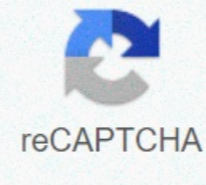




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## Stahl folder operator manual

Learning to run a folding machine can be a little overwhelming, especially if you thrust directly into the bindery department's production environment without much training. I remember my first day on the job of being shown an antique Baum folding machine and thinking, Seriously now... that thing actually folds the paper? To me old Baum looked like something from my grandparents generation that would be belching steam or smoke. Maybe it even requires a team of horses. It was a greasy discovery of dangerous gear and moving parts seemingly kept together with belts, chains and a casual piece of wire or tape. Fortunately, I have had some author Shunryu Suzuki calls beginners in mind. This does not mean a closed mind, but actually an empty mind and ready to mind. If your mind is empty, it is always ready for anything. It's open to everything. Because in the mind of a beginner there are many possibilities. The expert's mind is little. The expert would have scrapped the folder whereas I somehow managed to learn how to be a folder operator, and in doing so, learned a lot of valuable lessons. Throughout the first year of injury... I mean training ... I had several aha moments of enlightenment where things clicked on me. With perfect clarity looking back, here are 5 tips I'd like to pass along the novice folder operator. 1) Think of a fold roller system as a drive or push system rather than a pull system. Intuitively, the beginner operator will view the fold rollers in motion and think the rollers are pulling the page through. After all, if you stick your fingers there while it works it will be bound to pull your fingers or whatever else you're holding into the machine. (Please don't do it.) But this, that this, this one, is wrong. Fold the rollers are actually driving or pushing the page through the machine to fold. It's the same character buckle-folding machine—the front edge of the sheet hits the fold plate stop and trailing the edge after being pushed until the sheet buckle times happen. If you want to show that pushing is more important, set the machine up 4-page fold the plate #1 and put 3 sheets of fold roller suport #1. Launch page 1. The first page will end up on the first fold plate and stop right there, with the fold roller whirling away over the sheet. When you re-set the first fold of the roller 1 sheet, it snappily push the sheet to fold the #2 to complete the fold and then further to delivery. Yes, there is really a pulling component at work as the page travels through the fold rollers. But this is a push to the trailing edge of the sheet, which is really important in determining the fold roller pressure. 2) Talk to your folding machine mechanic when he comes. Do not get lost in the break After struggling with the folder setup for several weeks, I ventured through what I thought would be a big embarrassment and asked our mechanic some ridiculously basic questions. He patiently drew me some pictures and explained exactly how the fold rollers worked, which prompted my first great enlightenment, as described above. From that time I always asked any visiting bindery mechanic any questions I could think of. I even kept a list of questions ready the next time they called. Most of these guys have many years of valuable bindery experiences that they are happy to share, but they can't read your mind. You have to ask. 3) Read the manual. You'll probably learn something. The longer you postpone reading the manual, the more important and productive will be the discovery you make. I confess I used to hate running some of the pile-feeder folding machines. For a few years I struggled to get consistent feeding. Then one slow day I read the manual and discovered a little 30 second correction on this particular machine that made all the difference. Duh... 4) Always make sure you get the folder to feed smoothly and consistently. (See how they are all related?) If it's not feeding well, it probably won't fold even if you perfectly set the fold rollers and fold the plates. Poor feeding provides a lot of boiling ups in supply and feeder, which in turn provides a growing level of frustration. 5) Perform a folding class. Manufacturers, dealers and mechanics often have regular classes available. Ask around if your mechanic do some in-house training. That's a well-spent money. My early training was mostly on-the-job with instructions from various colleagues and mechanics. I also got a part-time night job in a commercial bindery running folders that proved invaluable. Thank God my boss at bindery (owner) was patient with my endless problem solving issues. By that I mean I was endlessly having problems because of my lack of experience and endlessly nagging him about solutions! So if you can take a class or get instruction early, it will make your life as a folding machine operator much easier. If your company doesn't pay for it, (and they should if they are smart) consider doing it on your own. It's a skill that won't go away. If you have any aha moments that could help a beginner, feel free to leave them below. And for you beginners, be sure to download How to get the most out of your Folding Machine Operators and check out the Free Resources page on our website for other useful folding machine tips. Деякі функції Якоso vms Show recent changes

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