EAMES™ Furniture Collection, Cover Weight
PRODUCT SCORING AND FOLDING INFORMATION

Because of the unique look, feel and finish of EAMES™ Paper Collection: *Furniture Collection,* Cover papers, production considerations are required when folding and scoring to minimize the cracking or lifting of the fibers.

EAMES: *Furniture Collection* is easy to work with when following these simple tips. It is recommended to pretest any folding and scoring procedures to ensure the desired results are achieved. Sample sheets are available through authorized Neenah Paper merchants or by contacting our sample department at 800-994-5993.

General Guidelines:
The unique texture results in the sheet looking slightly different head to tail. Load all of the paper into the press in the same direction.
- Prior to folding, always properly score the paper.
- Score and fold with the grain of the paper.
- When possible, score the paper when it is still moist from the litho press fountain solution. Moisture should improve scoring and folding.
- Fold toward the ridge or bulge in the paper.

Creasing Rule/Channel System:
- The most effective means of scoring EAMES Paper Collection: *Furniture Collection,* Cover papers is with the creasing rule/channel score.
- The best scores are usually achieved on a flat bed press.
- Experimentation is always recommended to discover the ideal rule/channel combination.
- The following rule/channel combinations are generally recommended:
  - With the grain: 2 point rule with a 40 or 50 channel for 80 lb. cover
  - Against the grain: 2 point rule with a 50 or 60 channel for 80 lb. cover
  - With the grain: 2 point rule with a 60 or 90 channel for double thick and duplex cover
  - Against the grain: 2 point rule with a 90 or 105 channel for double thick and duplex cover
  - Intersections where two or more rules meet may require filing down the channels

Scoring Against the Grain:
- A cut-score (or kiss-cut score) can be utilized when scoring and folding against the grain, or when fiber lift is a problem. A cut-score is a method of scoring using only a cutting rule (without the channel) creating a slight cut through part of the paper. This method is used to create a sharp and smooth break or fold in the paper at the point of the cut.
- Some double thick and duplex papers may score and fold better against the grain. *Again, experimentation with various rule/channel combinations is recommended.*

Scoring/Die-cut Combinations:
- When combining scoring with die cutting simultaneously, proper rule height is important. For example, if your scoring rule is .900, the cutting rule should be .918.

Trimming:
When ink is used as a full bleed, care in trimming will prevent the ink from chipping.
- Increase clamp pressure of the trimmer; significant increase may be required.
- Adjust blade angles, typically 20-22° for the primary and 22-24° for the secondary.
- Blade should be sharp.
- Reduce the size of the lift.
- Place 5 to 10 sheets of a smooth cover weight paper on top of the lift prior to trimming.

Other Suggestions:
- On heavyweight stock, consider a 60, 90 or 105 channel with 2 point rule.
- A shallow score, when folded, will have the tendency to resist cracking.
- On cylinder presses with scores running around the cylinder, it may be necessary to file down the surface of the channel to dull the edges and reduce cracking of the fold.
- When scoring 120 lb. presentation folders, a double score, which creates a gusset for the spine, is recommended; the gusset should be at least 1/8".
- Complex folders and covers should be hand folded.
- Lighter screen tints or no ink over score areas minimizes the impact of paper fibers along the fold, especially when scoring against the grain.

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