

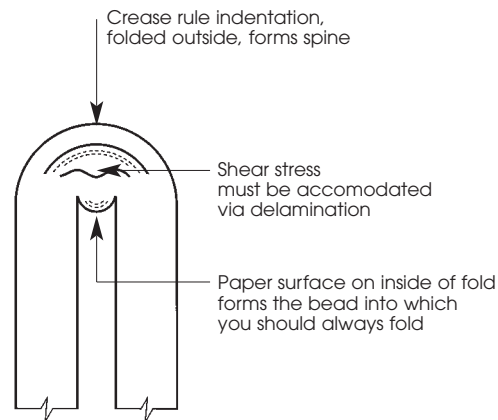
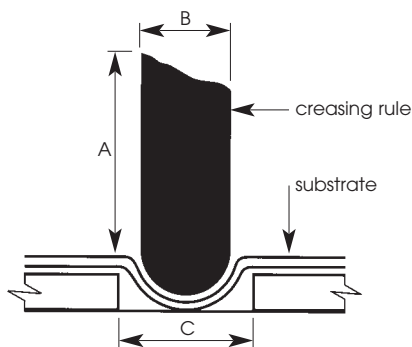
A Guide to Successful Folding

All materials of 150 g/m² and above, particularly coated stock, should be pre-creased.

Where a cylinder machine is used there will be a difference in the characteristics between creases formed around and those across the width of the cylinder. For this reason it may be necessary to use different rule heights in each direction; for example, reduction of the creasing rule height in the direction of sheet travel. Creasing with a platen machine requires common ruling.

There are a number of characteristics that will affect foldability, ie bulk, grain direction and rigidity. In some instances boards as low as 200 g/m² can be of a laminated construction which will dramatically alter rigidity compared to non-laminated board. It is therefore essential that the forme supplier is made aware of the type of product to be processed, supplying him with samples for testing.

The width of the matrix (C) is determined by the thickness of the creasing rule (B) and the caliper of the substrate



Rule and matrix guide

(when using a 23.80 mm height cutting rule)

Material caliper (um)	Crease rule height (mm)	Crease rule width	Matrix groove width (mm)
120	23.50	1.5 / 2 pt	0.8
150	23.45	1.5 / 2 pt	0.8
170	23.40	1.5 / 2 pt	0.8
220	23.35	2 pt	1.0
250	23.30	2 pt	1.3
350	23.25	2 pt	1.3
450	23.15	2 pt	1.5
520	23.10	2 / 3 pt	1.5
600	23.00	2 / 3 pt	1.7