

Job Title: Stahl Folding Machine Operator / Bindery Operator

Department: Post-Press / Bindery

Reports To: Bindery Supervisor / Production Manager

Job Summary

The Stahl Folding Machine Operator is responsible for setting up, operating, and maintaining systems (buckle plate and combination folders) to process printed sheets into accurate signatures, inserts, and folded collateral. The role requires a strong understanding of paper weights, grain directions, folding geometry, and quality control to ensure precise folds at optimal production speeds.

Key Responsibilities & Duties

- **Machine Setup & Changeovers:**
 - Set up and adjust buckle plates, deflectors, roller pressures, slit/perforating shafts, and cross-folding knife units based on job tickets and sample layouts.
 - Configure feeders (flat pile or round continuous pile) and alignment guides to ensure smooth, jam-free paper feeding.
- **Production & Operation:**
 - Operate the Stahl folder efficiently to meet target production quotas while minimizing waste and downtime.
 - Monitor folding accuracy, squareness, and register throughout the run, making micro-adjustments as needed.
 - Handle various stock types ranging from lightweight papers (pharmaceutical/Bible stocks) to heavy cover weights and laminated sheets.
- **Quality Assurance:**
 - Inspect folded signatures for defects such as cracking, dog-ears, wrinkling, tracking errors, or static buildup.
 - Verify page sequences and pagination alignment against customer proofs or dummy samples.
- **Maintenance & Troubleshooting:**
 - Perform routine preventive maintenance, including cleaning folding rollers, checking air pumps, and lubricating moving parts.
 - Troubleshoot mechanical feed issues, jams, or electronic sensor errors quickly to reduce machine downtime.
 - Maintain a clean and organized work area around the folding line.

Qualifications & Requirements

- **Experience:**
 - Minimum 2 to 5 years of hands-on experience operating Stahl folding machines (TH, KH, or TI series).
- **Technical Skills:**

- Deep knowledge of post-press folding mechanics, roller settings, and slit/score/perforate blade positioning.
- Understanding of paper characteristics (GSM, grain direction, humidity impact, and coating types).
- Ability to read and interpret complex job tickets, imposition layouts, and folding diagrams.
- **Physical & Operational Demands:**
 - Ability to stand for extended.
 - Strong mechanical aptitude and attention to detail.
 - Willingness to work in shifts if required by production schedules.

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