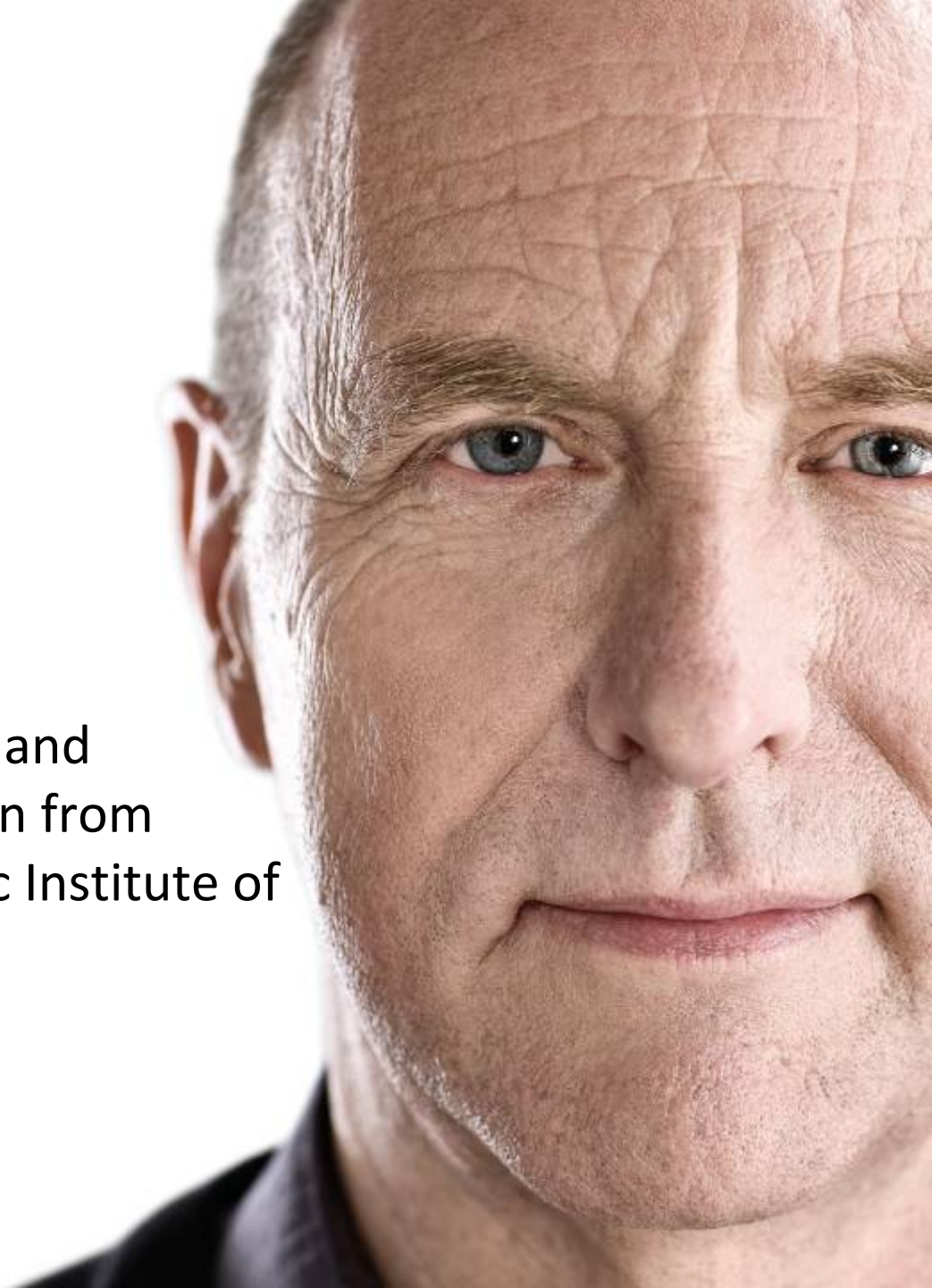


# Who cares?

## Folding and Finishing

Excerpts from 'Responsibility and Performance' – a presentation from StoraEnso for the Lithographic Institute of Australia (LIA).



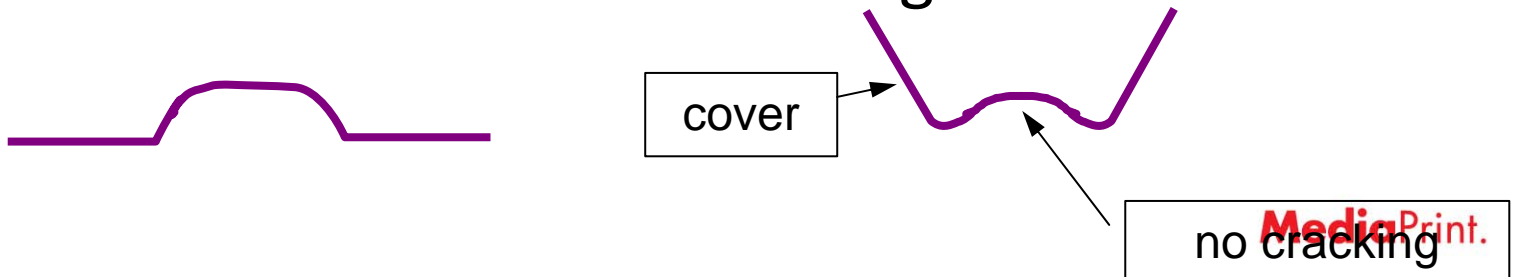
## Folding & Finishing

- Folding machines work to speeds as up to around 15,000 to 18,000 per hour
- However many machines only run at about 7,000 to 10,000 per hour
- Paper weight is a factor
- Cracking will make the process slower, so a more flexible paper will allow for faster folding speeds for the given weight of paper

# Cracking on the fold - tips

who cares?

- Scoring and folding recommended to be done close to paper RH% area
  - Oulu grades RH% 45-55%
  - increased cracking if
    - dry conditions
    - long waiting times printing – scoring - folding
  - scoring recommended over 170g
  - best result on Oulu cover weights with score I

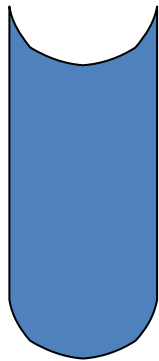


Who cares?

## Creasing / Scoring

Creasing and folding conditions as close to paper RH as possible, i.e. **RH 45 - 55 %**, more dry condition, paper will break more easily.

170 gsm and over, is recommended to crease before folding.



Crease line,  
Must be exactly in the middle of  
counterpart

Counterpart,  
groove is  $\frac{1}{2}$  - 1 mm wider than crease line.  
The thicker the paper the bigger the  
difference

# Cracking

who cares?



Creased before folding

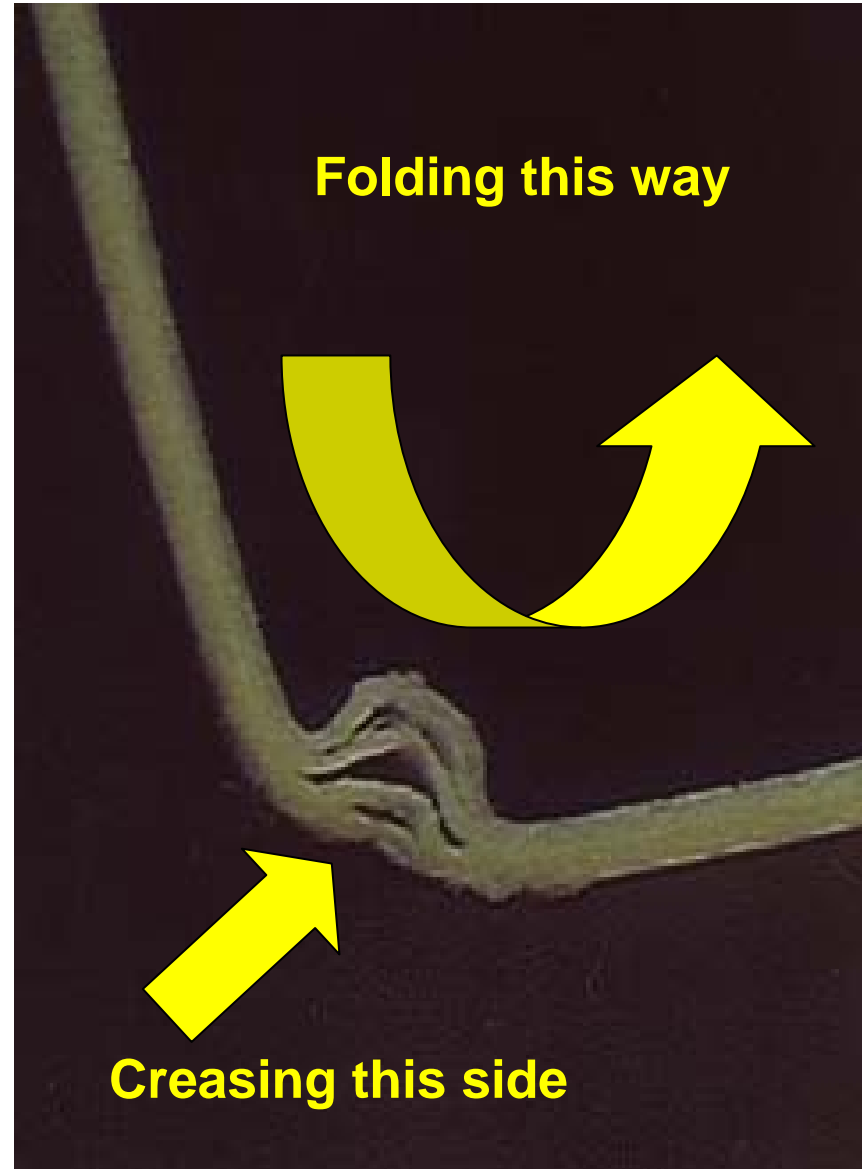
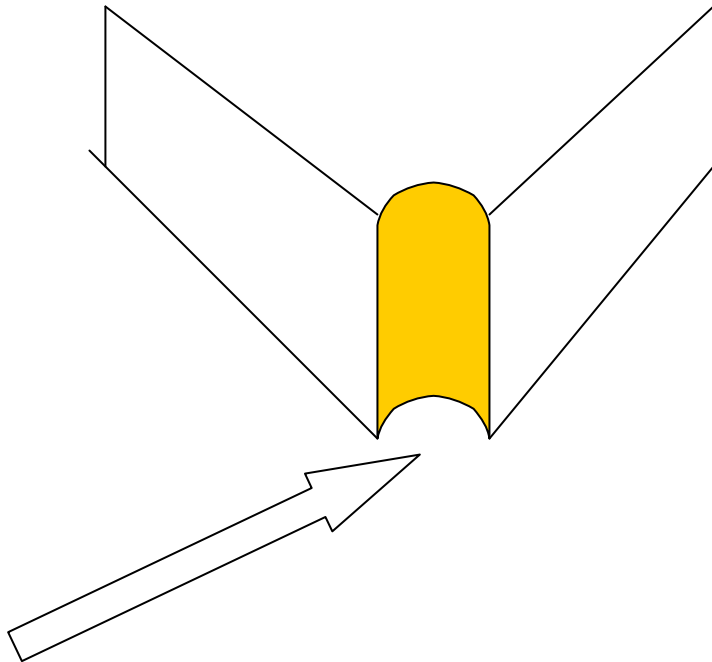
Not Creased

Same paper in these tests

# Creasing ( score)

who cares?

The only and right way to do creasing before doing folding



Burgo, CD

M-Real I, CD

M-Real II, CD

Sappi I, CD

Sappi II, CD

StoraEnso Oulu, CD

UPM, CD

GLOSS