

Perforating

When folding right angle folds for book signatures it is recommended to perforate the paper as it exits the previous folding station. Perforating the paper creates consistent, quality folds in the right angle folder. Perforating creates a weakness or definition in the paper that assists in folding multiple thicknesses or against grains in the paper and more importantly makes air passages in the paper to allow air to escape during the folding process and eliminate wrinkles and creases that occur from air pockets. When perforating you must determine the next application in the finishing process or the usage of the printed material by the end recipient. If you are perforating signatures for books that are to be gathered and stitched on a saddlestitcher, you will want to use a coarse perforating blade that has fewer number of teeth and creates large slits for the air to escape. If you are creating mailing pieces with coupons or reply sections you will want to use a finer tooth perforator blade that has several perforations per inch.

If you are folding 17x22" sheet in half in the first station folder and then in half again in the right angle to make standard 8-page signatures, you will need (1) line of perforation on the slittershafts on the first station folder. You will find (3) yellow scribe lines on the tie bar at the exit of the first station folder. The yellow line in the center is the approximate center of the folder

and the sheet and is where you can approximate the location of the perforating accessories for this job.



Perforating Continued:

To install the perforating accessories, first remove the slittershaft housing on the non-operator side of the folder. Loosen the holding knob and remove it from the housing. Insert the holding knob into the tapped hole in the side of the housing and screw it into the tapped hole completely. Pull out on the holding knob and remove the housing from the slittershafts. The slittershafts stay in the folder. Use the 4mm hex allen-key ball driver to loosen the brass tip setscrews that are holding existing accessories in place. Slide the accessories that need removed off of the slittershafts. Install the perforating blades onto the blade holder.

Note that there are multiple spacers of different thicknesses on the blade holder. These are for mounting multiple blades at incremental center distances on the same blade holder. These are helpful for perforations that are close together.

When installing the perforating blades onto the blade holders, be sure to mount the blade holders so that the rotation of the shaft will not loosen the locking nut. Use the “Y” spanner wrench that is included with the tools for the folder to loosen and tighten the blade holder nut.

The perforating blade is to have the flat side running against the sharp side of the female scoring collar and the bevel side is to be pointing toward the next folder. The (2) grooves in the collar are for scoring only. The

flat, sharp side of the collar acts as an anvil just like a pair of scissors. If the perforating blade is not against the anvil side the perforations will be ragged and of poor quality.



Perforating Continued:

Slide all accessories onto the slittershaft and leave all items loose. Use the yellow scribe marks on the exit tie bar to line up the perforating blades or pull up on the #1 and #3 foldplates and roll a marked sheet of paper through the folder and line up the perforating blades with the marks on the lead edge of the paper and place the pullout tires close to the perforating blades and at the edges of the sheet. Reinstall the slittershaft housing and tighten the holding knob back into the upper position.

Line up all the accessories and rotate them so that all of the setscrews are at the same position facing outward and tighten the setscrews. This reduces setup time for the next job having all of the setscrews at the same position.

Mount the springsteel stripper assembly onto the exit tiebar that has the yellow scribe marks as shown. The stripper is to be mounted beside the perforating blade. It does not straddle the blade. **YOU MUST USE THE STRIPPER TO PERFORATE!**

Set the adjustable depth to the nominal center position using the micrometer adjustment knobs at each end of the slittershafts. The milled notch at the center of the aluminum block is the nominal center adjustment.

To adjust the perforation position, you can use the microadjustment knob on the register table. This is only effective when one perforation is being adjusted. It will not adjust multiple perforations.

