



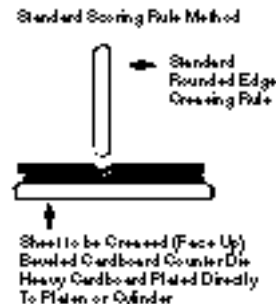
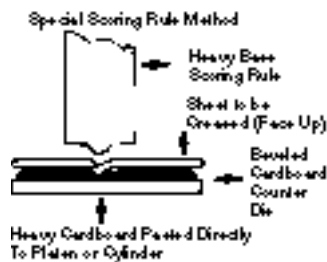
CREASING AND FOLDING

Most coated and uncoated bristols, translucents, cardboards and cover stocks can be folded without breaking if they are properly creased. The old method of scoring with a sharp rule is practically obsolete. Sharp rules merely cut the surface and when folded, split the surface. Proper creasing will give a "hinge" fold which does not crack or break.

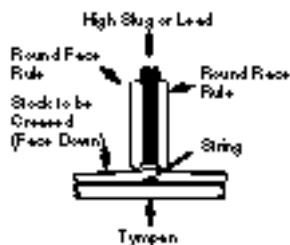
Round Faced Rule Scoring Method: The most successful method of scoring or creasing is the round faced rule scoring method. Use a rule with a round or very blunt creasing edge. The thickness of the rule used is determined by the thickness of the stock to be creased.

A. Paste a piece of heavy cardboard .040 thickness or over, directly to the press platen or cylinder to serve as the foundation of the counter. This cardboard should be a soft consistency in order that it may not offer too much resistance to the stock to be creased.

B. Pull a light impression of scoring rule or male die. On each side of this impression paste parallel strips of hard cardboard or Bristol, to form the sides of the channel. Make the strips of hard, smooth board, 4 to 5 ply in thickness. The inside edges of these strips should be beveled at about 130 degrees for perfect results. The width of the channel formed by these parallel strips depends upon the thickness of the stock to be creased. Make the channel wide enough to receive the scoring rule and stock to be creased, without "pinching" or great pressure. Heavy impression should be avoided as it will rupture the stock. Usually the best results are obtained by making the crease on the outside of fold (see illustration "C").



The success of the fold depends upon the "hinge". It is a common error in creasing heavy stock to make the crease too narrow: in creasing thin stock, to make the crease too broad. There is a tendency in all cases to make the crease too shallow. A deep and well defined channel is necessary to form the "hinge".



String Scoring Method: The shrink and rule score is a simplified method favored by many printers. A form of two-point brass rules with two-, three-, four- or six-point "high" spacing between them is used, according to the thickness of stock to be scored.

An impression is pulled on the tympan and a length of string is stretched on the top sheets to register between the double-rule impression, forming a die. Seal the string to tympan with gummed tape. Feed the sheet so that the outer side faces the tympan. Regulate the pressure to obtain a clean, unbroken score.

Other Methods: Bristols and heavy stocks are frequently scored at the same time printing is done.

Scoring While Printing, using a brass rule in the printing form, eliminates an extra scoring impression, but is used only where jobs are not of a critical character.

Press Scoring Wheels. Small automatics and cylinder presses are usually equipped with special scoring wheels which is practical, providing the stock is not too heavy.