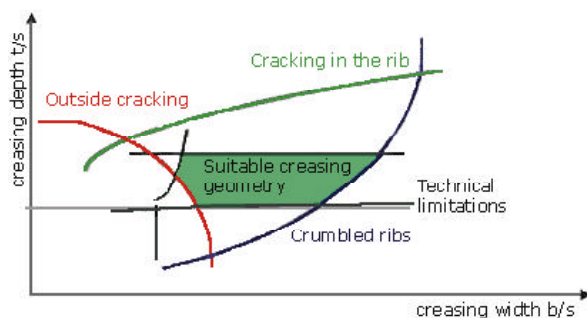


Creasing

t_e = Immersion depth
 t = Creasing depth
 b = Creasing width
 s = Cardboard thickness
 = technical limitations
 (min. and max. possible
 creasing depth/creasing width)



Suitable creasing geometry

Substance	Creasing Recommendations				
	Width of the creasing channel		Depth of the creasing channel	Breadth of the creasing knife	Hight of the creasing knife
	Groove in MD	Groove in CD			
g/m ²	mm	mm	mm	mm	mm
250	1,0	1,1	0,35	0,70	23,50
280	1,1	1,2	0,35	0,70	23,40
300	1,2	1,4	0,40	0,70	23,40
320	1,3	1,5	0,45	0,70	23,40
350	1,4	1,6	0,45	0,70	23,30
400	1,6	1,8	0,50	0,70	23,30
450	1,7	1,9	0,60	0,70	23,20
	1,9	2,1	0,60	1,05	23,20
500	2,1	2,3	0,65	1,05	23,20
550	2,3	2,5	0,70	1,05	23,10
600	2,6	2,8	0,80	1,05	23,10

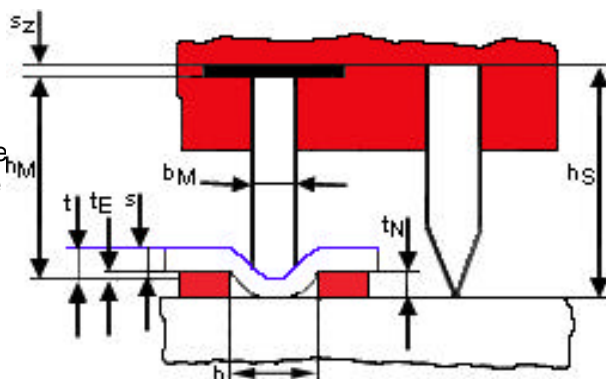
MD = Machine Direction

CD = Cross Direction

Note: Please consult our customer service if UV-varnish is used.

If Pertinax-matrixes are used, please choose height of creasing knife 0,1 mm lower.

t = Creasing depth
 b = Creasing width
 t_e = Immersion depth
 t_N = Depth of creasing channel
 h_M = Hight of the creasing knife
 b_M = Width of the creasing knife
 h_S = Height of the cutting knife
 s = Cardboard thickness
 S_z = Thickness of make ready



Note: Always select a packing thickness slightly thicker than the board thickness. The difference of cutting knife hight and creasing knife hight must be equal or lower than the board thickness.

As per March 2003