

microglue®

Product Guide For Use Of Glue On Commercial Folders

REV 122101

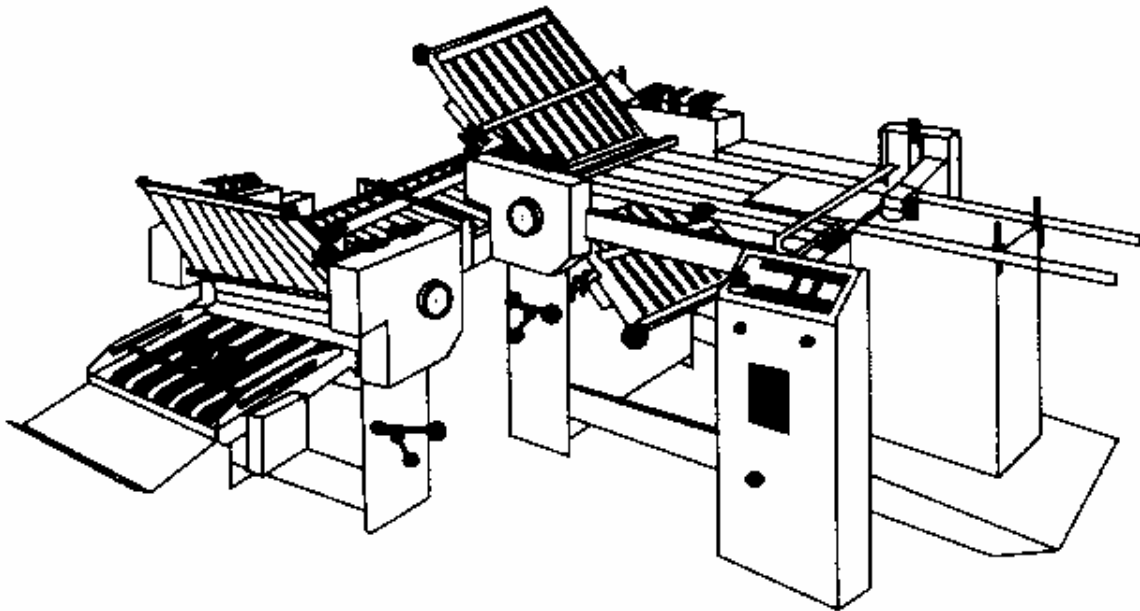


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GMS wishes to acknowledge and thank the Baumfolder Division of Heidelberg Finishing Systems for the use of product drawings found in this booklet.

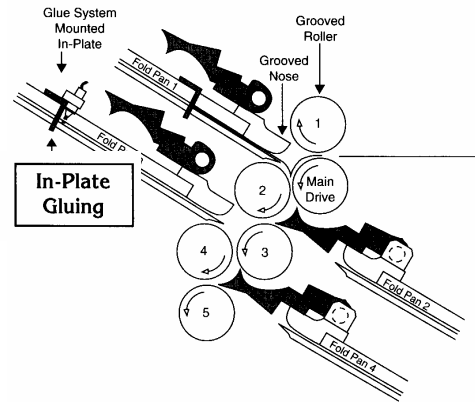
IN-PLATE VERSUS IN-LINE GLUING

IN-PLATE GLUING

“**In-plate**” refers to one of two application processes used for gluing on a commercial sheet-fed folder. If the applicator valves are positioned in such a manner as to apply the adhesive onto the paper while it is inside the fold plate, it is called “in-plate” gluing.

In-plate gluing has an advantage in that it eliminates the need for installation of segmented gluing rollers. The machine does, however, still require a specialized nose bar on the fold plate where the applicator valves are mounted. Nose bars can vary in quality and are generally more expensive than segmented gluing rollers. Only one nose bar is required.

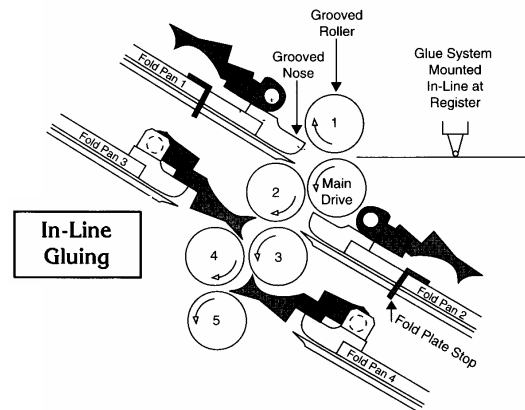
Because of its limitations, in-plate gluing is used almost exclusively for applying dots of adhesive to close a direct mail piece. There are only a few folds that lend themselves to in-plate gluing: a half fold, 3 and 4 panel letter folds, and some booklet work. Further, the size of the product must be such that it extends approximately one and a half inches beyond the nose bar, allowing the optical sensor to activate the glue valves. The actual size limitation for any product is based on the machine it is being folded on.



IN-LINE GLUING

With “**in-line**” gluing, the applicator valves are positioned in such a manner as to apply the adhesive onto the paper while it is on the register table, before it enters the roller assembly. Segmented or grooved rollers permit the paper to pass into the fold plates without contacting the adhesive just applied. Nose bars may also be required based upon the job being run (refer to specific jobs and required machine modifications).

In-line gluing provides the greatest flexibility and there generally are no size limitations. High quality segmented or grooved rollers are available for most machines at reasonable prices. The number of rollers required is dictated by the range of product that needs to be run. For example, a half fold only requires one roller while a 3-panel letter fold requires 2 rollers. Installing one, two, or more rollers offers the user optimum flexibility for a broad range of applications.



Application	In-line	In-plate
8-page booklet	Yes	No
12-page booklet	Yes	No
16-page booklet	Yes	No
½ fold self mailer	Yes	Yes
3-panel letter fold self mailer	Yes	Yes
4-panel letter fold self mailer	Yes	Yes
Any fold with tear-offs	Yes	No
Any fold with pockets	Yes	No

HOT GLUE VERSUS COLD GLUE

Selecting the correct type of glue is critical for a successful production run. Both cold and hot glues have their advantages and disadvantages. You should verify that the viscosity and solid content of the glue you plan to use is within an acceptable range, based on the type of application system and the material to be glued. The two most common glues used in commercial folder applications are fugitive and permanent. Both types are available in either hot or cold varieties

Permanent glues are pretty straight forward as they relate to most folder applications. However, for material that has been coated special adhesive will be required. This is true for both hot and cold adhesives.

Fugitive adhesives are a little trickier. Not only are there many different types available, the effect desired from a fugitive glue demands that it be more closely matched to the paper type. Many different factors may have an effect on the acceptability of the bond created by the adhesive. The purpose of a fugitive adhesive is to seal a product, but permit opening without tearing the substrate. The ink, coating, temperature, humidity and volume will affect the strength of the bond.

Cold glue advantages

- Cold glues are less expensive than hot glues.
- Typically, cold glue allows machinery to run at a higher speed.
- The cost of cold glue application equipment is much less.
- Glued products lay flatter when using cold glue.
- Set up time is less because the glue does not need to melt prior to use.
- Cold glues are safer to work with.

Cold glue disadvantages

- Matching the glue to the application is more sensitive.
- It has a limited shelf life.
- Temperature is critical to it's viscosity.
- System cleaning based on frequency of use is more important.
- Application of gummy fugitive adhesive is difficult and requires frequent cleaning
- Products require some pressure and stacking to ensure the integrity of the bond.

Hot glue advantages

- Glue selection is generally more straightforward than with cold glue.
- Cleaning and maintenance is less or almost nonexistent.
- Bond is immediate.
- Application of gummy fugitive adhesive is no problem

Hot glue disadvantages

- Glue is relatively expensive
- Applicator valves are very hot and can cause severe burns.
- Systems are expensive
- Set-up time is longer to allow the glue to melt.
- Machine speed is limited to reduce trailing and stringing.
- Products do not lay flat due to glue thickness.
- Glue produces fumes

8 PAGE BOOKLET

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
1	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

- 1 SEGMENTED GLUING ROLLER IN THE # 1 POSITION
- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE (optional)

CUSTOMER SUPPLIED ITEMS

- 110 OR 220 VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER
- RIGHT ANGLE OR EIGHT-PAGE SECTION FOLDER
- SLITTING SHAFT ASSEMBLY ON RIGHT ANGLE SECTION OF FOLDER (optional)

APPLICATION TECHNIQUE

Apply a line of glue down the tail half of the sheet before it enters the roller assembly. In some cases, it is better if the optical sensor is mounted above the number one fold plate. This eliminates variations based on paper registration problems. The glue valves are mounted over the register table, just before the rollers.

FOLD TECHNIQUE



Perform a half fold in the number one folding position on the parallel section and then a second half fold in the number one position on the right angle. A slitter can be used to remove the waste.

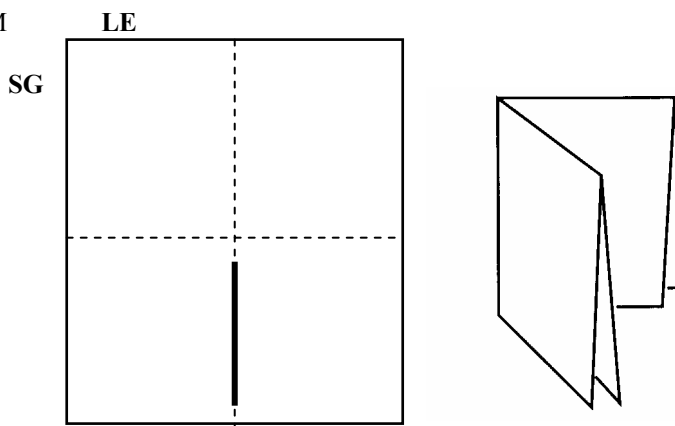
OPTIONAL EQUIPMENT

- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE FLUSHING SYSTEM

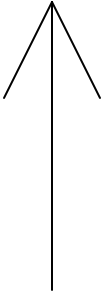
TYPE OF GLUE

Permanent

GLUE LINE 
FOLD LINE 



8-PAGE BOOKLET



DIRECTION OF PAPER TRAVEL

SECOND FOLD

FIRST FOLD

Glue Line

12 PAGE BOOKLET

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
1	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

2 SEGMENTED GLUING ROLLERS IN THE # 1 AND 2 ROLLER POSITIONS
2 SEGMENTED NOSE BARS ON THE # 1 AND 2 FOLD PLATES (optional)

CUSTOMER SUPPLIED ITEMS

110 OR 220VAC
80 PSI HOUSE AIR (or equivalent)
PARALLEL SECTION FOLDER
RIGHT ANGLE OR EIGHT-PAGE SECTION FOLDER
SLITTING SHAFT ASSEMBLY ON RIGHT ANGLE SECTION OF FOLDER (optional)

APPLICATION TECHNIQUE

Apply a line of glue down the tail two thirds of the sheet before it enters the roller assembly. In some cases it is better if the optical sensor is mounted above the number one fold plate. This eliminates variations based on paper registration. The glue valves are mounted over the register table, just before the rollers.

FOLD TECHNIQUE

Fold the sheet to one third of its length up in the number one position. Deflect off of the number two fold plate, and then again fold to one third of the original parent length in the number three fold position. This is referred to as "going up and up" in a letter fold format. Then do a half-fold in the number one position on the right angle. A slitter can be used to remove the waste.

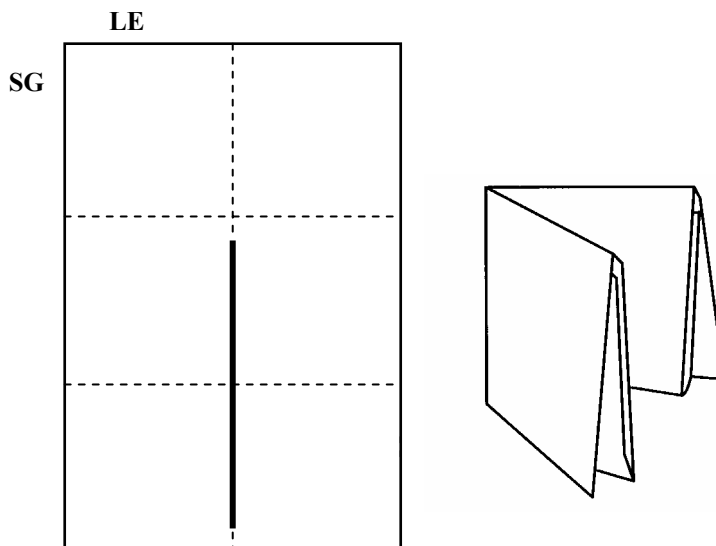
OPTIONAL EQUIPMENT

FIVE GALLON S.S. DELIVERY SYSTEM
GLUE SYSTEM FLUSHING SYSTEM

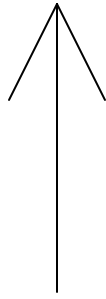
TYPE OF GLUE

Permanent

GLUE LINE —
FOLD LINE ---



12-PAGE BOOKLET



DIRECTION OF PAPER TRAVEL

THIRD FOLD

FIRST FOLD

SECOND FOLD

Glue Line

16 PAGE BOOKET

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
1	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

- 3 SEGMENTED GLUING ROLLERS IN THE # 1, MAIN AND 3 ROLLER POSITIONS
- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE
- 2 SEGMENTED NOSE BARS ON THE # 2 AND 4 FOLD PLATES (optional)

CUSTOMER SUPPLIED ITEMS

- 110 OR 220 VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER
- RIGHT ANGLE OR EIGHT-PAGE SECTION FOLDER
- SLITTING SHAFT ASSEMBLY ON RIGHT ANGLE SECTION OF FOLDER (optional)

APPLICATION TECHNIQUE

Apply a line of glue down on the lead three quarters of the sheet before it enters the roller assembly. The optical sensor should be positioned as close to the rollers as possible to reduce accuracy problems associated with paper registration. The glue valves are mounted over the register table, just before the rollers.

FOLD TECHNIQUE

Fold the sheet to three fourths of its length up in the number one position, fold at one fourth in the number two fold plate, deflect off of the number three fold plate, and then again fold to one fourth of the original parent length in the number four fold position. This is a standard four-panel letter fold format. Then do a half-fold in the number one position on the right angle. Two slitters can be used to remove the waste.

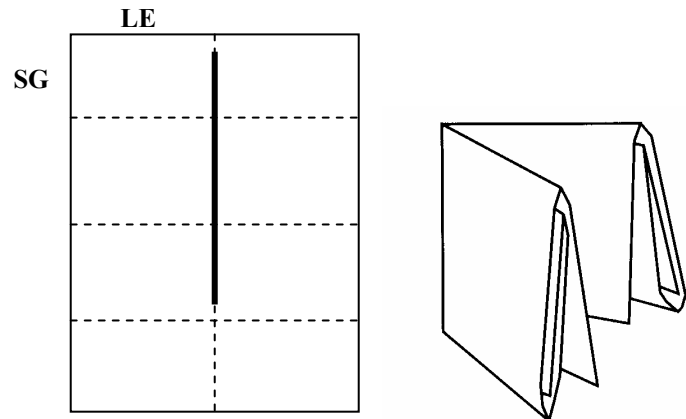
OPTIONAL EQUIPMENT

- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE SYSTEM FLUSHING SYSTEM

TYPE OF GLUE

Permanent

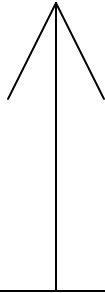
GLUE LINE —————
FOLD LINE -----



16-PAGE BOOKLET

FOURTH FOLD

DIRECTION OF PAPER TRAVEL



FIRST FOLD

SECOND FOLD

THIRD FOLD

Glue Line

16 PAGE BOOKLET (GATE FOLD)

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
1	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

- 1 SEGMENTED GLUING ROLLER IN THE # 1 POSITION (on the right angle)
- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE (optional) (on the right angle)

CUSTOMER SUPPLIED ITEMS

- 110 OR 220VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER
- RIGHT ANGLE OR EIGHT-PAGE SECTION OF FOLDER
- 16 PAGE SECTION OF FOLDER

APPLICATION TECHNIQUE

Apply a line of glue down the tail half of the sheet before it enters the roller assembly of the eight-page unit. In some cases it is better if the optical sensor is mounted above the number one fold plate. This eliminates variations based on paper registration problems. Your glue line will be between the flaps of paper created by the gatefold. The glue valve is mounted over the register table, just before the rollers.

FOLD TECHNIQUE



Do a gatefold by going up a little more than three fourths in the number one position and then one half in the number two position. Deflect off of three and four, and deliver the product on the register table of the right angle. Apply the glue and then do a half fold in the number one position on the right angle. Do another half fold on the sixteen page and then trim off the three sides with a trimmer.

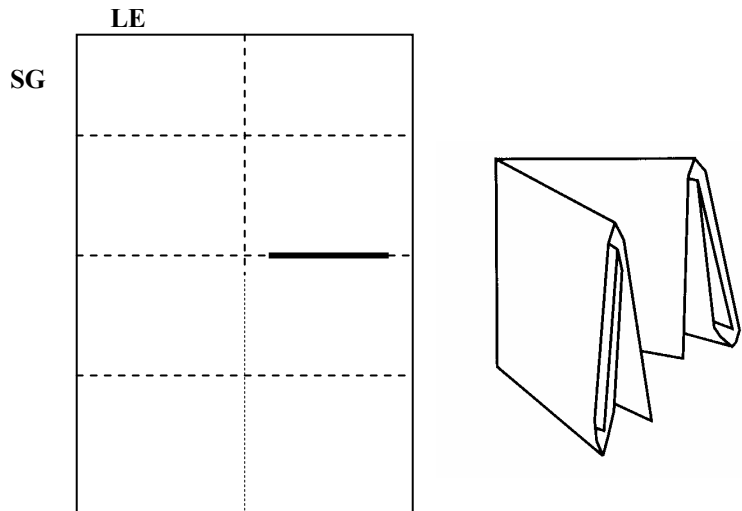
OPTIONAL EQUIPMENT

- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE SYSTEM FLUSHING SYSTEM

TYPE OF GLUE

Permanent

GLUE LINE 
FOLD LINE 



1/2 FOLD SELF MAILER

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
2	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

- 1 SEGMENTED GLUING ROLLER IN THE # 1 POSITION
- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE (optional)

CUSTOMER SUPPLIED ITEMS

- 110 OR 220VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER

APPLICATION TECHNIQUE

Apply dots or short lines of glue at the tail of the sheet before the sheet enters the rollers. Apply the dots one inch in from each side and less than one inch from the tail. Placing the optical sensor in the number one fold plate may help to eliminate variations created by registration problems. The glue valves are mounted over the register table, just before the rollers.

FOLD TECHNIQUE

Perform a half fold in the number one folding position on the parallel section.

OPTIONAL EQUIPMENT

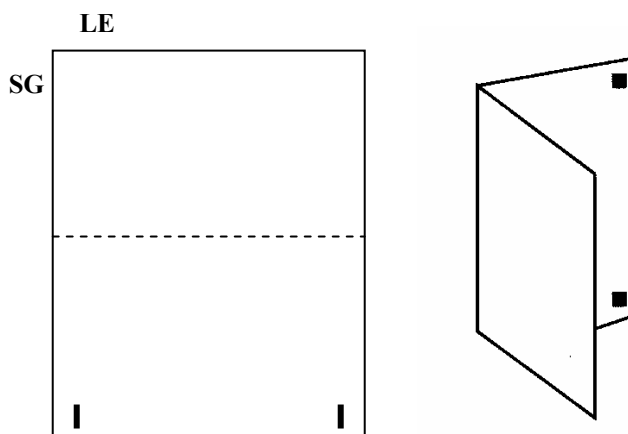
- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE SYSTEM FLUSHING SYSTEM
- ADD GLUE VALVES TO DO THREE DOTS OR TWO, THREE OR FOUR UP WORK.

TYPE OF GLUE

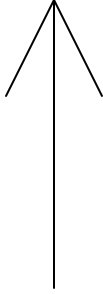
Fugitive

GLUE LINE ————

FOLD LINE - - - - -



1/2 FOLD SELF MAILER



DIRECTION OF PAPER TRAVEL

FIRST FOLD

12



1/2 FOLD SELF MAILER (IN-PLATE)

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
2	ASSY-23210	MICROGLUE LP OR HV GLUE VALVE ASSY .015 NOZZLE
1	ASSY-23100	MICROGLUE INPLATE BRACKET ASSEMBLY

REQUIRED MACHINE MODIFICATIONS

- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE
- 1 SEGMENTED GLUING ROLLER IN THE MAIN POSITION (optional)

CUSTOMER SUPPLIED ITEMS

- 110 OR 220VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER

APPLICATION TECHNIQUE

Apply dots of glue at the lead edge of the sheet in the number one fold plate. Apply the dots within one inch in from each side and less than one inch from the edge. Placing the optical sensor as close as possible to the nose bar will provide for the greatest flexibility. The glue valves are mounted on the number one fold plate.

FOLD TECHNIQUE

Perform a half fold in the number one folding position on the parallel section

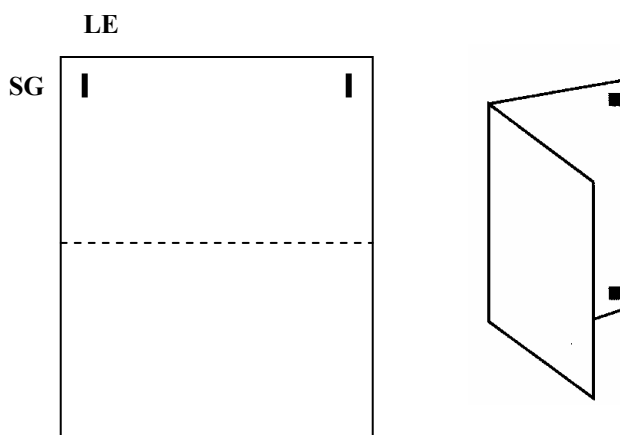
OPTIONAL EQUIPMENT

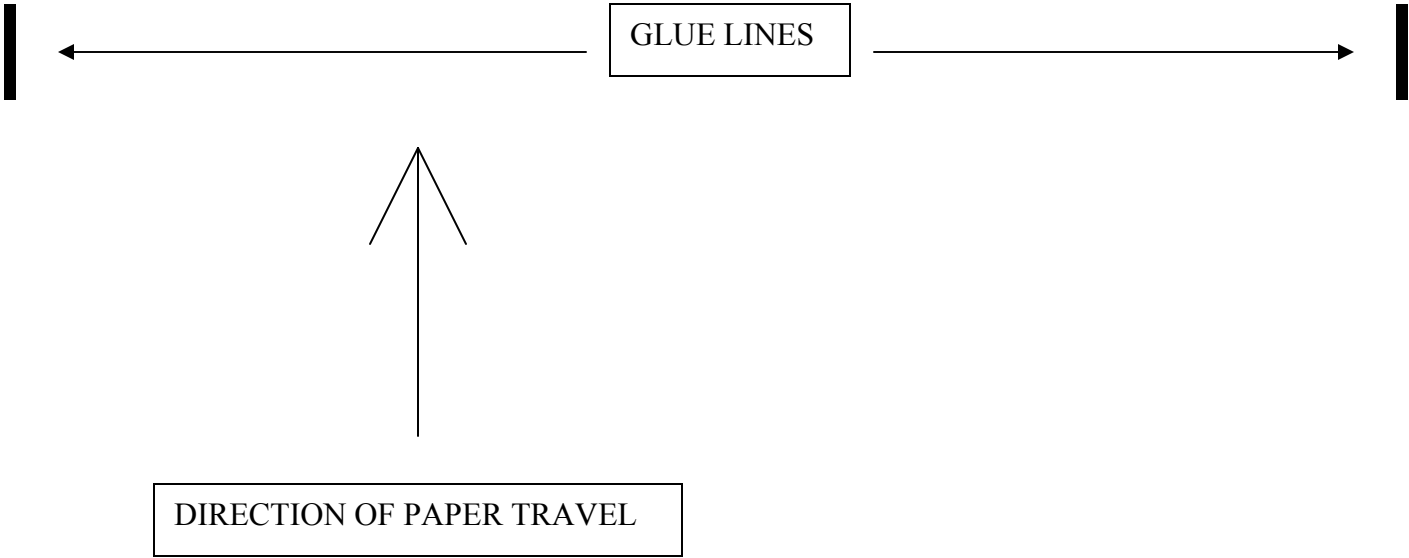
- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE SYSTEM FLUSHING SYSTEM
- SUBSTITUTE LP GLUE VALVES WITH GLUE VALVES WITH SHUTTERS AND ADD A SHUTTER CONTROL SYSTEM
- ADD GLUE VALVES IN SETS OF TWO TO DO TWO, THREE OR FOUR UP WORK.

TYPE OF GLUE

Fugitive

GLUE LINE —
FOLD LINE ---





FIRST FOLD

1/2 FOLD SELF MAILER WITH TEAR-OFFS

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-120 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
2	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

- 1 SEGMENTED GLUING ROLLER IN THE # 1 POSITION
- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE (optional)

CUSTOMER SUPPLIED ITEMS

- 110 OR 220VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER WITH PERFORATING WHEELS

APPLICATION TECHNIQUE

Apply a line of glue, one on each side, down the tail half of the sheet before it enters the roller assembly. In some cases, it is better if the optical sensor is mounted above the number one fold plate. This eliminates variations based on paper registration problems. The glue valves are mounted over the register table, just before the rollers.

FOLD TECHNIQUE




Perform a half fold in the number one folding position on the parallel section

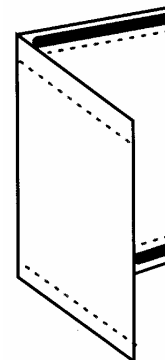
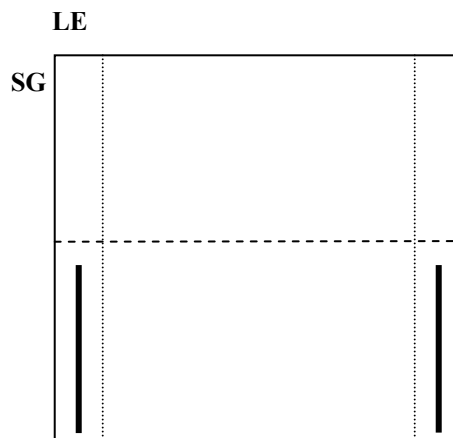
OPTIONAL EQUIPMENT

- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE SYSTEM FLUSHING SYSTEM
- ADD GLUE VALVES IN SETS OF TWO TO DO TWO, THREE OR FOUR UP WORK.

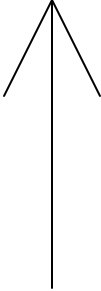
TYPE OF GLUE

Permanent

- GLUE LINE 
- FOLD LINE 
- PERF. 



1/2 FOLD SELF MAILER
WITH TEAR-OFFS



DIRECTION OF PAPER TRAVEL

FIRST FOLD



16

GLUE LINES



3 PANEL LETTER FOLD SELF MAILER

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
2	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

2 SEGMENTED GLUING ROLLERS IN THE # 1 AND 2 POSITIONS
2 SEGMENTED NOSE BARS ON THE # 1 AND 2 FOLD PLATES (optional)

CUSTOMER SUPPLIED ITEMS

110 OR 220VAC
80-PSI HOUSE AIR (or equivalent)
PARALLEL SECTION FOLDER

APPLICATION TECHNIQUE

Apply dots or short lines of adhesive on the tail of the sheet before the sheet enters the roller assembly. Placing the optical sensor on the number one fold plate may help to eliminate variations created by registration problems. The glue valves are mounted over the register table, just before the rollers.

FOLD TECHNIQUE

Fold the sheet to one third of its length up in the number one position, deflect off of the number two fold plate, and then again fold to one third of the original parent length in the number three fold position. This is referred to as "going up and up".

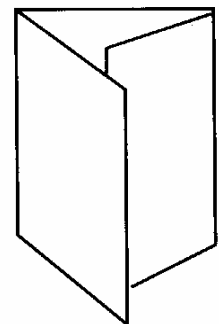
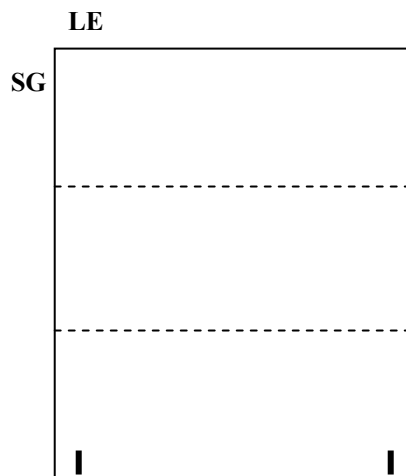
OPTIONAL EQUIPMENT

FIVE-GALLON S.S. DELIVERY SYSTEM
GLUE SYSTEM FLUSHING SYSTEM

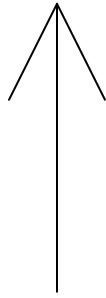
TYPE OF GLUE

Fugitive

GLUE LINE —
FOLD LINE - - - - -
PERF.



3 PANEL LETTER FOLD
SELF MAILER



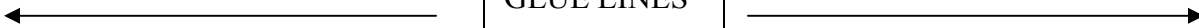
DIRECTION OF PAPER TRAVEL

FIRST FOLD

SECOND FOLD

18

GLUE LINES



3 PANEL LETTER FOLD SELF MAILER (IN-PLATE)

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
2	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE
1	ASSY-23100	MICROGLUE INPLATE BRACKET ASSEMBLY

REQUIRED MACHINE MODIFICATIONS

- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE
- 1 SEGMENTED GLUING ROLLER IN THE MAIN ROLLER POSITION

CUSTOMER SUPPLIED ITEMS

- 110 OR 220VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER

APPLICATION TECHNIQUE

Apply dots of adhesive as the paper enters the number two fold plate. Place the dots within an inch from the sides and an inch from the edge. The glue valves and optical sensor should be mounted on the number two fold plate as close as possible to the nose bar for greatest flexibility.

FOLD TECHNIQUE

Fold the sheet to two thirds of its length up in the number one position, then fold one third of the original parent length in the number two fold position. This is referred to as “going up long and down”. When going up long, the gap between products must exceed two thirds of the product length.

OPTIONAL EQUIPMENT

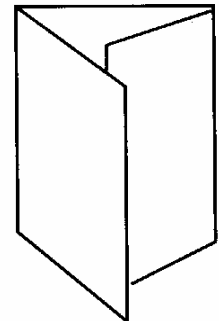
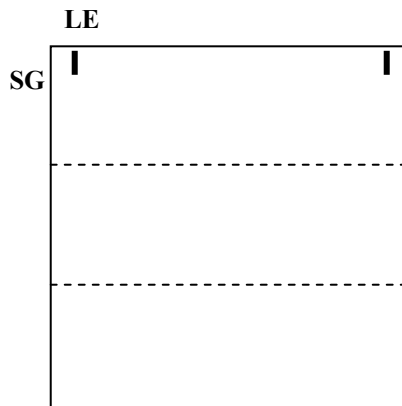
- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE SYSTEM FLUSHING SYSTEM
- ADD GLUE VALVES IN SETS OF TWO TO DO TWO, THREE OR FOUR UP WORK.

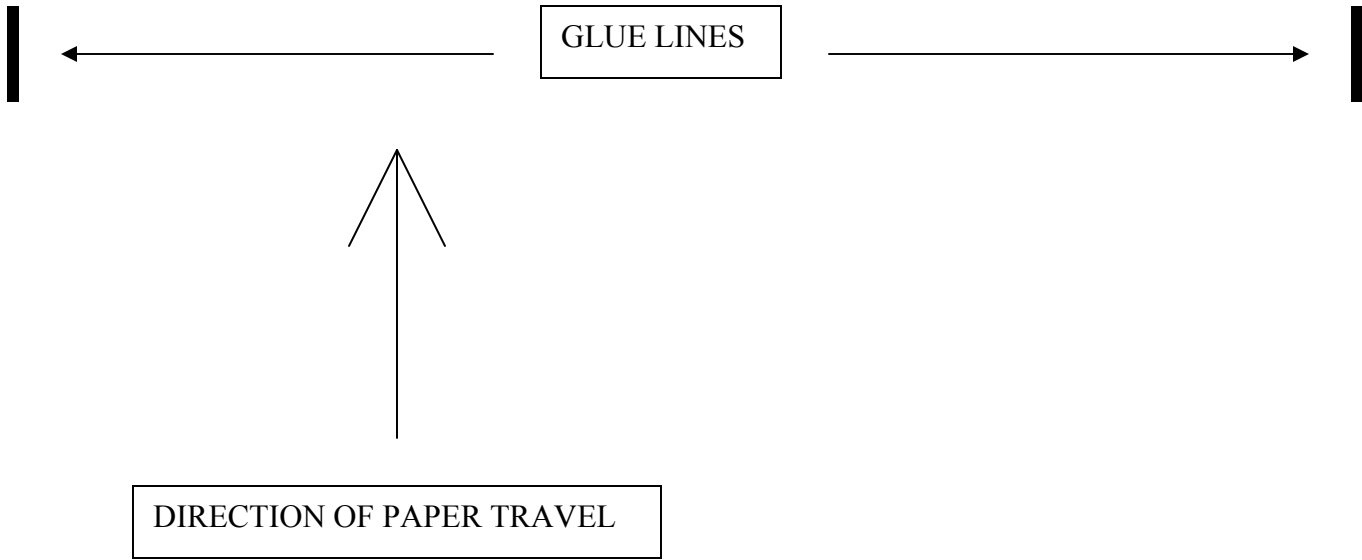
TYPE OF GLUE

Fugitive

GLUE LINE —————

FOLD LINE - - - - -





SECOND FOLD

FIRST FOLD

3 PANEL LETTER FOLD
SELF MAILER IN-PLATE

3 PANEL LETTER FOLD SELF MAILER WITH TEAR-OFFS

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
2	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

2 SEGMENTED GLUING ROLLERS IN THE # 1 AND 2 POSITIONS
2 SEGMENTED NOSE BARS ON THE # 1 AND 2 FOLD PLATES (optional)

CUSTOMER SUPPLIED ITEMS

110 OR 220VAC
80-PSI HOUSE AIR (or equivalent)
PARALLEL SECTION FOLDER WITH PERFORATING WHEELS

APPLICATION TECHNIQUE

Apply lines of glue on the tail two thirds of the sheet before the sheet enters the roller assembly. Placing the optical sensor in the number one fold plate may help to eliminate variations created by registration problems. The glue valves are mounted over the register table, just before the rollers.

FOLD TECHNIQUE



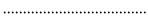
Fold the sheet to one third of its length up in the number one position, deflect off of the number two fold plate, and then again fold to one third of the original parent length in the number three fold position. This is referred to as "going up and up".

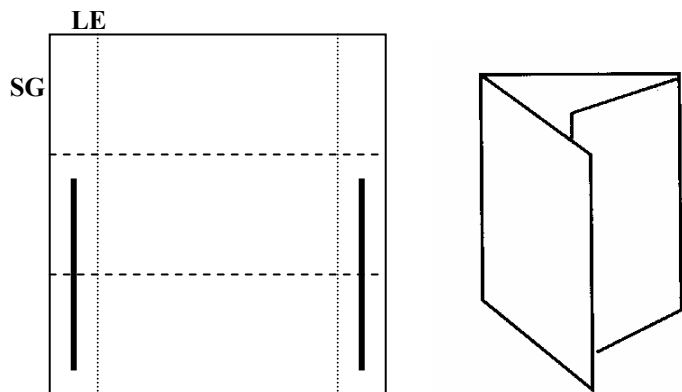
OPTIONAL EQUIPMENT

FIVE-GALLON S.S. DELIVERY SYSTEM
GLUE SYSTEM FLUSHING SYSTEM
ADD GLUE VALVES IN SETS OF TWO TO DO TWO, THREE OR FOUR UP WORK.

TYPE OF GLUE

Permanent

GLUE LINE 
FOLD LINE 
PERF. 



3 PANEL LETTER FOLD
SELF MAILER WITH TEAR-OFFS



DIRECTION OF PAPER TRAVEL

FIRST FOLD

SECOND FOLD

22

GLUE LINES



4 PANEL LETTER FOLD SELF MAILER

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODERASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
2	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

- 3 SEGMENTED GLUING ROLLERS IN THE # 1, MAIN AND 3 ROLLER POSITIONS
- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE
- 2 SEGMENTED NOSE BARS ON THE # 2 AND 4 FOLD PLATE S (optional)

CUSTOMER SUPPLIED ITEMS

- 110 OR 220 VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER

APPLICATION TECHNIQUE

Apply dots or short lines of glue down on the lead edge of the sheet before it enters the roller assembly. The optical sensor should be positioned as close to the rollers as possible to reduce accuracy problems associated with paper registration. The glue valves are mounted over the register table, just before the rollers.

FOLD TECHNIQUE

Fold the sheet to three fourths of its length up in the number one position, fold at one fourth of the original parent length in the number two fold plate, deflect off of the number three fold plate, and then fold to one fourth of the original parent length in the number four fold position. This is a standard "four-panel letter fold" format.

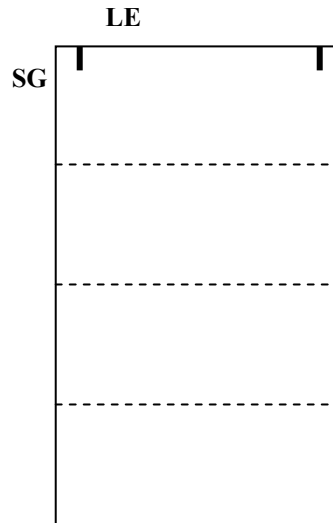
OPTIONAL EQUIPMENT

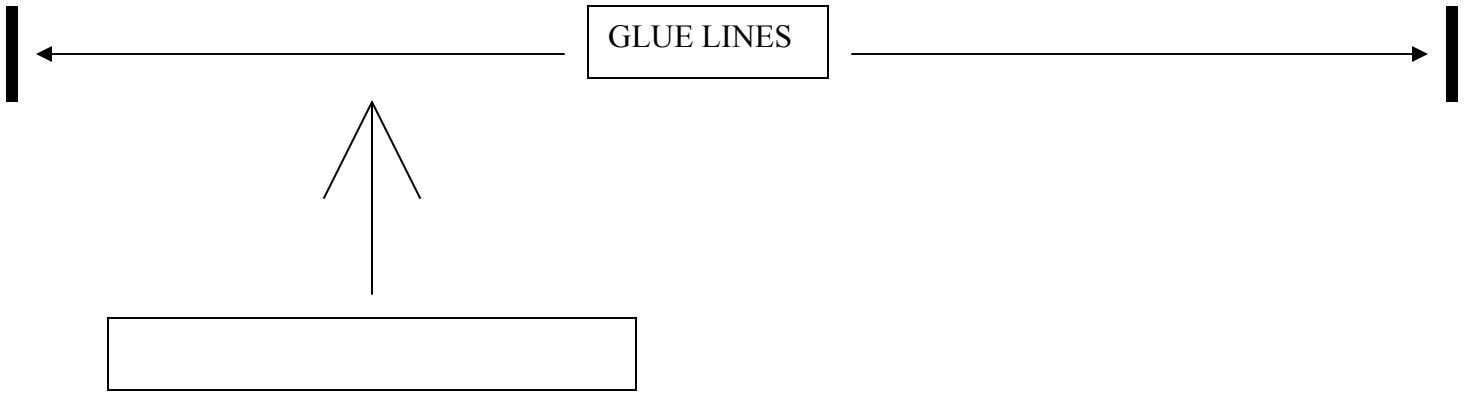
- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE SYSTEM FLUSHING SYSTEM

TYPE OF GLUE

Fugitive

GLUE LINE **—————**
FOLD LINE **-----**





THIRD FOLD

SECOND FOLD

FIRST FOLD

4 PANEL LETTERFOLD
SELF MAILER

4 PANEL LETTER FOLD SELF MAILER (IN-PLATE)

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
2	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

- 2 SEGMENTED GLUING ROLLERS IN THE MAIN AND # 3 ROLLER POSITIONS
- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE
- 2 SEGMENTED NOSE BARS ON THE # 2 AND 4 FOLD PLATES (optional)

CUSTOMER SUPPLIED ITEMS

- 110 OR 220 VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER

APPLICATION TECHNIQUE

Apply dots or short lines of glue down on the lead edge of the sheet as it enters the number one fold plate. The optical sensor should be positioned as close to the nose bar as possible to allow greatest flexibility. The glue valves are mounted over the number one fold plate, and should be as close as possible to the nose bar.

FOLD TECHNIQUE

Fold the sheet to three fourths of its length up in the number one position, fold at one fourth of the original parent length in the number two fold plate, deflect off of the number three fold plate, and then fold to one fourth of the original parent length in the number four fold position. This is a standard "four-panel letter fold" format.

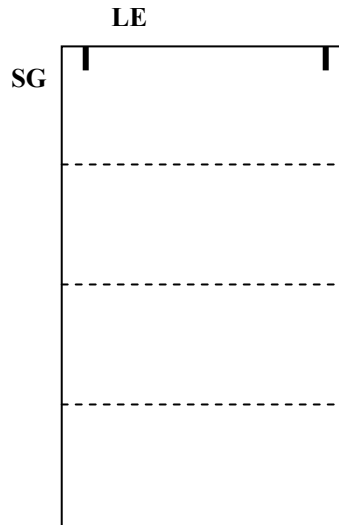
OPTIONAL EQUIPMENT

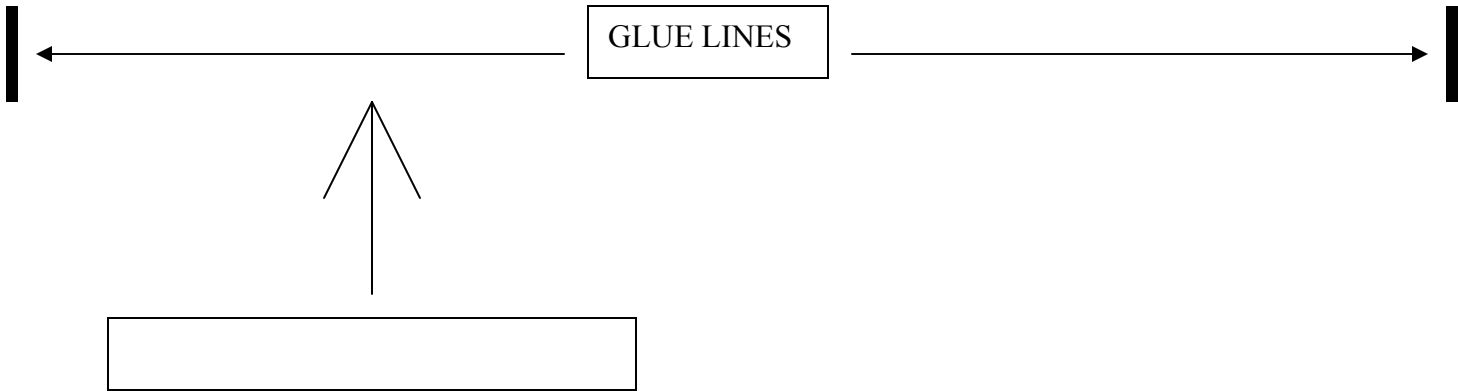
- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE SYSTEM FLUSHING SYSTEM

TYPE OF GLUE

Fugitive

GLUE LINE **—————**
FOLD LINE **- - - - -**





THIRD FOLD

SECOND FOLD

FIRST FOLD

4 PANEL LETTERFOLD
SELF MAILER IN-PLATE

4 PANEL LETTER FOLD SELF MAILER WITH TEAR-OFFS

REQUIRED GLUE SYSTEM

1	UNIT-23400	MICROGLUE 204 CONTROLLER
1	ASSY-23440	MICROGLUE P-60 POWERSUPPLY ASSEMBLY
1	ASSY-23006	MICROGLUE PHOTOEYE ASSEMBLY
1	ASSY-23050	MICROGLUE ENCODER ASSEMBLY
1	ASSY-23110	MICROGLUE CROSS BAR BRACKET ASSEMBLY
1	ASSY-23119	MICROGLUE 2 GALLON S.S. DELIVERY SYSTEM
2	ASSY-23252	MICROGLUE HV GLUE VALVE ASSEMBLY .015 NOZZLE

REQUIRED MACHINE MODIFICATIONS

- 3 SEGMENTED GLUING ROLLERS IN THE # 1, MAIN AND 3 ROLLER POSITIONS
- 1 SEGMENTED NOSE BAR ON THE # 1 FOLD PLATE
- 2-SEGMENTED NOSE BARS ON THE # 2 AND 4 FOLD PLATES (optional)

CUSTOMER SUPPLIED ITEMS

- 110 OR 220 VAC
- 80-PSI HOUSE AIR (or equivalent)
- PARALLEL SECTION FOLDER WITH PERFORATING WHEELS

APPLICATION TECHNIQUE

Apply a line of glue down on the lead three quarters of the sheet before it enters the roller assembly. The optical sensor should be positioned as close to the rollers as possible to reduce accuracy problems associated with paper registration. The glue valves are mounted over the register table, just before the rollers.

FOLD TECHNIQUE



Fold the sheet to three fourths of its length up in the number one position, fold at one fourth of the original parent length in the number two fold plate, deflect off of the number three fold plate, and then fold to one fourth of the original parent length in the number four fold position. This is a standard "four-panel letter fold" format.

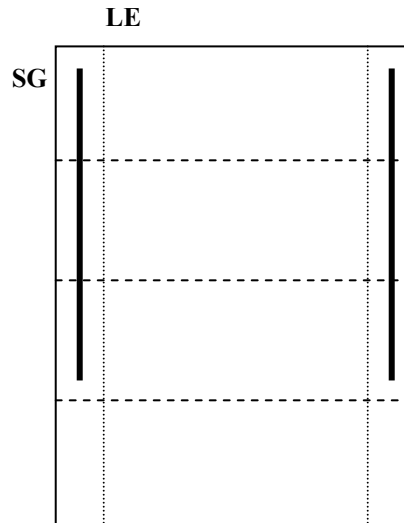
OPTIONAL EQUIPMENT

- FIVE-GALLON S.S. DELIVERY SYSTEM
- GLUE SYSTEM FLUSHING SYSTEM

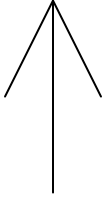
TYPE OF GLUE

Permanent

GLUE LINE 
FOLD LINE 



GLUE LINES



THIRD FOLD

SECOND FOLD

FIRST FOLD

4 PANEL LETTERFOLD
SELF MAILER WITH TEAR-OFFS