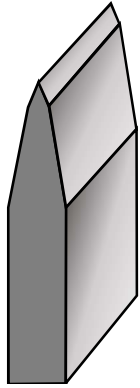


Recommendations for die-cutting thick virgin boards

Recommendation how to avoid poor quality of the cut edges and dusting when die-cutting high thickness virgin boards.



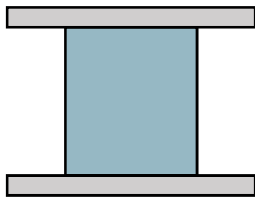
Centre face
double bevel profile

Cutting rule profile

We recommend using centre face double bevel profile die-cutting rules when cutting thick boards. This kind of profiles are available from many cutting rule manufacturers.

Centre face double bevel profile is specially used for die-cutting thick multi-layer boards.

Note: The most important thing in die-cutting is to keep the cutting tools in good condition and always adjust the machine well before starting production.



Ejection material
before pressing down



Traditional rubber
material expands
horizontally under
pressure



High quality foam material
is not expanding
horizontally under pressure

Die-cutting ejection materials

We recommend using high quality foam ejection material instead of rubber when die-cutting thick virgin boards. High quality foam materials are available from many ejection material manufacturers.

When pressed down during die-cutting, the high-quality foam material is holding the board well. Due to this, the board is not moving when the knife goes through the board and the cutting result will be optimal.

High quality foam can also be positioned very close to the cutting rule, as this type of foam is not expanding horizontally when pressed down, like traditional rubber ejection materials do. When the ejection material is close to the knife, there is no space for dust particles to form bigger dust agglomerates between knife and ejection material, which could eventually drop on top the board during die-cutting process.

Additional Tips:

- Always adjust cutting tool dimensions to the material to be used
- When designing a new die-cutting tool with your tool supplier, more important to pay attention to the board thickness, than the grammage