# How to greatly improve sheet register and decrease curl while 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 Graham Harris, the inventor of the Tri-Creaser, devised a quick and easy method of make ready to put to rest most of these problems. It is not conventional and does not fall in line with textbook methods, but then again none of his solutions do.

## Method

1. Place **one strip** of the material you are processing into fold roller caliper settig No. 1 and 1 sheet into the slitter shaft (exit roller) caliper.
2. Place **five strips** of the material you are processing in all of the roller caliper settings in between (#2 – 5)
3. Make sure that folding roller No. 1 and slitter shafts are set evenly and correctly for 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, fully pushed into the stops, 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 remove 1 strip from the caliper for roller No 2 or No 3 that side until the extra grip influences the outcome. If the desired result is not reached, remove more strips from the roller caliper 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? NOTE: the sheet must be long enough to be gripped by the slitter shaft before the tail of the sheet leaves roller #1—this will vary depending the size of the folding machine.

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 also helps to reduce curl. 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.

**Technifold USA**
Phone 973-383-7920
info@technifoldusa.com