

# THE NEW GENERATION

böhlerstrip®

## X-PRESS

Cutting Rule

# MAKE-READY – the productivity booster in die cutting

## Save time - save money

In die cutting make-ready activities represent the biggest cost factor, as it is necessary to achieve the perfect cut in a step-by-step process.

The more complex the die layout, the more productivity in die cutting is lost due to machine downtime. Every converter aims at minimizing patching activities for cost savings purposes.

Böhlerstrip X-PRESS cutting rule is a milestone innovation, helping reduce make-ready time in die cutting operations.

The innovative part lies in the back of the cutting rule. The patented\* micro-serrated rule back design serves as ‚pre-programmed‘ compensation zone which leads to quick self leveling of rules under pressure. The rule back deforms, thus

reducing the wear on the rule tip which helps to keep the tip sharp and last longer.

Extensive field testing for over two years in many locations in different countries in Europe has proven that patching time and make-ready cost can be reduced by up to 80 %.

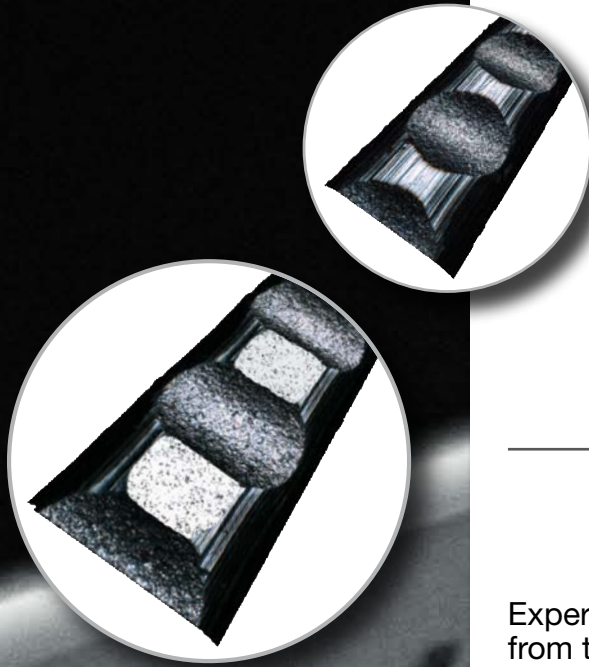
## Impact of the market

As nowadays packaging designs have a shorter life cycle, the number of sheets cut for one job has decreased continuously over the years. At the same time the number of re-runs for a die has increased permanently. X-PRESS supports all of these trends.

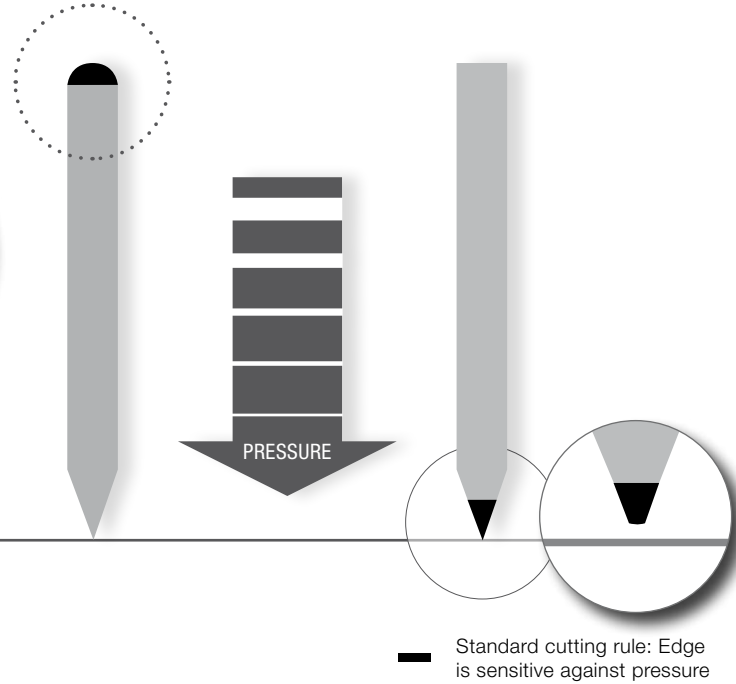
\*) Patent AT508551B1

Illustration below:

patented micro-serrated rule back under electron microscope, before and after pressure



+ X-PRESS cutting rule:  
Back deforms under pressure



### Experience from the field

- successfully introduced and continuously used for two years on an international scale
- over 52 re-runs executed with one die and one set of knives
- savings achieved in complicated dies with up to 60 ups/outs
- extended service life of knives
- up to 5.4 m sheets cut with original set of knives

### Availability

- quality/grade: UNIVERSAL
- bevels: CF/CFDB
- tip angles: 53°/42°
- special execution: „polished“/„supreme“
- heights: 23.80 mm / 23.60 mm
- thickness: 0.71 mm / 1.05 mm  
2 pt / 3 pt
- delivery form:
  - in coils  
(clockwise / anticlockwise)
  - in lengths of 1,000 mm each
  - Available from stock

# Everyone benefits from X-PRESS

## Cost Savings

Calculations based on one field test example:

- Folded box board, 16 ups
- Rules: 26 m cutting rules, 14.4 m creasing rules,  
2.2 m compensation rules
- Machine cost / hour: 200.00 €
- Number of re-runs: 6

**Cost reduction up to 67 %**

-67%

initial order	Standard	X-PRESS
time consumed	60 minutes	20 minutes
costs	200.00 €	66.00 €
re-runs		
time consumed	6 x 15 minutes	6 x 5 minutes
costs	300.00 €	100.00 €
<b>total cost</b>	<b>500.00 €</b>	<b>166.00 €</b>

## Benefits

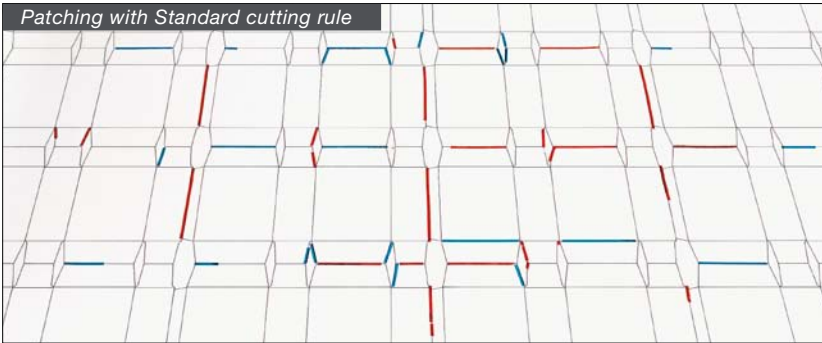
### for diemakers:

- standard processing on autobenders
- all processing steps possible without change
- attractive for high quality converting industry
- cost savings attractive as sales argument for converters

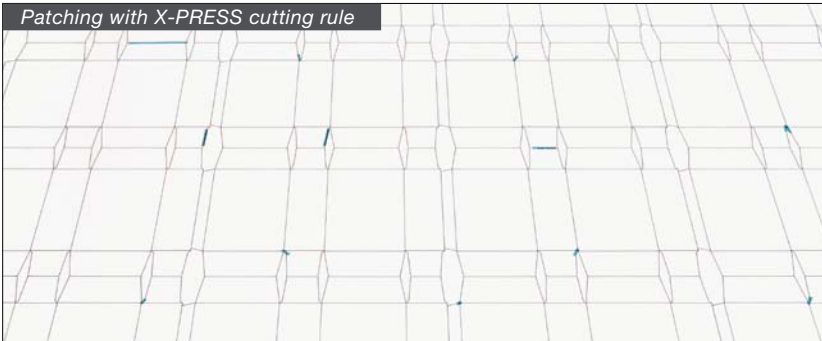
### for converters:

- make-ready time is minimized and productivity of diecutters increased (more sheets / hour)
- X-PRESS dies useable for re-orders without further patching
- extended service life of knives
- excellent and constant cut quality
- motivation for machine operators due to less patching

*Patching with Standard cutting rule*



*Patching with X-PRESS cutting rule*





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