

# BAUM

## Impositions and their setups

Before working on the folder, **DISCONNECT ALL ELECTRICAL POWER SUPPLY TO THE FOLDER to prevent the accidental start of the folder.** Check to be sure you have the correct tools to complete the job.

For reasons of safety, long hair must be tied back or otherwise secured, garments must be close fitting and no jewelry, such as rings or necklaces, may be worn while adjusting or setting up equipment. Injury may result from being caught up in the machinery or jewelry catching in moving parts.

- Reference diagrams
- Common Impositions

**Note:**

- When planning an imposition, check your folded layout for proper page numbers and correct guide edges. Verify that your folder is large enough to do the job, that is, that the fold plate depths are sufficient for the folds desired.
- If the desired imposition is unusual, try the stock on the folder before printing (make a trial folding run).
- Use the most logical layout and avoid unnecessary problems such as air pockets and adverse paper grain.
- For better results, use scores when possible.
- There are alternate ways of making many of these impositions; those shown are in common use to achieve the results shown. An experienced operator will often develop alternate methods to achieve the same results.
- Baumfolder Corporation does not assume responsibility for any errors that might inadvertently be contained in this document. Please recheck your layouts and verify the result.

For more information or to order parts phone Baum at 1-800-543-6107

### **Baumfolder Corporation**

1660 Campbell Rd Sidney, Ohio, U.S.A. 45365

Phone : 1-800-543-6107 or 1-937-492-1281

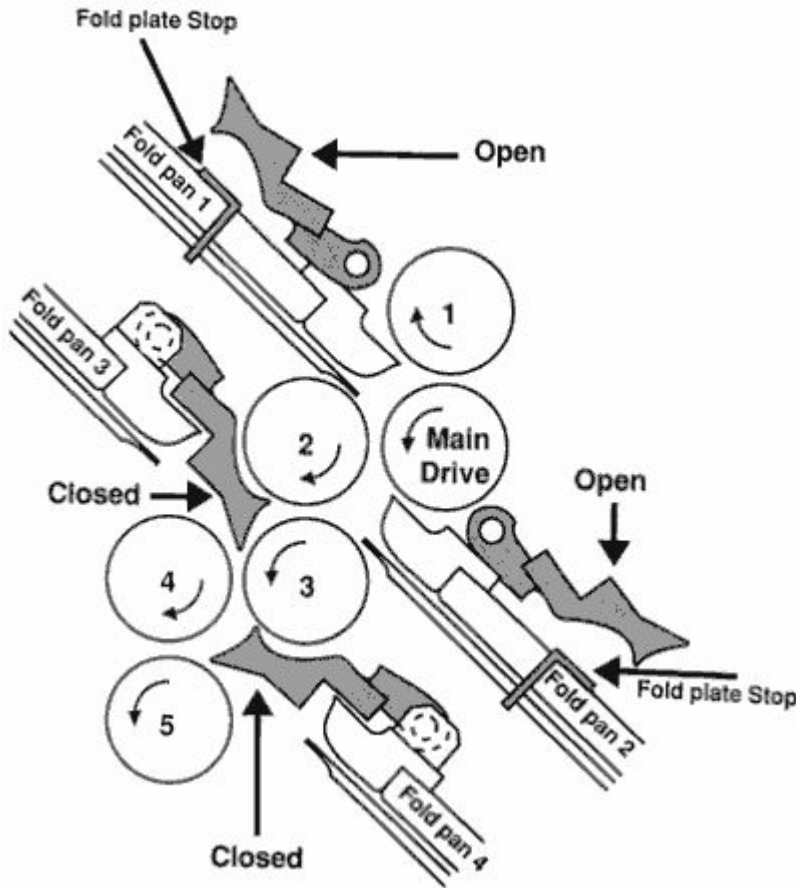
Fax: 1-937-492-7280

Copyright © 2002



# Impositions and their setup

Reference pictures for the roll positions outlined in the common impositions, as well as the gapset positions.



This diagram shows the relative positions of the five rolls and the associated fold plates. In this example the fold will occur in plates one and two, and plates three and four are deflecting the paper.



This picture shows the gapset assemblies that are referenced in the imposition setup instructions.

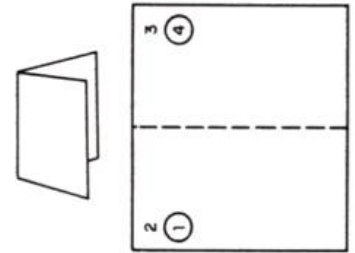


# Impositions and their setup

## 4-Page

Par: 1

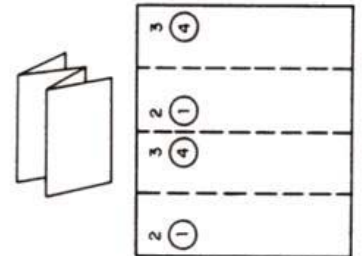
1. Fold up in number one plate  $\frac{1}{2}$  length of the sheet. Deflect other fold plates in that section. Insert one thickness strip of paper you are running in the number one gapset (both sides). Insert two thickness of the same paper in the remainder of the gapsets.



## 4-Page Double Imposition

Par: 1,2,3

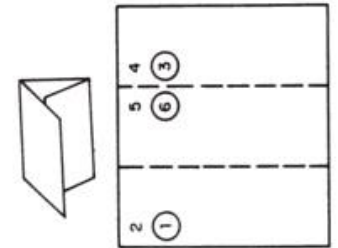
2. Fold up in the number one fold plate  $\frac{1}{4}$  the size of the sheet, down in number two plate  $\frac{1}{4}$  the size of the sheet, up in number three plate  $\frac{1}{4}$  the size of the sheet and deflect past number four fold plate. Insert one thickness of the paper you are running in the one, two, and three gapsets (both sides). Insert four thickness of the paper you are running in the number four and five gapsets (both sides).



## 6-Page Standard

Par: 1,3

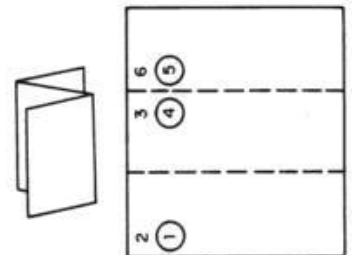
3. Fold up in number one fold plate  $\frac{1}{3}$ <sup>rd</sup> of the length of the sheet, minus  $\frac{1}{8}$  inch and deflect past the number two plate and up into the third fold plate  $\frac{1}{3}$ . Deflect past number four plate. Insert one thickness strip of paper you are running in number one, two and three gapsets (both sides). Insert three thickness strips of the paper you are going to run in number four and five gapsets (both sides).



## 6-Page Accordion

Par: 1,2

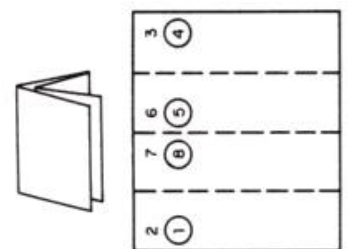
4. Fold up in number one fold plate  $\frac{1}{3}$ <sup>rd</sup> of the length of the sheet and down in number two fold plate  $\frac{1}{3}$ <sup>rd</sup> of the sheet and deflect three and four plates. Insert one thickness strip of the paper you are running in number one and two gapsets (both sides). Insert three thickness strips of paper in the number three, four, and five gapsets (both sides).



## 8-Page Parallel

Par: 1,2

5. Folds in number one fold plate  $\frac{1}{2}$  the length of the sheet and down  $\frac{1}{4}$  of the length of the sheet and deflect numbers three and four plate. Insert one thickness strip of the paper you are running in the number one gapsets, (both sides). Insert two thickness strips of the paper you are folding in the number two gapsets, (both sides). Insert four thickness strips in the three, four, and five gapsets, (both sides).

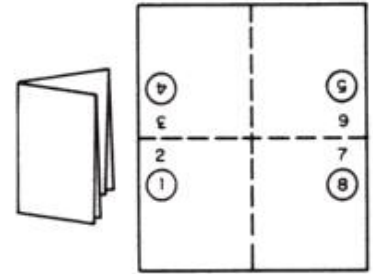


( continued )

# Impositions and their setup

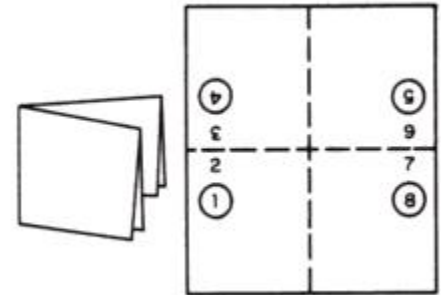
## 8-Page Right Angle Par: 1 8pg: 1

6. Folds in the number one fold plate one half the length of the sheet and deflect the second, third and fourth fold plates. Score the center of the sheet as it leaves the parallel section. Onto the cross carrier to the second unit (eight page) into the number one plate half of the width of the sheet. The fold should be folded on the score. Deflect the number two, three, and four fold plates. In the Parallel unit insert one thickness strip of the paper you are running in the number one gapset (both sides). Insert two thickness strips of the paper you are running in the number two, three, four and five gapsets (both sides). In the second unit, (eight-page unit), insert two thickness strips of the paper you are running in the number one gapset (both sides). Insert four thickness strips of the paper you are running in the second, third, fourth, and fifth gapsets (both sides).



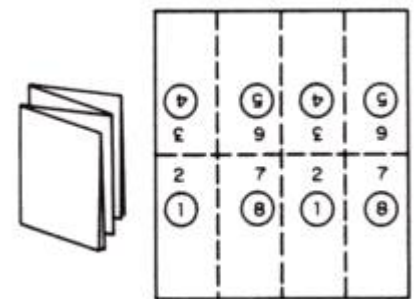
## 8-Page Two right angle oblong Par: 1 8pg: 1

7. This sheet is wider than it is long. Please remember this when we specify one half of the sheet. Folds up in the first fold plate one half of the length of the sheet (shortest length). Deflect the second, third, fourth fold plate and score down the center as it leaves the parallel unit. Go onto the cross carrier into the second unit (eight page); into the first fold plate one half of the width of the sheet. The fold should be on the score. Deflect past number two, three, and four fold plates. In the parallel unit, insert one thickness strip of the paper you are running in the number one gapsets, (both sides). Insert two thickness strips in the two, three, four, and five gapsets (both sides. In the second unit, (eight page unit), insert two thickness strips of the paper you are running in the number one gapsets, (both sides). In the second, third, fourth, and fifth gapset, insert 4 thickness strips of the paper you are running (both sides).



## 8-Page Right Angle, Double Imposition Par: 1 8pg: 1,2,3

8. Folds up in the first fold plate one half of the length of the sheet. Deflect past the second, third, and fourth fold plate and run three scores where you are folding in the second unit as you leave the parallel unit. First score between pages 1,4 and 5,8 with your score blade on the top slitter shaft  $\frac{1}{4}$  of the width of the paper. Second score on the bottom slitter shaft  $\frac{1}{2}$  the width of the paper. Third score on the top slitter shaft  $\frac{3}{4}$  of the width of the paper. Going on the crosscarrier into the second unit, (eight-page unit). Folds up in the first fold plate in the second unit  $\frac{1}{4}$  the width of the paper, down  $\frac{1}{4}$  the width of the paper, and up in the third fold plate  $\frac{1}{4}$  the width of the paper. Again the folds in this unit should be on the score lines made in the parallel unit. In the Parallel unit insert one thickness strip of the paper you are running in the number one gapsets (both sides). Insert two thickness strips of the paper you are running in the number two, three, four, and five gapsets (both sides). In the second unit, (eight page unit), insert two thickness strips of the paper you are running in the first, second and third gapsets (both sides). Insert eight thickness strips of the paper you are running in the fourth and fifth gapsets (both sides).



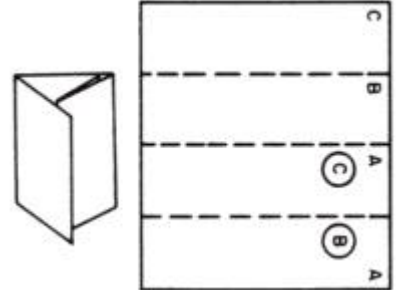
( continued )



# Impositions and their setup

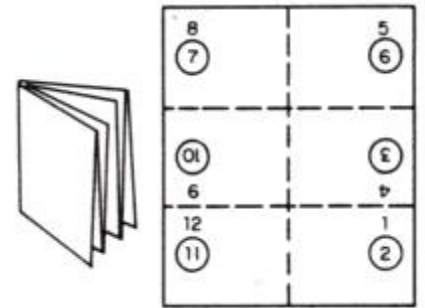
## 8- Page, Parallel over & over fold Par: 1,2,4

9. Folds up in the first plate  $\frac{3}{4}$  of the length of the sheet plus  $\frac{3}{16}$  of an inch. Down in the second fold plate  $\frac{1}{4}$  of the length of the sheet. Deflect the third fold plate and into the fourth fold plate  $\frac{1}{4}$  of the length of the sheet minus  $\frac{1}{16}$  inch. Insert one thickness strip of the paper you are running in the number one, two, three and four gapsets (both sides). Insert four thickness strip of the paper you are running in the number five gapsets (both sides).



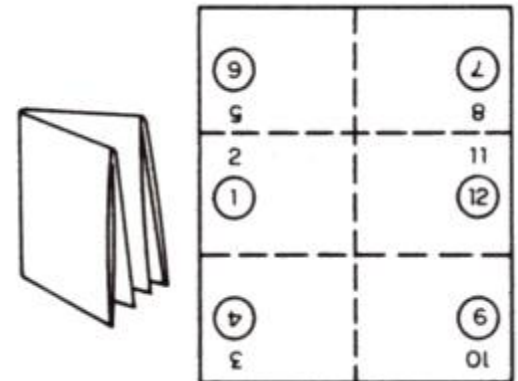
## 12-page book saddle stitch Par: 1,2 8pg: 2

10. Folds up in the first fold plate  $\frac{1}{3}$  of the length of the sheet. Down into the second fold plate  $\frac{1}{3}$  of the length of the sheet and deflects past number three and four fold plate. Score in the center as you leave the parallel unit then onto the cross-carrier. Then into the second unit (eight page) deflecting past the number one fold plate down into the second fold plate  $\frac{1}{2}$  the width of the sheet. The fold should be on the score. Deflect past the number three and four fold plate. In the parallel unit, insert one thickness strip of the paper you are running in the number one, two and three gapsets (both sides). Insert three thickness strips of the paper you are running in the number four and five gapsets (both sides). In the second unit (eight page), insert three thickness strips of the paper you are running in the number one and two gapset (both sides). Insert six thickness of the paper you are running in three, four, and five gapsets (both sides).



## 12-page book, saddle stitch Par: 1,2 8pg: 1

11. Folds up in the first fold plate  $\frac{2}{3}$  plus  $\frac{3}{16}$  of an inch. Folds down in the second fold plate  $\frac{1}{3}$  plus  $\frac{1}{16}$  of an inch. Deflect past number three and fourth fold plates and score in the center as it leaves the parallel unit. Then the sheet travels onto the cross-carrier into the number one fold plate in the second unit (eight page) one half of the width of the paper. It then deflects past second, third and fourth fold plate. Insert one thickness strip of the paper you are running in the number one and two gapsets (both sides). Insert three-thickness strips of the paper you are running in the three, four, and five gapsets (both sides) in the parallel unit. In the second unit, (8-page), insert three-thickness strips of the paper you are running in the number one gapsets (both sides). Insert six thickness strips of the paper you are running in two, three four, and five gapsets (both sides).



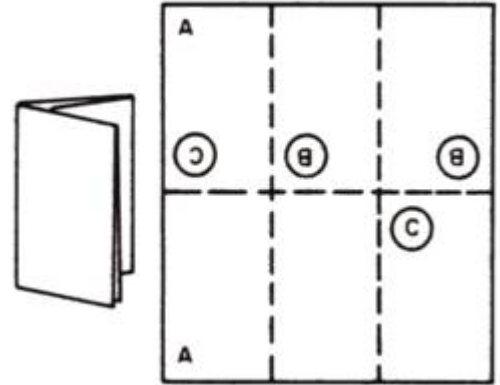
( continued )



# Impositions and their setup

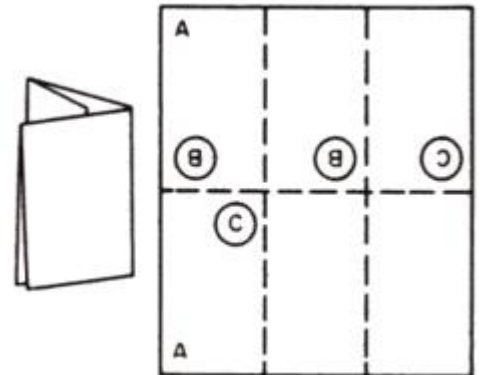
12-Page letter fold-heads out Par: 1 8pg: 1,2

12. Folds up in the number one fold plate  $\frac{1}{2}$  the length of the sheet. Then it deflects past the second, third and fourth fold plates. Then scores  $\frac{1}{3}$  of the width of the sheet minus  $\frac{1}{8}$  of an inch from the right side, side away from the side guide, second score  $\frac{2}{3}$  of the width of the paper as it leaves the parallel unit. Then the folded sheet goes onto the cross-carrier then into the second unit (8-page), up in the first fold plate  $\frac{2}{3}$  of the width of the paper plus  $\frac{1}{8}$  of an inch, down into the second fold plate  $\frac{1}{3}$  of the width of the paper. Deflect past third and fourth fold plates. Insert one thickness strip of the paper you are running in the number one gapsets (both sides). Insert two thickness strip of the paper you are running in the second, third, fourth, and fifth gapsets (both sides) in the parallel unit. In the eight-page unit, insert two-thickness strip of the paper you are running in the number one and two gapsets (both sides). Insert six thickness strip of the paper you are running in the three, four, and number five gapsets (both sides). The folds in the eight-page unit should be folded on the score made on the parallel slitter shaft.



12-Page letter fold-heads in Par: 1 8pg: 1,3

13. Folds in the number one fold plate  $\frac{1}{2}$  the length of the sheet. Then deflects past the second, third, and fourth fold plate. Score  $\frac{1}{3}$  of the width of the paper minus  $\frac{1}{8}$  of an inch from the left side of the sheet; guide side, score  $\frac{2}{3}$  of the width of the sheet plus  $\frac{1}{16}$  in the slitter shaft as it leaves the parallel unit. Then onto the cross-carrier into the first fold plate in the second unit, (8-page),  $\frac{1}{3}$  the width of the paper minus  $\frac{1}{8}$  of an inch. Then deflects past the second fold plate into the third fold plate  $\frac{1}{3}$  of the width of the sheet plus  $\frac{1}{16}$  of an inch. Deflect past the fourth fold plate. Insert one thickness strip of the paper you are running in the number one gapsets (both sides). Insert two thickness strip of the paper you are running in the numbers two, three, four, and five gapsets (both sides) in the parallel unit. In the 8-page unit, insert two- thickness strip of the paper you are running in the number one, two, and three gapsets (both sides). Insert six thickness strip of the paper you are running in the number four and five gapsets (both sides).

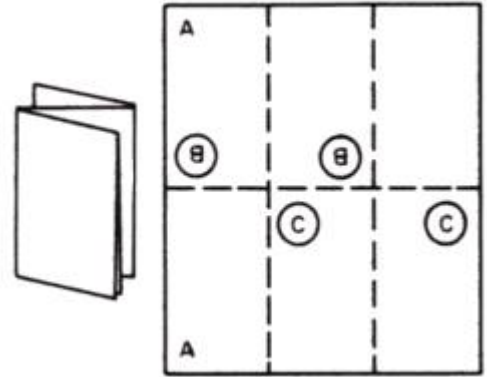


( continued )

# Impositions and their setup

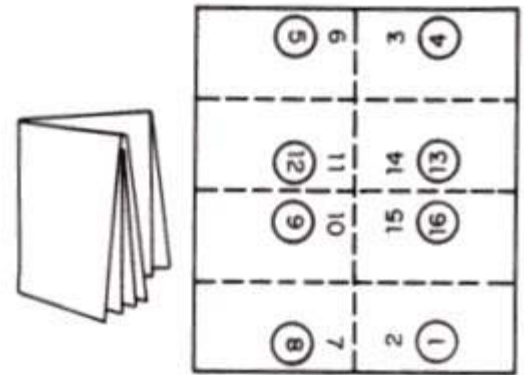
## 12-Page letter fold-accordion Par: 1 8pg: 1,2

14. Folds up in the number one fold plate  $\frac{1}{2}$  the length of the sheet and deflects the second, third, and the fourth fold plate in the parallel unit. Then scores  $\frac{1}{3}$  of the width of the sheet from the left side, side toward the side guide on the register, The second score will be  $\frac{2}{3}$  of the width of the paper from the left side. On the slitter shaft as the sheet leaves the parallel unit. Then onto the cross-carrier into the second unit (8-page) number one fold plate  $\frac{1}{3}$  on the width of the sheet. Then down into the second fold plate  $\frac{1}{3}$  of the width of the sheet and deflect past the third and fourth fold plate. Insert one thickness strip of the paper you are running in the number one gapsets (both sides). Insert two thickness of the paper you are running in the two, three, four, and five gapsets (both sides) in the parallel unit. Insert two thickness strips of paper in the number one and two gapsets (both sides). Insert six thickness strips of the paper you are running in the number three, four, and five gapsets (both sides).



## 16-Page, three right angle books imposition Par: 1 8pg: 1 16pg: 1

15. Folds up in the number one fold plate  $\frac{1}{2}$  the length of the sheet deflects past the second, third, and fourth fold plates. Scores in one half of the width of the sheet as it leaves the parallel unit. Then goes onto the cross-carrier and into the second unit (8-page). Then folds in the number one fold plate  $\frac{1}{2}$  the width of the sheet and deflect past the second, third, and fourth fold plates (folds on the score made in the parallel slitter shaft). Then it travels onto the second cross-carrier (16 page cross-carrier) into the 16-page unit number one fold plate  $\frac{1}{4}$  the length of the original flat sheet and deflects past the second, third, and fourth fold plates. Insert one thickness strip of the paper you are running in the number one gapsets (both sides). Insert two- thickness strip of the paper you are running in the number two, three, four, and five gapsets (both sides), in the parallel unit and score in the center of the width of the sheet as it leaves the parallel unit. Insert two thickness strips of the paper you are running in the number one gapsets (both sides), and four thickness strips of the paper you are running in the two, three, four, and five gapsets (both sides) in the 8- page unit. Insert four thickness strips of the paper you are running in the number one gapsets (both sides). Insert eight thickness strip of the paper you are running in the number two, three, four, and five gapsets in the 16-page unit.



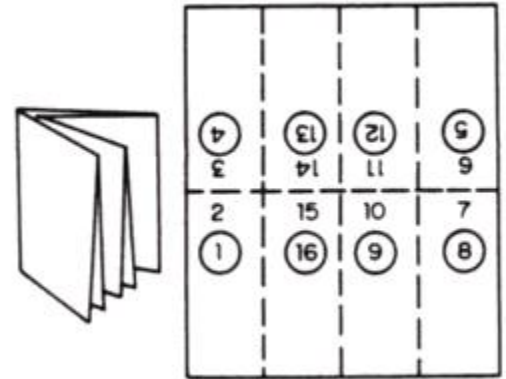
( continued )



# Impositions and their setup

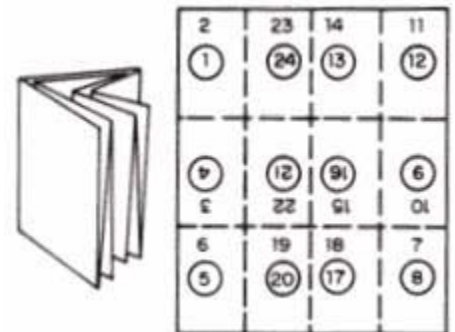
## 16-Page booklet fold - heads out Par: 1 8pg: 1,2

16. Folds up in the first fold plate  $\frac{1}{2}$  the length of the sheet and deflect past the second, third, and fourth fold plate in the parallel unit. Score with the score blade on the top slitter shaft in the center  $\frac{1}{2}$  the width of the sheet. Install another score with the score blade on the bottom slitter shaft  $\frac{3}{4}$  of the width of the sheet measuring from the side guide as the sheet leaves the parallel unit. Then the sheet goes onto the cross-carrier into the second unit (8-page). Folds up in the first fold plate  $\frac{1}{2}$  the width of the sheet, down into the second fold plate  $\frac{1}{4}$  the width of the sheet. It then deflects past the third and fourth fold plates. In the parallel unit, insert one thickness strip of the paper you are running in the number one gapsets (both sides). Insert two thickness strip of the paper you are running in the second, third, fourth, and fifth gapsets (both sides). In the 8-page unit, insert two thickness of the paper you are running in the number one gapsets (both sides). Insert four thickness strips of the paper you are running in the number two gapset (both sides), and finally, insert 8 thickness strips of paper in the number three, four, and five gapsets (both sides).



## 24-page booklet Par: 1,2 8pg: 1,2

17. Folds up  $\frac{1}{3}$  of the length of the sheet in the number one fold plate and down  $\frac{1}{3}$  of the length of the sheet in the second fold plate. Then deflects past the third and fourth fold plate in the parallel unit. Score as the sheet leaves the parallel unit. Install the score blade on the top slitter shaft in the center of the width of the sheet. Second score with the score blade on the bottom slitter shaft  $\frac{3}{4}$  of the width of the sheet measuring from the side guide. The sheet then travels onto the cross-carrier then into the 8-page unit. Folds up in the first fold plate  $\frac{1}{2}$  the width of the sheet and down  $\frac{1}{4}$  of the width of the sheet. Then deflects past the number three and fourth fold plates. Insert one thickness strip of the paper you are running in the number one and two gapsets (both sides). Insert three strips of the paper you are running in the number three, four, and five gapsets (both sides), in the parallel unit. Insert three thickness strips of the paper you are running in the number one gapsets (both sides). Insert six thickness strips of the paper you are running in the number two gapsets (both sides). Insert twelve thickness strips of the paper you are running in the number three, four and five gapsets (both sides).



( continued )

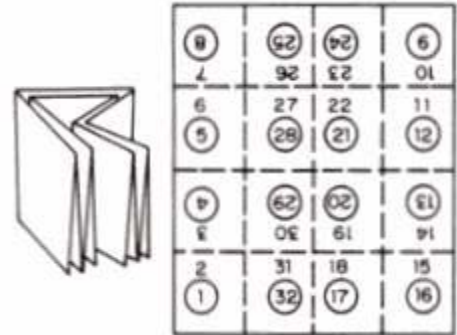




# Impositions and their setup

32-page book Par: 1,2,3 8pg: 1,2

18. Folds up in the number one fold plate  $\frac{1}{4}$  the length of the sheet and down  $\frac{1}{4}$  the length of the sheet. Then the sheet folds up in the third fold plate  $\frac{1}{4}$  and deflects past the fourth fold plate. As the sheet leaves the parallel unit it scores in the slitter shafts. One score with the score blade on the top slitter shaft, the center of the width of the sheet. Second score with the score blade on the bottom slitter shaft,  $\frac{3}{4}$  of the width of the sheet measuring from the guide side. The sheet travels onto the cross-carrier then into the 8-page unit. Folds up in the number one fold plate  $\frac{1}{2}$  of the width of the sheet. Folds down  $\frac{1}{4}$  the width of the sheet and deflects past the third and fourth fold plate. Insert one thickness strip of the paper you are running in the number one, two, and three gapsets (both sides). Insert four thickness strip of the paper you are running in the number four and five gapsets (both sides) in the parallel unit. Insert four thickness strips of the paper you are running in the number one gapsets (both sides). Insert eight thickness strip of the paper you are running in the number two gapsets (both sides). Insert sixteen thickness strips of the paper you are running in the number three, four, and five gapsets (both sides) in the 8-page unit.



\* End of Document