Instruction Guide
Spine-Hinge Creaser
to fit
Muller Perfect Binders
QC-DEL-MPB/30-FP-5

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.

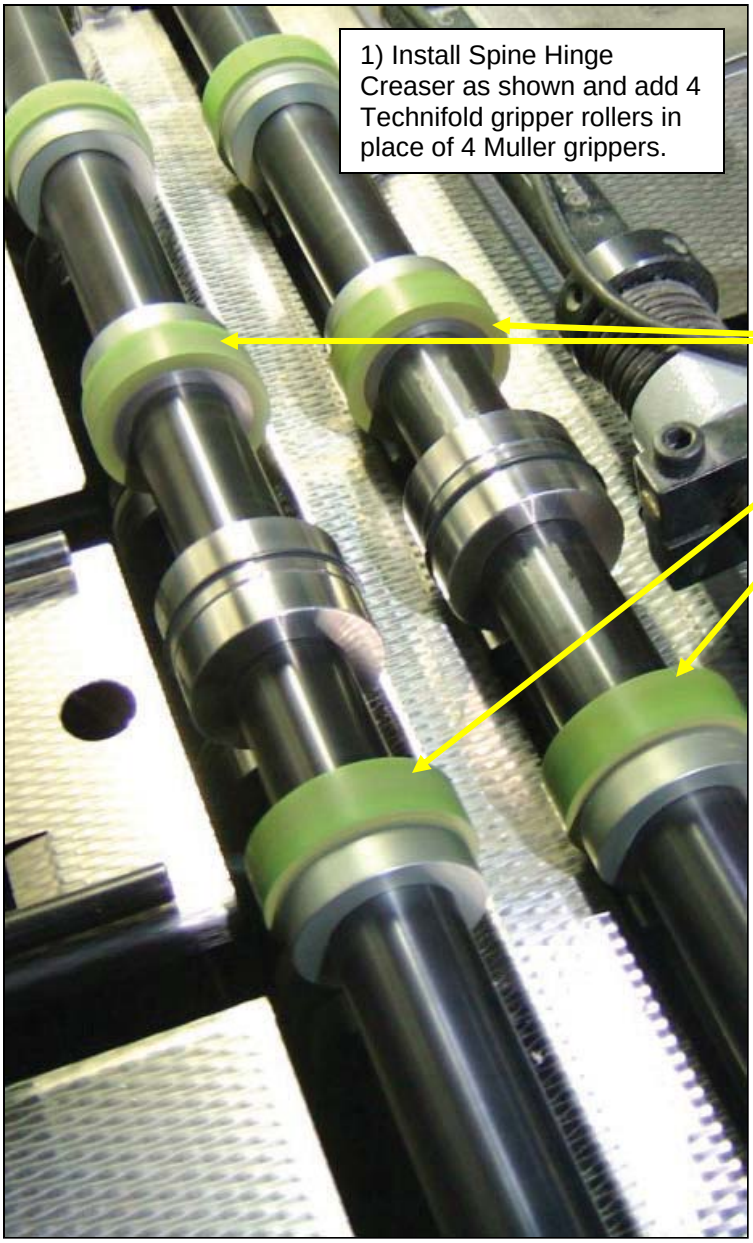
Be sure the cover feeder shafts are clean and free of burrs, and never, ever force anything! Everything should be moved with a finger touch—if not, there is something wrong!

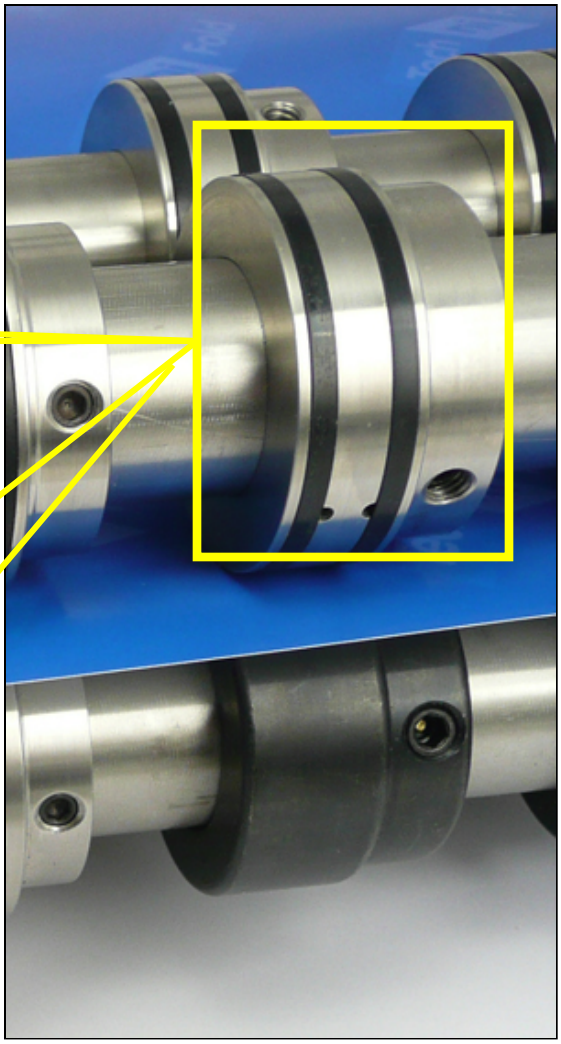
If you have any questions or are not getting the results you expect email techsupport@technifoldusa.com
or take a look at the FAQ and Tech Support page:
http://www.technifoldusa.com/faqs-support/

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 within a few hours or less, the same business day.

1) Install Spine Hinge Creaser as shown and add 4 Technifold gripper rollers in place of 4 Muller grippers.





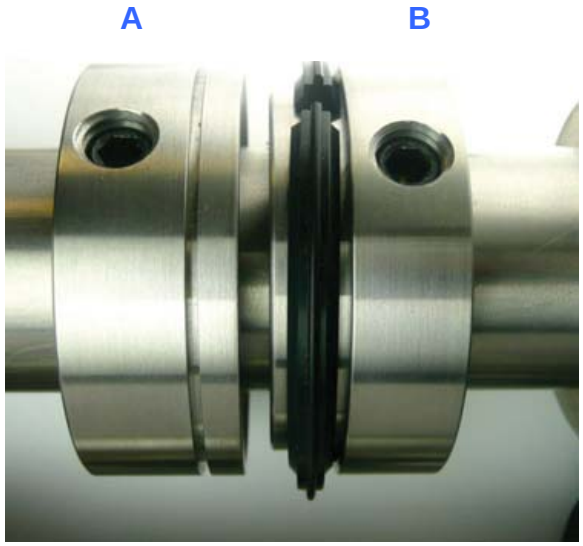
2) Insert desired creasing ribs into all 4 components. To do so, loosen allen screw in A, slide part away and insert rib. Push components back together and retighten A.

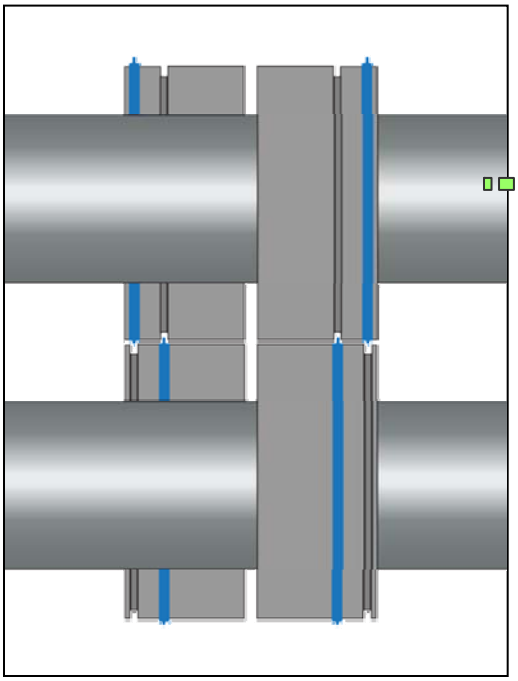
3) Jog a sheet up to creasing tools and position components on the bottom shaft only.

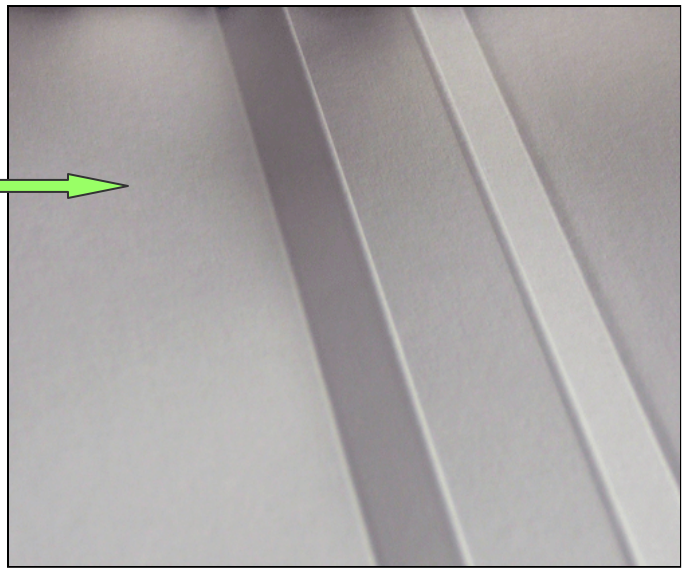
4) Carefully lower top shaft so upper creasing tools line up with bottom creasing tools. DO NOT TIGHTEN allen screws yet.

5) Jog a sheet of cover stock through creasing tools to center the upper components. With the sheet still gripped by the tools, tighten allen screws A and B.

6) Jog a sheet through and check that creases are centered and that they are the correct depth.

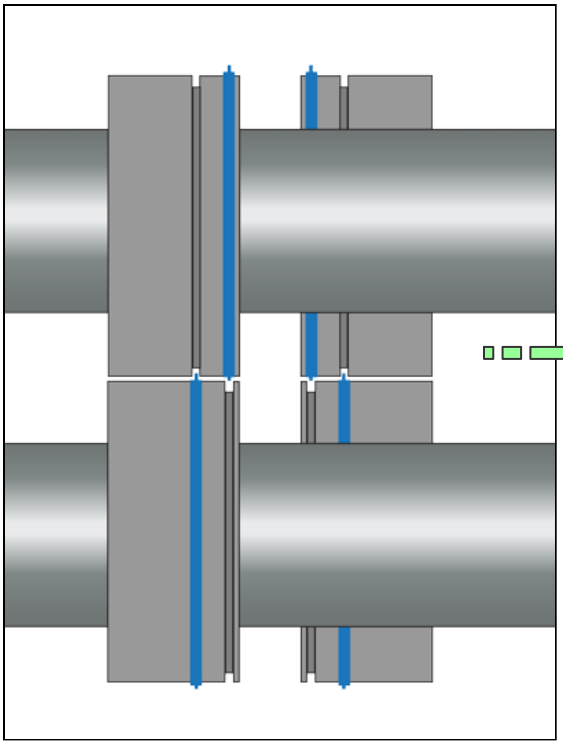






Reverse Crease Setup

Position tools as shown above to produce creases as shown at right, where the male is creasing into the outside of the cover's spine. This is considered the 'correct' way to get best results in order to eliminate fiber cracking. (Tools shown are for illustration purposes and may not match your actual creasing devices.



Position tools as shown at left to produce creases as shown at right, where the male is creasing into the inside of the cover's spine. This is the 'conventional' way to score.

Tips on Selecting the Right Creasing Rib

Think of your new Spine & Hinge Creaser as a device that gives you more control over how your perfect bound book covers will look and perform. Here are some brief suggestions.

If fiber cracking is not a problem with the stock you are running, start with the yellow nylon creasing ribs. 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.

For lighter stocks below 100# cover you may have to switch to the Pink M-41 creasing ribs.

If you expect fiber cracking to be a problem, then select one of the 2 types of rubber creasing ribs included with your new kit. Use the rubber Pink M-41 for 100-280 gsm (about 60# cover through 100# cover.) Use the black M-86 rubber ribs for heavier stocks.

** Important ** 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 OR you should switch to a lighter (thinner) creasing rib.

The outside of the crease should also be smooth and free of cracking or tearing.

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.

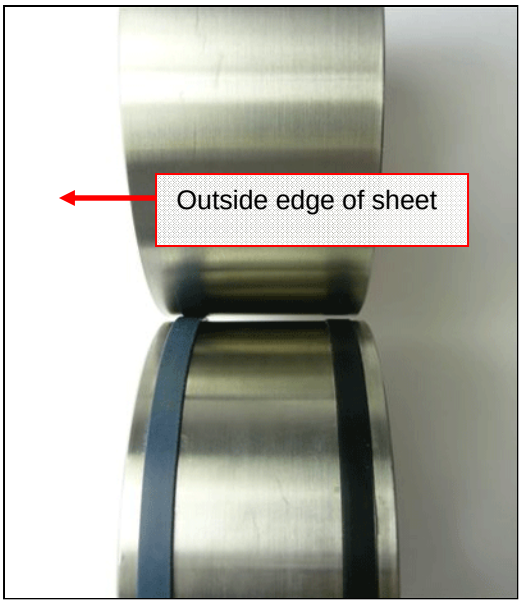
If you run a wide range of paper stocks, initially this will take a little work but it's well worth it the long run.

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

Running Laminated Stocks

Use the yellow nylon ribs for laminated stocks. For lighter laminations, you can also purchase a set of Red Nylon Creasing Ribs, part # QC-DEL-MPB/PC-R.

Optional Gripper Band Technique



Optional Gripper Band Technique

The Blue M-62 gripper band has a larger outside diameter than the black M-51 band. While most jobs will be OK using the black gripper band, you may need to use the blue gripper band if the grip isn't sufficient with the black band.

Here is a technique to quickly get the correct pressure on the gripper rollers without having to change the gripper bands.

Install one blue and one black band on each gripper roller. The blue band should be towards the outside edge of the cover. *(Photo shows gripper rollers set for left side of sheet. The right side of the sheet should be set up the opposite way.)*

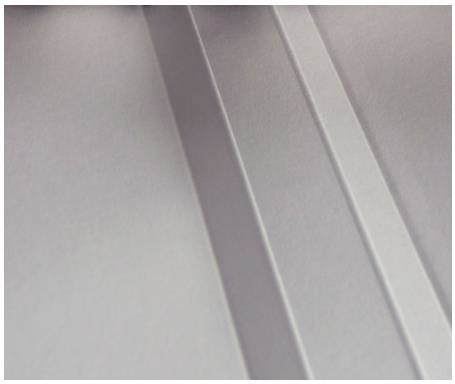
For normal jobs requiring the black band, position the gripper roller so only the black band is contacting the sheet.

If you have a satisfactory gap between male and female creasing units but you are losing grip on the sheet, use the blue gripper band by moving the gripper rollers inward.

Then when you go back to creasing a lighter sheet, simply move the gripper rollers outward so only the black band is gripping the sheet.

Frequently Asked Questions
for the Spine-Hinge Creaser to fit Muller

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 crease settings. 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.

What range of papers can I crease?

In general, the Spine-Hinge Creaser should work on stocks from about 60# cover up through 16pt. Paper varies substantially so feel free to experiment no matter what type of paper stock you are running.

For Technical Support
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or visit http://www.technifoldusa.com/faqs-support/

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