



WHAT TO PRINT AND HOW TO PRINT IT

No. 368
1963

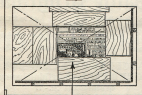
The Printer's HELPER

The KELSEY COMPANY
Meriden, Conn.

Single orders of \$3 or more keep the Helper coming for at least a year.

The Place to Lock the Form in the Chase

On small jobs — which, frequently, like stationery, may be put on sheets much larger than the printed form itself — the place to put the form is where it will make easy feeding of the press. Such printing doesn't put much of a strain on the machine,



NOTE THAT HEAVY PART OF FORM IS JUST BELOW CENTER OF CHASE

ILLUSTRATING USE OF CHASE IRONS AND SCREWS

and it will usually ink and operate easily with the type in any position.

On bigger work, the story is a little different. The heaviest part of the form should be a little below the center of the chase. Note that we said the heaviest part of it. Such a location may bring some parts well over toward the edge.

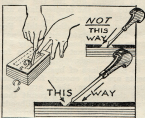
This is done to take advantage of the best inking qualities of the press, which are in lower center, and also to put the strain of the impression where it will have the least effect on the mechanism.

This may sometimes require gauging your sheets out from the side of the platen, but there are many ways of taking care of that, including putting a piece of stiff cardboard on the platen which projects out far enough for you to mount your gauge pin. If the projection at the top is troublesome, get a piece of thin metal, bend an edge of it, and put it under the top tympan bale. It will stick up and hold the paper in place.

If you take these points into consideration, you'll require less

The Correct Way to Cut Linoleum Blocks

We show here a picture illustrating both the right and the wrong way of cutting linoleum blocks. They should not be under-



cut—this will cause the pressure in printing to break off the linoleum. The base should be slightly broader than the printing surface, so as to furnish a firm foundation on which to print. It is just as easy and quick to do it the right way, and it will save a lot of grief unless you don't mind cutting the whole block over again.

How to Avoid Tough Jobs

Naturally you want to give your customers what they require, but frequently you will get an order or an inquiry on a job which, if the customer knew as much about printing as you do, could be altered without hurting its effectiveness or value in the slightest, often with a saving in cost and time consumed in getting it up and running it. Sometimes the customer will have a layout which is almost impossible to turn out except on very expensive equipment, if at all, he being ignorant of printing press limitations.

Printers large and small can profit by some of the cautions issued by one typographic organization for use by printing salesmen. The owner of medium and small sized equipment will recognize among these limitations several which he probably thought never applied to big equipment, but which actually are troublesome in many respects to all classes of printers. If you believe you are unnecessarily hampered, this list may change your mind.

The first "Don't" refers to the attempt on the part of the buyer or printing salesman to combine large solid spaces and fine halftones in a single form. The amount of ink required for solids

(Continued on page two)

makeready, less impression, and obtain better inking.

How to Perforate, Cut and Crease with Your Press

Perforating rule, as you know, comes in strips, as also does cutting and creasing rule. It can be cut into pieces of any length you need for your work.

While printing and perforating may be done at one operation in your press, the sharp face of the rule has a tendency to cut the face of good rollers, so if you have a pair of old, hard ones around you can use them instead. The alternative is to run the rule as a separate impression.



A Help in Perforating

The illustration shows what you need to do to get a clear, sharp perforation. The rule needs a hard surface on the platen opposite it, and this calls for a strip of metal, which must be softer than the rule so that the perforating face will not be damaged. If your rule is brass, the backing material can be a two point lead, or a strip of copper one or more points thick. For steel perforating or cutting rule, one point or thicker brass is good. Cutting rule requires the same backing.

Creasing requires a little different handling. Creasing rule must make a depression, and your tympan as you make it for either printing or perforating hasn't enough give in it for creasing. One way to get the desired results is as follows:

Paste a piece of pad back, or some other heavy but not too hard cardboard on the platen. Put the creasing rule in the chase, and take a light impression of it on the cardboard. On each side of the impression you have just made (on the platen tympan) paste strips of hard, smooth cardboard like our heavy white (about 4 ply, that is.) The width of the space between the strips depends on the thickness of the stock you are going to crease, but you will have to experiment to get the best spacing. The strips can be bevelled on the heavy white (edge toward the crease mark. The channel should be wide enough to take the rule plus the stock you are creasing.

Placing the crease in the outside of the required fold may be the

(Continued on page four)

Printed on Kelsey Standard White Book paper, with Kelsey Many Purpose Black Ink

Keep The Helper for Reference. We cannot furnish back numbers. Edition is exhausted in month of issue. For standard binder punch holes as indicated.

Heavy Old English

Type styles come and go, but a few, like Heavy Old English, seem destined to have a permanent place in the catalog. It follows the design of the Old English black letter which was used rather than Roman for everyday printing in England well into the 18th century. Old English is the true Gothic, whereas what we nowadays call Gothic is no Gothic at all but a sans-serif.

Heavy Old English is particularly appropriate for church, program, and announcement work. Tickets and programs, while not very often printed entirely in it are frequently seen with the most important line, or title, in Heavy Old English. Others use it, not only for the main title, but for each item in the program, followed by details in a smaller size of Goudy, Caslon, Century or some similar face.

Some people like personal cards set in this style, which calls for 8, and 10 point 084, and 104 respectively. In church and program work the most used sizes are 104, 124 and 144 with 184 and 244 for the front if it is a four page affair.

How to Avoid . . . (Cont'd)

is too great to work well on a good halftone. Either the form will be overinked for one, or underinked for the other.

Another related caution is the necessity for a larger press on jobs with heavy, solidly inked spaces than for the same size form more lightly set. Many a small or medium sized press owner runs into difficulty when he tackles a job that nearly fills the chase and includes either cuts or heavy type, or borders, or all three. Such jobs belong on larger machines, or should be run part at a time. It isn't a peculiarity of small equipment. Work of this character should cost the customer more money because it must either be run through more than once or put on a bigger press. The proper figuring of costs means a higher press charge on a bigger machine.

The printing salesman is told not to take a job with too much solid or rule work on an envelope, because as every printer knows, the uneven thickness of the envelope must be taken care of by makeready, and the more complicated the setup is, the harder to make a good looking job. Of course, if the customer wants it regardless of cost, that is something else. In most cases, he simply does not realize that those lapped over edges have anything to do with the cost of printing.

Excessive amounts of hand work, such as filing, mitering and routing out are to be avoided, unless you can get enough extra money to cover the time. That doesn't mean that where a frame or box of rule is needed the ends should be butted together without mitering, but it

Billheads or Statements

Quite a little confusion seems to be created by failure on the part of many printers to distinguish between billheads and statements.

A billhead is made primarily for use as an invoice of merchandise, whereas a statement is supposed to be what its name implies—a statement of the customer's account, often sent out each month with the total amount due for the period. Usually only the invoice dates and amounts appear on it, or sometimes just the monthly total. For this reason, statements are narrower than billheads—usually 5½ inches, as against 8½ inches for regular billheads.

In some lines of business, statements are wide enough for invoice purposes, hence they are often used that way. As a result they are frequently miscalled billheads. If your customer likes to purchase statements for billhead or invoice purposes, by all means give them to him, and let him call them what he wishes. Don't, however, order them by the wrong name, because you may not get what you expect, and that means delay in filling your customer's requirements.

does mean intelligent care in the layout of the job to eliminate unnecessary time-consuming details.

Don't write instructions as to size, etc., on the back of a photograph or drawing which must be made into a cut, unless you do it very lightly, because it may show through in the cut making and spoil the picture. On photo stock it often embosses and reads in reverse right through the picture.

When laying out work remember that space must be left somewhere for the grippers (or some substitute) to hold the card or paper.

A halftone cut made to print on smooth finish paper is not going to look its best on rough stock, such as newsprint, antique, eggshell, etc.

For best results many gold and some silver jobs should be run through the press twice. This should be remembered in making prices. The same goes for printing in white ink. One impression may be all right for some jobs, depending on how fussy it is.

No job is going to look as good on cheap paper as on the better grades of book stocks, such as glossy book or enamelled.

To these we could add a few of our own, but will reserve them for another time. Work with your customer to give him a satisfactory job for the intended purpose without unnecessary expense and you will make him your friend. It will also be harder for somebody else to take him away by calling his attention to savings he might have made before. And perhaps you will get some new customers yourself by offering them such suggestions.

QUOINS

Escalator changes are furnished with screws and chase irons, but heavy prefer to use quoin.

Quoins, Hempel the most popular of all quoin, per set of two pieces. - - - - - **35**
per half-dozen. - - - - - **1.89**

Hempel Key Wrench - - - - - **.95**

Midget Quoins (screw-type) cadmium plated, disc has four holes by which it can be easily turned with a nail or iron rod. Minimum thickness ¼-inch, maximum thickness - - - - -
□ each, **.80** □ six, **3.55** □ doz. **6.20**

Wickerson Quoins, extra fine, a sure, safe lock, each. - - - - - **7.00**
per half-dozen. - - - - - **12.60**

Key Wrench, for above, - - - - - **2.20**

Heavy Old English

No. 084 8 Point 10A 62 \$2.05—10A 12a \$4.20

Other Sizes Britain of Cut Style \$ 85

No. 104 10 Point 18A 44 \$2.45—4A 14a \$4.70

Suitable for use on any **17 3**

No. 124 12 Point 16A 87a \$11.05—10A 12a \$4.16

Kinds of Printed Work 500

No. 144 14 Point 14A 82a \$13.60—1A 10a \$5.75

Especially Headings, 139

No. 184 28 Point 8A 20a \$14.65—1A 10a \$9.55

Stationery, Tickets

No. 244 24 Point 6A 13a \$16.25

Daily Program

No. 264 26 Point 4A 9a \$21.50

The Timer

A B C D E F G H I J K L M N O P

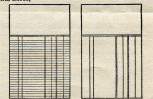
Q R S T U V W X Y Z abcdefghijklmnop

qrstuvwxyz . : ; - ' ?

\$ 1 2 3 4 5 6 7 8 9 0

Billheads and Statements

Ruled Heading, White Bond Paper
Pictured below are the 100 styles of statements. Billheads have lines running the other way to that of the sheet.



Style A - Ruled complete with vertical and all horizontal lines for use with pen and ink.
Style B - Ruled with column and head line only, for typewriter use.
Be sure to state style wanted when ordering.

BILLHEADS

| Quantities of | 500 | 1,000 | 5,000 | 10,000 |
|----------------------|--------|---------|---------|---------|
| Prices per | \$50 | \$1,000 | \$1,000 | \$1,000 |
| 5 Sizes, 8½ x 4½ in. | \$1.80 | \$3.00 | \$2.80 | \$1.80 |
| Four 8½ x 7 | 1.85 | 3.00 | 2.80 | 2.75 |

STATEMENTS

| | | | | |
|-------------------|------|------|------|------|
| Standard, 8½ x 8½ | 1.40 | 2.42 | 2.20 | 2.10 |
| Midget, 4 x 6 in. | 1.30 | 1.95 | 1.82 | 1.75 |

© Not made in style B

2 The Printer's Helper

WITH OUR READERS

Uses Allen Set Screws in Chase

From an old reader:

I find Allen set screws an advantage over the regular set screws for tightening the form in the chase. The Allen set screw wrench gives better control over screws than the screw driver kind. However, it should be remembered that an Allen wrench can give an extremely powerful leverage and care must be taken not to over-tighten.

I also use the method recently appearing in the reader's column which calls for chase screws on the top side of the chase for quick makeready. However, I had to drill and tap my chase for it as my model was not reversible.

I have found that placing a single sheet of newspaper UNDER the form before making the squeeze to level the form is helpful. I believe there is less wear on type in the long run by this method as it permits using a harder tympan and less platen pressure when printing.

(Editor's Note — the other reader had much heavy form work to do; after planing the form and putting the chase in the press, he loosened the screws a half turn, made an impression, retightened the screws — before releasing pressure of type on paper. One or two extra thicknesses of paper were put on the platen during this operation, and then removed.)

Another Way of Printing Two Colors at Once

From an old correspondent:

"Recently you explained different methods of printing several colors at the same time. Here is our method: Disconnect the ink plate so it will not turn while in operation. (Editor's note—In most cases this can be done by tying down the ink plate operating dog.) Put one color ink on one side of the plate and the other color on the other. Use two different hand rollers to spread the ink out evenly on each side, and you are ready to go. This gives a blending effect."

To Remove Ink Marks

There are not many occasions when the printer wants to remove ink from paper, with paper stock as cheap as it is in most cases, but we have requests for the information from time to time, so

The Printer's Helper 3

An Easy Way to get Accurate Gaging

You can save spoilage on Christmas card and similarly expensive stock if you stretch a sheet of tissue, onion skin or some other transparent paper over the tympan on your platen—and under the baills of the platen, on which you can make an impression. A sheet of the stock to be printed may then be slipped under this top sheet, and moved around until the correct position has been located. Gages may then be placed in the tympan, and the thin top sheet torn off the platen.

Another Composing Stick Rest

The publishing of an illustration of a rest for composing sticks in a recent issue of *The Helper* has reminded another reader of a rest which is if anything even more simple than the one previously described. As every printer knows, there are innumerable times when the composing stick must be laid down when it is more or less full, and every time it is put down, there is a chance that it will not stay in position—with "pi" and general trouble as a result. Very often the telephone bell rings, or there is somebody at the door, and in such cases there is not always time to find a safe place to put the stick.

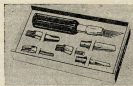
The suggestion is advanced that an old piece of brass rule may be bent into the shape of the letter "S" except that in place of one of the rounded curves in the rule, a sharp bend be made, so that the stick will fit snugly. Such a rest may be kept in the pocket of your work apron and put to instant use when an emergency makes it necessary to drop the composing stick in a hurry.

We have had several other good ones shown to us, either in the actuality or in sketches. One reader made his out of a discarded coffee can, and another similar was in which to set a tube of ink when printing. The latter, he says, keeps the open end of the tube off the shelf, and prevents wasteful and messy dribbling.

apparently it will be of interest to some readers of the *Printer's Helper*.

This may be effected by a chloride of lime solution, one ounce to a half pint of water, and a little 80% strength acetic acid, the latter being a near relation of vinegar. Dampen the ink with the chloride of lime solution, and follow it up with the acetic acid. This can be used on writing inks as well—in fact, many of the trademarked ink removers which sell at good prices are either in part or wholly made from these ingredients.

X-Acto Linoleum Cutting Tools



- Set of 6 Tools, (knife, U-shaped gages and V-shaped veiners) with plastic tool handle, (blade locks in handle) - - - - - **\$2.40**
- Cutting Knife, (with handle), - - - - - **1.22**
- (Same handle used with knife or tools.)
- Single Tool, (with handle), - - - - - **1.25**
- Single Tools, (without handle), each, - - - - - **.25**
- Five tools, without handle, - - - - - **1.25**
- Cutting Knife (without handle), - - - - - **.12**
- Five knives, without handle, - - - - - **.60**
- Hand Roller, 5 1/2 inch, with handle, - - - - - **2.48**
- Rubber Roller, 4 in. 1 in. diam. #3, - - - - - **.90**
- Rubber Roller, 4 in. 1 1/4 in. diam. #5L - - - - - **1.75**

LINOLEUM PRINTING BLOCKS

Smooth Surface for Easy Drawing of Design



Linoleum blocks are best grade 1/4-inch linoleum, mounted type high on laminated blocks to make them non-warpage.

| Size | One | Six | Dozen |
|------------|------|-------|-------|
| 2x3 inches | .38 | 1.28 | 1.88 |
| 3x4 " | .45 | 1.78 | 2.68 |
| 4x6 " | 1.90 | 4.40 | |
| 6x8 " | 1.80 | 6.00 | 9.50 |
| 9x12 " | 2.90 | 13.40 | 18.90 |

Assortment, consists of two sizes 2x3 blocks, and one each of sizes 3x4, 4x6, and 6x8. **3.50**

For cutting, perforating, creasing

- Steel Rule**
- Perforating Rule is used to cut a line of small slots between coupons, checks, etc. so that they may be easily torn apart.
- Cutting Rule frused for cutting paper boxes, envelopes, and paper novelties of many kinds. It is also used for "scoring" or cutting part way thru the sheet so that it may be easily folded along the scored line.
- Creasing Rule is used for the same purpose but does not cut the sheet, simply embosses or presses a crease into the paper.
- (Sold only in two-foot strips.)
- Perforating Rule, per strip, - - - - - **.80**
- Cutting Rule, " " " " - - - - - **.33**
- Creasing Rule, " " " " - - - - - **.33**



Combination Label Holder—Drawer Pull



Same as supplied with new cabinet-front type cases. White card covered with celluloid strip for identification of type in case—can easily be read from standing position.

45¢ each, per dozen, 4.95

Brass Label Holders

Brass Label Holders, 3/4 x 1 1/2 inches, to attach on front of type cases. Label slips in and can be changed at any time. Much neater than labels that are pasted on.

10 cents each, 90 cents per dozen



The KELSEY MAN Talks About Quoins

The custom of using quoins or wedges in chases to hold the type is about as old as printing itself. Up to well into the present century it was possible to buy wooden quoins and "shooting sticks" which were used for wedging them in the chase.

Along the latter part of the nineteenth century there appeared several different kinds of patented metal quoins. Among them was the Hempel, which uses the principle of the wedge, but improves on it, offering a key for tightening and loosening. The Hempel and variations of it are still among the most popular today.

Another later arrival was the Wickersham, which uses the cam, as a wedge, and Wickershams practically divide the field with various kinds of Hempels, for standard size work.

So-called midget or register quoins have a place for very close work, and also in forms where close register is important. A row of these register or midget quoins around a form enables the printer to make minute adjustments back and forth, tilting the form at will until it is correctly lined up. They are a screw quoin, using the same principle as Kelsey screw-type chases.

Gloves Cut Spoilage

A pair of cheap cotton gloves, which may be slipped on and off at will, can save you time and money in your shop. They will keep your hands clean when you are putting more ink on the press, or if you need to remove the chase for any reason.

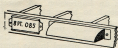
When the press is inked up, you can get a smudge of ink on your hands without even realizing it, until you pick up a piece of paper stock and make an impression — with your finger. Reaching back onto the platen to adjust a gauge pin can cause a transfer of ink from the rollers to you. Incidentally, if you do want to touch gauge pins or tympan you can slip a piece of paper between the rollers and the grippers so that if you do get too close to the rollers the paper will take the rub instead of your fingers. Use gloves, here too, except in places where they are too clumsy.

One of our readers says he uses gloves with the fingers cut off when operating his press. He keeps cleaner, and avoids possible blisters.

Aside from the stock you preserve unsmudged, you'll save time by making fewer washups. An old, dirty pair of gloves will protect your hands while inking up, or when cleaning the press, too.

Label Your Own Cases

You will find it of much help to have clearly printed labels on your type cases, and while you are about it, if you have any other boxes of material, drawers, or other places where your supplies can not be examined without



opening up the box, drawer, or other compartment, you will find it of help to paste a printed label on the front showing the contents.

It will be well to pick out one of your clearest and boldest faces of type for doing the job—or, if you prefer in the case of the type, you can set a line of the style and size itself, and put that on. The size of the type should be very conspicuously displayed, as well as the style. Label holders may be used for the labels, which may be printed on cardboard, and some printers recommend coating the label with shellac after it is put on, to protect it.

Double or Triple Capacity From Your Press

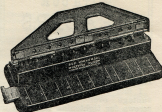
From a letter of sometime ago: I am sending you a sample of work done on my 4x10 Excelsior press, thinking it may interest readers of the Printer's Helper, because I have received help from it in several ways.

"This job was run by printing half at a time, running one-half, of course, upside down in the press, so as to match up with the other half. Five thousand impressions were made by giving quads to the tympan for gauges instead of gauge pins, and letting the work fall through and under the press as it opened. By this method the sheets were handled only once for each run, instead of twice as is the usual way, thus doubling the output."

The sample referred to is a good looking piece of advertising matter, single sheet printed on one side, which because of its size looks as if it were run on a 9x13 machine at the least. By running half at a time it was possible to double the size of the work ordinarily done on the 6x10 press.

It is possible not only to double, but to triple and even quadruple the size of jobs on a press by running the job through the machine two or more times. Each impression need not be a separate page, they may be all the same page or column. Naturally, if you are getting much big work you will want a bigger machine, but as an infrequent or emergency method, or on very small poster runs, you will find the idea useful.

Universal Punch



Sturdily constructed of heavy sheet steel 1/8-inch thick, die formed, finished in gray enamel and highly polished nickel plate with felt base. This punch will make four 1/4-inch holes in 10 sheets of ordinary bond paper. The handle contains four movable stops which are set over the punches you desire to use. The side plate is double marked and can be used from either end. Has a pan on bottom for holding punching scrap—easily removed by pressing on edge of pan.

Complete, \$8.95
Shipping Weight, 4 pounds

140 Paned Informals

For short notes, acknowledgments, invitations and all occasions where a neat combination of smartness and informality is required. Also suitable for sympathy cards. Folded size of sheet 27 1/2 x 4 1/2 inches, with a 2 1/2 x 3 1/2 inch panel on front. Envelopes size 3 1/2 x 4 1/2 inches.

| Quantities of | 100 | 500 | 1000 |
|----------------|---------------|--------|--------|
| | Price per 100 | 200 | 600 |
| 140A Sheets | \$2.75 | \$4.25 | \$7.00 |
| 140B Envelopes | 1.25 | 2.25 | 3.25 |
| 140C Sets | 2.50 | 4.10 | 6.10 |

Use This Calendar Cut

On all kinds of advertising—cards, leaflets, blotters, etc. It will assure longer life for your own publicity and your customers' printed matter, too.

| 1964 CALENDAR 1964 | | | | | | | | | | | |
|--------------------|----|----|----|------|----|----|----|-----------|----|----|----|
| JANUARY | | | | MAY | | | | SEPTEMBER | | | |
| S | M | T | W | T | F | S | S | S | M | T | W |
| 5 | 6 | 7 | 8 | 12 | 13 | 14 | 15 | 19 | 20 | 21 | 22 |
| 9 | 10 | 11 | 12 | 16 | 17 | 18 | 19 | 23 | 24 | 25 | 26 |
| 13 | 14 | 15 | 16 | 20 | 21 | 22 | 23 | 27 | 28 | 29 | 30 |
| 17 | 18 | 19 | 20 | 24 | 25 | 26 | 27 | 31 | | | |
| 21 | 22 | 23 | 24 | 28 | 29 | 30 | 31 | | | | |
| 25 | 26 | 27 | 28 | | | | | | | | |
| 29 | 30 | 31 | | | | | | | | | |
| FEBRUARY | | | | JUNE | | | | OCTOBER | | | |
| S | M | T | W | T | F | S | S | S | M | T | W |
| 1 | 2 | 3 | 4 | 1 | 2 | 3 | 4 | 1 | 2 | 3 | 4 |
| 5 | 6 | 7 | 8 | 5 | 6 | 7 | 8 | 5 | 6 | 7 | 8 |
| 9 | 10 | 11 | 12 | 9 | 10 | 11 | 12 | 9 | 10 | 11 | 12 |
| 13 | 14 | 15 | 16 | 13 | 14 | 15 | 16 | 13 | 14 | 15 | 16 |
| 17 | 18 | 19 | 20 | 17 | 18 | 19 | 20 | 17 | 18 | 19 | 20 |
| 21 | 22 | 23 | 24 | 21 | 22 | 23 | 24 | 21 | 22 | 23 | 24 |
| 25 | 26 | 27 | 28 | 25 | 26 | 27 | 28 | 25 | 26 | 27 | 28 |
| 29 | 30 | | | 29 | 30 | | | 29 | 30 | | |
| 31 | | | | | | | | | | | |
| MARCH | | | | JULY | | | | NOVEMBER | | | |
| S | M | T | W | T | F | S | S | S | M | T | W |
| 1 | 2 | 3 | 4 | 1 | 2 | 3 | 4 | 1 | 2 | 3 | 4 |
| 5 | 6 | 7 | 8 | 5 | 6 | 7 | 8 | 5 | 6 | 7 | 8 |
| 9 | 10 | 11 | 12 | 9 | 10 | 11 | 12 | 9 | 10 | 11 | 12 |
| 13 | 14 | 15 | 16 | 13 | 14 | 15 | 16 | 13 | 14 | 15 | 16 |
| 17 | 18 | 19 | 20 | 17 | 18 | 19 | 20 | 17 | 18 | 19 | 20 |
| 21 | 22 | 23 | 24 | 21 | 22 | 23 | 24 | 21 | 22 | 23 | 24 |
| 25 | 26 | 27 | 28 | 25 | 26 | 27 | 28 | 25 | 26 | 27 | 28 |
| 29 | 30 | 31 | | 29 | 30 | 31 | | 29 | 30 | 31 | |
| | | | | | | | | | | | |

No. M1149 \$2.25 (any year desired)

How to Perforate . . . (Cont'd)

opposite of what you would think, but that's the best way, because that is the side which must be stretched when the actual folding is done. Adhesive tape is sometimes used instead of cardboard strips. The channel should be deep enough to break the stock in the middle for satisfactory folding, and the crease should be wide on heavy stock, narrow on thin stock.