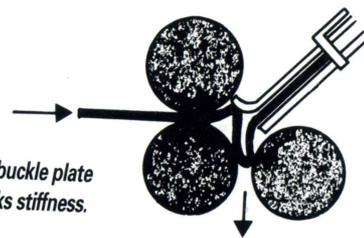


FOLDERS

Fortunately, or unfortunately, depending on how you look at it, nearly every problem encountered with today's folding equipment is due to incorrect setting by the operator; and more than 50 per cent of call-outs by suppliers results in the engineer doing nothing more than adjusting settings which the operator could and should have done.

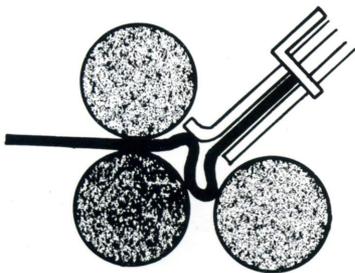
Often, the operator will make several adjustments to the folder and start the machine without checking the initial settings, which may well be affected by subsequent ones. Production pressure has much to do with this and a common mistake is to adjust settings, such as roller pressure, on-the-run. This type of adjustment is impossible to carry out properly without stopping the folder.

(Always return to zero those settings not required). An extra 20 minutes making sure that feeder, roller and plate settings are correct would solve the majority of folder problems.

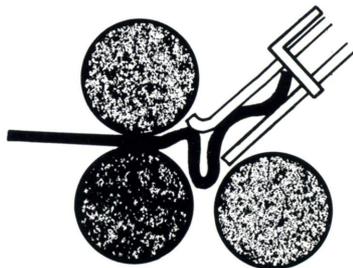


A small buckle space and a narrow buckle plate are needed if the stock is thin or lacks stiffness.

If the buckle space is too large the sheet will not be able to be controlled on buckling.



If the buckle plate gap is too large the stock will bend causing inaccurate folding.



A buckle plate which is too small will not allow the stock to buckle sufficiently to be drawn into the rollers.

