



Les principes de pliage à la machine

(Sources : Heidelberg - Techniques de pliage - impression-juillet 2004)

Deux techniques sont courantes pour l'opération de pliage mécanique : le pliage par couteaux et le pliage par poches. Il est possible d'utiliser un de ces deux principes seul ou de combiner les deux techniques dans une machine.

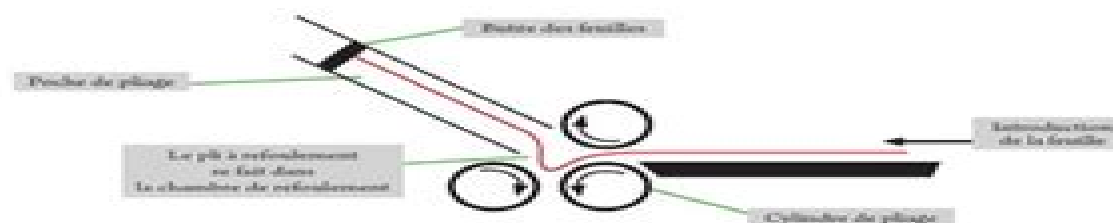
1. Le pliage par couteaux

Ce procédé nécessite un couteau verticalement amovible et deux cylindres de pliage contre-rotatifs. En passant par le groupe de pliage, la feuille est transportée du margear jusqu'à la butée de feuilles et, après un bref temps de séjour, elle est prise entre les cylindres par la descente verticale du couteau de pliage. L'action des cylindres contre-rotatifs permet ainsi de former le pli. La vitesse de pliage est fonction de la cadence du couteau. L'écart entre les deux cylindres de pliage doit absolument correspondre à l'épaisseur du papier à plier.



2. Le pliage par poches

Pour cette technique de pliage, il faut une poche et trois cylindres pour former un groupe. Les deux premiers cylindres verticalement superposés introduisent la feuille dans la poche jusqu'à la butée de feuilles qui est réglable à volonté. La feuille est introduite dans la poche avec une vitesse adaptée à la qualité du papier. Lorsque le bord avant de la feuille arrive sur la butée, la feuille continue son avancée et un pli à refoulement se produit entre les deux cylindres contre-rotatifs du bas. Ce pliage se fait en continu, il n'est donc pas lié à une certaine cadence d'où résultent les rendements de pliage importants. Chaque groupe de pliage standard peut recevoir jusqu'à 6 poches placées alternativement en haut ou en bas. Les poches non utilisées sont remplacées par des déflecteurs de feuilles qui permettent ainsi de sauter une ou plusieurs poches.



3. Pliures combinées

La pliure combinée est la combinaison d'une pliure à poches et d'une pliure à couteaux. Il est ainsi possible d'utiliser les avantages des deux systèmes sur une seule machine. Les pliures combinées ont une très grande flexibilité et sont peu encombrantes. Les pliures d'aujourd'hui travaillent avec des réglages électroniques, un asservissement et un contrôle permanent de la production. Le déplacement des feuilles imprimées et des feuilles pliées est facilité par différents margear et systèmes de sortie.

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Christian Drosten



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Table of Contents **Autoition Lautoition Plates Formes Dimpression Demande**

1. Understanding the eBook **Autoition Lautoition Plates Formes Dimpression Demande**
 - The Rise of Digital Reading **Autoition Lautoition Plates Formes Dimpression Demande**
 - Advantages of eBooks Over Traditional Books
2. Identifying **Autoition Lautoition Plates Formes Dimpression Demande**
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an **Autoition Lautoition Plates Formes Dimpression Demande**
 - User-Friendly Interface
4. Exploring eBook Recommendations from **Autoition Lautoition Plates Formes Dimpression Demande**
 - Personalized Recommendations

- Autoition Lautoition Plates Formes Dimpression Demande User Reviews and Ratings
- Autoition Lautoition Plates Formes Dimpression Demande and Bestseller Lists
- 5. Accessing Autoition Lautoition Plates Formes Dimpression Demande Free and Paid eBooks
 - Autoition Lautoition Plates Formes Dimpression Demande Public Domain eBooks
 - Autoition Lautoition Plates Formes Dimpression Demande eBook Subscription Services
 - Autoition Lautoition Plates Formes Dimpression Demande Budget-Friendly Options
- 6. Navigating Autoition Lautoition Plates Formes Dimpression Demande eBook Formats
 - ePub, PDF, MOBI, and More
 - Autoition Lautoition Plates Formes Dimpression Demande Compatibility with Devices
 - Autoition Lautoition Plates Formes Dimpression Demande Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Autoition Lautoition Plates Formes Dimpression Demande
 - Highlighting and Note-Taking Autoition Lautoition Plates Formes Dimpression Demande
 - Interactive Elements Autoition Lautoition Plates Formes Dimpression Demande
- 8. Staying Engaged with Autoition Lautoition Plates Formes Dimpression Demande
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Autoition Lautoition Plates Formes Dimpression Demande
- 9. Balancing eBooks and Physical Books Autoition Lautoition Plates Formes Dimpression Demande
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Autoition Lautoition Plates Formes Dimpression Demande
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Autoition Lautoition Plates Formes Dimpression Demande
 - Setting Reading Goals Autoition Lautoition Plates Formes Dimpression Demande
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Autoition Lautoition Plates Formes Dimpression Demande
 - Fact-Checking eBook Content of Autoition Lautoition Plates Formes Dimpression Demande

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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