



Instructions, Operating Tips, and FAQ's for the CP Applicator (for all folding machines)

For Technical Support:
email: info@technifoldusa.com

To order parts online:
<http://store.technifoldusa.com>
or Call 973-383-7920 M-F 10-4 eastern





A Threaded Collar

This locks perf blades, creasing ribs, and spacers into place. When the unit is installed on the top shaft, the set screw faces towards the operator. Reverse for the lower shaft.

B Floating Blade Holder

The second perf blade mounts on this movable (floating) holder.

C Floating Crease Holder

One of the 3 color-coded creasing ribs mounts on this movable rib holder.

D Spacer Rings

There are 2 sets of identical spacer rings on each side of the adjustable crease holder. Each spacer set consists of 1 ea. 6, 5, 4, 3, 2, and 1mm widths. Use these to adjust the space between perfs and the score.

E Nylon Sleeve and Holder

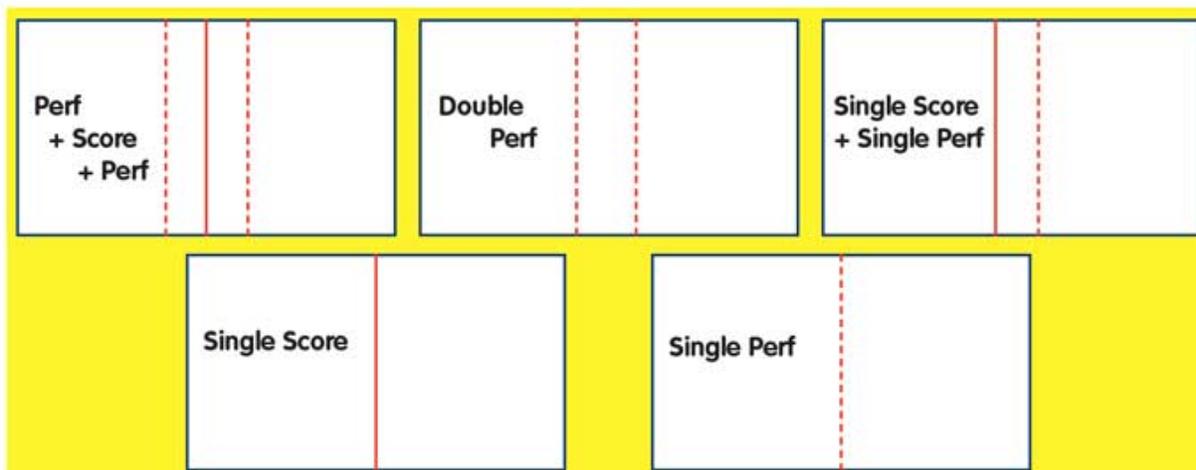
The perforation cuts gently into the nylon sleeve, producing a flat, fine perf. The blue and black anvils each have different diameters. Blue is used for heavier paper.

F Color Coded Females

3 ea. Color coded females correspond to the creasing rib colors.

CP Applicator Setup Instructions

Your CP Applicator can be set up to run in any of the following configurations:



Step One

Select the configuration you need for the job and install the necessary perf blades, creasing rib, and ALL spacers. Use the Selection Guidelines below as a starting point to pick your perf blade, nylon anvil, and creasing rib. Tighten the assembly with the threaded collar.

Remember that each spacer in each set is a different thickness. You have a total of 12 spacers—2 each of 6mm, 5mm, 4mm, 3mm, 2mm, and 1mm. In other words, there are 2 different sizes for each color so you want to be sure to get the correct width spacers on either side.

Perf Blade + Nylon Anvil Selection

52tpi + Black anvil Use for any light stocks 7 pt or less (65-100gsm.)

25tpi + Black anvil Use for 6-8pt (100-170gsm)

17tpi + Black anvil Use for 6-10pt (130-280gsm)

17tpi + Blue anvil Use for approx. 10pt + (250-350gsm)

Nylon Anvil Guidelines

The **Black Anvil** is used on
65-280gsm

The **Blue Anvil** is used on
250-350 gsm.

Important

The Blue anvil has a larger Outside Diameter than the black anvil. As you run heavier stocks, you will open up the slitter shafts to compensate for extra thickness. The extra diameter on the blue helps to compensate for the bigger gap.

The 17tpi blade also has a larger Outside Diameter than the 25tpi and 52tpi blades, again to compensate for thicker sheets.

These guidelines are suggested starting points and there is no exact right or wrong setup. There is a bit of gray area so feel free to experiment to see what works best for your jobs.

Creasing Rib selection for Single Sheet Work

Orange rib for paper equal to or lighter than about 8pt, 65# cover, or 200gsm

Blue rib for light to medium covers, 7-14pt, 60# - 100# Cover, 150-270gsm

Yellow rib for heavy stocks, 10pt-16pt, 80#-120# cover and up, 220-350gsm

To prevent fiber cracking, always crease with the male into the face of the folded piece.

Creasing Rib + Female Guidelines

Creasing rib color corresponds to female channel color. (Orange to orange, etc.)

For slightly narrower creases, you can also run the yellow rib in the blue female, the blue rib in the orange female.

For slightly wider, try the blue rib in the yellow female or the orange rib in the blue female.

Creasing Rib Selection for Multiple Sheet Work

Test as needed for best results. In this case you may end up using the creasing component in a conventional fashion by scoring into the inside of the folded piece. There is no right or wrong way here—test!

Start by using corresponding colors. You can also try the slightly narrow or slightly wider crease options mentioned in the box above.

Step Two

Carefully open up the slit shaft and slide the female channel into place under the creasing rib. Don't lock the set screw yet!

Step Three

With the nylon perf anvils off to the side, hand crank a sheet of cover stock through a revolution or two. This will automatically center the female under the rib.



Now, while the sheet is still between the male and female, tighten the set screw on the female. It should be locked into a centered position. You can run a sheet to check this. If it's centered correctly, you'll have a smooth, rounded bead on the inside of the fold.

Step Four

Back off the pressure on the slitter shaft calipers. You can do this in one of two ways:

- 1) Add a few extra sheets of thin paper such as 20# bond to the calipers (beyond what you need for the job) or
- 2) Manually adjust the dial on the calipers to reduce pressure.

Once you use your CP Applicator a few times, this part will be easy. You'll know exactly how much pressure to remove. In the beginning, have a little patience with this extra step. It pays off in high quality perforations!



Step Five

Once the female is centered and locked, move the nylon anvils into position underneath the perf blades.

Manually open up the slitter shaft gap and carefully slide the anvils into place. If you forget to do this, you can damage a perf blade or create a flat spot on the nylon anvil. Flat spots or dents are to be avoided because they will affect the quality of the perforation.

Positioning the Set Screws

For the most consistent perforating results, position the set screws so that when one set screw is at a 12 o'clock position, all set screws are at 12 o'clock. The photo at right illustrates the idea. (The components in the photo aren't in their final position—they're separated for clarity in illustrating the direction of the set screws.)



Once in position, add a perf stripper next to the unit to prevent paper from wrapping around the perf blades. You may not need a stripper on cover stocks.

Step Six

Run a sheet to check position and to check how well the perf is cutting. At this point, it should NOT be cutting, or only cutting very slightly.

Add a bit of pressure. (Do this manually or remove one of the extra sheets, depending on your preference.) Run another sheet and check.

Repeat the process as necessary until you are satisfied with the quality of cutting on your perforation(s).

Once you have a good sheet, run 15-20 sheets and check the perf again. If it's still good then you are ready to run. If not, add a bit more pressure and run another 10 sheets or so and check it again.

This technique ensures you are using the minimum pressure needed to get a good perforation. This will keep your perforations flat and clean. It will also extend the life of your nylon anvils.

Check the perf (and score) periodically during the run and adjust as needed. Typically if you follow this careful setup procedure you won't have to make any adjustments for a long time.

Frequently Asked Questions – CP Applicator

What's the best perf blade to use for tear-off pages in signature work?

Start with the 17 or 25tpi blade when running 8pp, 12pp or 16pp work with tear-off pages. It depends on the paper caliper, grain direction and density. If you need a coarser perf, we have 10 and 12tpi perf blades available for some CP Applicators.

What's the maximum thickness (caliper) of paper I can cut through using your perf blades?

52tpi maximum is about 7-8 pt.

25tpi maximum is about 12 pt.

17tpi maximum is about 14 pt.

Yet as you know, most maximums and minimums in bindery work can be exceeded. So be sure to test. If it works and is acceptable to your customer, then use it.

For thicker paper, we have other perf blades available that will add a few thousandths of an inch to the maximum.

When doing signature work, how many sheets of paper can the perf blades cut through?

Add up the combined thickness of paper in your signature and check against the maximums listed above. If your signature is thicker, then ask us about our extra deep or "4-sheet" perf blades designed for signature work.

For instance if you are running a 16-page right angle signature with tear-off pages, you'll need to perf through 4 sheets in the right angle section. A 50 or 60# text will be about .016" and the 4-sheet blade will handle that depth.

Can I do single perfs or scores with the CP Applicator?

Yes. Download the instruction guide for a diagram of all possible production configurations. You can score, or perf, or any combination of score + perf.