Tech-Ni-Tips

August 2009

Global Leaders in creasing technology

Eliminating fibre cracking 100%

World Class Print Finishing Advice & Product Updates

Welcome to this month's newsletter. I have included a technical tip from America that came to us via our USA partners that I hope some of you may try on your saddle stitcher. The piece is entitled **'Reduce Double Sheets on Thin Signatures'**. If you give it a go please let me know how you get on as I will be interested to know if this tip works as well as the 'Bindery Doctor' indicates. Also included on the back page is probably **the best ever folding tip we have created**. We ran this enhancement procedure on **improving sheet register** in a newsletter three years ago and received a lot of positive feedback. We feel that now is a good time to repeat it, not only for the sake of new readers but also as a refresher to existing customers.

On a personal note I am delighted to report that Tech-ni-Fold are thriving in the area of development, so much so that we are preparing for the announcement of three new product launches in October. Of course we will keep you updated as it happens. Why not sign up at www.technifold.com for our online newsletter for regular print finishing hints and tips?

Finally, a friend told me recently that during economical downturns the printing industry is undoubtedly hit harder than most sectors, but the one ray of sunlight is that it has always been the first to recover and lead everyone out of recession – let's hope he is right and that this starts happening soon.

Graham Harris, Managing Director, Tech-ni-Fold Ltd

Tech-ni-Tip

Reduce Double Sheets on Thin Signatures

Although this tip came to us from the saddle stitcher arena, it's one that can be put to much wider use.

The Problem: When running a thin 4pp signature in a saddle stitcher feeder pocket (or any feeder pocket for that matter) it can be hard to control the vacuum so that you don't pull double signatures, especially on uncoated stocks. Too little vacuum and you don't pull a signature at all, increase it just a touch and suddenly you're pulling doubles again.

Most of the doubled sigs will just fall on the floor under the chain. That's really just a housekeeping problem but it does take time, especially if running a big job at high speeds. Bigger problems arise a few other ways: static can keep them attached and cause them to jam at subsequent pockets or at the stitcher heads, or they curl under and jam in the pocket itself before opening on the chain. And remember, the key to maximum production is continuous running, so every machine stop you eliminate brings you closer to that goal.

The Solution: this comes to us from our anonymous friend, the Bindery Doctor. Simply take a scrap piece of stitching wire, run it through the suckers as shown below:

This could easily be tried on any feeder that uses suckers. The Bindery Doctor claims it works like a dream (I haven't tried this one myself.) Let us know how you get on!

Snap up a Nifty
Table Top Creaser

If you are looking for a straightforward and easy to operate machine to take care of those smaller digital and Litho creasing jobs, the Speedcreasa could be just perfect for you. Although it requires the operator to hand feed sheets through the creasing shafts, due to its rotary nature it can still exceed the output speeds of rule and matrix versions. In fact hand feeding 3000–4000 sheets per hour is the average, depending on sheet size.

The machine has one Tri-Creaser Fast Fit included plus the option to add on cutting and perf options later. The machine is ideal for short run digital or Litho creasing from 1-5000 copies and is in very good working condition. Please call for more information or check out the details of the machine on our website - www.technifold.com.

To learn more about the Speedcreasa email graham.harris@technifold.co.uk

Top Tech-ni-Tip

How to greatly improve sheet register whilst creasing single sheet cover stock on your folding machine…

Producing quality creasing on your folding machine is one thing. Expecting the sheet to run through perfectly straight is another. Many factors can lead to sheet variance such as intermittent feeding, out of square side lay, uneven roller pressure setting, or incorrect deflector alignment.

Many years ago I devised a quick and easy method of make ready to eliminate most of these problems. It is not conventional and does not fall in line with textbook methods, but then again none of my solutions do.

Method

1. Place one strip of the material you are processing into roller calliper setting No. 1 and slitter shaft (exit roller).

2. Place five strips of the material you are processing in the entire roller calliper settings in between.

3. Make sure that folding roller No. 1 and slitter shafts are set even and sufficiently to the material being used.

4. Check alignment of side lay, making sure it is set squarely so that there is no obvious curtailing of the sheet as it enters No. 1 roller.

5. It is also important to align all the deflectors' level, as they will not be used to influence the squareness of the finished product.

6. With all these procedures carried out, run a sheet through the unit.

7. Check the squareness of the fold by hand folding the sheet down the line of the crease. If the fold is out of square, identify which side of the sheet is running through the slowest and then displace 1 strip from calliper roller pressure No 2 or No 3 that side until the extra grip influences the outcome. If the desired result is not reached displace more strips from roller calliper settings. Eventually, through careful checking, the sheet should run through perfectly straight.

The idea behind this method is not as crazy as you may think. Why? – The No.1 roller is adequate enough to grip the sheet and guide it through to the exit shafts without interference from the rollers in between. After all they do not really serve much of a purpose when not being utilized for folding do they?

I can guarantee that this method of practice will greatly enhance the quality of the finished job and will speed up make ready times considerably. It is a technique that I found effective 85% of the time. It is fair to say that in 15% of cases normal set up procedure is sufficient.

Crease & Perf Those 6pp Mail Shots And Leaflets

Wouldn't you like to have the choice to produce letterpress quality creasing and perforating on your folder in one pass? Are you fed up of sending those 6pp mailers and leaflets that require tear-off order forms straight out for outsourcing? Well you may be surprised to learn that replicating the perfect cylinder crease and perf is now so simple to carry out **and** it will save you all those expensive outsourcing costs and unwanted "bottle necks" in productivity.

To carry out creasing and micro-perforating in this way you will need 2 separate devices, the micro-perforator and the Tri-Creaser Fast Fit.

The Micro-Perforator produces flat and almost invisible 17, 25 & 52 teeth per inch cuts in 65-350gsm stock ranges to replicate quality letterpress methods.

Here are just a few benefits of our Micro-Perforator…

- Produces flat and almost invisible micro-perforations to cater for a full range of material, so good that the perfed sheets can easily run through laser printers
- Eliminates outsourcing of micro-perforating
- Allows you to handle jobs you used to turn away
- Simple installation
- Requires no special operator skills
- Runs alongside Tech-ni-Fold's or other manufacturer's devices

The Tri-Creaser Fast Fit is our very latest creasing innovation and benefits from our new patented split creasing ribs that can be applied to the male component's locking chamber while it is still mounted on the machine's shaft.

So, if you're looking to eliminate crease and perf outsourcing and save time and money go to the distributor section of our website to contact your local Tech-ni-Fold representative and find out more
www.technifold.co.uk/global-distribution-network


Micro-Perforator


Tri-Creaser Fast Fit