

Folders 23", 26", 30" w/ right angles

January 2017

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.

12pt Maximum for Buckle folders

Final fold Minimum: 2" – If final fold under 3", stock MUST BE 7pt or greater
Minimum Width: 4-3/4" (*Consult with Bindery Manager on smaller pieces*)

Slit sheets in-line: Can slit w/ no gutter up to a 3up sheet
Gutter Trims: Must allow for .25 slit off - .5" TOTAL gutter

Moll Score / Fold in-line: Maximum of 2 scores
Maximum width of feeding edge 20" (except for signature folding)

32 page signatures: Max 60# Offset

Envelope Folding: *Use Envelope Fold Modifier*

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
2up & Slit	20 Minutes	0	Reduce 30%	N/A
3up & Slit	40 Mintes	0	Reduce 40%	0
Fold Envelope	0	0	Reduce 30%	0
Folder Score/Perf	15 Minutes	0	Reduce 15%	0
Map Fold MR	120 Minutes	100 Sheets	N/A	N/A

Helpers

Use additional Helpers when:

Variable Data

Batching

Over 6 Versions of material

Fold/Slit Material

Carton for multiple up jobs

23" Folder

1st Unit 6 plate 23" max width (3up/3down) Either straight or 90° angle to next unit

2nd Unit 4 plate 22" max width (2up/2down)

26" Folder

1st Unit 6 plate 26" max width (3up/3down) Either straight or 90° angle to next unit

2nd Unit 4 plate 26" max width (2up/2down) Either straight or 90° angle to next unit

3rd Unit 4 plate 23" max width (3up/3down)

30" Folder

1st Unit 4 plate 30" max width (2up/2down) Either straight or 90° angle to next unit

2nd Unit 4 plate 27" max width (2up/2down) Either straight or 90° angle to next unit

3rd Unit 4 plate 23" max width (2up/2down)

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.