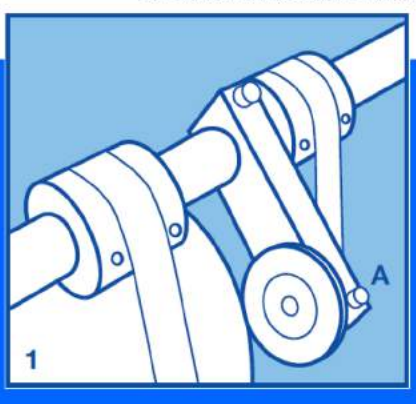
SPINE-CREASER

For ST-350 & ST-450

INSTALLATION GUIDE

Before installation make sure all power to the machine is switched off. Ensure that all residue such as dust and grease is wiped from the feeder drum using white spirit or similar cleaning substances.

The cover feeder clutch must be set in the out of drive mode to allow a forward motion of the drum to be manually turned during make ready.

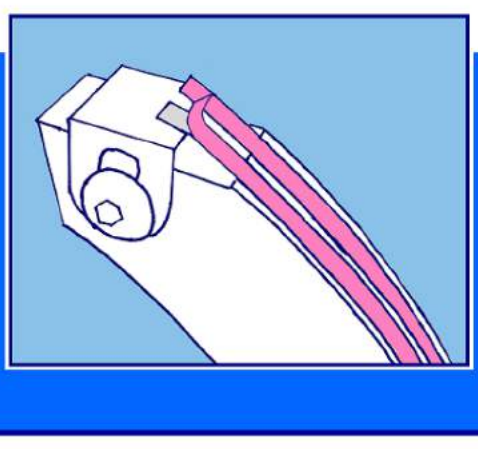


Step 1 - Remove Old Device

Remove the creasing wheel (A) with a No 5 hexagon key located in the pressure creasing arm.

Remove the Tech-ni-Fold stud located in one of the females supplied using a No 5 hexagon key.

Slide the new stud through the 17mm opening on the creasing arm (A) and tighten with a No 5 hexagon key.

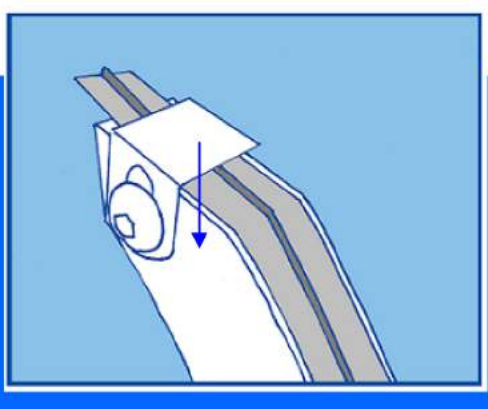


Place the red 2 sided adhesive on each side of the stainless steel horseshoe drum.
Remove the protection strip to expose the adhesive.

As shown in diagram

Choose the male rubber creasing matrix which corresponds to the weight of the stock you are about to crease.

Orange dot	(Mould 154)	100-135gsm
White dot	(Mould 153)	135-300gsm
Yellow dot	(Mould 01)	250-350gsm

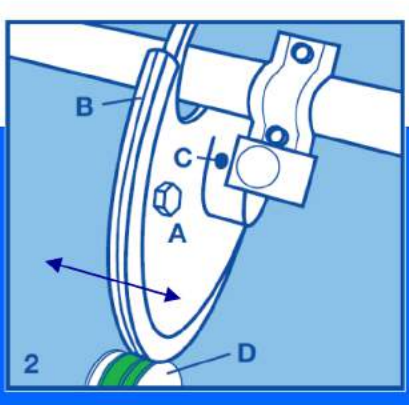


Insert black creasing matrix into the alignment channel.
Place matrix under the brackets.

Push bracket onto matrix and tighten fixing screw.
Trim of any protruding surplus matrix.

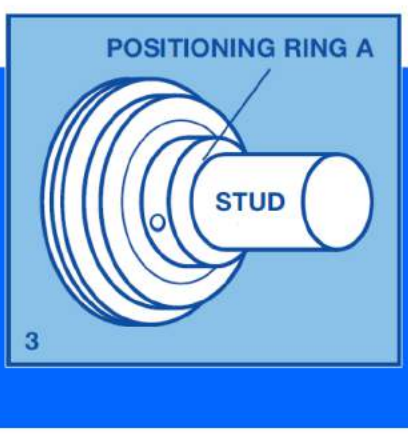
Step 2

Unscrew the 3 x 10mm bolts (A) that hold the horseshoe creaser to the drum. These are located in the centre of the cover feeder, the horseshoe should now be detached and hang loosely from the drum.
With the gripper and sucker bar facing towards the direction of the stitching heads the horseshoe needs to be rotated by hand in a clockwise direction so that it can be pulled free without getting stuck on any feeding mechanisms.
The new stainless steel horseshoe can now be fixed back onto the drum using the same method as the removal process.



Centralise the horseshoe drum.

Loosen the 2 screws holding drum (C) on the main drive shaft. Gently push the drum sideways to centralise the matrix with the centre of the green recessed belt (D) this is located immediately after the horseshoe. When this has been achieved retighten the 2 drum fixing screws.



Step 3 - Choosing the female channel width

Orange dot	Small	100-200gsm
White dot	Medium	170-330gsm
Yellow dot	Large	280-350gsm

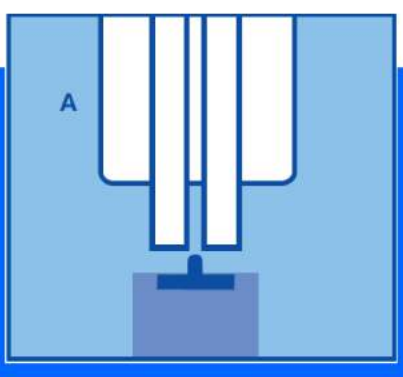
See diagram 1 for attaching the female
(shown at top of page)

Push the desired female onto the special fitting 17mm stud and tighten with a No 5 hexagon key.

Centralising the female channel

Loosen the screw (A) as shown in diagram 1, with the No. 5 hexagon key holding the stud in place.

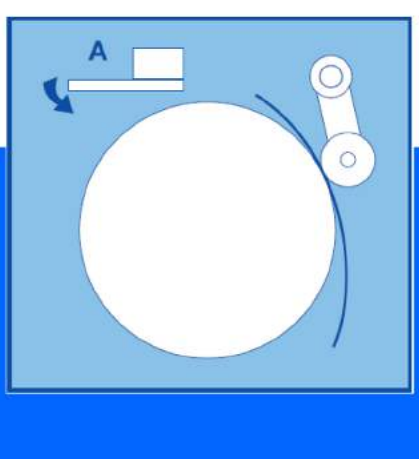
Align the female into the centre of the black rubber matrix. Place a piece of cover stock in between the matrix and the female and slowly rotate the drum by hand. As the cover stock rotates through the creasing components the loose female will automatically adjust to the optimum creasing position.
While the paper is still held in position tighten the screw (A) as shown in diagram 1 using No. 5 Hexagon key.



The positioning ring (A) on diagram 3 should be pushed against the creasing arm and locked in place using a 2.5mm hexagon key. This ensures that if the stud is removed the position of the ring automatically aligns the creasing matrix to the correct position.

It is important to remember that maximum results can only be achieved through central alignment of the female channel to the creasing matrix.

Step 4 - Setting the calliper



Place the correct stock into the callipers and adjust until the optimum crease is obtained. The female should spin freely where there is no cover stock passing over the female.

The Tech-ni-Fold Spine Creaser installation is now complete.

Installing a new matrix

When removing the old glue strip from the matrix it is important to remove all the clear plastic tape that is hidden inside the glue strip. Clean the old glue away using white spirit and dry. Rub the horseshoe recess with an abrasive brush to remove all traces of the spirit as this can dissolve the glue strip on the back of the new matrix.

MATRIX CREASING GUIDE

There are three types of Matrix available to crease the full range of cover stock materials

ORANGE	100-135 gsm
WHITE	135-300 gsm
YELLOW	250-350 gsm (Wide option)

RE-USABLE MATRIX
Each matrix can be carefully peeled off and re-used

We also provide creasing solutions for the following machines:

Folding Machines
Stahl/Heidelberg, MBO, Herzog & Haymann, GUK, Horizon, Shoei, Baum, Morgana, MB

Creasing Machines
CreaseStream, Rollem, Rosback, Agor

Stitchers
Heidelberg, Muller Martini, Hohner, Osako

Perfect Binders
Muller Martini, Kolbus, Wohlenberg, Horizon, Harris

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