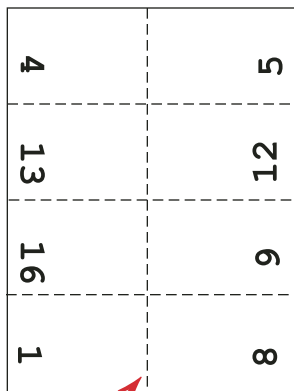


Some Tips & Shortcuts For Better 16 Page Signatures



The Layout: A standard 16pp signature running 1 fold in the parallel section, plus 1 fold in each of the 2 right angle sections.

- **Don't use a score** on the spine in the 8pp section. As long as the head is perfed in the parallel section, the last fold in the 16pp section will not need to be scored in the 8pp section—no matter the stock.

- **If you need to trim the sig for the stitcher, do it on the folder,** not the cutter. Leaving the original guide and gripper edges on will dramatically improve registration quality, cross-overs and folding on bleeds (as long as the operator follows the guide and gripper edge!)

- Now if you know the stock you're running is inconsistent in squareness and trim, and generally just a really bad sheet, and you just have to buy the cheapest stock on earth, take the time to trim it on the guillotine

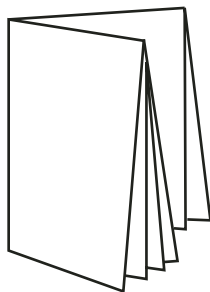
before you print it. This gives both the pressman and the bindery a fighting chance to produce a job that registers in print, folding and stitching.

Most pressman I know are pretty clever and can jam almost anything through a press. But then in their sadistic glee, it gets passed to the folder operator who hopelessly chases register sheet to sheet.

The pressman says, pointing to the consistent side guide marks, "look, it registers so don't blame me," not realizing that the folder registers to the entire side of the sheet, not just the single point of register as on the press. Hence an inconsistent, out-of-square sheet = a different fold position on every sheet.

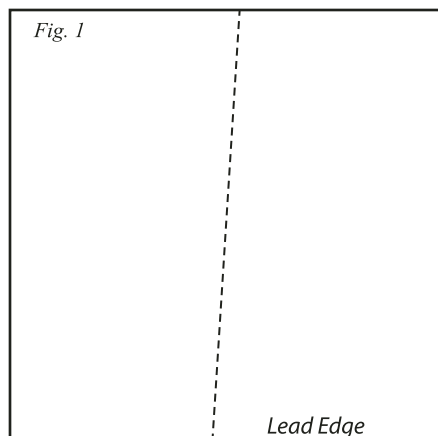
- **Focus troubleshooting efforts in the main parallel section** (this is related to the previous tip.) If the sheets coming off this section are folded square and in register, and if the perf is consistently straight, you'll rarely have to re-set anything in the 8 or 16pp sections.

Put a perf here at the head, and you won't need a score on the spine.



The Perf...critical to success when using the 16pp imposition above.

Some common problems and solutions. (Diagrams illustrate sheet after the first fold, as it exits the slitter shafts in the parallel section.)



Perf Not square: (Fig. 1)

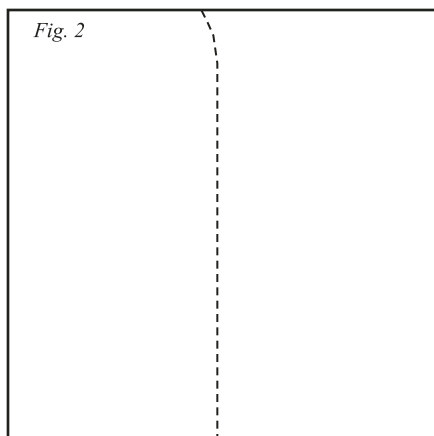
If the perf is not square, and it's consistent in position, and the fold is consistently good, then check these...

FIRST STEP

- 1) Be sure the fold roller calipers are sheeted correctly.
- 2) Check fold roller and slitter shaft tension.

SECOND STEP

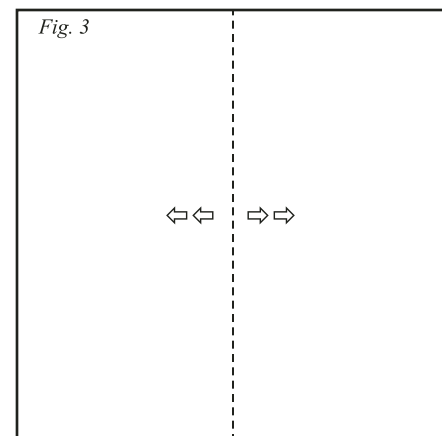
If this doesn't fix the problem, drop the deflector plate on the side of the sheet that you want to slow down. For example, in the above diagram you want to slow the left side. Assuming we're



using Fold Plate #1, we can drop the left side deflector (opposite operator side) on plate #2, 3 or 4, pulling away from the fold roller. And if you find a large amount of adjustment is needed, you'll get better results if you make small adjustments to 2 or 3 plates, instead of making one large adjustment.

Perf Tails Off at Trailing Edge: (Fig. 2)

- 1) Check slitter shaft tension on pull out wheels. Check fold rollers too.
- 2) Use *fewer* pull-out wheels. One pair on either end of the sheet may be all you need.
- 3) Check that perf blade is mounted with the bevel edge facing the next fold section.

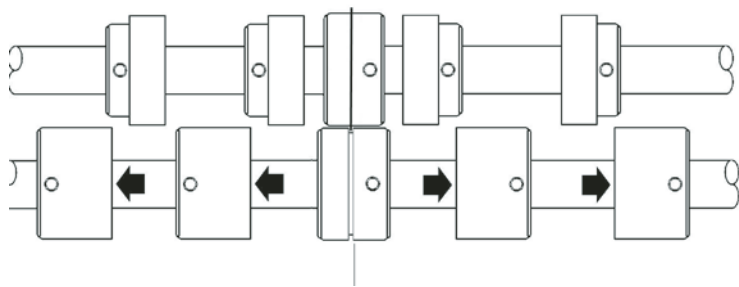


This is the "conventional" setup that usually works best. Of course, there's an exception to every rule, so try it out the opposite way too! Also be sure the perf blade holder is on the shaft correctly so that it doesn't loosen during rotation.

4) Be sure perf blade and counter knife are in good condition and that you have a perf stripper in place next to the perf blade.

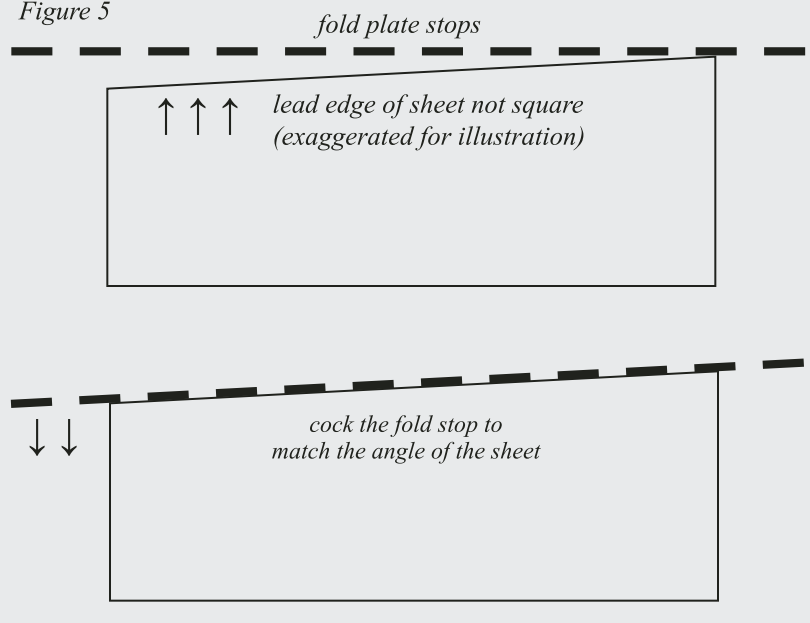
5) If the problem remains, try offsetting the pull-out wheels as shown in **Fig 4** on the next page...

Figure 4 (continued from page 1)



Try offsetting the pull-out wheels as shown to counteract the "tailing" effect common with many conventional folding machine perfs and scores. Note: this is not an issue with Technifold devices.

Figure 5



Perf Is Inconsistent, Jumps Around (Fig. 3 above)

1) **Check fold consistency.** If the fold is not consistently square, the perf will appear to move from side to side or will seem to be out of square, when in fact it's the fold that is moving. So be sure you've got this licked before moving on. Check all the usual fold troubleshooting items first.

2) **Check the paper itself** for inconsistent size and squareness at the guide and gripper edge. Variation here can send the operator on a fruitless quest for consistency but there are a couple of things that can be done.

- If the lead edge is angled but is consistently so, then try this:

a) Run a sheet through at slow speed or by hand, making sure that it is against the side lay, and that as it runs through fold roller # 1 it is going perfectly straight.

b) Stop the sheet as soon as one corner of the sheet hits the fold stops.

c) Carefully angle the fold stop to match the sheet (Figure 5)

d) Run a sheet and adjust fold as necessary. The end result should be a far more consistent, accurate fold than what you get with a small corner of the sheet taking all the force.

Dog Ears at the head along the perf?



Lengthen the fold stop (in the 8pp section) on the side of the sheet where the dog ear is happening, as if we were going to force the fold longer on that side only.

Alternative Impositions to Right Angle 16 pagers

Instead of automatically running a 16pp signature in a right-angle imposition, consider alternative layouts such as **parallel folds**, especially when the books are smaller than 8.5 x 11.

For instance, you can run a 4x9 book on a 23x35 sheet, 2-up as a parallel 16pp signature. Slit it on the folder (or on the stitcher, if equipped for that.)

This layout is 3 folds in the parallel section only--for instance use plates #1, 2 and 3. For clarity's sake, the trim for the lip is not shown here.

The benefits?

Improved registration, especially great for jobs with crossovers on every page. With this layout, every page will line up (as long as the art and press back-up are good, of course.)

Much Faster run speeds not limited by right angle cross-carrier constraints.

Save paper. Depending on the size you will often get more out of a sheet.

8	9	16	1	4	13	12	5
8	9	16	1	4	13	12	5

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