

Print Media Performance & Training Center.

Advanced Folding.

Overview

This class will build upon the curriculum taught in “Introduction to Folding.” Experienced operators will review the components of a folder, then focus on high performance folding, product quality and advanced folding techniques including scoring and perforating.

Introduction

- Safety, operation and machine controls, machine control screen, and documentation
- Folding terminology
 - Buckle Folders: Ti/BH/TH machines
 - Kombi Folders: CH/KH machines
 - Shingling Folders: TH/KH-P/TX machines
 - Delivery types and configurations

Makeready Process

- Overall Machine Capabilities
 - Dimensions
 - Machine folding formats
 - Connections between machine modules and delivery
- Folding Basics
 - Paper grain direction
 - Paper properties
 - Folding principles
- Feeder Set-up – Fine Tuning
 - Adjustment of pile, continuous, pallet, shingling, etc.
- Tremat Head
 - Adjustment and fine tuning of suction plate blower and suction wheel
- Register Table
 - Side guide positioning and skew adjust
 - Thickness sensor
- Buckle Plate Station/Crossfold Unit/Shingling Unit
 - Mechanical adjustments, knife/angle height
 - Shingling function
- Operation MCT Control System
 - Buttons, settings, automated set-up



Stahlfolder® KH 82.

- Deliveries
 - (Stream-, Stack-, Horizontal Stack-Delivery, Autonomous)
 - Marking function, pressing rollers
 - P-Stacker technology
- Makeready process + production of complex folds:
 - Perforating and scoring
 - Crossfold
 - Three-directional crossfold
- Performance Folding
 - Fine setting adjustments for best performance
 - Tips & tricks for optimum changeover times
- Factors that affect fold quality
 - Roller condition
 - Creasing roller selection
 - Slitting knife types
- Troubleshooting tips & tricks, understanding common issues
- Control screen error messages, understanding how to analyze
- Scenario setting, define problem, identify solutions
- Maintenance overview

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