



# Technical information

## Stahlfolder TH/KH

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### **Folding machines with the widest range of applications**

Stahlfolder TH buckle plate machines and Stahlfolder KH combination folding machines are consistently modular in design. With numerous options, you can expand your range of products and services exactly as you wish, and successfully move into new areas of business. Additional modules such as the gate fold buckle plate and gluing device ensure folding with higher added value. This unique modularity that even allows custom configuration opens up new opportunities to set you apart from the competition.

Whatever challenges you face – Stahlfolder TH/KH folding machines ensure high productivity for a wide range of products. Fold different jobs economically and with short throughput times. Because extensive automation options and an ergonomic machine design simplify operation. Standardized fold types can be selected directly via the graphic control interface, shortening makeready times. On this basis, you can fold any production run efficiently and profitably. With a Stahlfolder TH/KH, you have a flexible folding machine at your disposal, that you can rely on for numerous different applications. Fold 16-page A4 signatures at a speed of 9,000 to 12,000 sheets per hour reliably and in constantly high quality. With the Stahlfolder TH/KH 82-P folding machines, you can further increase this output by incorporating shingled folding, and achieve up to 16,000 sheets per hour. And all at the same machine speed.



You can find more about the technical data for the Stahlfolder TH/KH here: [heidelberg.com/th-kh/technical-data](https://heidelberg.com/th-kh/technical-data)

# Technical data

## Stahlfolder TH 56

	Feeder		Folding units		
	Flat pile	Round continuous	1 <sup>st</sup> station 56	2 <sup>nd</sup> station 56	3 <sup>rd</sup> station 56
Version	Automated				
Max. sheet size, width × length (cm)	56 × 90	56 × 128			
Min. sheet size, width × length (cm)	14 × 18	14 × 18			
Paper weight (g/m <sup>2</sup> )	40 – 250	40 – 250			
Max. pile height (cm)	80	8			
Number of buckle plates			4, 6 or 8	4, 6 or 8	2 or 4
Max. fold length (cm) position 1 Combination/comfort buckle plate <sup>1</sup> Small format buckle plate <sup>2</sup>			58/63 58	46 46	46
Min. fold length (cm) Combination/comfort buckle plate Small format buckle plate			6/6.85 3.5	6 3.5	6
Max. speed (m/min.)			230	210	210
Min. speed (m/min.)			25	25	25
Diameter of folding rollers (mm)			44	44	44
MCT control system	touchscreen	touchscreen		control panel with display	control panel with display
Power consumption (kVA) 3 × 400V, 50/60Hz, 35A 3 × 230V, 50/60Hz, 50A	incl. pump 5.7/6.3 5.7/6.3	incl. pump 6.6/7.4 6.6/7.4	in feeder in feeder	1.6 1.6	1.6 1.6

<sup>1</sup> Comfort buckle plate with continuous sheet stop and separate sheet deflector

<sup>2</sup> Modified combination buckle plate for producing small format products

Technical data subject to machine configuration, job, format, substrate and possibly other factors.  
The combination of individual features may vary from one country to another.

1 cm equals 0.3937 inches.

# Technical data

## Stahlfolder TH 66

	Feeder			Folding units		
	Flat pile	Round continuous	Pallet	1 <sup>st</sup> station 66	2 <sup>nd</sup> station 66/56	3 <sup>rd</sup> station 56
Version	Manual or automated					
Max. sheet size, width × length (cm)	66 × 104	66 × 128	66 × 104			
Min. sheet size, width × length (cm)	14 × 18	14 × 18	14 × 18			
With twin suction wheel	20 × 18	20 × 18	20 × 18			
Paper weight (g/m <sup>2</sup> )	40–250	40–250	40–250			
Max. pile height (cm)	80	8	120			
Number of buckle plates				4, 6 or 8	4, 6 or 8	2 or 4
Max. fold length (cm) position 1						
Swing-deflector buckle plate				62	58	58
Combination/comfort buckle plate <sup>1</sup>				58/67	46	46
Min. fold length (cm)						
Swing-deflector buckle plate				5.5	5.5	5.5
Combination/comfort buckle plate				6/6.85	6	6
Max. speed (m/min.)				230	210	210
Min. speed (m/min.)				25	25	25
Diameter of folding rollers (mm)				44	44	44
MCT control system	control panel with display or touchscreen	control panel with display or touchscreen	control panel with display or touchscreen		control panel with display	control panel with display
Power consumption (kVA)	incl. pump	incl. pump	incl. pump			
3 × 400 V, 50/60 Hz, 50 A	5.7/6.3	6.6/7.4	7.0/7.8	in feeder	1.6	1.6
3 × 230 V, 50/60 Hz, 63 A	5.7/6.3	6.6/7.4	7.0/7.8	in feeder	1.6	1.6

<sup>1</sup> Comfort buckle plate with continuous sheet stop and separate sheet deflector

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# Technical data

## Stahlfolder TH 82

	Feeder			Folding units			
	Flat pile	Round continuous	Pallet	1 <sup>st</sup> station 82	2 <sup>nd</sup> station 82/66	3 <sup>rd</sup> station 66/56	4 <sup>th</sup> station 56
Version	Manual or automated						
Max. sheet size, width × length (cm)	82 × 120	82 × 128	82 × 120				
Min. sheet size, width × length (cm)	14 × 18	14 × 18	14 × 18				
With twin suction wheel	20 × 18	20 × 18	20 × 18				
Paper weight (g/m <sup>2</sup> )	40 – 250	40 – 250	40 – 250				
Max. pile height (cm)	80	8	120				
Number of buckle plates				4, 6 or 8	4, 6 or 8	2 or 4	2
Max. fold length (cm) position 1							
Swing-deflector buckle plate				62	58	58	33
Combination/comfort buckle plate <sup>1</sup>				58/67	46	46	33
Min. fold length (cm)							
Swing-deflector buckle plate				5.5	5.5	5.5	5.5
Combination/comfort buckle plate				6/6.85	6	6	6
Max. speed (m/min.)				230	210	210	210
Min. speed (m/min.)				25	25	25	25
Diameter of folding rollers (mm)				44	44	44	44
MCT control system	control panel with display or touchscreen	control panel with display or touchscreen	control panel with display or touchscreen		control panel with display	control panel with display	control panel with display
Power consumption (kVA)	incl. pump	incl. pump	incl. pump				
3 × 400 V, 50/60 Hz, 50 A	6.7/7.5	6.6/7.4	7.0/7.8	in feeder	1.6	1.6	1.6
3 × 230 V, 50/60 Hz, 63 A	6.7/7.5	6.6/7.4	7.0/7.8	in feeder	1.6	1.6	1.6

<sup>1</sup> Comfort buckle plate with continuous sheet stop and separate sheet deflector

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# Technical data

## Stahlfolder TH 96

	Feeder	Folding units			
	PFX pallet	1 <sup>st</sup> station 96	2 <sup>nd</sup> station 82	3 <sup>rd</sup> station 66	4 <sup>th</sup> station 56
Version	Automated		Manual or automated		
Max. sheet size, width × length (cm)	96.5 × 132				
Min. sheet size, width × length (cm)	42 × 30				
Paper weight (g/m <sup>2</sup> )	70 – 250				
Max. pile height (cm)	120				
Number of buckle plates		6	4, 6 or 8	4	2
Max. fold length (cm) position 1					
Swing-deflector buckle plate		67 <sup>1</sup>	58	58	33
Combination buckle plate			58	46	33
Min. fold length (cm)					
Swing-deflector buckle plate		6.85 <sup>1</sup>	5.5	5.5	5.5
Combination buckle plate		6	6	6	6
Max. speed (m/min.)		230	210	210	210
Min. speed (m/min.)		25	25	25	25
Diameter of folding rollers (mm)		44	44	44	44
MCT control system	touchscreen		control panel with display	control panel with display	control panel with display
Power consumption (kVA)	incl. pump				
3 × 400 V, 50/60 Hz, 50 A	6.3/6.8	in feeder	1.6	1.6	1.6
3 × 230 V, 50/60 Hz, 63 A	6.3/6.8	in feeder	1.6	1.6	1.6
Required compressed air flow at 6 bar (standard l/min.)	2,000				
The compressed air supply must be provided by the customer.					
It must satisfy the following specifications, as a minimum:					
• Quick-release coupling DN 10 (NPS) with a minimum flow rate of 3,000 l/min.					
• Compressed air quality to ISO 8573-1:2010 (4-4-2)					

<sup>1</sup> With motor-controlled sheet stop and folding sheet deflector

Technical data subject to machine configuration, job, format, substrate and possibly other factors.  
The combination of individual features may vary from one country to another.

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# Technical data

## Stahlfolder KH 66

	Feeder			Folding units		
	Flat pile	Round continuous	Pallet	Parallel fold	1 <sup>st</sup> cross-fold	2 <sup>nd</sup> cross-fold
Version	Manual or automated					
Max. sheet size, width × length (cm)	66 × 104	66 × 128	66 × 104		66 × 52	52 × 33
Min. sheet size, width × length (cm)	14 × 18	14 × 18	14 × 18		14 × 10	14 × 10
With twin suction wheel	20 × 18	20 × 18	20 × 18			
Paper weight (g/m <sup>2</sup> )	40–250	40–250	40–250			
Max. pile height (cm)	80	8	120			
Number of buckle plates				4 or 6		
Max. fold length (cm) position 1						
Swing-deflector buckle plate				62		
Combination/comfort buckle plate <sup>1</sup>				58/67		
Min. fold length (cm)						
Swing-deflector buckle plate				5.5		
Combination/comfort buckle plate				6/6.85		
Cross-fold configurations						
Compact (manual)						KL, KTL, KZ
Automated						KL, KTL
Max. speed (m/min.)						
Manual/automated				230	200/230	200/230
Min. speed (m/min.)				25	25	25
Diameter of folding rollers (mm)				44	44	44
MCT control system	control panel with display or touchscreen	control panel with display or touchscreen	control panel with display or touchscreen		control panel or touchscreen	
Power consumption (kVA)						
3 × 400 V, 50/60 Hz, 35 A	incl. pump 7.6/8.2	incl. pump 8.5/9.3	incl. pump 8.9/9.7			
3 × 230 V, 50/60 Hz, 50 A	7.6/8.2	8.5/9.3	8.9/9.7	in feeder in feeder	in feeder in feeder	in feeder in feeder
Compressed air consumption at 6 bar (standard liters)					85	
The compressed air supply must be provided by the customer.						

<sup>1</sup> Comfort buckle plate with continuous sheet stop and separate sheet deflector

Technical data subject to machine configuration, job, format, substrate and possibly other factors. The combination of individual features may vary from one country to another.

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# Technical data

## Stahlfolder KH 78 Compact

	Feeder			Folding units			
	Flat pile	Round continuous	Pallet	Parallel fold	1 <sup>st</sup> cross-fold	2 <sup>nd</sup> cross-fold	3 <sup>rd</sup> cross-fold
Version	Manual or automated				Manual		
Max. sheet size, width×length (cm)	78×120	78×128	78×120		78×58	58×39	39×30
Min. sheet size, width×length (cm)	14×18	14×18	14×18		14×10	14×10	14×10
With twin suction wheel	20×18	20×18	20×18				
Paper weight (g/m <sup>2</sup> )	40–250	40–250	40–250				
Max. pile height (cm)	80	8	120				
Number of buckle plates				4 or 6			
Max. fold length (cm) position 1 Swing-deflector buckle plate Combination/comfort buckle plate <sup>1</sup>				62 58/67			
Min. fold length (cm) Swing-deflector buckle plate Combination/comfort buckle plate				5.5 6/6.85			
Cross-fold configurations						KL, KTL, KZ	KLL, KTLL, KZ L/R
Max. speed (m/min.)				230	200	200	200
Min. speed (m/min.)				25	25	25	25
Diameter of folding rollers (mm)				44	44	44	44
MCT control system	control panel with display or touchscreen	control panel with display or touchscreen	control panel with display or touchscreen		control panel		
Power consumption (kVA) 3×400 V, 50/60 Hz, 50 A 3×230 V, 50/60 Hz, 63 A	incl. pump 7.5/8.3 7.5/8.3	incl. pump 7.4/8.2 7.4/8.2	incl. pump 7.8/8.6 7.8/8.6	in feeder in feeder	in feeder in feeder	in feeder in feeder	in feeder in feeder

<sup>1</sup> Comfort buckle plate with continuous sheet stop and separate sheet deflector

Technical data subject to machine configuration, job, format, substrate and possibly other factors.  
The combination of individual features may vary from one country to another.

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# Technical data

## Stahlfolder KH 82

	Feeder			Folding units		
	Flat pile	Round continuous	Pallet	Parallel fold	1 <sup>st</sup> cross-fold	2 <sup>nd</sup> cross-fold
Version	Automated					
Max. sheet size, width×length (cm)	82×120	82×128	82×120		82×62	62×41
Min. sheet size, width×length (cm) With twin suction wheel	14×18 20×18	14×18 20×18	14×18 20×18		16×10 <sup>1</sup>	16×10 <sup>1</sup>
Paper weight (g/m <sup>2</sup> )	40–250	40–250	40–250			
Max. pile height (cm)	80	8	120			
Number of buckle plates				4 or 6		
Max. fold length (cm) position 1 Combination/comfort buckle plate <sup>2</sup>				58/67		
Min. fold length (cm) Combination/comfort buckle plate				6/6.85		
Cross-fold configurations						KL, KTL, KZ
Max. speed (m/min.)				230	230	230
Min. speed (m/min.)				25	25	25
Diameter of folding rollers (mm)				44	44	44
MCT control system	control panel	control panel	control panel		touchscreen	
Power consumption (kVA) 3×400V, 50/60 Hz, 35A 3×230V, 50/60 Hz, 50A	incl. pump 8.6/9.4	incl. pump 8.5/9.3	incl. pump 8.9/9.7 8.9/9.7	in feeder in feeder	in feeder in feeder	in feeder in feeder
Compressed air consumption at 6 bar (standard liters) The compressed air supply must be provided by the customer.					85	

<sup>1</sup> With small-size format stop in the cross-fold unit

<sup>2</sup> Comfort buckle plate with continuous sheet stop and separate sheet deflector

Technical data subject to machine configuration, job, format, substrate and possibly other factors.  
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# Technical data

## Stahlfolder TH 82-P

	Feeder	Folding units		
	PFX pallet	1 <sup>st</sup> station 82	2 <sup>nd</sup> station 66	3 <sup>rd</sup> station 66
Version	Automated	Manual or automated		
Max. sheet size, width × length (cm)	82 × 112.5			
Min. sheet size, width × length (cm)	42 × 30			
Paper weight (g/m <sup>2</sup> )	70–250			
Max. pile height (cm)	120			
Number of buckle plates		6	4	4
Max. fold length (cm) Comfort buckle plate <sup>1</sup>		63 <sup>2</sup>	51 <sup>3</sup>	38 <sup>3</sup>
Min. fold length (cm) Combination/comfort buckle plate <sup>1</sup>		6/15 <sup>2</sup>	6/19.5 <sup>3</sup>	6/16.5 <sup>3</sup>
Max. speed (m/min.)		230	210	210
Min. speed (m/min.)		25	25	25
Diameter of folding rollers (mm)		44	44	44
MCT control system	touchscreen		control panel with display	control panel with display
Power consumption (kVA) 3 × 400 V, 50/60 Hz, 50 A 3 × 230 V, 50/60 Hz, 63 A	incl. pump 8.0/8.8 8.0/8.8	in feeder in feeder	2.8 2.8	1.6 1.6
Required compressed air flow at 6 bar (standard l/min.) The compressed air supply must be provided by the customer. It must satisfy the following specifications, as a minimum: • Quick-release coupling DN 10 (NPS) with a minimum flow rate of 3,000 l/min. • Compressed air quality to ISO 8573-1:2010 (4-4-2)	2,000			

<sup>1</sup> Comfort buckle plate with continuous sheet stop and separate sheet deflector

<sup>2</sup> At roller frame position 2

<sup>3</sup> At roller frame position 1

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# Technical data

## Stahlfolder KH 82-P

	Feeder	Folding units		
	PFX pallet	Parallel fold	1 <sup>st</sup> cross-fold	2 <sup>nd</sup> cross-fold
Version	Automated			
Max. sheet size, width × length (cm)	82 × 112.5		82 × 62	62 × 41
Min. sheet size, width × length (cm)	42 × 30		42 × 15	15 × 21
Paper weight (g/m <sup>2</sup> )	70 – 250			
Max. pile height (cm)	120			
Number of buckle plates		6		
Max. fold length (cm) position 2 Comfort buckle plate <sup>1</sup>		63		
Min. fold length (cm) Combination/comfort buckle plate		6/15 <sup>2</sup>		
Cross-fold configurations				KL, KTL, KZ
Max. speed (m/min.)		230	230	230
Min. speed (m/min.)		25	25	25
Diameter of folding rollers (mm)		44	44	44
MCT control system	control panel with display		touchscreen	
Power consumption (kVA) 3 × 400 V, 50/60 Hz, 35 A 3 × 230 V, 50/60 Hz, 50 A	incl. pump 10.3/11.7 10.3/11.7	in feeder in feeder	in feeder in feeder	in feeder in feeder
Required compressed air flow at 8 bar (standard l/min.) The compressed air supply must be provided by the customer. It must satisfy the following specifications, as a minimum: • Quick-release coupling DN 10 (NPS) with a minimum flow rate of 3,000 l/min. • Compressed air quality to ISO 8573-1:2010 (4-4-2)	2,000			

<sup>1</sup> Comfort buckle plate with continuous sheet stop and separate sheet deflector  
<sup>2</sup> At roller frame position 2

Technical data subject to machine configuration, job, format, substrate and possibly other factors.  
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Heidelberger Druckmaschinen AG  
Kurfuersten-Anlage 52 – 60  
69115 Heidelberg  
Germany  
Phone +49 6221 92-00  
Fax +49 6221 92-6999  
contact@heidelberg.com  
Further details at:  
heidelberg.com

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For details on the emissions of the Stahlfolder TH/KH folding machines, please visit us at [heidelberg.com/emissiondetails](http://heidelberg.com/emissiondetails)

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