

Recommendations for cutting and creasing *ref Kromopak

Details of the necessary documentation needed when reporting a fault are supplied below. The documentation provided should be as extensive as possible.

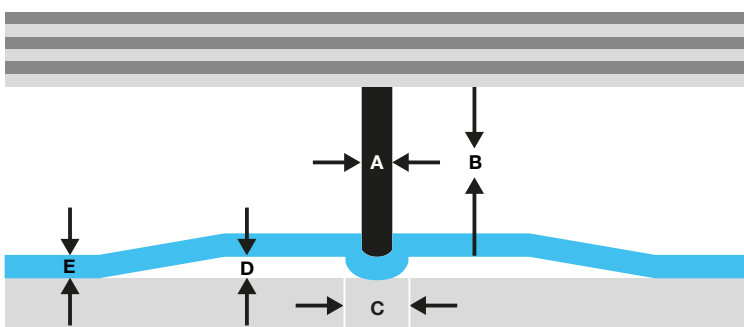
Thickness of cartonboard (mm) (E)	Width of creasing knife (mm) (A)	Height of creasing knife (mm) (B)	Width of groove of make ready (C)		Height of make ready (D)
			Cross direction	Machine direction	
0.28 - 0.35	0.5	23.5	0.9 - 1.0	0.8 - 0.9	0.3
0.36 - 0.39	0.7	23.4	1.1 - 1.2	1.0 - 1.1	0.4
0.40 - 0.45	0.7	23.4	1.2 - 1.3	1.1 - 1.2	0.4
0.46 - 0.49	0.7	23.3	1.3 - 1.4	1.2 - 1.3	0.5
0.50 - 0.55	0.7	23.3	1.4 - 1.5	1.3 - 1.4	0.5
0.56 - 0.59	0.7	23.2	1.5 - 1.7	1.4 - 1.6	0.6
alternative					
0.56 - 0.59	1.0	23.2	1.7 - 1.9	1.6 - 1.8	0.6
0.60 - 0.65	1.0	23.2	1.9 - 2.1	1.7 - 1.9	0.7
0.66 - 0.69	1.0	23.1	2.1 - 2.3	1.9 - 2.1	0.7
0.70 - 0.75	1.0	23.1	2.3 - 2.5	2.1 - 2.3	0.8
0.76 - 0.79	1.0	23.0	2.5 - 2.7	2.3 - 2.5	0.8
0.80 - 0.85	1.5	23.0	2.7 - 2.9	2.5 - 2.7	0.9
0.86 - 0.89	1.5	22.9	2.7 - 3.0	2.5 - 2.7	0.9
0.90 - 0.95	1.5	22.9	3.1 - 3.3	2.8 - 3.0	1.0
0.96 - 1.00	1.5	22.8	3.4 - 3.5	3.0 - 3.2	1.0

* For Kromopak refer to separate recommendation sheet

Height of cutting knife: 23.8mm

When using ready-made matrixes (e.g Pertinax) the height of the creasing knife (B) has to be reduced by 0.1mm

For Kromopak refer to separate recommendation sheet



- A Thickness of creasing rule
- B Height of creasing rule
- C Width of groove
- D Height of make ready
- E Thickness of cartonboard

