the machine. *Tooling shown will differ to pack contents.*

The top shafts (shown to the bottom) use the Tech-ni-Fold Gripper Boss Support Rollers.

Please note: to stop damage, please remove the creasing ribs before installation.

INSTALLING THE BOTTOM SHAFT COMPONENTS

It is important to use the original plain metal bottom support collars.

Select the correct colour coded split creasing ribs and attach them on to the holders.

Align a bottom crease unit with the edge of the book clamp and tighten the fixing screws.

Align the remaining crease unit into the desired position and tighten the fixing screw.

INSTALLING THE TOP SHAFT COMPONENTS

It is important to use the Tech-ni-Fold Gripper Boss Support Rollers on the top shafts.

The 2x top shaft creasing units are supplied with bearings installed on the inside bore (see image right).

Once the crease units are on the shafts insert the required coloured split creasing ribs.

To achieve the correct grip between the Support Collars, align the top and bottom collars together. Equal gentle pressure should be achieved on each collar.

As the top shaft is being lowered, slide the male rib protrusions into the corresponding female channels.

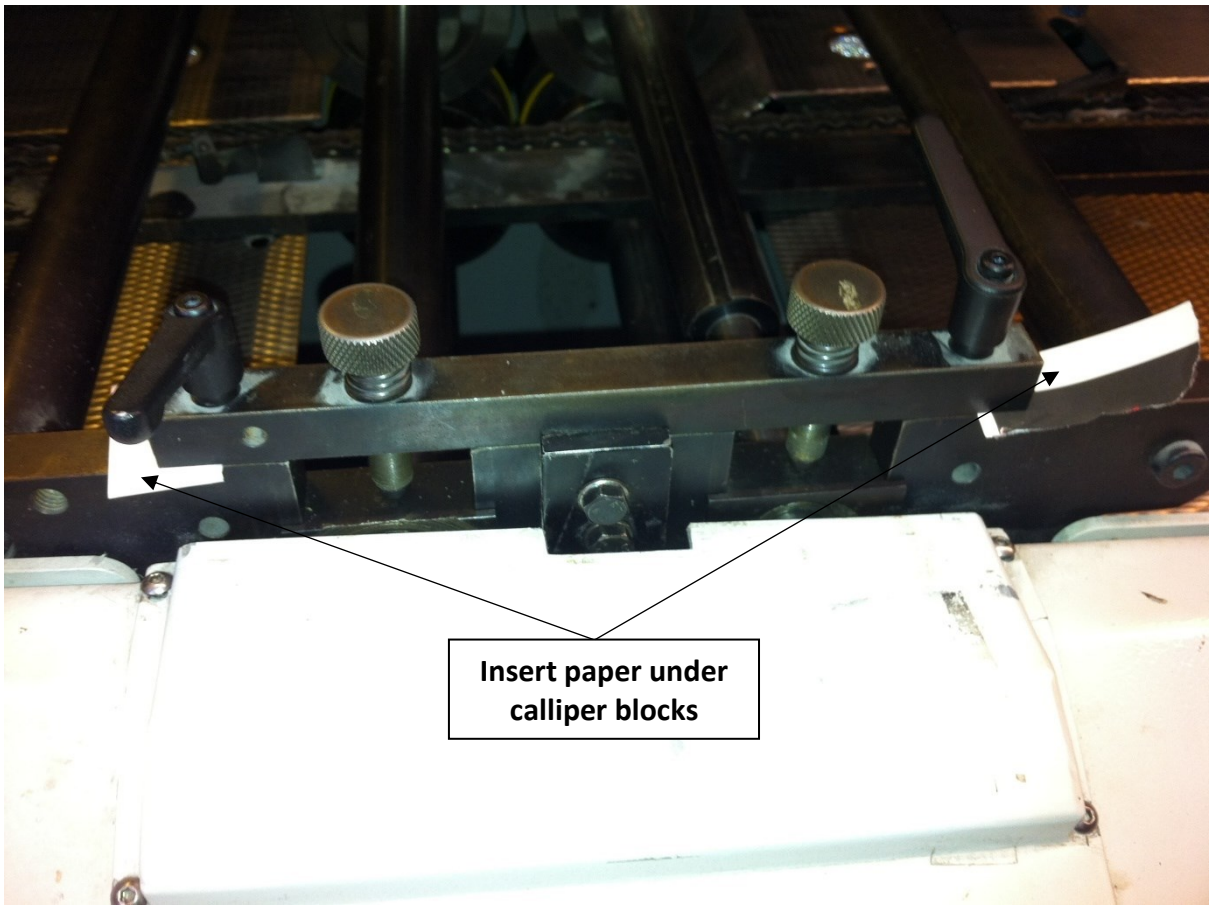
Slowly run a sheet of cover stock between the creasing units. As the cover stock is fed through the crease units the loose top crease units automatically centralise to the optimum crease position.
Tighten down the fixing screws when the crease unit fixing screws come into view.

If the creasing ribs open-up during production, loosen the fixing screws on the top crease units to allow the creasing units to rotate freely on their in-built bearings.

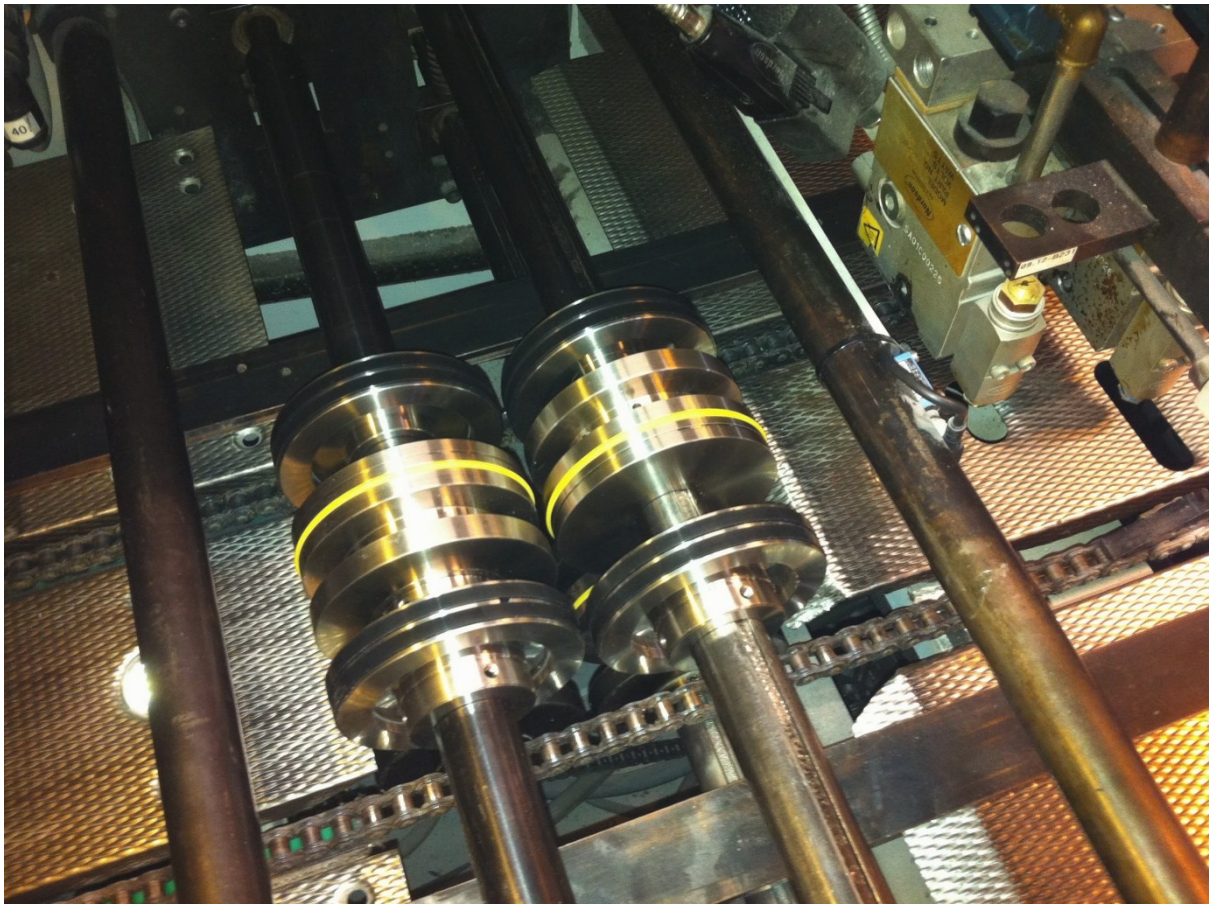
Bearings located in the inside bore of the top creasing units

Please note: to achieve the optimum crease quality, the creasing ribs must be located into the centre of the female creasing channels.

SETTING AND ADJUSTING SHAFT PRESSURES



To finely set the calliper pressure for the first time, it may be advantageous to insert 80gsm paper between the blocks (as shown in above photograph). When setting for different weights of stock simply insert the correct stock in to the 4x calliper blocks and the shafts will automatically be set to the correct pressure.



** Tooling shown will differ to pack contents.*

THE MACHINE IS NOW READY TO RUN

NOW AVAILABLE…

Tech-ni-Fold's Flap Creasing Add-On

Available for Wohlenberg Binding Machines with 98mm Outside Diameter

Order Code: QC-DEL-WO/98-ENDFLAP-FP

Do you have a requirement to produce outer flap creasing on the cover stocks you put through your Wohlenberg Binding machine? Please ask your local representative for more information on this Tech-ni-Fold Flap Creasing Add-On.

BINDING STYLE CONFIGURATION SETTINGS:

FOR 6-CREASE CONFIGURATIONS WITH VARIABLE INSIDE HINGE GAP DISTANCE

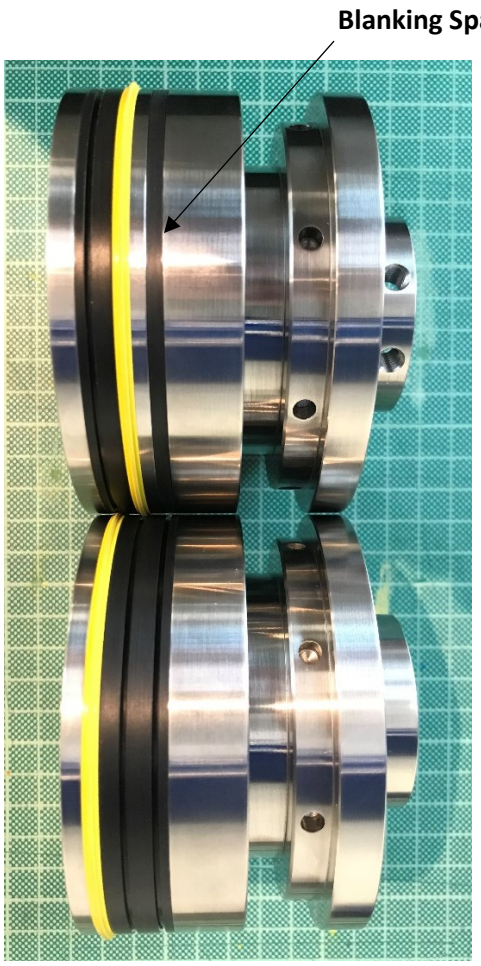
(SETTING INSTRUCTIONS BELOW USING THE 10MM HINGE SPACER AS AN EXAMPLE)

1. Select the required Coloured Male Creasing Rib for the weight of cover stock being processed
2. **TOP COMPONENTS**
   Insert the 10mm Female (Single Channel) Hinge Spacer on to the component, followed by the 1st Male Creasing Rib. Position the Metal Divider against the installed Male Creasing Rib. Then insert the 2nd Male Creasing Rib. Screw and tighten the collar and secure the 2x locking screws
3. Replicate the installation process on the 2nd TOP COMPONENT
4. **BOTTOM COMPONENTS**
   Insert the Male Creasing Rib followed by the 10mm Female (Double Channel) Hinge Spacer onto the component. Screw and tighten the collar and secure the 2x locking screws
5. Replicate the installation process on the 2nd BOTTOM COMPONENT
6. Align the top and bottom Male Creasing Ribs with their corresponding Female Channels

FOLLOW THE ABOVE GUIDANCE FOR EACH HINGE SPACER GAP: 10MM, 6MM, 5MM & 4MM

FOR 4-CREASE CONFIGURATIONS
(TRADITIONAL SPINE & HINGE CREASING)

(SETTING INSTRUCTIONS BELOW USING THE 6MM HINGE SPACER AS AN EXAMPLE)



1. Select the required Coloured Male Creasing Rib for the weight of cover stock being processed
2. **TOP COMPONENTS**
   Insert the 6mm Female (Single Channel) Hinge Spacer on to the component, followed by a Male Creasing Rib. Position the Metal Divider against the installed Male Creasing Rib. Then insert the Blanking Spacer. Screw and tighten the collar and secure the 2x locking screws
3. Replicate the installation process on the 2nd TOP COMPONENT
4. **BOTTOM COMPONENTS**
   Insert the Male Creasing Rib followed by the 6mm Female (Double Channel) Hinge Spacer onto the component. Screw and tighten the collar and secure the 2x locking screws
5. Replicate the installation process on the 2nd BOTTOM COMPONENT
6. Align the top and bottom Male Creasing Ribs with their corresponding Female Channels