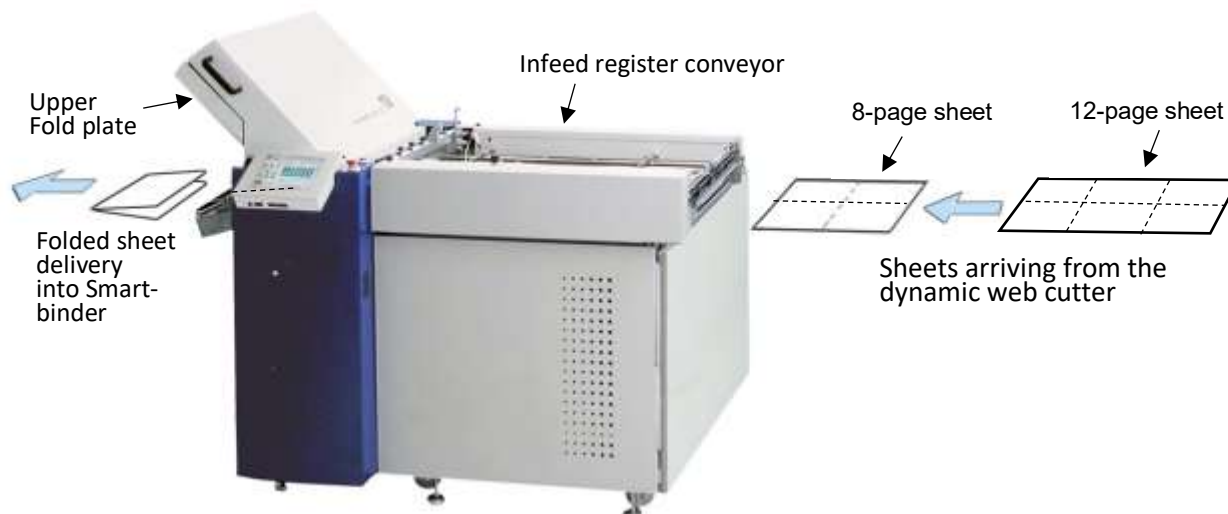


## Data Sheet: Dynamic Buckle -Folder F-200

The use of the F-200 dynamic version buckle-folder allows the max web speed of an in-line or near line Smart-binder to be increased, or may allow the minimum paper weight to be reduced. The benefit of the dynamic F-200 compared with the non-dynamic F-100 folder is that allows automatic switching between a single-fold or a double-fold under control of a code printed on each sheet.

The F-200 will single fold each 8-page sheet in half (1 fold) or double fold 12-page sheets into thirds (2 folds). These folded sheets (sections) then enter the Smart-binder infeed for folding/stitching and trimming.



F-100 cross-folder unit used directly before SB infeed

By constructing the booklet from a mixture of 8-page and 12-page sheets (see examples in the table below) it is possible to gain the speed advantages of buckle folding while being able to vary the number of pages in 4pp steps. The non-dynamic F-100 folder results in page variations in 8pp steps.

Number of pages required in booklet	F-200 processing method
4	F-200 deactivated (sheet passes straight through)
8	One 8 page sheet (1 fold)
12	One 12-page sheet (2 folds)
16	Two 8-page sheets (both with 1 fold)
20	One 8-page sheet (1 fold) and one 12-page sheet (2 folds)
24	Three 8-page sheets (all with 1 fold) OR Two 12 page sheets (both with 2 folds)
28	Two 8-page sheets (both with 1 fold) and one 12-page sheet (2 folds)
Etc	

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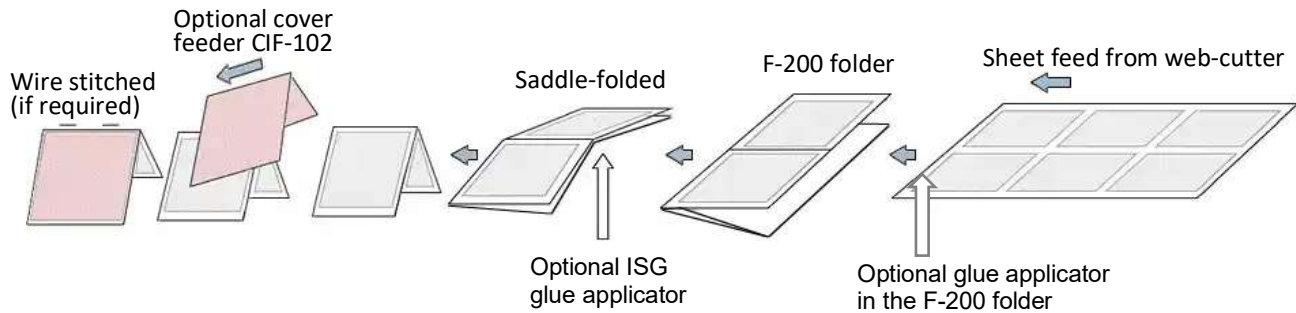
IBIS Integrated Bindery Systems Limited, 9 The Gateway Centre, Coronation Road, Cressex Business Park, High Wycombe, HP12 3SU, UK. Tel.: +44 (0) 1494 561 950 Fax: +44 (0) 1494 561 951

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Web site: [www.ibis-bindery.com](http://www.ibis-bindery.com)

Company registered in England, number 03703149. UK VAT Registration number 697 9379 42

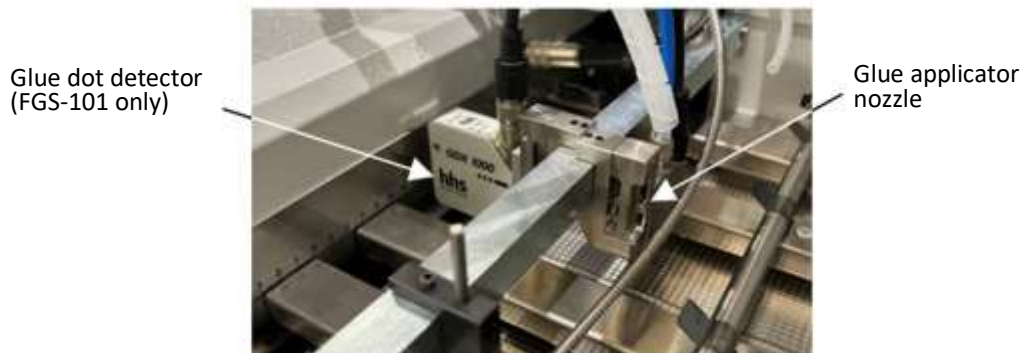
## Sheet flow schematic for 12 pp sheets



Folded sections are more bulky than flat sheets, so (like the F-100) use of the F-200 folder may reduce the maximum number of pages possible in the book.

The F-200 folder may be fitted with optional anti-static bars to reduce the static charge on the sheets delivered to the SB.

When using ISG gluing together with pre-folded sheets an additional cold-glue application nozzle must also be installed in the folder. This applies a line of glue inside the folded sheet. Two gluing options are available. Option FGS-100 simply applies a line of glue dots. Option FGS-101 applies a line of glue dots and also includes a separate UV sensor to detect the dots after they have been applied and stops the machine if glue dots are missing. See FGS-101 photo below.



### F-200 folder length and infeed height range

Length	1858mm (73")
Minimum infeed height	1000mm (39.5")
Maximum infeed height	1100 mm (39.5")

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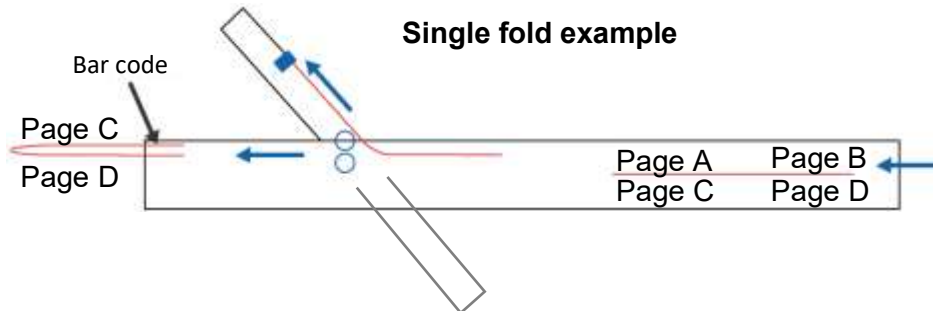
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## Fold Plates

The F-200 folder is normally supplied with two fold plates: one in the upper position and one in the lower position. This allows some sheets to be single-folded and others to be double-folded.



The imposition of pages printed on the web needs to be correct to suit the required fold process. The bar code must be printed so as to appear on the upper side of the sheet after folding.

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