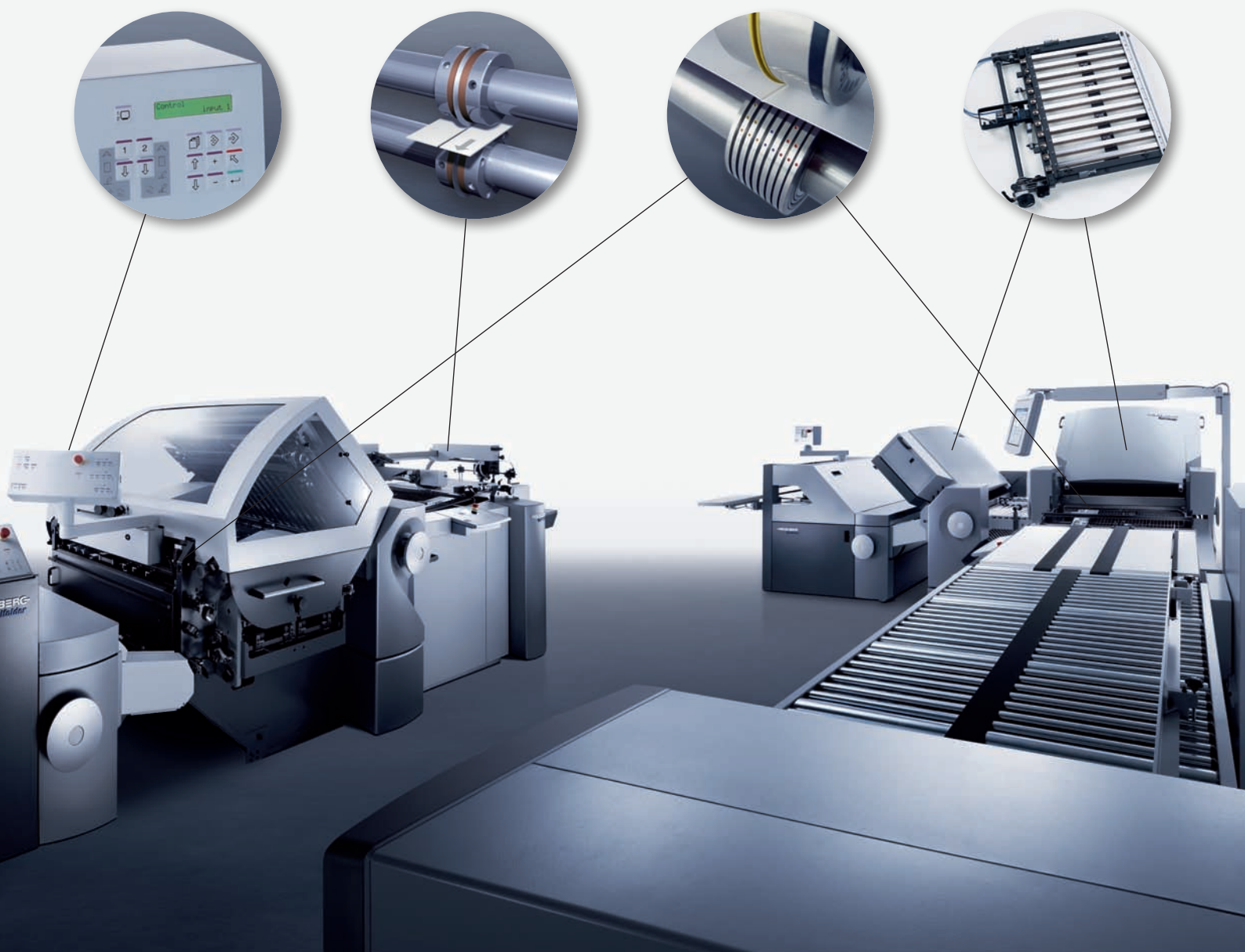




Systemservice

HEIDELBERG

Stahlfolder Retrofit Options

More Functions for Your Stahlfolder. Retrofit Options.

Have your customers' requirements changed? Are you looking to extend your range of functions or replace components? Or would you like to find out more about optimizing your production operations?

Our catalog contains commonly requested retrofit options, structured clearly according to machine type along with article numbers for obtaining further details.

Use our retrofit options to enhance the productivity and flexibility of your postpress operations.

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ACC 2.4 digital controller

Controls the pneumatically operated FFP gatefold buckle plate, glue guns, and EAP heads for timed perforations. The ACC 2.4 digital controller developed by Heidelberg® combines flexible functions with incredible ease of use. It controls the inline processes of gatefolding, gluing, and timed perforation, which create significant added value. Thanks to its flexibility, the ACC 2.4 digital controller offers users a considerable financial advantage over conventional controllers that are designed for one application only. The controller is operated using simple buttons that are well laid out and feature clear symbols.

A retrofit kit is available for all folding machines and stations without an encoder. As a result, users of older folding machines now also have access to this extra added value.

The ACC 2.4 digital controller consists of a control unit, a support, an air and power supply, and an encoder connection.



ACC 2.4 digital controller.

Gluing with the ACC 2.4 digital controller

Intermittent glue lines, variable spot gaps and sizes, and in-plate cold glue guns for auxiliary gluing without segmenting the folding rollers. Cold glue should preferably be used if permanent bonding is required. The ACC 2.4 digital controller enables two contact-free spot gluing guns to be used intermittently. This extends the production options to include, for example, envelopes, photo pockets, and insert pockets.

Gluing attachments help increase the folding machine's added value, open up additional market segments, and improve the handling of intermediate products.

- 8-, 12-, and 16-page brochures are produced inline in a single operation.
- Mailings with different types of folds are sealed ready for postal delivery.
- Production of lottery tickets.
- Auxiliary gluing for finishing covers and folded sheets with flaps for optimizing postpress operations on saddlestitchers or adhesive binders.



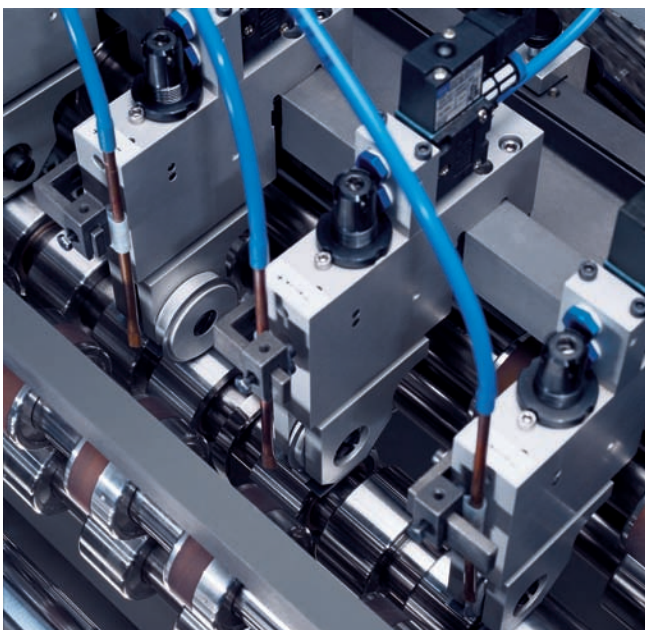
Intermittent glue lines, variable spot gaps and sizes, and in-plate cold glue guns for auxiliary gluing without segmenting the folding rollers.

EAP timed perforations

Timed operations extend the range of cutting and perforating applications and enable, for example, simple shaped/angled perforations. Timed perforation thus opens up a whole host of attractive mailing options. Mailings designed to generate a response often include a detachable reply card. To execute the required angled perforation, there must be a pair of front-mounted slitter shafts on both the first and second folding stations. The timed perforators are mounted on a swing crossbar instead of the upper slitter shaft and are available as start-and-stop perforators with precise adjustment, but also as heads for double or multiple lines.

Start-and-stop perforators can be set for any timed perforation length, thereby making timed cutting of windows and sheet sections easy. The ACC 2.4 digital controller is used for timed perforation and cutting, resulting in outstanding efficiency and significant cost savings in everyday operation.

Timed perforation with EAP heads opens up a variety of new, attractive, and yet cost-effective product options that satisfy customers' need to stand out and improve rates of return.



Using the ACC 2.4 digital controller cuts the investment cost required to produce attractive products.

2. Pneumatically operated FFP gatefold buckle plate

Pneumatically operated FFP gatefold buckle plate

Extremely easy to use, short setup time, minimal flap gap of just 0.5 to 1.0 mm (0.02 to 0.04 in), and 15,000 cycles per hour in continuous operation. The six/eight-page gatefold is popular with designers, but bookbinders needed a great deal of experience and an instinctive feel to produce this type of fold with the previously available folding technology while also ensuring compliance with deadlines and good fold quality. Bookbinders who failed to keep to the specific sequence of settings often did not achieve the desired result.

The digitally controlled gatefold attachment from Heidelberg enables:

- Minimal flap gaps of just 0.5 to 1.0 mm (0.02 to 0.04 in)
- 15,000 cycles per hour in continuous operation
- Highly straightforward operation

The ACC 2.4 digital controller precisely controls the switching times for the gatefold buckle plate, independently of the folding speed. The deflecting profile

has minimal contact with the flap on the folded sheet. This eliminates the friction that used to lead to double folding.

The digital controller automatically determines the switching points for the gatefold with the pneumatically operated FFP gatefold buckle plate once the fold lengths for the first and second folds have been entered.

Retrofitting of existing equipment is possible as long as it has an encoder or one is retrofitted.



Pneumatically operated FFP gatefold buckle plate.

Stahlfolder TH/KH, pneumatically operated FFP 56 gatefold buckle plate

Description	Designation	Article no.
For PFH pallet feeder/FFH flat pile feeder Not automated	Pneumatic gatefold buckle plate ¹	FH.1072930/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161955/02
For PFH pallet feeder/FFH flat pile feeder Automated	Pneumatic gatefold buckle plate ¹	FH.1072930/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161965/02
For RFH round continuous feeder	Pneumatic gatefold buckle plate ¹	FH.1072930/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161975/02
For 2nd/3rd/4th folding station	Pneumatic gatefold buckle plate ¹	FH.1072930/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161945/02

Stahlfolder TH/KH, pneumatically operated FFP 56 gatefold buckle plate with 2 spindle drives

Description	Designation	Article no.
For PFH pallet feeder/FFH flat pile feeder Automated	Pneumatic gatefold buckle plate ¹	FH.1072960/02
	plus ACC 2.4 digital controller, incl. support ²	FH.1161965/02
RFH round continuous feeder	Pneumatic gatefold buckle plate ¹	FH.1072960/02
	plus ACC 2.4 digital controller, incl. support ²	FH.1161975/02
For 2nd/3rd/4th folding station	Pneumatic gatefold buckle plate ¹	FH.1072960/02
	plus ACC 2.4 digital controller, incl. support ²	FH.1161945/02

2. Pneumatically operated FFP gatefold buckle plate

Stahlfolder TH/KH, pneumatically operated FFP 66 gatefold buckle plate

Description	Designation	Article no.
For PFH pallet feeder/FFH flat pile feeder Not automated	Pneumatic gatefold buckle plate ¹	FH.1072940/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161955/02
For PFH pallet feeder/FFH flat pile feeder Automated	Pneumatic gatefold buckle plate ¹	FH.1072940/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161965/02
For RFH round continuous feeder	Pneumatic gatefold buckle plate ¹	FH.1072940/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161975/02
For 2nd/3rd/4th folding station	Pneumatic gatefold buckle plate ¹	FH.1072940/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161945/02

Stahlfolder TH/KH, pneumatically operated FFP 66 gatefold buckle plate with 2 spindle drives

Description	Designation	Article no.
For PFH pallet feeder/FFH flat pile feeder Automated	Pneumatic gatefold buckle plate ¹	FH.1072970/02
	plus ACC 2.4 digital controller, incl. support ²	FH.1161965/02
RFH round continuous feeder	Pneumatic gatefold buckle plate ¹	FH.1072970/02
	plus ACC 2.4 digital controller, incl. support ²	FH.1161975/02
For 2nd/3rd/4th folding station	Pneumatic gatefold buckle plate ¹	FH.1072970/02
	plus ACC 2.4 digital controller, incl. support ²	FH.1161945/02

Stahlfolder TH/KH, pneumatically operated FFP 82 gatefold buckle plate

Description	Designation	Article no.
For PFH pallet feeder/FFH flat pile feeder Not automated	Pneumatic gatefold buckle plate ¹	FH.1072950/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161955/02
For PFH pallet feeder/FFH flat pile feeder Automated	Pneumatic gatefold buckle plate ¹	FH.1072950/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161965/02
For RFH round continuous feeder	Pneumatic gatefold buckle plate ¹	FH.1072950/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161975/02
For 2nd/3rd/4th folding station	Pneumatic gatefold buckle plate ¹	FH.1072950/01
	plus ACC 2.4 digital controller, incl. support ²	FH.1161945/02

Stahlfolder TH/KH, pneumatically operated FFP 82 gatefold buckle plate with 2 spindle drives

Description	Designation	Article no.
For PFH pallet feeder/FFH flat pile feeder Automated	Pneumatic gatefold buckle plate ¹	FH.1072980/02
	plus ACC 2.4 digital controller, incl. support ²	FH.1161965/02
For RFH round continuous feeder	Pneumatic gatefold buckle plate ¹	FH.1072980/02
	plus ACC 2.4 digital controller, incl. support ²	FH.1161975/02
For 2nd/3rd/4th folding station	Pneumatic gatefold buckle plate ¹	FH.1072980/02
	plus ACC 2.4 digital controller, incl. support ²	FH.1161945/02

¹ and ² must always be ordered together.

Turn buckle plate for Stahlfolder KH combination folding machines

The new turn buckle plate can be used in the cross-fold unit instead of the KTL buckle plate. Using the turn buckle plate extends the folding machine's processing options, enabling folds to be produced that are otherwise only possible with the KZ cross-fold unit or a mobile VFZ four-directional folding unit.

Operation • After passing through the cross-fold unit, the whole of the folded sheet enters the turn buckle plate and is ejected again by a pneumatically controlled sheet stop. The sheet is then turned and transported open side first under the second cross-fold knife. Turning the sheet means it is folded in the opposite direction to the usual one in the second cross-fold unit. This creates a different fold layout that was previously only possible with a KZ combination folding machine (additional knife on the drive side) or a KL/KTL combination folding machine with a mobile VFZ four-directional folding unit after the first cross-fold unit.

The following fold types are now also possible with a KTL or KTLL machine:

- 16-page newspaper fold (with KTL)
- 32-page German four-directional fold (with KTLL or KTL with four-directional folding unit)

The fact that the folded sheet is turned in the turn buckle plate means that a slightly larger distance is needed between sheets. As a result, the production speed is somewhat slower than with the KZ version.

The turn buckle plate is a cost-effective alternative if you require a relatively small number of the above-mentioned fold types. For long runs, we still recommend a Stahlfolder® KZ combination folding machine.

With the turn buckle plate, Heidelberg now offers a much more cost-effective alternative that enables any KTL cross-fold unit to also cover the fold types executed by the KR version. Depending on the number of folding jobs requiring the above-mentioned fold types, the alternatives of the Stahlfolder KH 82 or the Stahlfolder KH 78 in the KZ model or the KTL model with turn buckle plate are now also available.

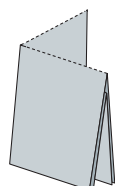
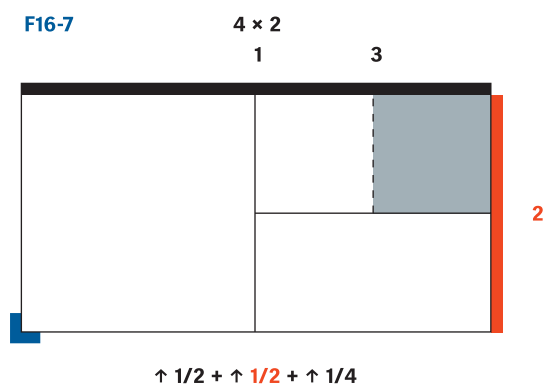
Retrofitting • A support complete with wiring and an ACC 2.4 digital controller with a free connection (or link kit for connecting several ACC 2.4 digital controllers) are required to retrofit existing equipment with the turn buckle plate.

3. Turn buckle plate for Stahlfolder KH combination folding machines

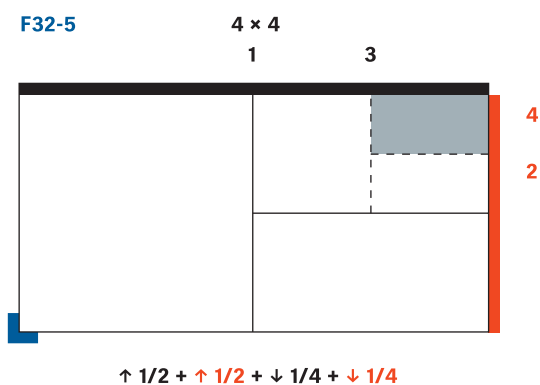
The turn buckle plate retrofit can be ordered under the following article numbers:

Folding machine	Feeder	Automation	Article no. for ACC 2.4 digital controller support, wiring, and pneumatics	Article no. for turn buckle plate
Stahlfolder KH 56 Compact	Flat pile feeder	Yes	FH.1299765/00 +	FH.1211800/01
		No	FH.1299755/00 +	FH.1211800/01
	Round continuous feeder	Yes	FH.1299775/00 +	FH.1211800/01
		No		
Stahlfolder KH 66 Compact	Flat pile feeder	Yes	FH.1299765/00 +	FH.1211800/01
		No	FH.1299755/00 +	FH.1211800/01
	Round continuous feeder	Yes	FH.1299775/00 +	FH.1211800/01
		No		
Stahlfolder KH 78 Compact	Flat pile feeder	Yes	FH.1299765/00 +	FH.1299700/00
		No	FH.1299755/00 +	FH.1299700/00
	Round continuous feeder	Yes	FH.1299775/00 +	FH.1299700/00
		No		
Stahlfolder KH 66	Flat pile feeder	Manual TBP*	–	FH.1233900/01
		Automatic TBP*	–	FH.1211600/01
	Round continuous feeder	Manual TBP*	–	FH.1233900/01
		Automatic TBP*	–	FH.1211600/01
Stahlfolder KH 82	Flat pile feeder	Manual TBP*	–	FH.1233900/01
		Automatic TBP*	–	FH.1211600/01
	Round continuous feeder	Manual TBP*	–	FH.1233900/01
		Automatic TBP*	–	FH.1211600/01

*TBP = Turn buckle plate



16-page German four-directional fold.



32-page German four-directional fold.

Strip trimming

Designation	Type of machine	Article no.	Description
Strip trimming, rear-mounted 35 mm (1.38 in) slitter shaft	Stahlfolder TH/KH	FH.1143430/03	- Strip trimming attachments work with two parallel blades and trim strips from multiple-ups, mainly from parallel-folded sheets. - Strip widths of between 5 and 15 mm (0.20 and 0.59 in) can be trimmed, in special circumstances up to 24 mm (0.94 in). A special stripper is used between the two blades that removes the strips of paper downwards out of the working area. - If there are large amounts of trimmings, mobile or stationary extraction devices ensure production is not disrupted.
Strip trimming after the parallel fold	Stahlfolder TH/KH/TD	ZD.023-002-VE-00	
Strip trimming after the parallel fold	Stahlfolder KD	ZD.023-007-VE-00	
Strip trimming after the parallel fold	Stahlfolder Ti 40, Ti 52, Ti 55	ZD.024-013-VE-00	
Strip trimming after the parallel fold	Stahlfolder TD	ZD.024-019-VE-00	
Slitter shaft, complete, after the parallel fold	Stahlfolder KD, KD.1	ZD.024-020-VE-00	
Strip trimming, rear-mounted slitter shaft	Stahlfolder KD, KD.2, KHC	ZD.024-021-VE-00	



Edge trimming

Designation	Type of machine	Article no.	Description
Edge trimming on R/L with polyurethane for 35 mm (1.38 in) slitter shaft	Stahlfolder TH 56-82	FH.1109415/03	Edge trimming attachments are used to trim the top and bottom of one-up folded sheets inline in the folding machine. However, accurate trimming and problem-free removal of trimmings are only ensured if the trimming width is at least 6 mm (0.23 in) and the conveying function of the guide rollers works properly. With thicker products, the double circular knife attachment can also be used for edge trimming. This trimming method is used in particular for adhesive folding, for example with glued brochures.
Edge trimming on R/L	Stahlfolder Ti 52, Ti 55, Ki 55	ZD.020-027-VE-00	
Edge trimming after the parallel fold	Stahlfolder TD 56-94	ZD.020-031-VE-00	
Edge trimming after the parallel fold, rear-mounted slitter shaft	Stahlfolder KD 56-94	ZD.051-022-VE-00	
Edge trimming with polyurethane, rear-mounted slitter shaft	Stahlfolder KD.2	ZD.051-026-VE-00	



Circular knives

Designation	Type of machine	Article no.	Description
Trimming attachment, double circular knife	Stahlfolder TD/TH	FH.1231995/00	Trimming blades are used to separate multiple-up folded sheets with a single cut. A double circular knife attachment is available for thick products. It works in a similar way to a pair of scissors, i.e. trimming blade against trimming blade.
Edge trimming, trimming attachment with double circular knife	Stahlfolder Ti 40, Ti 52, Ti 55	ZD.273-722-BE-05	
Trimming attachment with double circular knife and polyurethane	Stahlfolder TH/KH 56-82	ZD.273-722-BE-08	



Punch perforating attachment after the parallel fold

Designation	Type of machine	Article no.	Description
Punch perforation for rear-mounted 35 mm (1.38 in) slitter shaft, 1st to 3rd station	Stahlfolder TH 56-82	FH.1109405/02	Punch perforations are created using a rotating punch perforating knife and two die plates. The punch perforating knife, which can be either 0.8 or 1.2 mm (0.031 or 0.047 in) thick, punches out pieces of paper 11 mm (0.43 in) long along the perforation line. The fold quality is significantly improved by trapped air escaping. Consequently, punch perforations are ideal for cross-folding large numbers of pages (32, 48 or 64 pages) or high grammages. Punch-perforated sheets are often turned into a book block in the adhesive binder without milling. The signatures remain together and the superior sheet edge adhesion produces a more durable end product.
Punch perforation after the parallel fold	Stahlfolder Ti 52, Ti 55	ZD.058-009-VE-00	
Punch perforation after the parallel fold	Stahlfolder TD 56-94	ZD.058-011-VE-00	
Punch perforation after the parallel fold	Stahlfolder KD 56-94, KD.1	ZD.058-014-VE-00	
Punch perforation after the parallel fold	Stahlfolder KD.2, KHC	ZD.058-015-VE-00	



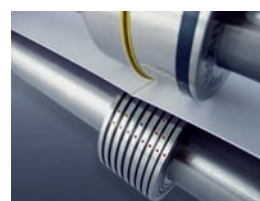
Perforating/trimming attachment and creaser

Designation	Type of machine	Article no.	Description
Perforating/trimming attachment and creaser	Stahlfolder TH	FH.1109465/01	Paper or lightweight cardboard is creased or perforated in folding machines to facilitate subsequent cross-folding. Creasing takes place at the previous station, facilitating the subsequent folding process and improving fold quality.
Perforating/trimming attachment and creaser	Stahlfolder Ti 52, Ti 55, Ki 55	ZD.016-022-VE-00	
Perforating/trimming attachment and creaser	Stahlfolder TD 56-94	ZD.016-032-VE-00	
Perforating/trimming attachment and creaser	Stahlfolder KD 56-94, KD.1	ZD.016-033-VE-00	
Perforating/trimming attachment and creaser	Stahlfolder KD.2, KHC	ZD.016-036-VG-00	
Perforating attachment/creaser	Stahlfolder Ti 40, Ti 52, Ti 55	ZD.273-421-BE-02	



Creasers

Designation	Type of machine	Article no.	Description
Creaser for use against rubber, 35 mm (1.38 in) slitter shaft	Stahlfolder TD/KD, TH/KH	FH.1280685/00	Paper or lightweight cardboard is creased or perforated in folding machines to facilitate subsequent cross-folding (buckle or knife fold principle). Creasing takes place at the previous station, facilitating the subsequent folding process and improving fold quality. • Suitable for creasing paper grammages between 35 and 150 gsm against a polyurethane ring. • The creasing blade creates a sharp, precise longitudinal crease, marking the exact folding position for the subsequent cross-fold. • It is particularly helpful at the next station if there are several folds running in parallel, for example letterfolds and concertina folds
Creaser for use against rubber, 25 mm (0.98 in) slitter shaft	Stahlfolder Ti 40, Ti 52, Ti 55	FH.1290795/00	
Fast-Fit creaser, 25 mm (0.98 in) slitter shaft	Stahlfolder Ti 55	FH.1291640/00	
Fast-Fit creaser, 35 mm (1.38 in) slitter shaft	Stahlfolder TH/KH 56-82	FH.1291650/00	
Creaser for use against polyurethane, 25 mm (0.98 in) slitter shaft	Stahlfolder Ti 40, Ti 52, Ti 55	ZD.039-005-VE-00	
Creaser for use against polyurethane, 35 mm (1.38 in) slitter shaft	Stahlfolder TD/KD, TH/KH, KHC	ZD.039-007-VE-00	



Equipping the front-mounted slitter shaft – benefits of new, additional equipment

This package makes it quick and easy for you to retrofit equipment on the front-mounted slitter shaft. There are a number of benefits:

- There is no need to remove the front-mounted slitter shaft.
- You no longer have to move the knife boss to different positions.
- There is no need to move the knife boss between the top and bottom slitter shafts.
- Numerous knife insertion positions are available as standard (currently none).
- You will avoid endless screwing when using screwed knife bosses.

Designation	Article no.	Comments
Accessories for equipping front-mounted slitter shaft	FH.1296455/00	Working widths 66/82 cm
	FH.1297105/00	Working widths 112/142 cm

Retrofitting a front-mounted slitter shaft for all Stahlfolder TH/KH and Stahlfolder TD/KD machines from Heidelberg

Due to the constant increase in processing speeds, fold preparation has become an important consideration. The front-mounted slitter shafts in the first parallel folding unit can be retrofitted on both the Stahlfolder TH/KH and Stahlfolder TD series. On the Stahlfolder TH, it is also possible to retrofit the front-mounted slitter shafts of the subsequent stations. Although front-mounted slitter shafts typically only replace the standard rear-mounted configuration in special cases, the use of such shafts opens up new and improved processing options.

Front-mounted slitter shafts form the basis for special solutions that are applied prior to folding such as:

- Timed perforation
- Timed trimming
- Center (parting) cuts
- Creasing/perforating/trimming device for calendars
- More space for gluing

To determine the required parts, please contact your local Heidelberg subsidiary. For retrofitting a front-mounted slitter shaft, please indicate the machine number and bear in mind that this will take an experienced technician approximately one working day (the feeder has to be dismantled and re-installed).

Rapid replacement thanks to separate perforating and punching blades

High-grade steel specifically developed by Heidelberg is used for the production of Original Heidelberg Performance Blades. As a result, they benefit from a long service life at maximum speeds and under constant stress. In consultation with one of our customers, we have developed separate perforating and punching blades. With the new split blades, it is not necessary to remove the slitter shaft to replace a perforating or punching blade. This boosts productivity by cutting folding machine downtimes.

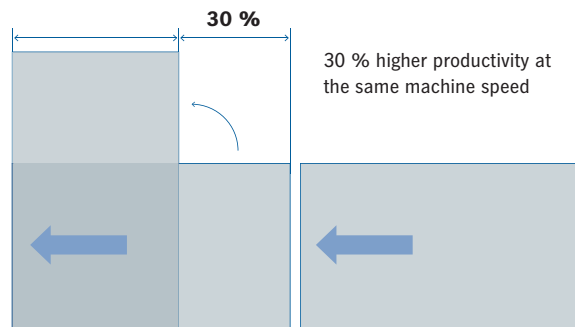
Separate perforating and punching blades

Article no.	Designation	Type of machine
FH.1282711/00	Perforating blade D38.5/26 10Z	Stahlfolder Ti 36
FH.1282721/00	Perforating blade D47.5/30 10Z	Stahlfolder Ti 40, Ti 52, Ti 55, Ki 55
FH.1282731/00	Perforating blade D47.5/30 15Z	Stahlfolder Ti 40, Ti 52, Ti 55, Ki 55
FH.1282741/00	Perforating blade D47.5/30 10Z	Stahlfolder Ti 40, Ti 52, Ti 55, Ki 55
FH.1282751/00	Perforating blade D47.5/30 15Z	Stahlfolder Ti 40, Ti 52, Ti 55, Ki 55
FH.1282761/00	Perforating blade D47.5/30 10Z	Stahlfolder Ti 40, Ti 52, Ti 55, Ki 55
FH.1282771/00	Punching blade, Z=10	Stahlfolder Ti 40, Ti 52, Ti 55, Ki 55
FH.1282781/00	Punching blade, Z=10	Stahlfolder Ti 40, Ti 52, Ti 55, Ki 55
FH.1282791/00	Perforating blade, V-shape	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1282801/00	Perforating blade, V-shape	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1282811/00	Perforating blade, V-shape	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1282821/00	Perforating blade, Z=32, 2.0 mm	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327071/00	Perforating blade D61.5/40 12Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327081/00	Perforating blade D61.5/40 18Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327091/00	Perforating blade D61.5/40 12Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327101/00	Perforating blade D61.5/40 18Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1280611/00	Perforating blade D61.5/40 12Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327121/00	Perforating blade D61.5/40 18Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327131/00	Perforating blade D61.5/40 12Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1282831/00	Perforating blade, V-shape	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327141/00	Perforating blade, V-shape	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327151/00	Perforating blade, V-shape	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327161/00	Punching blade, Z=12, s=0.9	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327171/00	Punching blade, Z=12, s=1.2	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1282841/00	Perforating blade D78.5/55/1 18Z	Stahlfolder TD 112, TD 142
FH.1282851/00	Perforating blade D78.5/55/2 18Z	Stahlfolder TD 112, TD 142
FH.1282861/00	Perforating blade D80/55/2 18Z	Stahlfolder TD 112, TD 142
FH.1282851/00	Perforating blade D78.5/55 30Z	Stahlfolder TD 112, TD 142
FH.1282861/00	Perforating blade D78.5/55 18Z	Stahlfolder TD 112, TD 142
FH.1294001/01	Punching blade, Z=16, s=0.9	Stahlfolder TD 112, TD 142
FH.1294011/01	Punching blade, Z=16	Stahlfolder TD 112, TD 142
FH.1327061/00	Perforating blade D47.5/30 10Z	Stahlfolder Ti 40, Ti 52, Ti 55, Ki 55
FH.1327051/00	Perforating blade D47.5/30 15Z	Stahlfolder Ti 40, Ti 52, Ti 55, Ki 55
FH.1327041/00	Perforating blade D78.5/55 18Z	Stahlfolder TD 112, TD 142
FH.1327031/00	Perforating blade D78.5/55 30Z	Stahlfolder TD 112, TD 142
FH.1327011/00	Perforating blade D47.5/30 10Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1327021/00	Perforating blade D47.5/30 15Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1282991/00	Perforating blade D78.5/55 18Z	Stahlfolder TD 112, TD 142
FH.1282981/00	Perforating blade D78.5/55 30Z	Stahlfolder TD 112, TD 142
FH.1327001/00	Perforating blade D47.5/30 15Z	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH
FH.1282971/00	Perforating blade, V-shape	Stahlfolder Ki 55, KC, KD, KH, TF, TC, TD, TH

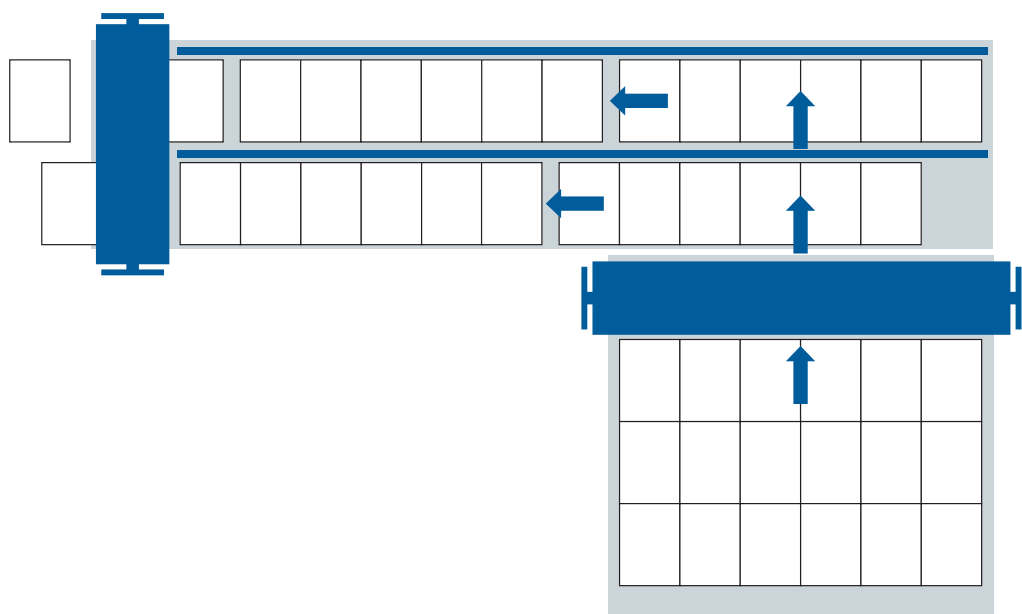
New pneumatic twin lay system for correct rotation

Oblong sheet feeding improves folding performance by 30 to 40 percent. Two simple steps can significantly increase the productivity of the buckle plate folding machine on Stahlfolder TH and Stahlfolder TD machines – rotating the sheet to be folded 90 degrees at the feeder and locating the new pneumatic twin lay system before the second folding unit. The sheet's shorter feed length at the same press speed boosts performance by around 30 to 40 percent, depending on the sheet format (see the figure on the right).

The pneumatic twin lay system enables the folded sheets to be aligned and transported in parallel on the second folding unit. This means that twice as many folded sheets can be transported as before, enabling customers to halve the speed of the second folding unit. Oblong sheet feeding into the first parallel folding unit at the same machine speed increases productivity significantly and, thanks to the low speed of the second folding unit, also improves the folding quality, which makes the folding process even more reliable.



The principle: Oblong sheet feed at the buckle plate folding machines.



A "new" twin lay system avoids overlapping restrictions.

High-Performance Kit – for feeders

Higher speeds and large sheets of paper are presenting bookbinders with new challenges all the time. Sheets still need to be transported quickly and in a straight line. Stahlfolder machines from Heidelberg can be retrofitted with the company's High-Performance Kits to ensure that sheets are transported quickly, in a straight line, and reliably while maintaining consistently high quality.

High-Performance Kit for flat pile feeders •

Includes front blowers extending across the entire width of the feeder and double suction wheels for working widths of 66 and 82 centimeters (25.98 and 32.28 inches) – minimum sheet format 20 × 18 centimeters (7.87 × 7.09 inches).

High-Performance Kit for round continuous feeders • Includes a second conveyor belt for the loading table, double suction wheels with two rows of holes for working widths of 66–82 centimeters (25.98–32.28 inches), cast rollers that can be swung up, and small rollers for transverse formats – minimum sheet format 20 × 18 centimeters (7.87 × 7.09 inches).

High-Performance Kit for pallet feeders • Includes double suction wheels and rotating blowers on the drive side – minimum sheet format 20 × 18 centimeters (7.87 × 7.09 inches). Powerful air compressor/vacuum pump for working width of 82 centimeters (32.28 inches).

High Performance Kit – mechanical

Includes two V-shaped poly-urethane stripper rollers with holder (perforation shaped so that it is folded correctly), four conveyor rollers for the belt shaft, two bearing hold-down elements, and two telescopic damper bars.

Article no.	Designation
FH.1163605/00	Mechanical, 2nd-4th folding station
FH.1163625/00	Mechanical, 3rd folding station

High-Performance Kit – electronic setup mode

The electronic setup function eliminates the need to stop sheets manually and turn the handwheel.

- Reduction in makeready time
- Less setup waste (one sheet is sufficient for the entire machine)

Electronic setup mode also offers users the option of risk-free fold checking. A sheet is conveyed at full production speed to the folding station where the operator is located. Since this station is not in operation, it is safe for the operator to remove the folded sheet from the machine and check it. This reduces the risk of accidents.

In setup mode, the operator can set up the folding machine station by station with just one sheet. This sheet is transported from the feeder to the 1st folding station (buckle plate folding unit) and automatically stopped at the infeed. After checking the angle of the alignment guide and, if necessary, setting up front-mounted slitter shafts, the sheet continues to the exit of the unit. Here, it stops again for the rear-mounted slitter shaft to be set (tool, stripper rollers, hold-down element, etc.). After that, the sheet is transported to the next unit (folding station) for further buckle plate folding machine settings to be made. With combination folding machines, sheets are automatically stopped around 10 centimeters (about 4 inches) before the sheet stop of the 1st folding knife. The sheet is guided slowly up to the sheet stop in inching mode and the lateral stops can be positioned precisely with the very first setup sheet. Each folding knife is gradually adjusted in this way.

High-Performance Kit – sheet travel monitoring

Every Stahlfolder TH/KH has a mechanical sheet jam switch at the exit of the folding unit. This stops the folding machine as soon as a crumpled sheet triggers the switch. Sensor-based sheet monitoring is optionally available for the Stahlfolder TH/KH (High-Performance Kit). This monitors sheet travel from feeder to delivery. A sensor at the infeed and exit of each folding unit compares the length of sheets and keeps track of the number of sheets in the unit. Deviations are immediately identified as sheet travel errors and the machine stops straight away. A sensor on the guide of the inclined-roller register tables monitors the transfer area between folding unit and table. It identifies jams causing folded sheets to pile up in this area and stops the folding machine immediately. A sensor on each knife of the cross-fold unit even identifies sheets with minor folding errors. The knife stroke is not activated and the combination folding machine stops immediately. This even faster detection (sheet travel monitoring) minimizes the time it takes to rectify a jam, thereby increasing the machine's effective output and minimizing waste. Sheet travel monitoring also protects the folding machine against damage caused by serious jams. It is easy to set up.

The process is completed automatically by the MCT machine control system and takes no additional time.

- Production stoppages and waste minimized.
- Straightforward operation – sheets are compared on the fly, so the system does not need to be stopped.
- No additional calibration sheet required.



Saphira consumables for Stahlfolder machines

All Saphira® consumables are carefully selected for optimum integration into your production system. Our range includes the following items:

Banderoles for the Stahlfolder Speedbender • For our fully automated Speedbender pack module, we can offer you Original Heidelberg banderoles in two different widths. These can be exchanged easily as required.

Saphira Cleaner Antistatic • We recommend Saphira Cleaner Antistatic for cleaning monitors, membrane keyboards, plastics, acrylic glass, etc. It reliably removes dirt, dust, fingerprints, streaks, and nicotine – and neutralizes electrostatic charges. (Reference number: FH.1164784/00)

Saphira Special Cleaner for folding rollers • Saphira Special Cleaner cleans and renews folding rollers such as those in the Stahlfolder range from Heidelberg, and does so in a single operation. The rollers are left with a velvety smooth rubber surface with outstanding grip properties. Their service life is extended significantly and no swelling takes place in the rubber rollers. (Reference number: FH.1061774/01)



Saphira consumables are available through the usual Heidelberg sales channels and, in many countries, online at www.heidelberg.com/shop.

Original Heidelberg Service Parts for Stahlfolder machines

Original Heidelberg Service Parts ensure stable production and optimum results over the long term. Whether you need mechanical, electrical or electronic parts for older or new models, you need look no further than Heidelberg. A few examples from our range are provided below.

Blades • Original Heidelberg blades are made of very high-grade steels, are extremely durable, and are designed to handle very high speeds and loads. When replaced regularly, they ensure work of a high standard and efficient, problem-free production.

Folding rollers • Original Heidelberg folding rollers are available in Classic and Extra Grip versions. They consist of a hard steel core with a corrugated surface and large journals that ensure smooth running. Polyurethane rings 15 millimeters (0.59 inches) wide in the steel core ensure sheets are transported precisely in the direction of paper travel.



Lubrication cartridges • The formulation of the Original Heidelberg lubrication cartridge was specifically developed for Heidelberg. The cartridge can be used for all Stahlfolder machines, the FS 100 and FS 150 thread-sealing machines, and the Stitchmaster® ST 300 saddlestitcher. There is no other product like it available on the market. (Reference number: ZD.228-326-01-00)

Our logistics center, the largest anywhere in the world in the print media industry, stocks more than 130,000 different items. This enables us to deliver virtually all parts worldwide within 24 hours. Simply ask your Heidelberg contact for details.

Our Range of Services for You

Nothing is as good as the original.

Our retrofit options are manufactured with the same precision we apply to all our other equipment. Whether installed from the outset or retrofitted, top Heidelberg quality ensures your productivity over the long term – for enhanced efficiency, optimum results, and the great feeling that you are ideally equipped for the future.

What does it cost?

Ask for our price list or get in touch with your Heidelberg Systemservice® contact. Our team will be happy to provide you with the relevant details.

Who will retrofit my machine?

All retrofit options – with the exception of slitter shaft tools and blades – are installed by a Heidelberg Systemservice engineer. Your Heidelberg contact will be happy to tell you about our comprehensive installation service.

Looking for other retrofits or service parts?

Are you familiar with our other Heidelberg Systemservice catalogs? Further information can be found in:

- “Original Heidelberg Service Parts for Folders, Saddlestitchers, Adhesive Binders and Thread-sealing Machines”
- “Stitchmaster ST 100 Retrofit Options”, “Stitchmaster ST 350 Retrofit Options”, and “Stitchmaster ST 450 Retrofit Options”

Any questions? Just give us a call.

If you are finding it difficult to track down an article, having problems installing an option or looking for assistance with some other matter, we'll be happy to help. Useful telephone numbers can be found online at www.heidelberg.com/systemservice.

Technical services from Heidelberg Systemservice



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