

A Guide to Successful Folding (continued)

Do's and Don't's

- ✓ In order to produce constant crack-free folds we suggest a platen approach using a creasing rule and matrix system. Always fold into the bead. Folding around the bead is likely to produce cracking.
- ✓ Check the quality of fold during production on a regular basis. If cracking is evident, stop. An adjustment may well rectify the problem.
- ✓ Take care at guillotine stage. Use minimum clamp pressure to avoid damaging the bead.
- ✓ Ensure a minimum distance of 4-6 mm between parallel folds.

- ✗ Do not attempt to rotary crease or score. There is little if any adjustment with this method; it is ineffective and damaging to the surface.
- ✗ Do not use UV varnish in areas to be pre-creased.
- ✗ Do not subject the printed material to dry conditions. Folding quality deteriorates as the moisture content of the substrate decreases.

Hints and tips

Problem	Likely cause	Solution
Crease cracks in centre fold	Creasing rule too high	Lower rule required
Crease cracks at one edge of fold	Creasing rule not in correct alignment with centre of matrix	a If hand cut m/r, trim edge b If matrix strip, replace c If counter die, reposition, use a wider channel or replace
Crease cracks at two edges of fold	Channel too narrow	Use a wider channel
Poor definition of crease	Creasing rule too low or channel too wide	Increase height of rule, using shim tape if appropriate, or use a narrower channel
Head collapses at back of crease	Creasing rule too low	Increase height of rule, using shim tape if appropriate
Poor definition of crease in poor quality board	Channel depth may be too shallow	Use deeper matrix
Bruising at end of creases	Too much pressure	Rub down or chamfer ends of matrix