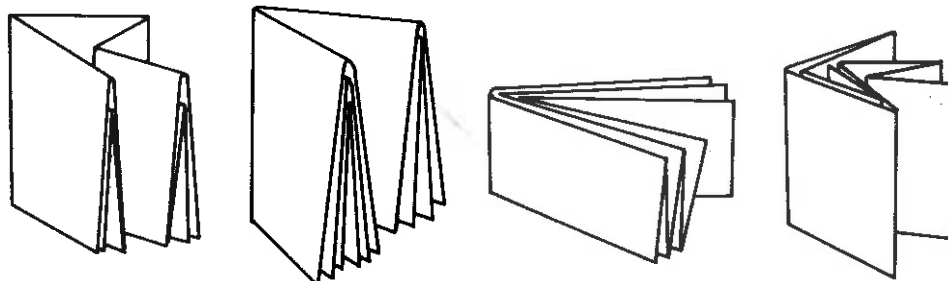
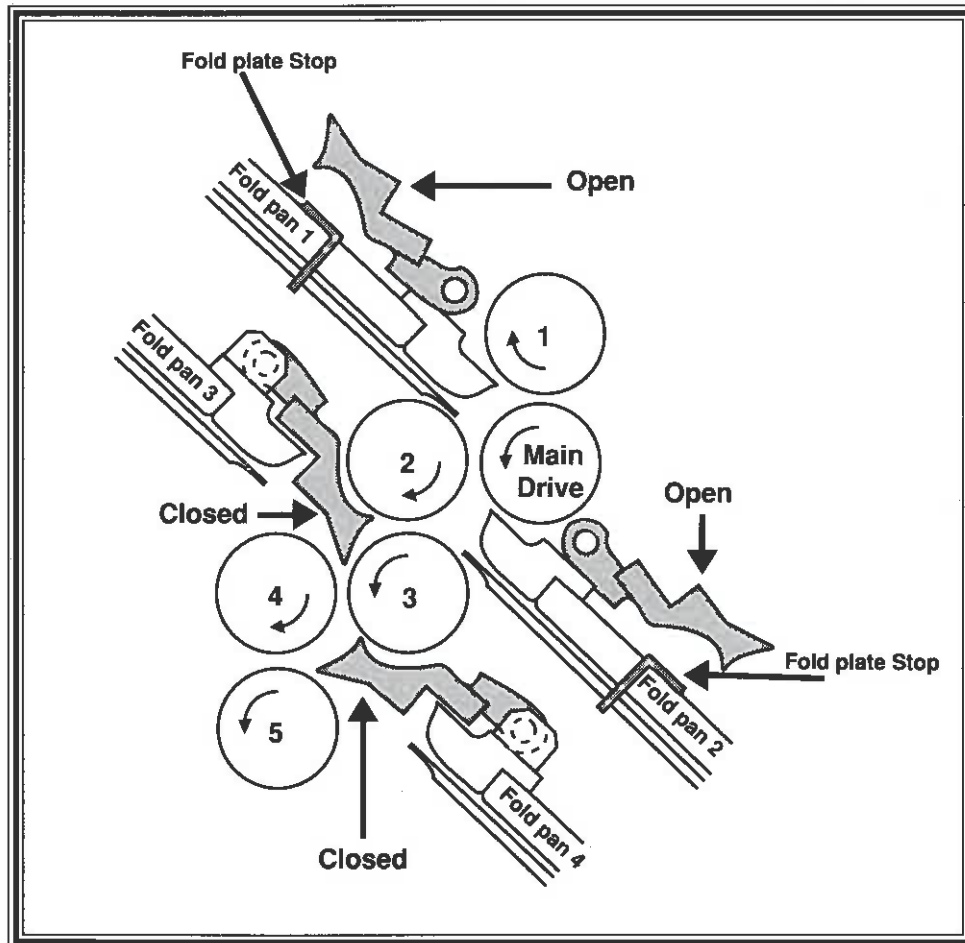




# BAUMFOLDER

## Imposition Manual

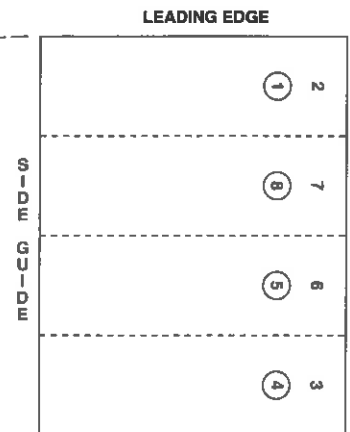


# How to use this manual

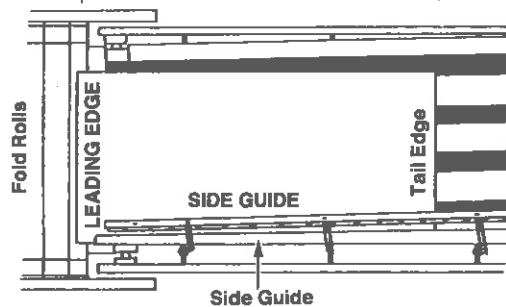
Use this manual when you need to know how to set-up your folder to end up with a particular folded piece or, if possible, when planning the layout before printing the job. In most cases, the page numbers and their orientations after the fold are included. Below is an explanation of how to read the diagrams in this manual. On the next page is a quick explanation of the basic theory of buckle folding. Although reasonable care has been taken to assure accuracy, Baum USA does not assume any responsibility for any errors that might inadvertently be contained in this manual. When trying a new fold, it is always advisable to set up a test run to check for potential problems.

Refer to the diagram below. Visualize the sheet to be folded lying flat on the register table. The edge toward the fold rolls is called the "LEADING EDGE". The paper edge under the register guide will be referred to as the SIDE GUIDE.

In this manual, each folding diagram has been rotated 90° from what is illustrated below so that they appear as pictured to the right. The dotted lines represent the creases where the paper has been folded.



Example of folding diagrams found throughout this book



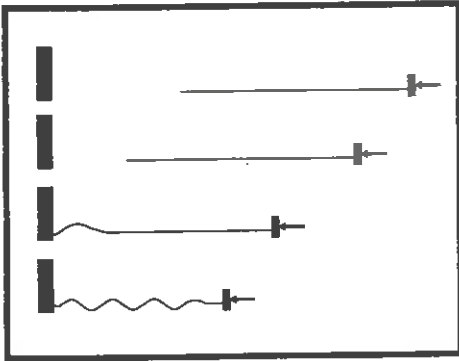
In each folding diagram throughout this book, if numbers are present, they represent page numbers as they would appear on a layout to be folded in the manner described by the diagram. Numbers in circles represent the page orientations on the *underside* of the sheet.

If letters are used, they will always appear in pairs (i.e. two A's, two B's, two C's etc.). Each pair represents two points on the surface of the paper that will come in contact with each other once the fold is

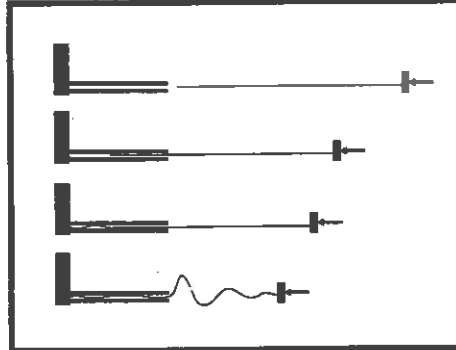
made. A's represent the first fold, B's the second, and so on. As with numbers, letters in circles represent points on the underside of the sheet.

Letters are included merely to clarify the folding procedure. Once you understand how each of the fold pans affects a fold, you may no longer need to refer to the letters, since you will be able to arrive at a particular fold given only the fold pan information at the top of each section.

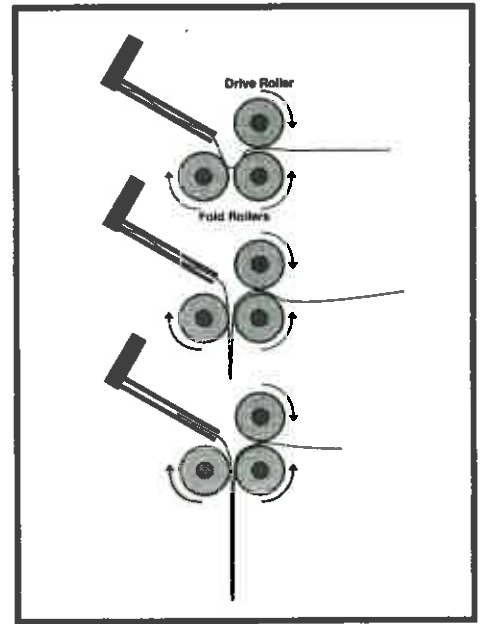
# The basic theory of buckle folding



If a sheet of paper is laid on a flat surface and driven into a stationary object, a buckle or series of buckles will form along the surface of the sheet.



If the paper is pushed into a narrow channel before butting up against the stationary object, the buckles that form within the channel will be of a much smaller size than free-forming buckles. At the end of the channel, however, larger buckles will again start to form.



If the channel is angled to produce a downward pressure, and two folding rollers, spinning as indicated above, are placed close to the end of the channel, the larger buckles that start forming there will always form downward and be pulled into the rollers, compressing into a fold.

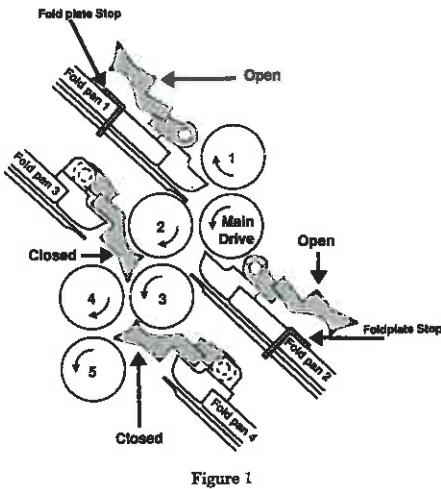


Figure 1

On a buckle folder, the sheet is laid flat on a register table and then enters the fold pan assembly where it comes to a stop against the stationary fold plate stop. A series of buckles then forms throughout the sheet. The buckles within the fold plate are kept very small by the narrow channel design. The buckles at the end of the fold plate, however, will be larger. The fold plates and rollers are configured such that the large buckle will always form downward, where it can be grabbed by the fold rollers and compressed into a fold.

Look at figure 1. You can see that fold pans # 1 and #3 are angled upwards. Because of this and the configuration of the fold rolls, sheets fed into the #1 and #3

pan will always be folded up (i.e. so that the "up" surface of the sheet is folded into contact with itself).

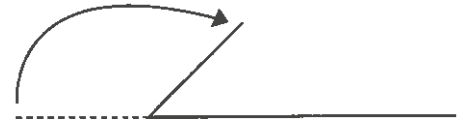


Fig. 2: Sheets in the #1 or #3 fold pans will be folded up.

Likewise, because foldpans #2 and #4 are angled down, sheets fed into them will be down-folds; the "down" surface of the sheet will be folded into contact with itself.

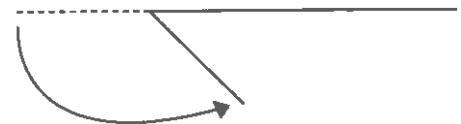


Fig. 3: Sheets in the #2 or #4 fold pans will be folded down.

## Fold plate

- #1
- #2
- #3
- #4

## fold

- up
- down
- up
- down



This applies to all folder sections: the parallel, the 8-page, the 16-page and the 32-page (Note: a 32-page rollaway, however, almost always has only two fold pans: a #1 and a #2 fold pan).

# CONTENTS

Imposition Number	Description
1	4-Page
2	4-Page, Double Imposition
3	6-Page, Standard
4	6-Page, Accordion
5	8-Page Parallel
6	8-Page Accordion
7	Double Cover
8	Semi-Gate Fold
9	8-Page, Step Fold
10	8-Page, Right Angle
11	8-Page, Two Right Angle Oblong
12	Two Right Angle, French Fold Inside
13	Two Right Angle, French Fold Outside
14	Two Right Angle, Oblong, French Fold Inside
15	Two Right Angle, Oblong, French Fold Outside
16	8-Page, Right Angle, Double Imposition
17	8-Page, Parallel Over & Over Fold
18	8-Page, Parallel Map Fold
19	10-Page, Parallel Mailing Folder
20	10-Page, Parallel Mailing Folder
21	10-Page, Parallel Mailing Folder
22	10-Page, Parallel Mailing Folder
23	10-Page, Parallel
24	10-Page, Accordion Fold
25	12-Page Book, Saddle Stitch
26	12-Page Book, Saddle Stitch
27	12-Page Book, Saddle Stitch
28	12-Page Book, Saddle Stitch
29	12-Page Book, Saddle Stitch, Double Imposition
30	12-Page Letter Fold, Heads Out
31	12-Page Letter Fold, Heads In
32	12-Page Letter Fold, Accordion
33	12-Page Inside French Fold, Heads Out
34	12-Page Inside French Fold, Heads In
35	12-Page Outside French Fold, Heads Out
36	12-Page Outside French Fold, Heads In
37	12-Page Three Right Angle Fold
38	12-Page Three Right Angle Fold
39	12-Page Three Parallel Booklet
40	12-Page Three Parallel Booklet
41	12-Page Three Parallel Booklet
42	12-Page Three Parallel Fold
43	12-Page Three Parallel
44	12-Page Three Parallel
45	14-Page Three Parallel
46	14-Page Three Parallel
47	14-Page Three Parallel
48	16-Page Three Right Angle Book Imposition
49	16-Page Three Right Angle Book Imposition

<b>Imposition Number</b>	<b>Description</b>
50	16-Page Three Right Angle Book Imposition
51	16-Page Three Right Angle Newspaper Imposition
52	16-Page Three Right Angle Newspaper Imposition
53	16-Page Folder, Heads Out
54	16-Page Folder, Heads In
55	16-Page Oblong Booklet
56	16-Page Oblong Booklet
57	16-Page Oblong Booklet
58	16-Page Oblong Booklet
59	16-Page Inside French Fold, Heads Out
60	16-Page Inside French Fold, Heads In
61	16-Page Outside French Fold, Heads Out
62	16-Page Outside French Fold, Heads In
63	16-Page Folder or Broadside
64	16-Page Three Parallel Booklet
65	16-Page Four Parallel Booklet
66	16-Page Three Parallel Booklet
67	16-Page Four Parallel Folder
68	16-Page Booklet, Double Imposition
69	16-Page Booklet, Two On
70	16-Page Booklet, Two On
71	18-Page Broadside
72	18-Page Broadside
73	18-Page Broadside
74	18-Page Broadside
75	18-Page Broadside
76	18-Page Broadside
77	18-Page Broadside
78	18-Page Broadside
79	18-Page Four Parallel
80	18-Page Four Parallel
81	18-Page Four Parallel
82	20-Page Oblong Book
83	20-Page Upright Booklet
84	20-Page Four Parallel Booklet
85	20-Page Four Parallel
86	24-Page Booklet
87	24-Page Booklet
88	24-Page Booklet
89	24-Page Booklet
90	24-Page Booklet
91	24-Page Booklet
92	24-Page Right Angle Booklet
93	24-Page Right Angle Booklet
94	24-Page Right Angle Booklet
95	24-Page Right Angle Booklet
96	24-Page Right Angle Booklet
97	24-Page Right Angle Booklet
98	24-Page Right Angle Booklet
99	24-Page Right Angle Double Letter Fold
100	24-Page Right Angle Double Letter Fold

<b>Imposition Number</b>	<b>Description</b>
101	24-Page Folder or Broadside
102	24-Page Folder or Broadside
103	24-Page Folder or Broadside
104	24-Page Folder or Broadside
105	24-Page Folder or Broadside
106	24-Page Folder or Broadside
107	24-Page Four Parallel
108	24-Page Four Parallel
109	24-Page Four Parallel
110	28-Page Book
111	28-Page Book
112	30-Page Broadside
113	30-Page Broadside
114	32-Page Book
115	32-Page Book
116	32-Page Book
117	32-Page Book
118	32-Page Book
119	32-Page Book
120	32-Page Book
121	32-Page Book
122	32-Page Book
123	32-Page Book
124	32-Page Book
125	32-Page Book
126	32-Page Book
127	32-Page Book
128	32-Page Book
129	32-Page Book
130	36-Page Book
131	36-Page Book
132	40-Page Book
133	40-Page Book
134	48-Page Book
135	48-Page Book, Oblong
136	48-Page Book, Oblong
137	64-Page Book
138	64-Page Book
139	Semi-Gate Fold & One First Right Angle
140	Semi-Gate Fold & Two Parallel at Right Angle
141	Semi-Gate Fold & Two Parallel at Right Angle
142	Order Blank Envelope
143	Order Blank Envelope
144	Order Blank Envelope
145	Map Fold
146	Map Fold
147	Map Fold
148	Map Fold
149	Map Fold
150	Map Fold
151	Map Fold

# NOTES



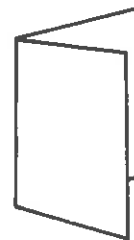
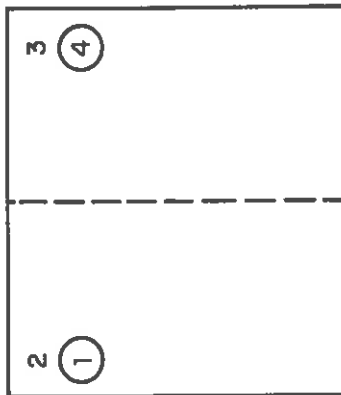
**BAUMFOLDER**  
CORPORATION  
1660 Campbell Rd.  
P. O. Box 728  
Sidney, Ohio 45365  
513/492-1281

# Everything after the press

**1**

## 4-PAGE

Parallel: 1

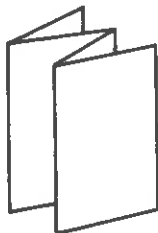
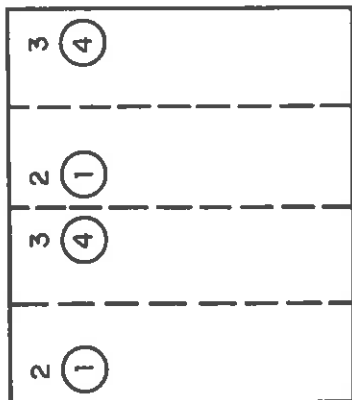


May be folded two or more up and cut apart

**2**

## 4-PAGE, DOUBLE IMPOSITION

Parallel: 1,2,3

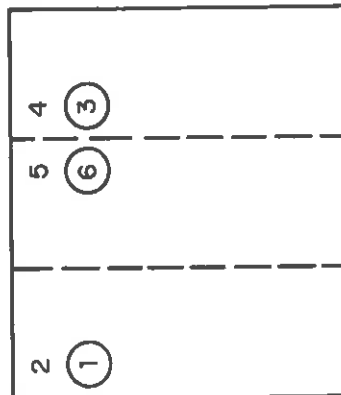


May be folded two or more up and cut apart. Trim edge after folding

**3**

## 6-PAGE, STANDARD

Parallel: 1,3

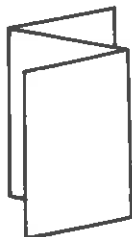
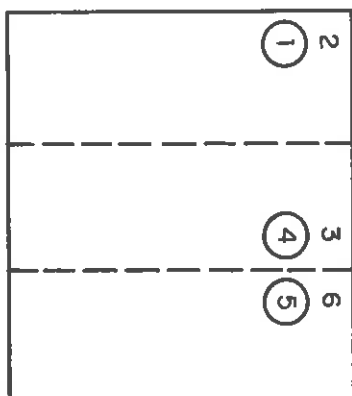


May be folded two or more up and cut apart

**4**

## 6-PAGE ACCORDION

Parallel: 1,2

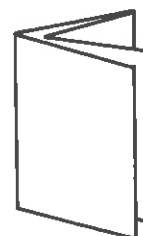
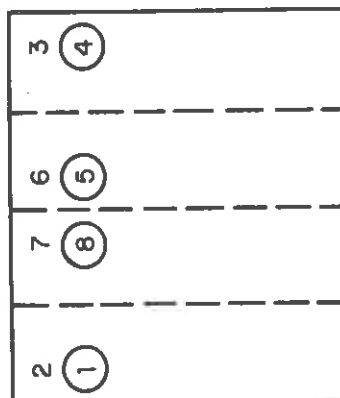


May be folded two or more up and cut apart

**5**

## 8-PAGE PARALLEL

Parallel: 1, 2

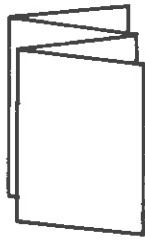
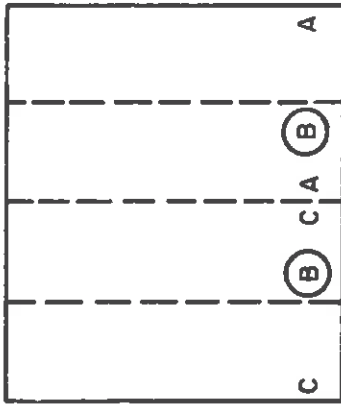


May be folded two or more up and cut apart



**6** 8-PAGE ACCORDION

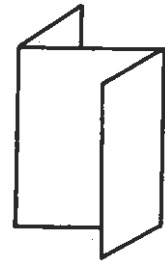
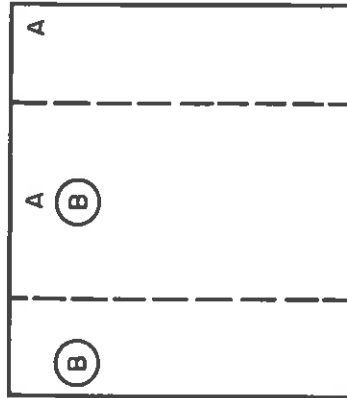
Parallel: 1,2,3



May be folded two or more up and cut apart

**7** DOUBLE COVER

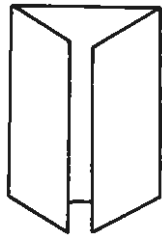
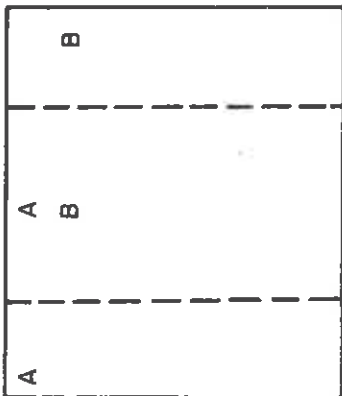
Parallel: 1,2



May be folded two or more up and cut apart

**8** SEMI-GATE FOLD

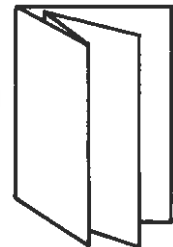
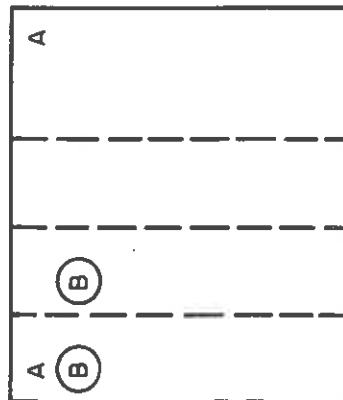
Parallel: 1,2



May be folded two or more up and cut apart

**9** 8-PAGE, STEP FOLD

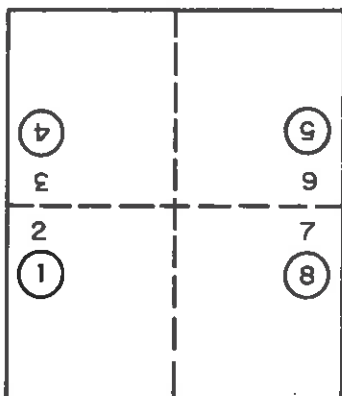
Parallel: 1,2



May be folded two or more up and cut apart

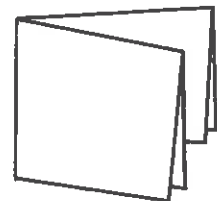
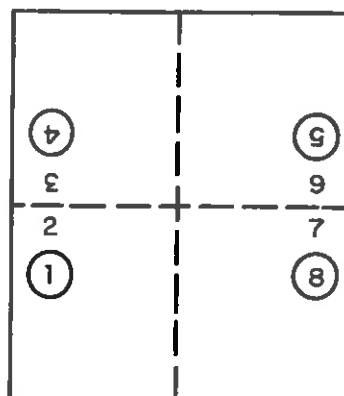
**10** 8-PAGE RIGHT ANGLE

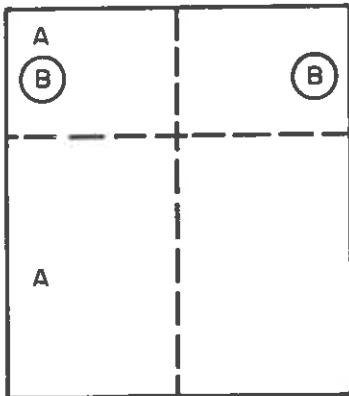
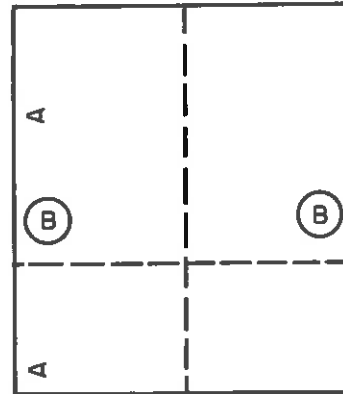
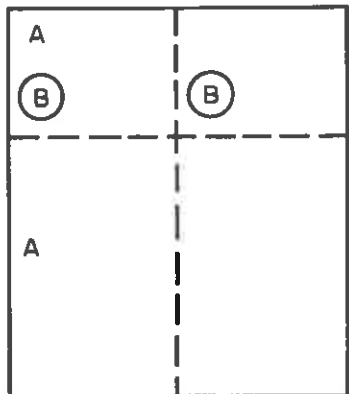
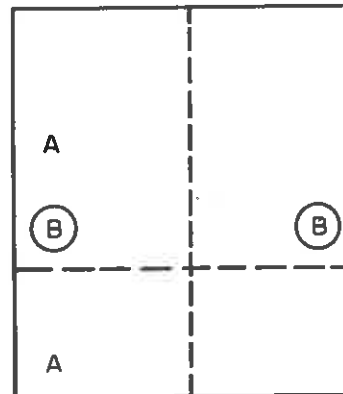
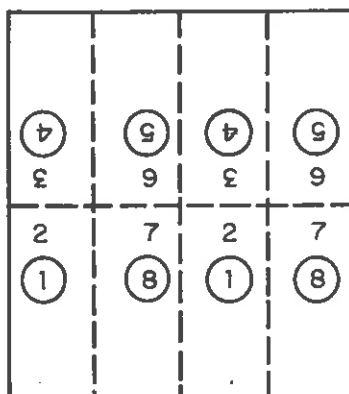
Parallel: 1  
8-Page: 1



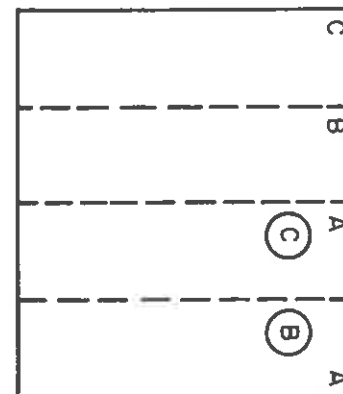
**11** 8-PAGE, TWO RIGHT ANGLE OBLONG

Parallel: 1  
8-Page: 1



**12****TWO RIGHT ANGLE, FRENCH FOLD INSIDE**Parallel: 1  
8-Page: 1**13****TWO RIGHT ANGLE, FRENCH FOLD OUTSIDE**Parallel: 1  
8-Page: 2**14****TWO RIGHT ANGLE OBLONG, FRENCH FOLD INSIDE**Parallel: 1  
8-Page: 1**15****TWO RIGHT ANGLE OBLONG, FRENCH FOLD OUTSIDE**Parallel: 1  
8-Page: 2**16****8-PAGE, RIGHT ANGLE DOUBLE IMPOSITION**Parallel: 1  
8-Page: 1,2,3**17****8-PAGE, PARALLEL OVER & OVER FOLD**

Parallel: 1,2,4

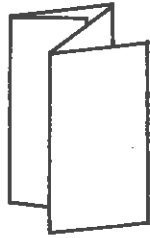
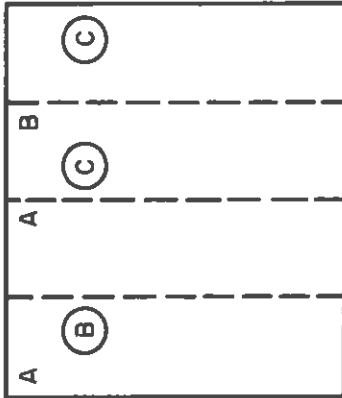


May be run two or more up and cut apart

**18**

**8-PAGE, PARALLEL MAP FOLD**

Parallel: 1,2,3

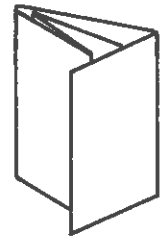
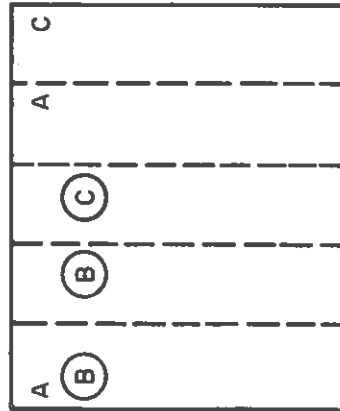


May be run two or more up and cut apart

**19**

**10-PAGE, PARALLEL MAILING FOLDER**

Parallel: 1,2,4

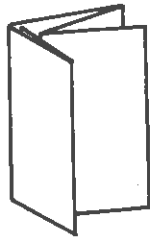
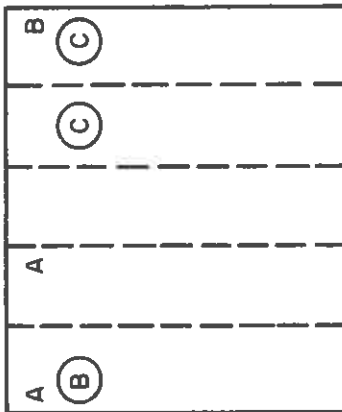


May be run two or more up and cut apart

**20**

**10-PAGE, PARALLEL MAILING FOLDER**

Parallel: 1,2,3

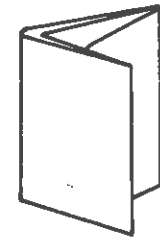
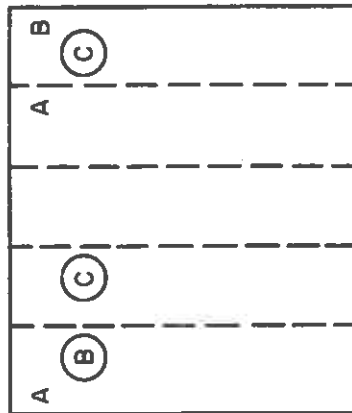


May be run two or more up and cut apart

**21**

**10-PAGE, PARALLEL MAILING FOLDER**

Parallel: 1,2,3

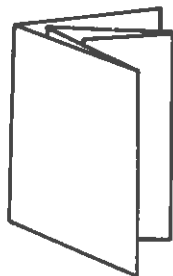
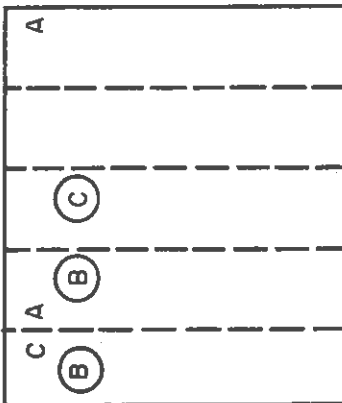


May be run two or more up and cut apart

**22**

**10-PAGE, PARALLEL MAILING FOLDER**

Parallel: 1,2,3

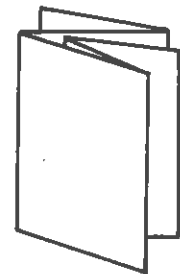
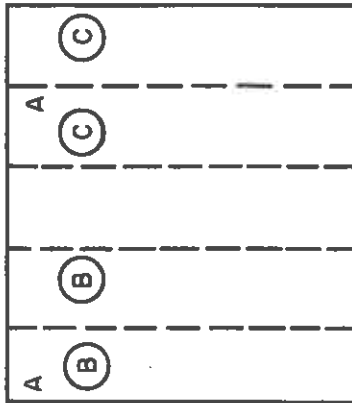


May be run two or more up and cut apart

**23**

**10-PAGE, PARALLEL**

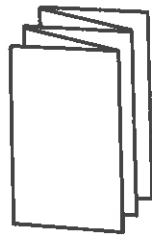
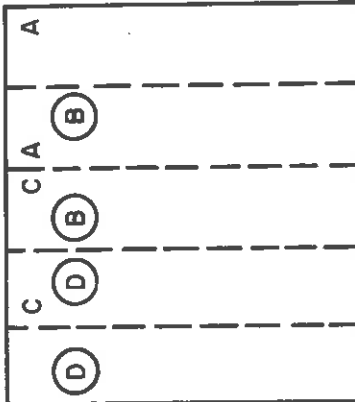
Parallel: 1,2,3



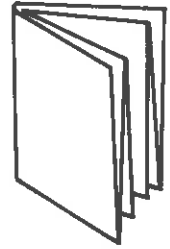
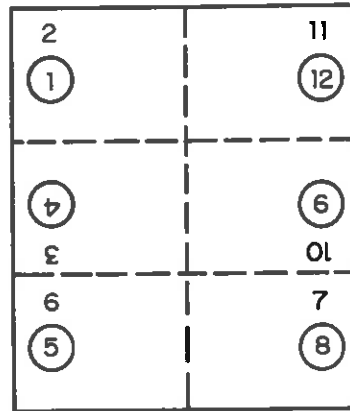
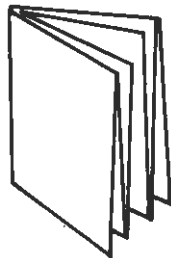
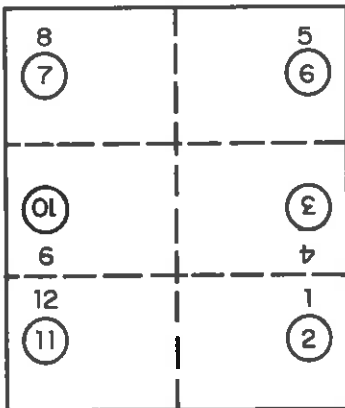
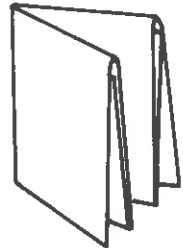
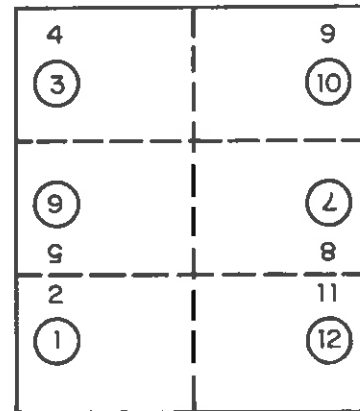
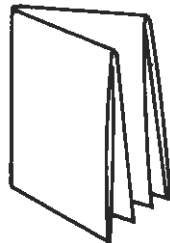
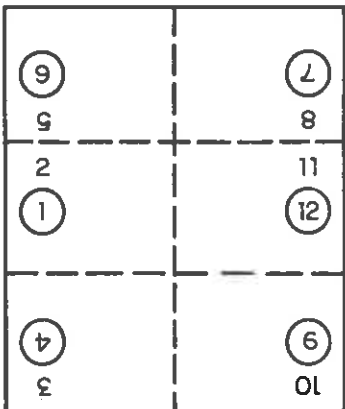
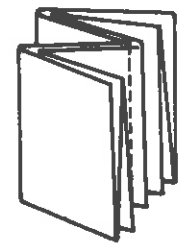
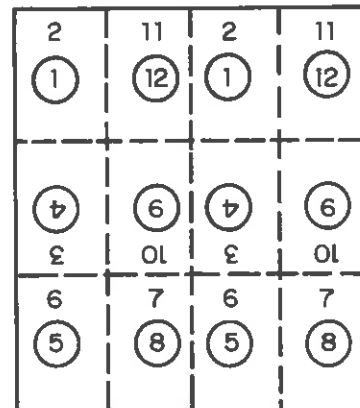
May be run two or more up and cut apart

**24****10-PAGE, ACCORDION FOLD**

Parallel: 1,2,3,4



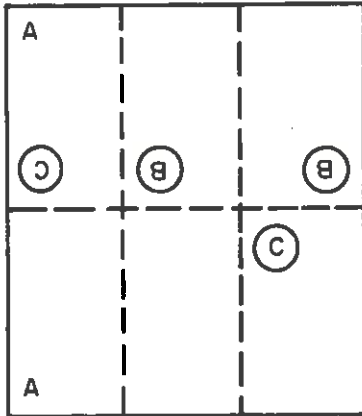
May be run two or more up and cut apart

**25****12-PAGE BOOK, SADDLE STITCH**Parallel: 1,2  
8-Page: 1**26****12-PAGE BOOK, SADDLE STITCH**Parallel: 1,2  
8-Page: 2**27****12-PAGE BOOK, SADDLE STITCH**Parallel: 1,3  
8-Page: 1**28****12-PAGE BOOK, SADDLE STITCH**Parallel: 1,2  
8-Page: 1**29****12-PAGE BOOK, SADDLE STITCH, DOUBLE IMPOSITION**Parallel: 1,2  
8-Page: 1,2,3

Must cut to saddle stitch

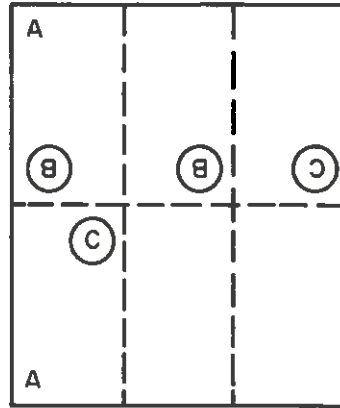
**30** 12-PAGE LETTER FOLD, HEADS OUT

Parallel: 1  
8-Page: 1,2



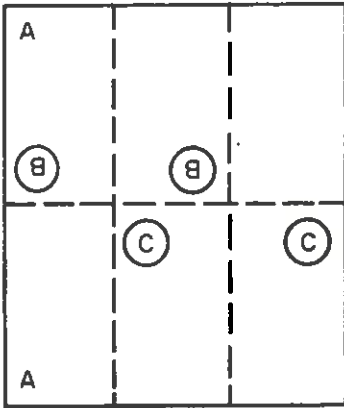
**31** 12-PAGE LETTER FOLD, HEADS IN

Parallel: 1  
8-Page: 1,3



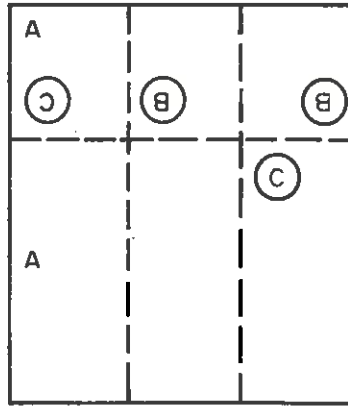
**32** 12-PAGE LETTER FOLD, ACCORDION

Parallel: 1  
8-Page: 1,2



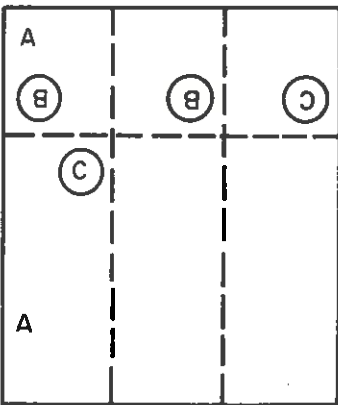
**33** 12-PAGE INSIDE FRENCH FOLD, HEADS OUT

Parallel: 1  
8-Page: 1,2



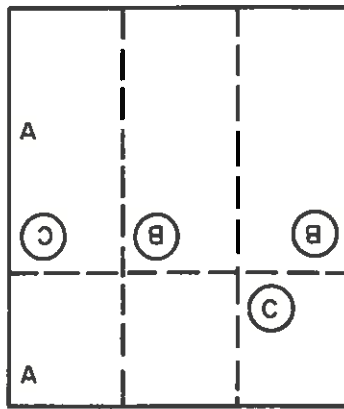
**34** 12-PAGE INSIDE FRENCH FOLD, HEADS IN

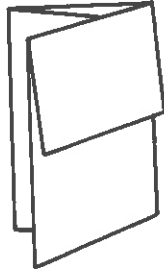
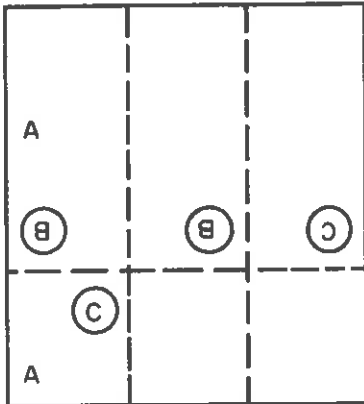
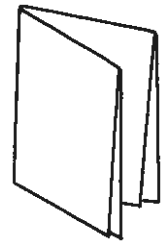
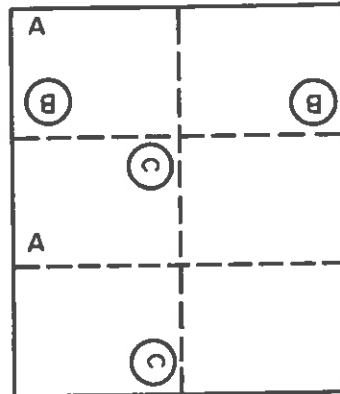
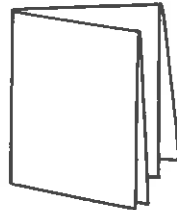
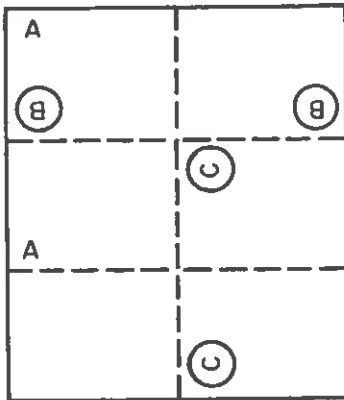
Parallel: 1  
8-Page: 1,3



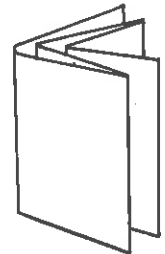
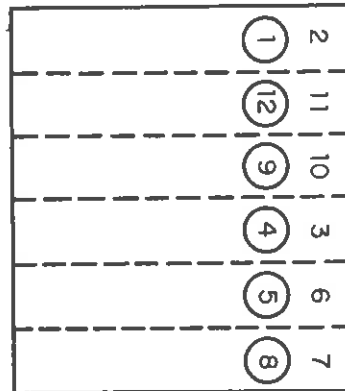
**35** 12-PAGE OUTSIDE FRENCH FOLD, HEADS OUT

Parallel: 1  
8-Page: 1,2



**36****12-PAGE OUTSIDE FRENCH FOLD, HEADS IN**Parallel: 1  
8-Page: 1,3**37****12-PAGE THREE RIGHT ANGLE FOLD**Parallel: 1  
8-Page: 1  
16-Page: 1**38****12-PAGE THREE RIGHT ANGLE FOLD**Parallel: 1  
8-Page: 1  
16-Page: 2**39****12-PAGE THREE PARALLEL BOOKLET**

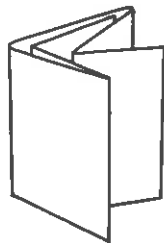
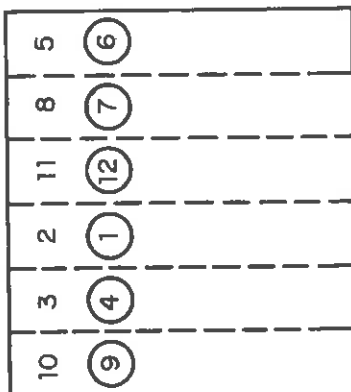
Parallel: 1,2,3



May be run two or more up and cut apart

**40****12-PAGE THREE PARALLEL BOOKLET**

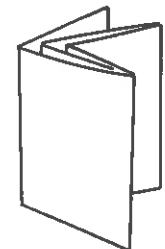
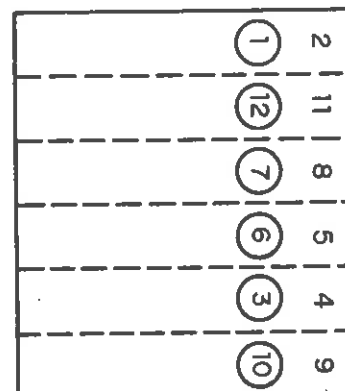
Parallel: 1,2,3



May be run two or more up and cut apart

**41****12-PAGE THREE PARALLEL BOOKLET**

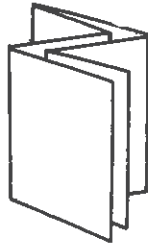
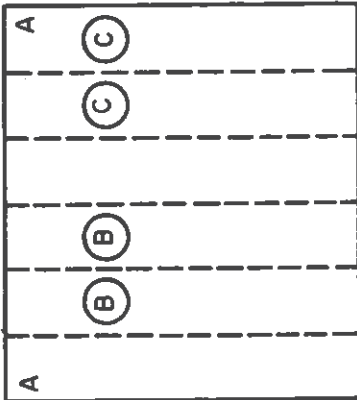
Parallel: 1,2,4



May be run two or more up and cut apart

**42****12-PAGE THREE PARALLEL FOLD**

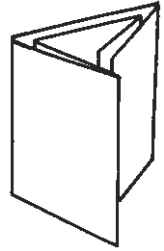
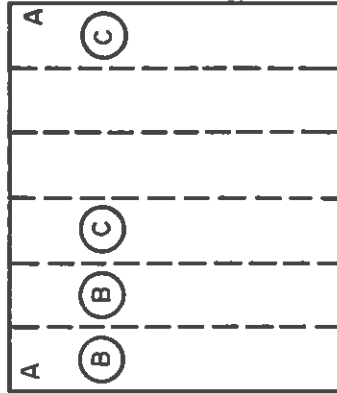
Parallel: 1,2,3



May be run two or more up and cut apart

**43****12-PAGE THREE PARALLEL**

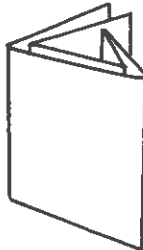
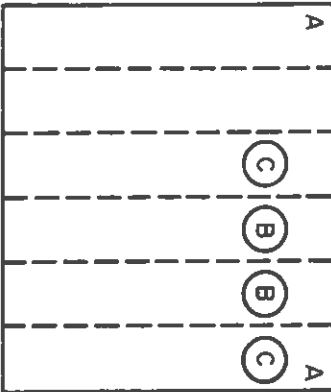
Parallel: 1,2,3



May be run two or more up and cut apart

**44****12-PAGE THREE PARALLEL**

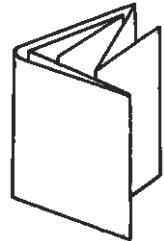
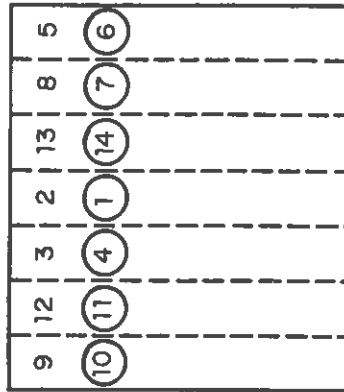
Parallel: 1,2,4



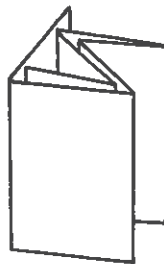
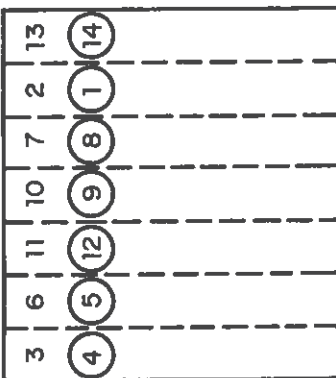
May be run two or more up and cut apart

**45****14-PAGE THREE PARALLEL**

Parallel: 1,2,3

**46****14-PAGE THREE PARALLEL**

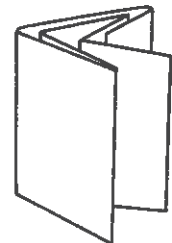
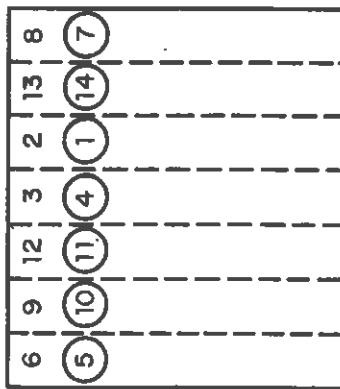
Parallel: 1,2,4



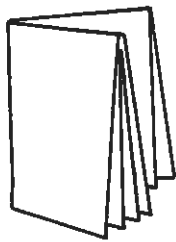
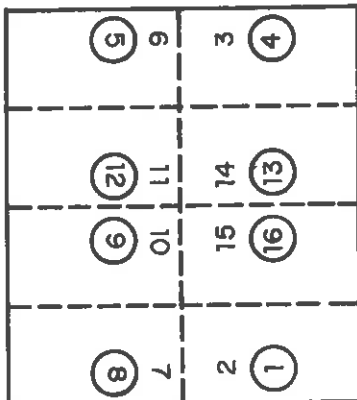
May be run two or more up and cut apart

**47****14-PAGE THREE PARALLEL**

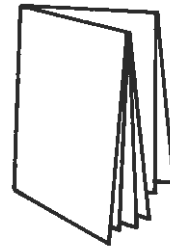
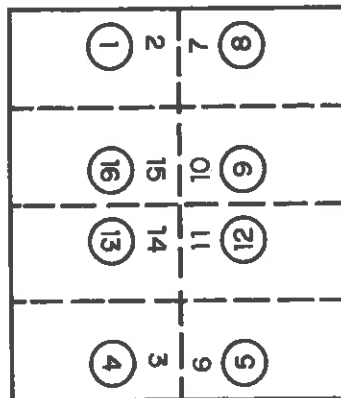
Parallel: 1,2,3



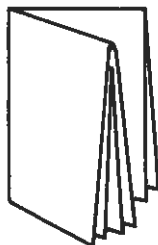
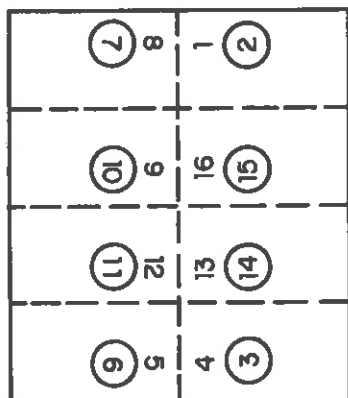
May be run two or more up and cut apart

**48****16-PAGE THREE RIGHT ANGLE BOOK IMPOSITION**Parallel: 1  
8-Page: 1  
16-Page: 1

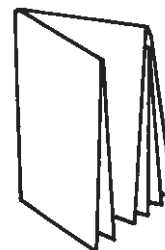
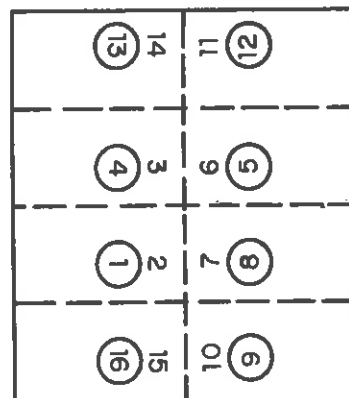
May be tun two or more up and cut apart

**49****16-PAGE THREE RIGHT ANGLE BOOK IMPOSITION**Parallel: 1  
8-Page: 2  
16-Page: 1

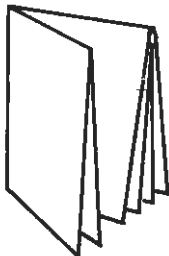
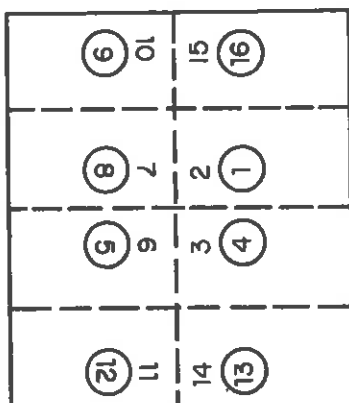
May be perforated at head

**50****16-PAGE THREE RIGHT ANGLE BOOK IMPOSITION**Parallel: 2  
8-Page: 1  
16-Page: 1

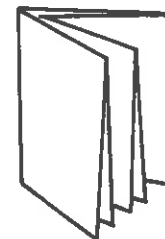
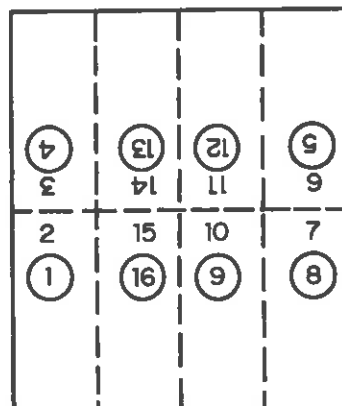
May be perforated at head

**51****16-PAGE THREE RIGHT ANGLE NEWSPAPER IMPOSITION**Parallel: 1  
8-Page: 1  
16-Page: 2

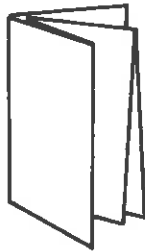
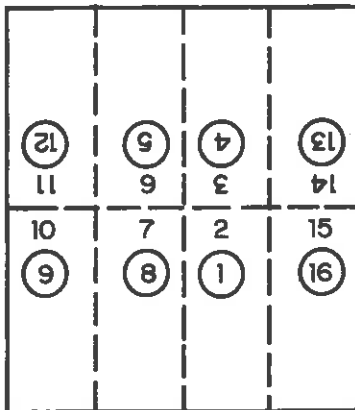
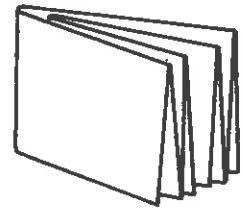
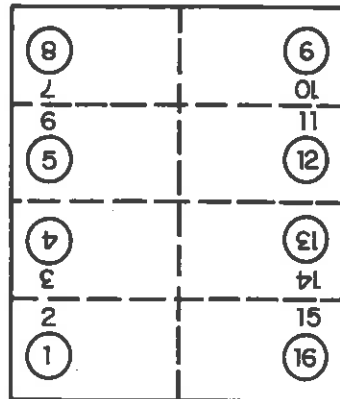
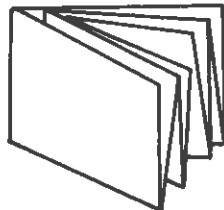
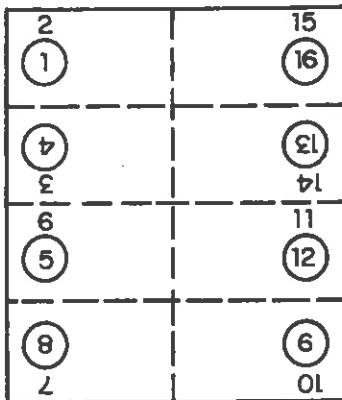
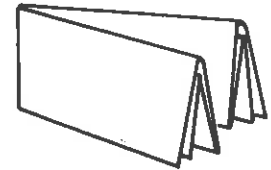
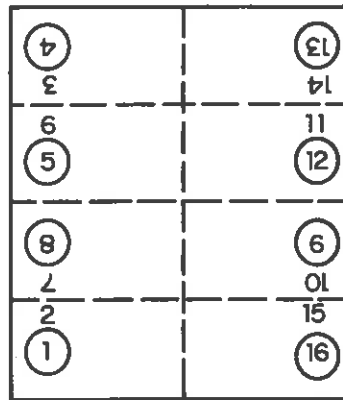
May be perforated at head

**52****16-PAGE THREE RIGHT ANGLE NEWSPAPER IMPOSITION**Parallel: 1  
8-Page: 2  
16-Page: 2

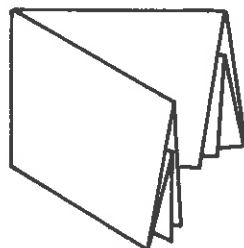
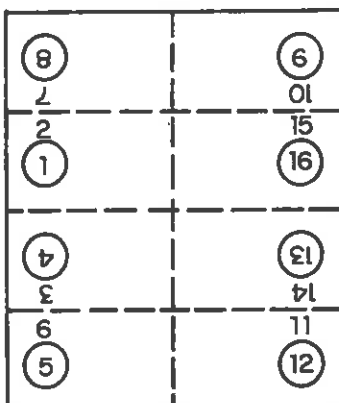
May be perforated at head

**53****16-PAGE FOLDER, HEADS OUT**Parallel: 1  
8-Page: 1,2

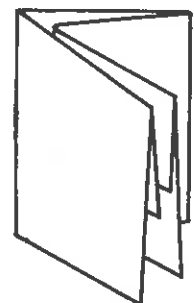
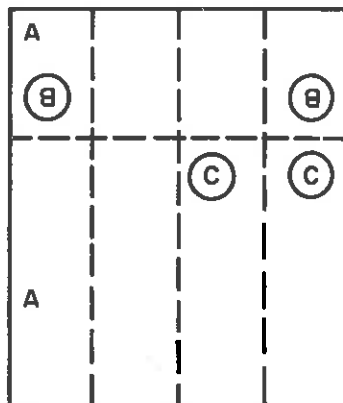


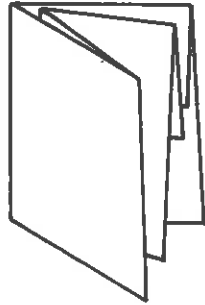
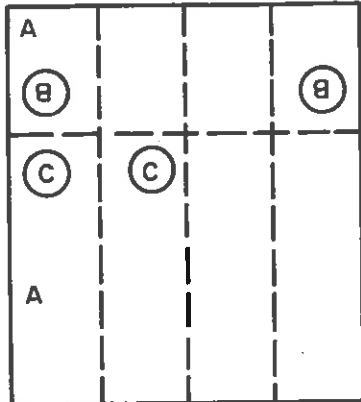
**54****16-PAGE FOLDER, HEADS IN**Parallel: 1  
8-Page: 1,3**55****16-PAGE OBLONG BOOKLET**Parallel: 1,2,3  
8-Page: 1**56****16-PAGE OBLONG BOOKLET**Parallel: 1,2,3  
8-Page: 2**57****16-PAGE OBLONG BOOKLET**Parallel: 1,3  
8-Page: 1

Not recommended for heavy sheets

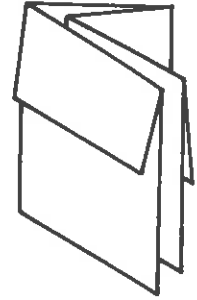
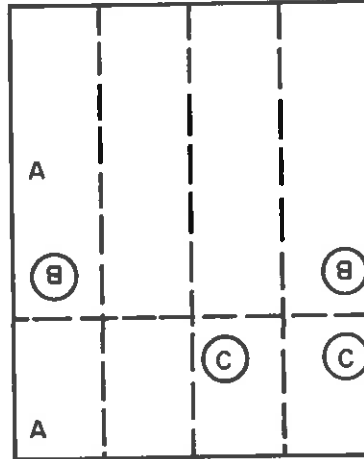
**58****16-PAGE OBLONG BOOKLET**Parallel: 1,2  
8-Page: 1

Not recommended for heavy sheets

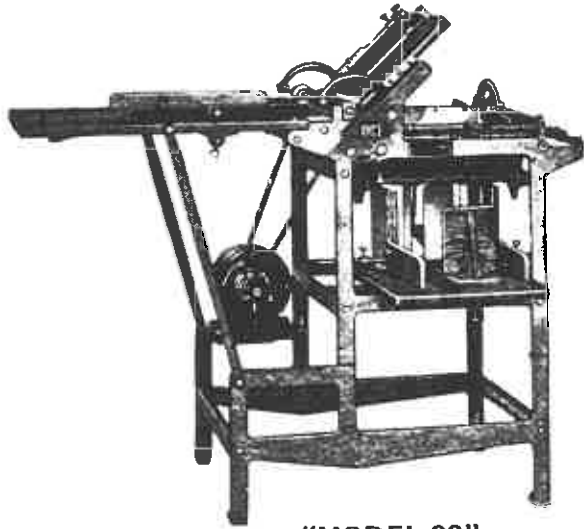
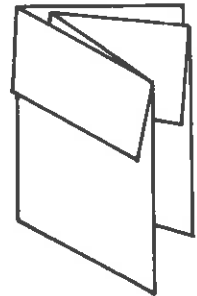
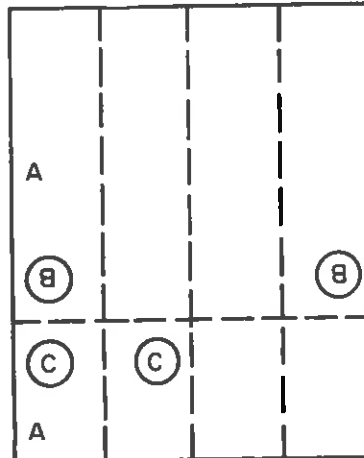
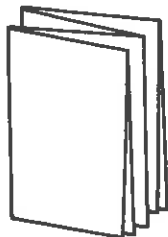
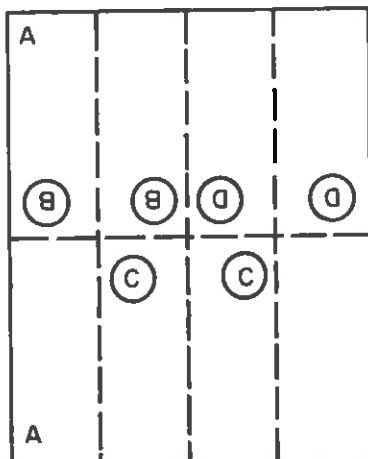
**59****16-PAGE INSIDE FRENCH FOLD, HEADS OUT**Parallel: 1  
8-Page: 1,2

**60****16-PAGE INSIDE FRENCH FOLD, HEADS IN**Parallel: 1  
8-Page: 1,3**61****16-PAGE OUTSIDE FRENCH FOLD, HEADS OUT**

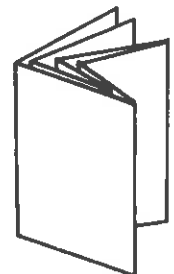
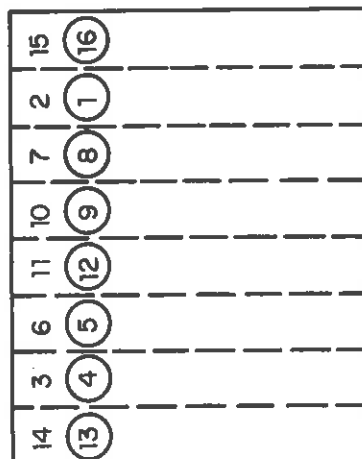
Parallel: 1      8-Page: 1,2

**62****16-PAGE OUTSIDE FRENCH FOLD, HEADS IN**

Parallel: 1      8-Page: 1,3

**"MODEL 90"**  
*circa 1920***63****16-PAGE FOLDER OR BROADSIDE**Parallel: 1  
8-Page: 1,2,3**64****16-PAGE THREE PARALLEL BOOKLET**

Parallel: 1,2,4

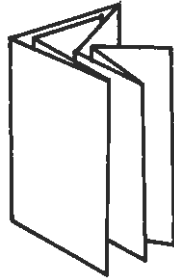


May be run two or more up and cut apart

**65****16-PAGE FOUR PARALLEL BOOKLET**

Parallel: 1,2,3,4

10	9	8	7	6	5	4	3	2	15
	9	8	7	6	5	4	3	2	15
	9	8	7	6	5	4	3	2	15
	9	8	7	6	5	4	3	2	15
	9	8	7	6	5	4	3	2	15
	9	8	7	6	5	4	3	2	15
	9	8	7	6	5	4	3	2	15
	9	8	7	6	5	4	3	2	15
	9	8	7	6	5	4	3	2	15
	9	8	7	6	5	4	3	2	15

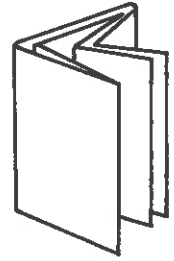


May be run two or more up and cut apart

**66****16-PAGE THREE PARALLEL BOOKLET**

Parallel: 1,2,3

6	5	4	3	2	15	10	7	8
	5	4	3	2	15	10	7	8
	5	4	3	2	15	10	7	8
	5	4	3	2	15	10	7	8
	5	4	3	2	15	10	7	8
	5	4	3	2	15	10	7	8
	5	4	3	2	15	10	7	8
	5	4	3	2	15	10	7	8
	5	4	3	2	15	10	7	8
	5	4	3	2	15	10	7	8

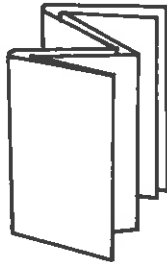


May be run two or more up and cut apart

**67****16-PAGE FOUR PARALLEL FOLDER**

Parallel: 1,2,3,4

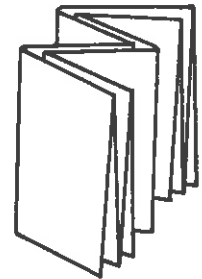
A									
	C								
	C								
		B							
		B							
		D							
		D							
A									



May be folded two or more up and cut apart

**68****16-PAGE BOOKLET, DOUBLE IMPOSITION**Parallel: 1,2,3  
8-Page: 1,2,3

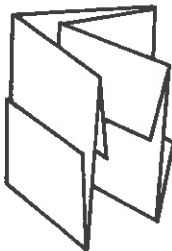
8	6	8	6
7	10	7	10
9	11	9	11
5	12	5	12
4	13	4	13
3	14	3	14
2	15	2	15
1	16	1	16



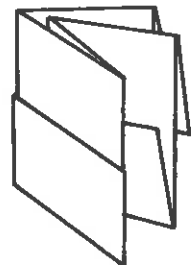
Trim front edge after folding

**69****16-PAGE BOOKLET, TWO ON**Parallel: 1,2  
8-Page: 1,2

91	1	8	6
91	2	7	10
14	3	6	11
13	4	5	12
2	91	10	7
1	91	6	8
4	13	12	5
3	14	11	6

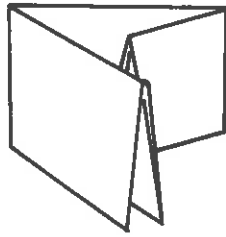
**70****16-PAGE BOOKLET, TWO ON**Parallel: 1,2  
8-Page: 1,3

8	6	91	1
7	10	91	2
9	11	14	3
5	12	13	4
10	7	2	91
6	8	1	91
12	5	4	13
11	6	3	14

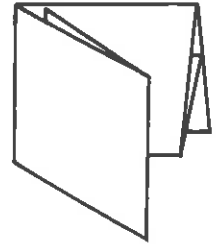


**71****18-PAGE BROADSIDE**Parallel: 1,3  
8-Page: 1,2

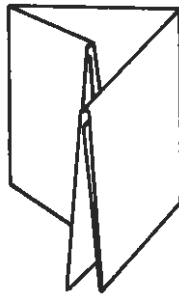
4 3	15 16	10 9
9 5	13 14	12 11
2 1	17 18	8 7

**72****18-PAGE BROADSIDE**Parallel: 1,3  
8-Page: 1,3

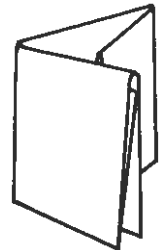
9 10	4 3	15 16
7 8	9 5	13 14
11 12	2 1	17 18

**73****18-PAGE BROADSIDE**Parallel: 1,2  
8-Page: 1,3

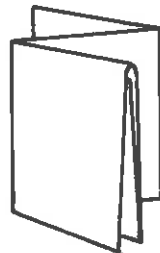
7 8	6 5	13 14
11 12	2 1	17 18
9 10	4 3	15 16

**74****18-PAGE BROADSIDE**Parallel: 1,2  
8-Page: 1,2

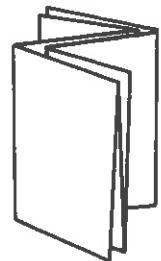
6 5	13 14	12 11
2 1	17 18	8 7
4 3	15 16	10 9

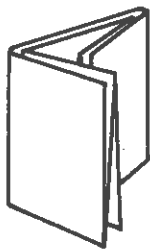
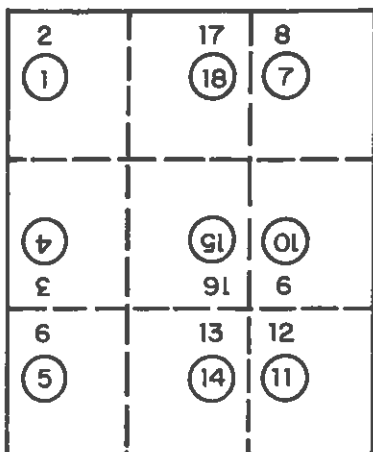
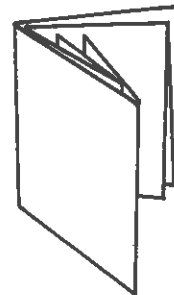
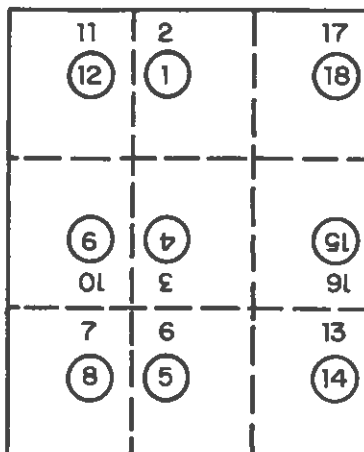
**75****18-PAGE BROADSIDE**Parallel: 1,2  
8-Page: 1,2

6 5	7 8	18 17
2 1	11 12	14 13
4 3	9 10	16 15

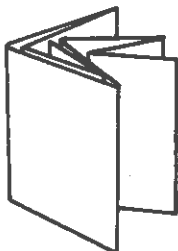
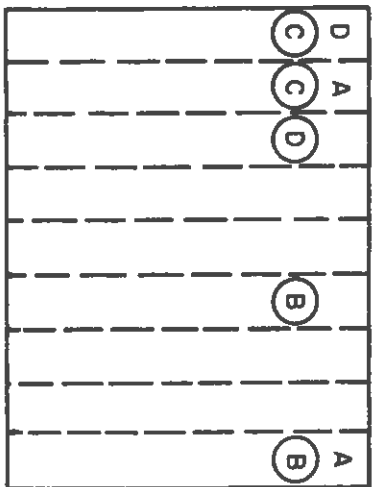
**76****18-PAGE BROADSIDE**Parallel: 1,2  
8-Page: 1,2

2 1	11 12	14 13
4 3	6 10	16 15
9 5	7 8	18 17



**77****18-PAGE BROADSIDE**Parallel: 1,2  
8-Page: 1,2**78****18-PAGE BROADSIDE**Parallel: 1,2  
8-Page: 1,3**79****18-PAGE FOUR PARALLEL**

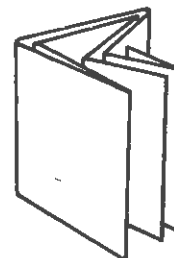
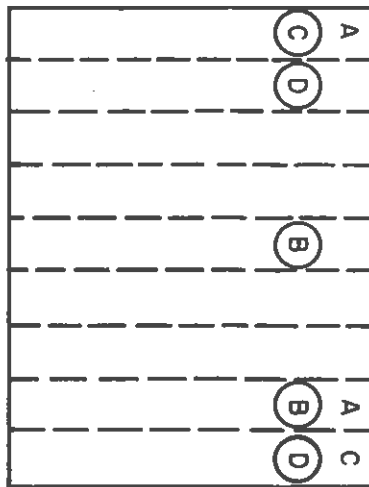
Parallel: 1,2,3,4



May be run two or more up and cut apart

**80****18-PAGE FOUR PARALLEL**

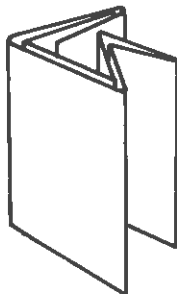
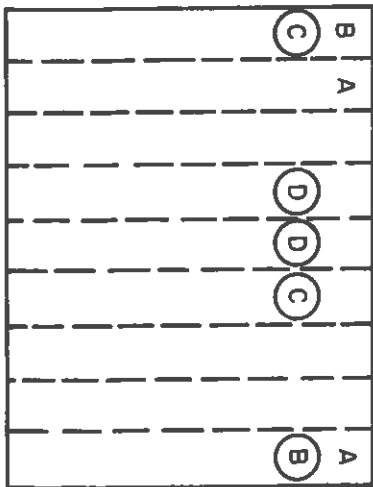
Parallel: 1,2,3,4



May be run two or more up and cut apart

**81****18-PAGE FOUR PARALLEL**

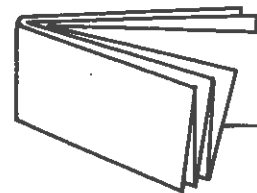
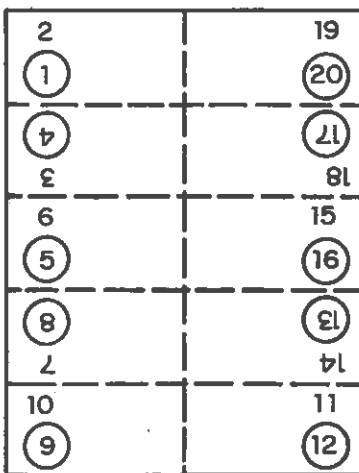
Parallel: 1,2,3,4

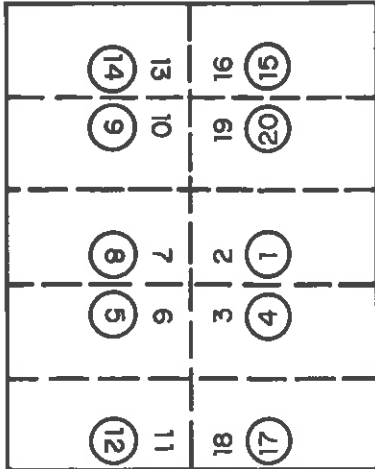


May be run two or more up and cut apart

**82****20-PAGE OBLONG BOOK**

Parallel: 1,2,3,4 8-Page: 1

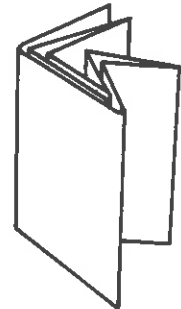
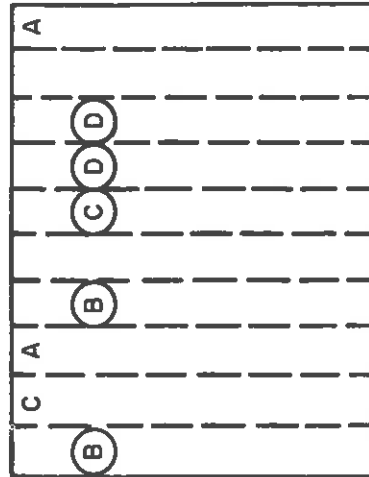


**83****20-PAGE UPRIGHT BOOKLET**Parallel: 1,2  
8-Page: 1,4

Leave 1/4" on pages 13 and 16 for binding saddle stitch

**84****20-PAGE FOUR PARALLEL BOOKLET**

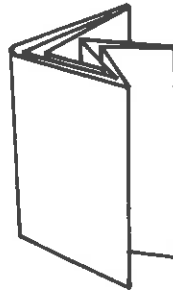
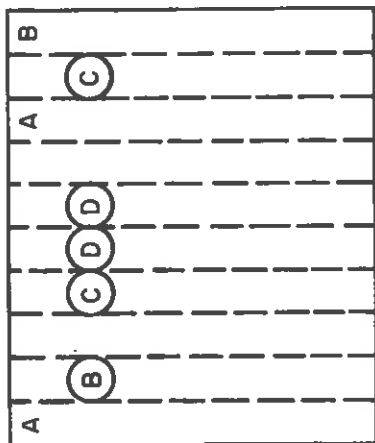
Parallel: 1,2,3,4



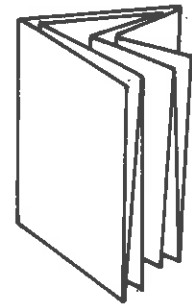
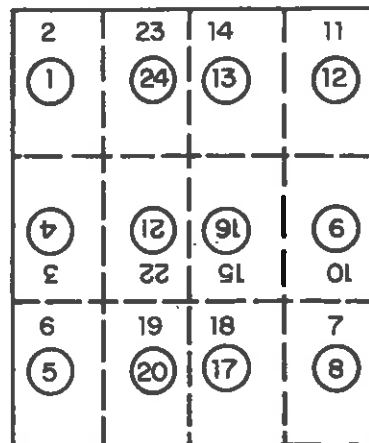
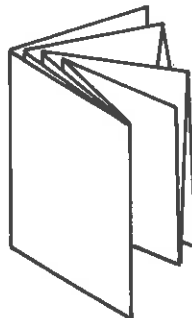
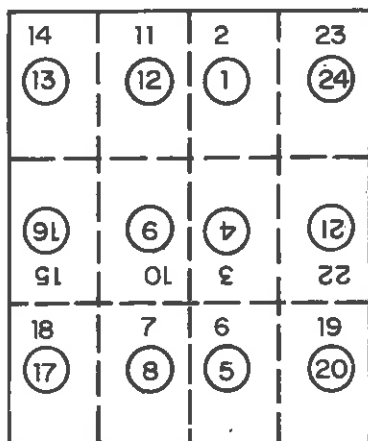
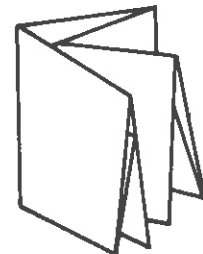
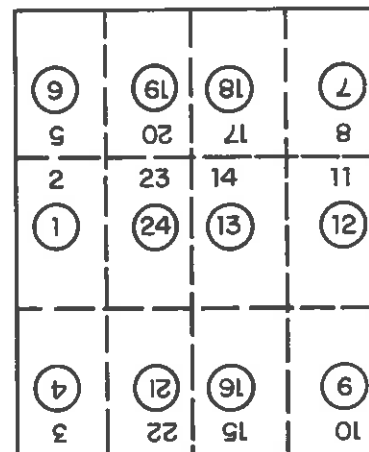
May be run two or more up and cut apart

**85****20-PAGE FOUR PARALLEL**

Parallel: 1,2,3,4

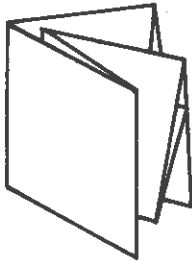


May be run two or more up and cut apart

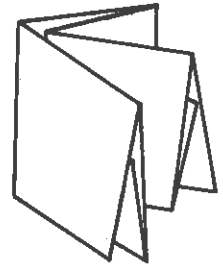
**86****24-PAGE BOOKLET**Parallel: 1,2  
8-Page: 1,2**87****24-PAGE BOOKLET**Parallel: 1,2  
8-Page: 1,3**88****24-PAGE BOOKLET**Parallel: 1,2  
8-Page: 1,2

**89****24-PAGE BOOKLET**Parallel: 1,2  
8-Page: 1,3

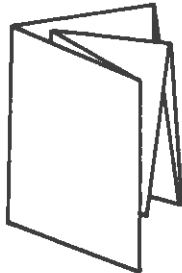
81 21	2 8	9 5	61 20
14 13	11 12	2 1	23 24
91 15	6 10	4 3	21 22

**90****24-PAGE BOOKLET**Parallel: 1,3  
8-Page: 1,2

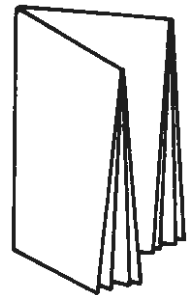
4 3	21 22	16 15	9 10
9 5	61 02	81 21	2 8
2 1	23 24	14 13	11 12

**91****24-PAGE BOOKLET**Parallel: 1,3  
8-Page: 1,3

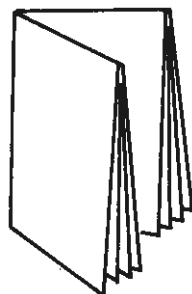
16 15	9 10	4 3	21 22
81 17	2 8	9 5	61 20
14 13	11 12	2 1	23 24

**92****24-PAGE RIGHT ANGLE BOOKLET**Parallel: 1,2  
8-Page: 1  
16-Page: 1

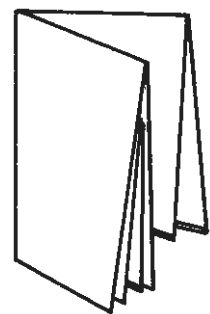
13 14	23 24	2 1	1 1
6 10	3 4	4 21	21 21
17 18	19 20	5 6	5 5

**93****24-PAGE RIGHT ANGLE BOOKLET**Parallel: 1,2      16-Page: 2  
8-Page: 1

1 2	11 12	21 22	21 21
24 23	41 42	91 92	61 62
4 3	01 02	8 7	8 7
5 6	7 8	11 12	11 12

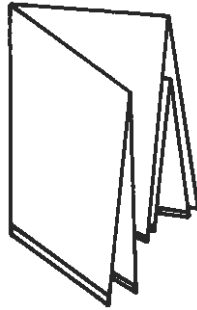
**94****24-PAGE RIGHT ANGLE BOOKLET**Parallel: 1,3  
8-Page: 1,4  
16-Page: 1

15 16	21 22	3 4	3 4
10 9	6 5	9 8	9 8
18 17	20 19	61 62	61 62
13 14	23 24	1 2	1 2

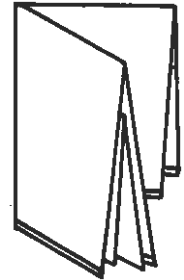


**95****24-PAGE RIGHT ANGLE BOOKLET**Parallel: 1,3      16-Page: 2  
8-Page: 1

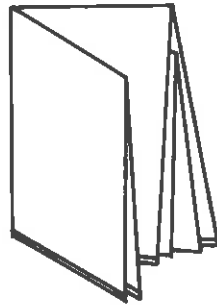
3	4	6	10
22	21	9	15
19	20	7	18
6	5	8	7
1	2	11	12
24	23	14	13

**96****24-PAGE RIGHT ANGLE BOOKLET**Parallel: 1,2  
8-Page: 1  
16-Page: 1

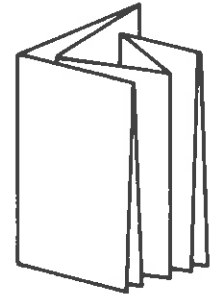
7	8	5	9
18	17	20	19
13	14	23	24
12	11	2	1
9	10	3	4
16	15	22	12

**97****24-PAGE RIGHT ANGLE BOOKLET**Parallel: 1,2      16-Page: 2  
8-Page: 1

19	20	17	18
6	5	8	7
1	2	11	12
24	23	14	13
21	22	15	16
4	3	10	9

**98****24-PAGE RIGHT ANGLE BOOKLET**Parallel: 1  
8-Page: 1,2,3

4	21	20	5	12	13
3	22	19	6	11	14
2	23	18	7	10	15
1	24	17	8	9	16

**99****24-PAGE RIGHT ANGLE DOUBLE LETTER FOLD**

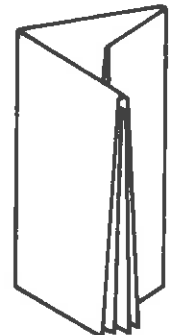
Parallel: 1      8-Page: 1      16-Page: 1,2

A		
B		B
	D	
	C	
A	C	D

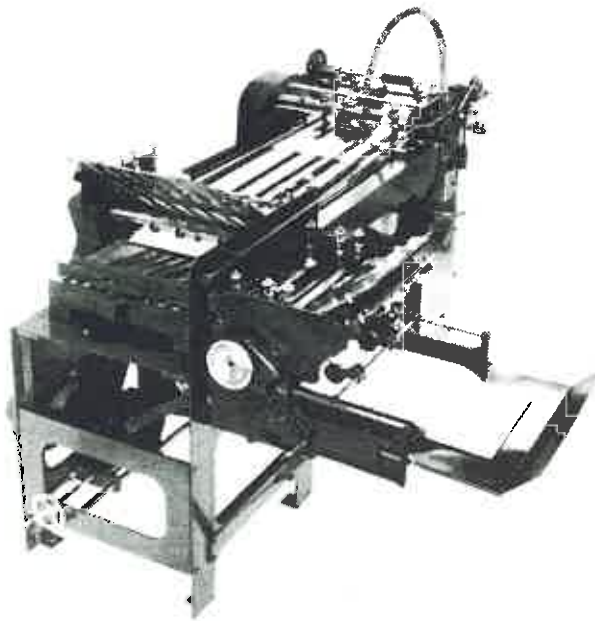
**100****24-PAGE RIGHT ANGLE DOUBLE LETTER FOLD**

Parallel: 1      8-Page: 1      16-Page: 1,3

A		
B		B
	C	D
	C	
A	D	







**"JUNIOR JET" - Introduced in 1950**

**101** 24-PAGE FOLDER OR BROADSIDE  
 Parallel: 1,2  
 8-Page: 1,2

A		
(D)	(C)	(C)
		(D)
	(B)	
A	(B)	

**102** 24-PAGE FOLDER OR BROADSIDE  
 Parallel: 1,2  
 8-Page: 1,3

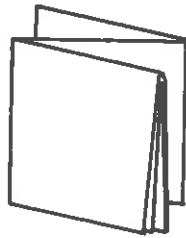
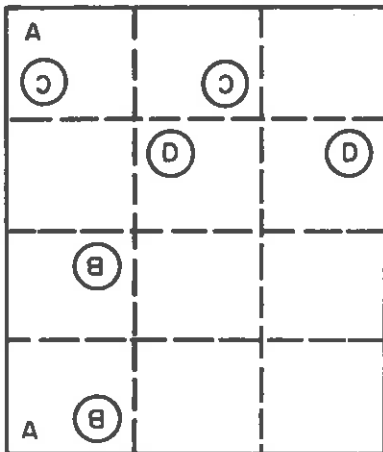
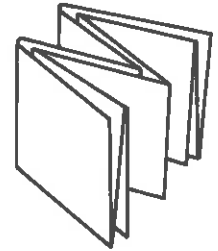
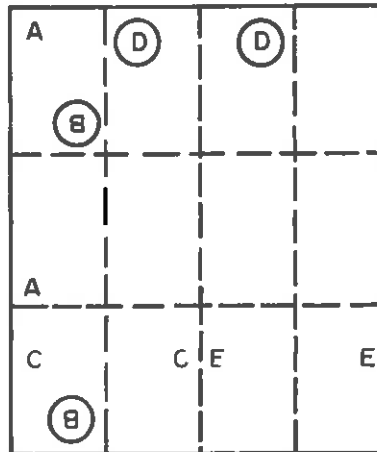
A		
(C)	(C)	(D)
	(D)	
	(B)	
A	(B)	

**103** 24-PAGE FOLDER OR BROADSIDE  
 Parallel: 1,3  
 8-Page: 1,3

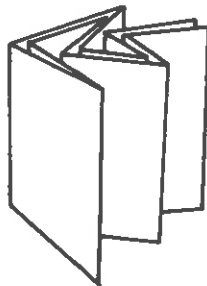
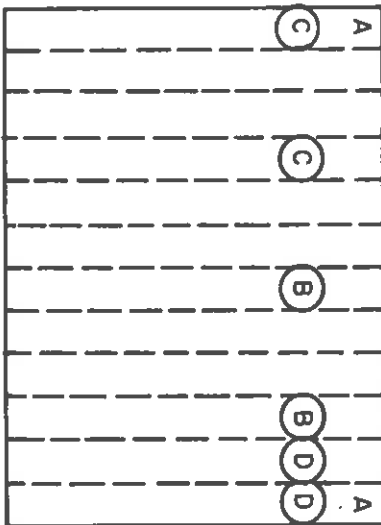
A	(B)	
	(B)	
(C)	(C)	(D)
A	(D)	

**104** 24-PAGE FOLDER OR BROADSIDE  
 Parallel: 1,3  
 8-Page: 1,2

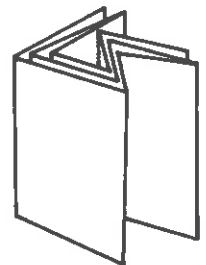
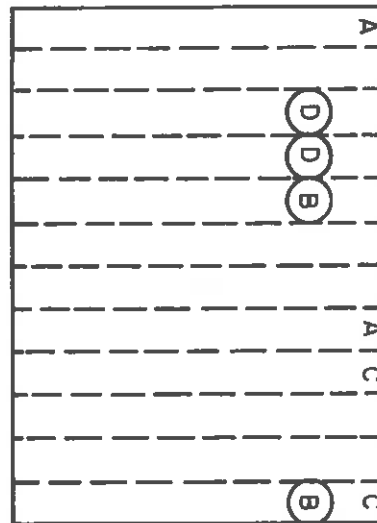
A		
(B)		
	(B)	
(D)	(C)	(D) (C)
A		

**105****24-PAGE FOLDER OR BROADSIDE**Parallel: 1,2  
8-Page: 1,2**106****24-PAGE FOLDER OR BROADSIDE**Parallel: 1,2  
8-Page: 1,2,3**107****24-PAGE FOUR PARALLEL**

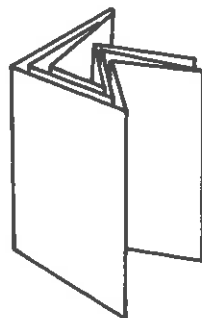
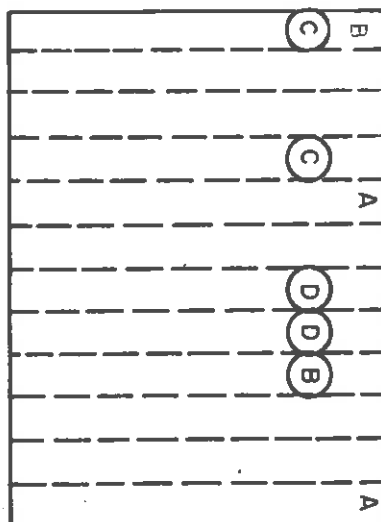
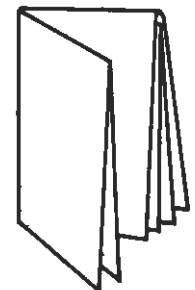
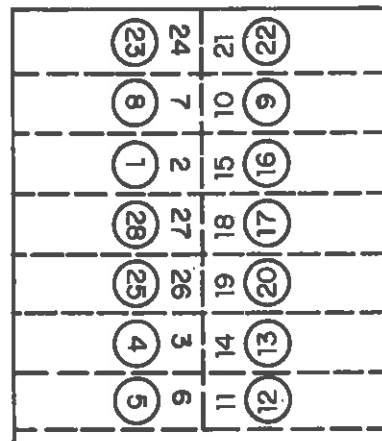
Parallel: 1,2,3,4

**108****24-PAGE FOUR PARALLEL**

Parallel: 1,2,3,4

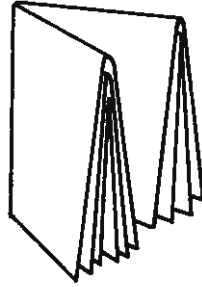
**109****24-PAGE FOUR PARALLEL**

Parallel: 1,2,3,4

**110****28-PAGE BOOK**Parallel: 1,2  
8-Page: 1  
16-Page: 2Leave 1/4" for binding  
pages 6 and 11 in stitch  
book. Perforate Head

**123****32-PAGE BOOK**Parallel: 1,2,3    16-Page: 1  
8-Page: 1

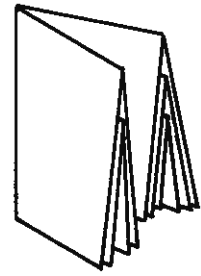
9	10	7	8
24	23	26	25
21	22	27	28
12	11	6	5
13	14	3	4
20	19	30	29
17	18	31	32
16	15	2	1



Perforate Head

**124****32-PAGE BOOK**Parallel: 1,2,3    16-Page: 2  
8-Page: 1

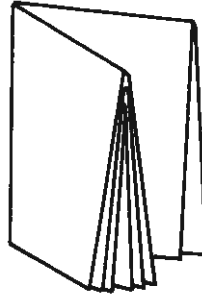
25	26	23	24
8	7	01	6
5	6	11	12
28	27	22	21
29	30	19	20
4	3	14	13
1	2	15	16
32	31	18	17



Perforate Head

**125****32-PAGE BOOK**Parallel: 1,3    16-Page: 1  
8-Page: 1

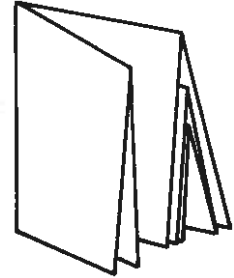
13	14	3	4
20	19	30	29
21	22	27	28
12	11	6	5
9	10	7	8
24	23	26	25
17	18	31	32
16	15	2	1



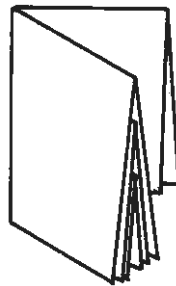
Perforate Head

**126****32-PAGE BOOK**Parallel: 1,3    16-Page: 2  
8-Page: 1

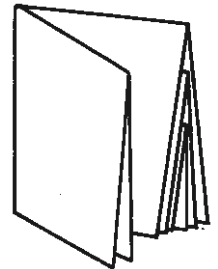
29	30	61	20
4	3	41	13
5	6	11	12
28	27	22	21
25	26	23	24
8	7	01	6
1	2	15	16
31	32	18	17

**127****32-PAGE BOOK**Parallel: 1,2    16-Page: 1  
8-Page: 1

9	10	7	8
24	23	26	25
17	18	16	15
16	15	2	1
13	14	3	4
20	19	30	29
21	22	27	28
12	11	6	5

**128****32-PAGE BOOK**Parallel: 1,2    16-Page: 2  
8-Page: 1

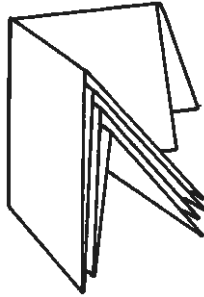
25	26	23	24
8	7	01	6
1	2	15	16
32	31	18	17
29	30	19	20
4	3	14	13
5	6	11	12
28	27	22	21



**129****32-PAGE BOOK**

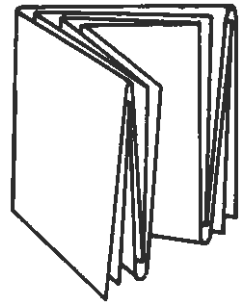
Parallel: 1      16-Page: 1  
 8-Page: 1      32-Page: 2

		A	
B			B
	C		
		D	D
C		A	

**130****36-PAGE BOOK**

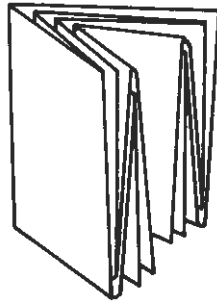
Parallel: 1,2  
 8-Page: 1,2  
 16-Page: 2

17	18	7	8	5	6
20	19	30	62	32	31
21	22	27	82	33	34
16	15	10	6	4	3
13	14	11	21	1	2
24	23	26	52	36	35

**131****36-PAGE BOOK**

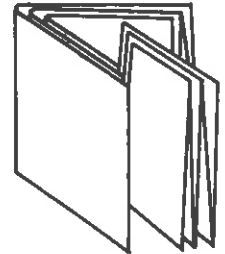
Parallel: 1,2      16-Page: 1  
 8-Page: 1,2

35	36	25	92	23	24
2	1	12	11	14	13
3	4	6	10	15	16
34	33	82	22	21	21
31	32	62	30	19	20
6	5	8	7	18	17

**132****40-PAGE BOOK**

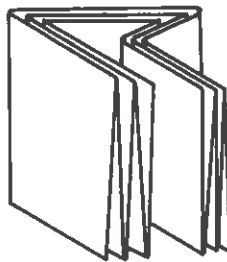
Parallel: 1,2,3,4  
 8-Page: 1,2

40	1	20	21
39	2	61	22
38	3	18	23
37	4	17	24
36	5	16	25
35	6	15	26
34	7	14	27
33	8	13	28
32	9	12	29
31	10	11	30

**133****40-PAGE BOOK**

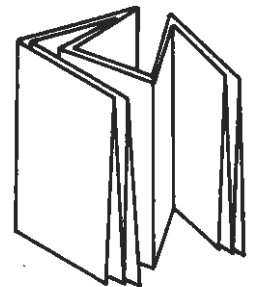
Parallel: 1,2,3,4  
 8-Page: 1,3

20	21	40	1
19	22	39	2
18	23	38	3
17	24	37	4
16	25	36	5
15	26	35	6
14	27	34	7
13	28	33	8
12	29	32	9
11	30	31	10

**134****48-PAGE BOOK**

Parallel: 1,2,3  
 8-Page: 1,2,3

8	41	40	9	24	25
7	42	39	10	23	26
9	43	38	11	22	27
5	44	37	12	21	28
4	45	36	13	20	29
3	46	35	14	19	30
2	47	34	15	18	31
1	48	33	16	17	32



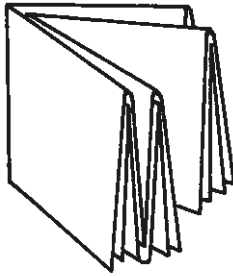
Try stock before  
 printing

# 135

## 48-PAGE BOOK, OBLONG

Parallel: 1,2  
8-Page: 1,2,3  
16-Page: 1

25	26	35	93	37	38	47	48
24	23	41	31	12	11	2	1
21	22	51	91	9	10	3	4
28	27	43	33	40	39	46	45
29	30	13	32	41	42	43	44
20	19	81	21	8	7	6	5



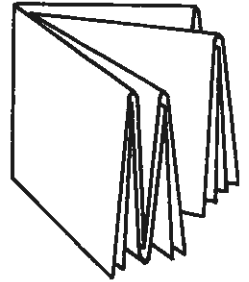
Try stock before printing. May be perforated head and foot

# 136

## 48-PAGE BOOK, OBLONG

Parallel: 1,2  
8-Page: 1,2,3  
16-Page: 2

1	2	11	21	13	14	23	42
48	47	38	25	36	35	92	52
45	46	36	04	33	34	22	82
4	3	01	6	16	15	22	12
5	6	7	8	17	18	61	02
44	43	24	14	32	31	30	62



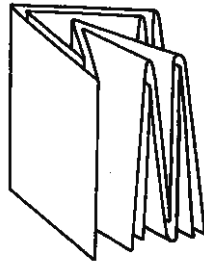
Try stock before printing. May be perforated head and foot

# 137

## 64-PAGE BOOK

Parallel: 1  
8-Page: 1,2,3  
16-Page: 1,2

45	46	34	44	37	38	52	93
20	19	22	12	28	27	03	62
13	14	11	21	5	6	3	4
52	51	45	39	60	59	29	19
49	50	95	95	57	58	39	49
16	15	01	6	8	7	2	1
17	18	23	42	25	26	31	32
48	47	24	14	40	39	43	33



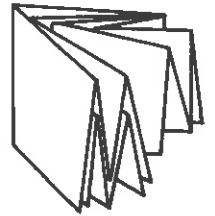
Try stock before printing. May be perforated head and foot

# 138

## 64-PAGE BOOK

Parallel: 1  
8-Page: 1,2,3  
16-Page: 1,3

13	14	11	21	5	6	3	4
52	51	45	35	60	59	29	19
45	46	34	44	37	38	52	93
20	19	22	12	28	27	03	62
17	18	32	42	25	26	13	23
48	47	24	14	40	39	43	33
49	50	95	95	57	58	39	49
16	15	01	6	8	7	2	1

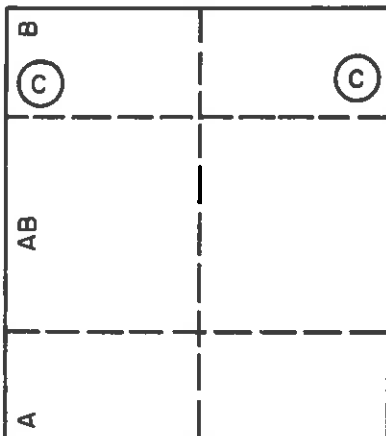


Try stock before printing. May be perforated head and foot

# 139

## SEMI-GATE FOLD & ONE FIRST RIGHT ANGLE

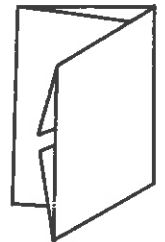
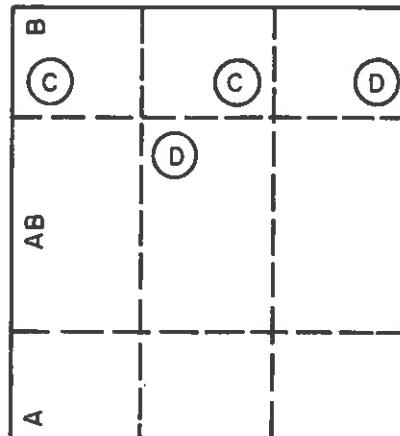
Parallel: 1,2  
8-Page: 1



# 140

## SEMI-GATE FOLD & TWO PARALLEL AT RIGHT ANGLE

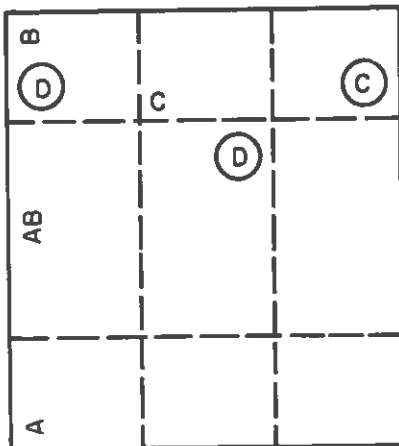
Parallel: 1,2  
8-Page: 1,3



# 141

## SEMI-GATE FOLD & TWO PARALLEL AT RIGHT ANGLE

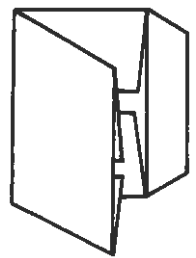
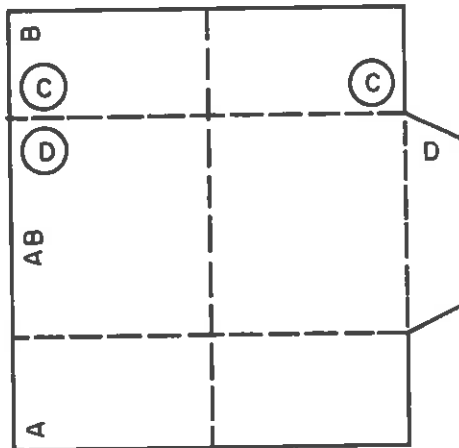
Parallel: 1,2  
8-Page: 1,2



# 142

## ORDER BLANK ENVELOPE

Parallel: 1,2  
8-Page: 1,3

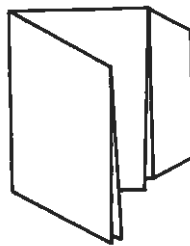
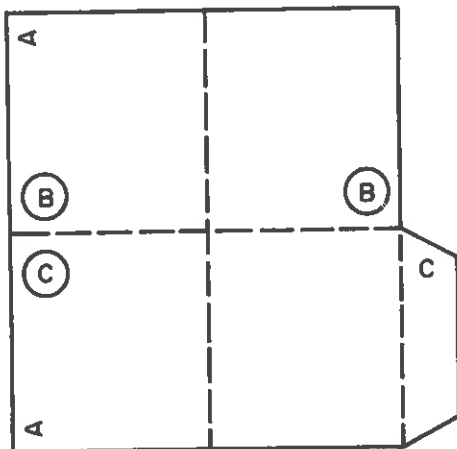


Flap must be 1½" wide

# 143

## ORDER BLANK ENVELOPE

Parallel: 1  
8-Page: 1,3

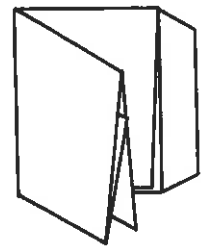
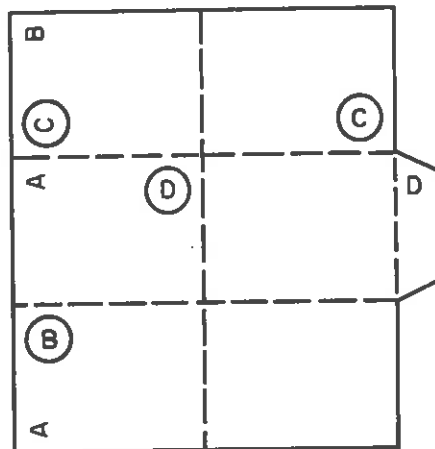


Flap must be 1½" wide

# 144

## ORDER BLANK ENVELOPE

Parallel: 1,2  
8-Page: 1,3

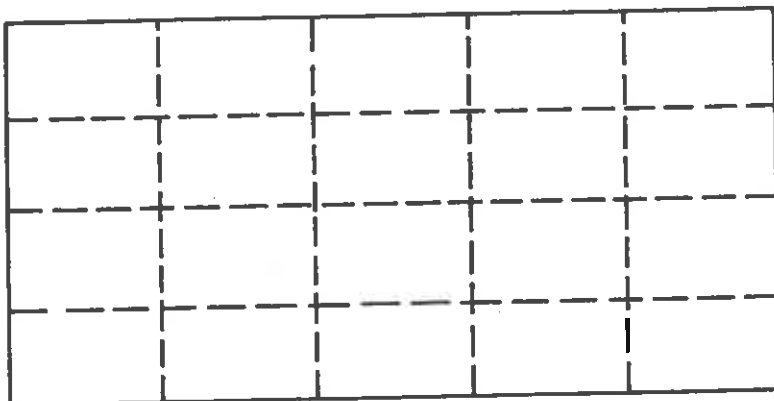


Flap must be 1½" wide

# 145

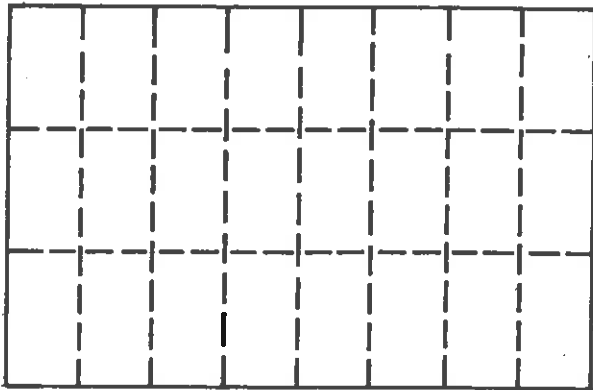
## MAP FOLD

MAP FOLDS SHOWN IN IMPOSITIONS 145 THROUGH 151 MAY BE ACHIEVED IN A VARIETY OF WAYS WITH DIFFERENT BAUMFOLDERS. CHECK YOUR IMPOSITION CAREFULLY, AND IF YOU REQUIRE ASSISTANCE, CALL YOUR BAUMFOLDER REPRESENTATIVE.



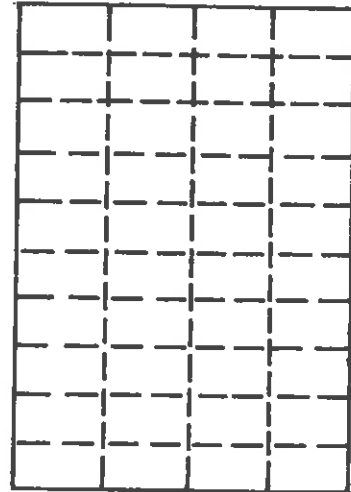
**146**

MAP FOLD



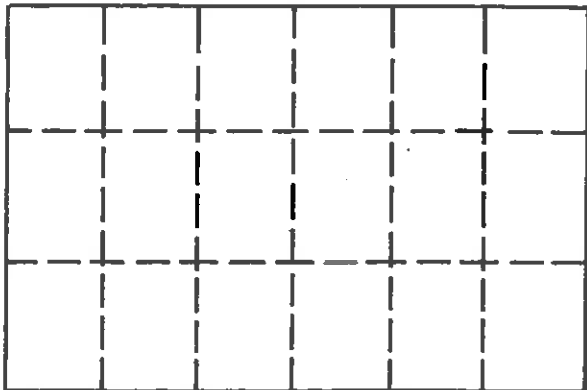
**147**

MAP FOLD



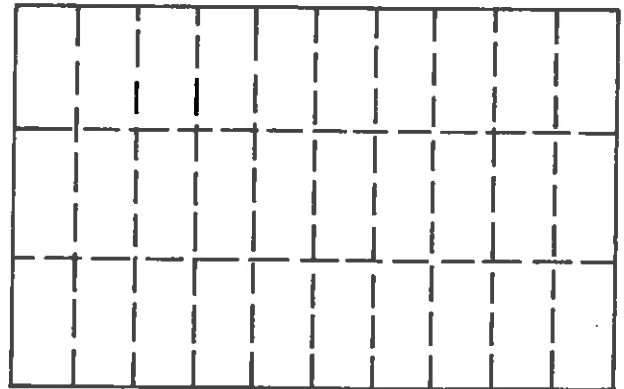
**148**

MAP FOLD



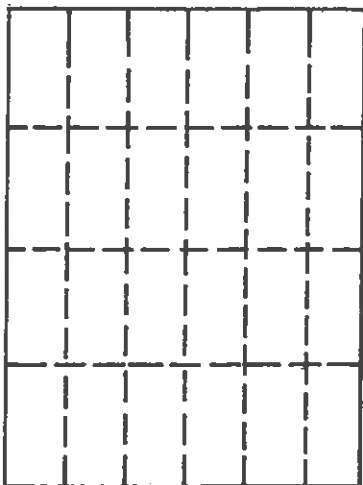
**149**

MAP FOLD



**150**

MAP FOLD



**151**

MAP FOLD

