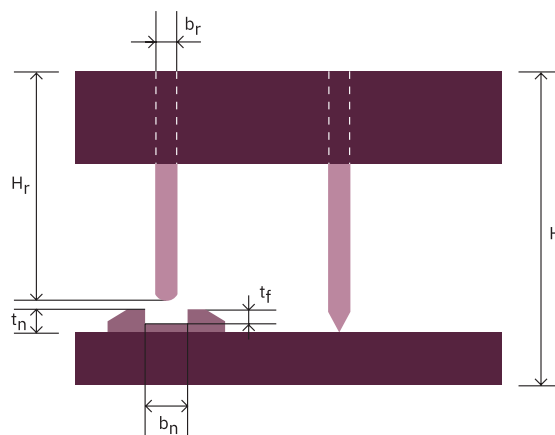


Creasing recommendations

Please observe that these are general recommendations and adjustments might be necessary in each case.



Height of cutting rule, $H=23.8$ mm Groove depth, $t_r = t_n - 0.1$ mm

Paperboard Thickness ¹⁾ (μm)	Groove width ¹⁾ , b_n		Matrix thickness ³⁾ , t_n (mm)	Creasing rule	
	MD ²⁾ (mm)	CD ²⁾ (mm)		Height, H_r (mm)	Thickness, b_r (mm)
300	1.1	1.2	0.5	23.3	0.7
350	1.1	1.2	0.5	23.3	0.7
400	1.2	1.3	0.5	23.3	0.7
450	1.3	1.4	0.5	23.3	0.7
500	1.3	1.4	0.6	23.2	0.7
550	1.4	1.5	0.6	23.2	0.7
550	1.6	1.7	0.6	23.2	1.05
600	1.7	1.8	0.7	23.1	1.05
650	1.7	1.8	0.7	23.1	1.05
700	1.8	1.9	0.8	23.0	1.05
750	1.9	2.0	0.8	23.0	1.05
800	2.0	2.1	0.9	22.9	1.05
¹⁾ Maximum recommended tolerance on groove width ± 0.2 mm ²⁾ MD = Creases parallel to the machine direction, CD = Creases parallel to the cross direction ³⁾ Matrix (Pertinax)					