

Folder with Glue

June 2016

The information below reflects the standards for this equipment. Please contact department manager for questions on projects that may fall outside of the standard. If you are unsure about any of the information, please check with manager or estimating.

Flat Minimum 4.75" Width
Finished Minimum 4" x 4.75"
Stock Minimum 60# Text

Flat Maximum 30" Width
Stock Maximum 10pt

Modifiers

Name	MR Time	MR Waste	Run Speed	Run Waste
Additional Helper	N/A	N/A	N/A	N/A
Additional MR Minutes	Enter Additional Minutes	N/A	N/A	N/A
Additional MR Sheets	N/A	Enter Additional Sheets	N/A	N/A
Fold w/ 1 Fugitive Glue Head	15 Minutes	N/A	N/A	N/A
Fold w/ 2 Fugitive Glue Head	30 Minutes	N/A	N/A	N/A
Fold w/ 3 Fugitive Glue Head	45 Minutes	N/A	Reduce 40%	N/A
Fold w/ 4 Fugitive Glue Head	60 Minutes	N/A	Reduce 50%	N/A
Score/Perf	15 Minutes	N/A	Reduce 15%	N/A

Equipment Notes

Can NOT Do Closed Double Gate Folder

20" Max Width for Moll Score in line

Can use either Permanent or Fugitive Glue

Knock Out for glue areas on all pieces with permanent glue

Other Info

OK to Use UV

Helpers

Use additional Helpers when:

Variable Data

Quantities over 75,000

Batching

Over 6 Versions of material

Fold/Slit Material

Sort for USPS In-Line

50,000 MINIMUM Quantity

30% slowdown

Add 2 Helpers – (result is Operator + 2 additional helpers)

MAX RUN SPEED 11,500/HR

Document owner to approve spec sheet. After approval, deliver to Estimating Manager for final review. Approval by document owner and Estimating Manager is needed for update of controlled form.