

bohlerstrip®

ROTARY DIE STEEL –
LASTING IMPRESSIONS.

WHAT MAKES OUR ROTARY RULES UNIQUE?

They are in shape for a fast-moving world. Industrial and consumer goods are delivered to commercial enterprises and end users in various forms of packaging. Corrugated board offers the necessary protection for the product and ensures that goods are delivered safely around the globe, thus allowing for intact delivery without transport damage, contamination or chemical impact. Additionally, state-of-the-art flexographic printing has enabled companies to utilize the rotary process as a high-end advertising medium.

Rotary die cutting is a special form of cutting technique using a cylindrical drum. Cutting and creasing rules are mounted radially (curved) and axially (straight) into a wooden shell to permit a continuous manufacturing process.

Typical product features:

- » Serrated cutting rules for die cutting into soft anvil covers or blankets
- » Straight cutting rules for axial use
- » Curved cutting rules for radial use

PRODUCT BENEFITS

Consistency in our production process – our product is made of the highest quality raw material and tightest dimensional accuracy

Cutting rule lifetime – our special edge hardening method results in high wear resistance

Bendability of straight and curved rotary rules – we have developed a fine teeth grinding process, which benefits our full product line

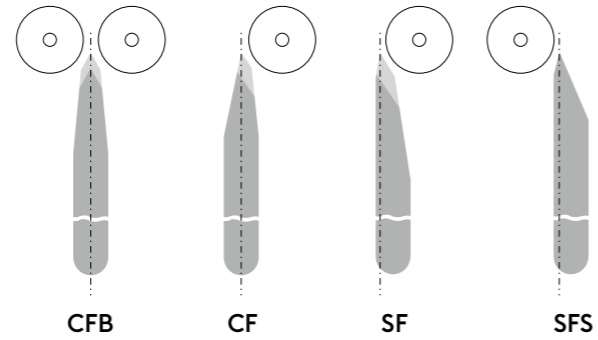
Rule stability – all our curved rotary rules receive mechanical and thermal stress relief to avoid fatigue cracking

Service and product range – we constantly extend the range and stock volume according to global customer requests

BOHLERSTRIP ROTARY CUTTING RULES

Cutting Bevel Types

- CFB** Centered cutting edge of steel rule (symmetrical)
- CF** Centered cutting edge (symmetrical)
- SF** Off-center bevel (unsymmetrical)
- SFS** Off-center bevel (unsymmetrical), teeth ground on short bevel



- » Provide uniform edge appearance
- » Ideal for automated rule processing equipment

CENTER BEVEL SERRATED CUTTING RULES – FOR STANDARD APPLICATIONS.

USC 10

bohlerstrip USC 10 is one of the most versatile rotary cutting rules in this industry. USC 10 is a true center bevel rule that is recommended for cutting a wide range of corrugated materials. This profile also provides superior bending properties and reduced anvil wear.

Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)

Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")–26.16 mm (1.030")	
Bevel type	CFB	

STC 12

bohlerstrip STC 12 is a standard center bevel cutting rule. This rule provides an enhanced finished product edge appearance for both light-weight singlewall and micro-flute corrugated board. Additionally, this profile is recommended for cutting a variety of foam materials.

Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)

Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)

Thickness	3 pt / 1.05 mm, 4 pt / 1.42 mm	
Heights	23.80 mm (.937")–101.60 mm (4")	
Bevel type	CFB	

SWC 8

bohlerstrip SWC 8 is engineered to cut heavy-weight double and triple wall corrugated board with minimal pressure. As with all the SWC rules, this material is also recommended for lead and trail edges to reduce the cutting pressure.

Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	4 pt / 1.42 mm	
Heights	21.60 mm (.850")–30.16 mm (1.187")	
Bevel type	CFB	

SWC 10

bohlerstrip SWC 10 performs superbly, in both directions, on 32 ECT and above singlewall corrugated board. SWC 10 can also be used on longer lead and trail edges to reduce cutting pressure and deflection. To see the benefit of the reduced gullet and anvil wear it is recommended to increase the creasing rule height.

Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)

Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")–27 mm (1.063")	
Bevel type	CFB	

US 8

bohlerstrip US 8 is a center bevel rule that is designed to combine the benefits of a side bevel rule with the convenience of a center bevel. This unique profile provides reduced edge crush along with improved stripping. To improve stripping it is recommended that the serrated edge goes towards the scrap (to crush it) to help removal. Although this rule has different finishes on each side the tip is still precisely in the center. This is very important to obtain dimensional accuracy when cutting multiple out designs.

Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)

Quality	TOP 40	
Hardness	Body	~ 390 HV (40 HRC)
	Edge	~ 390 HV (40 HRC)

Thickness	4 pt / 1.42 mm	
Heights	24.64 mm (.970")–26.16 mm (1.030")	
Bevel type	CF	



PROCUT – THE RULE THAT STANDS STRONG ABOVE THE REST.

PROCUT

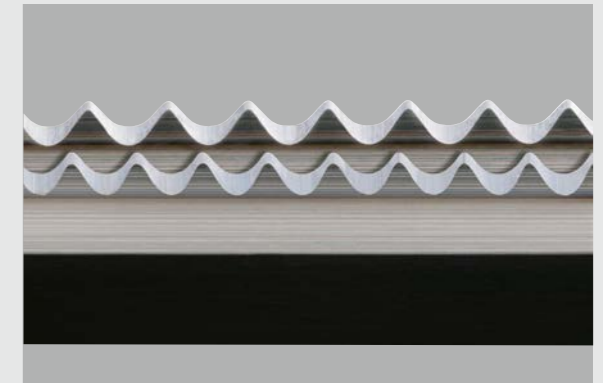
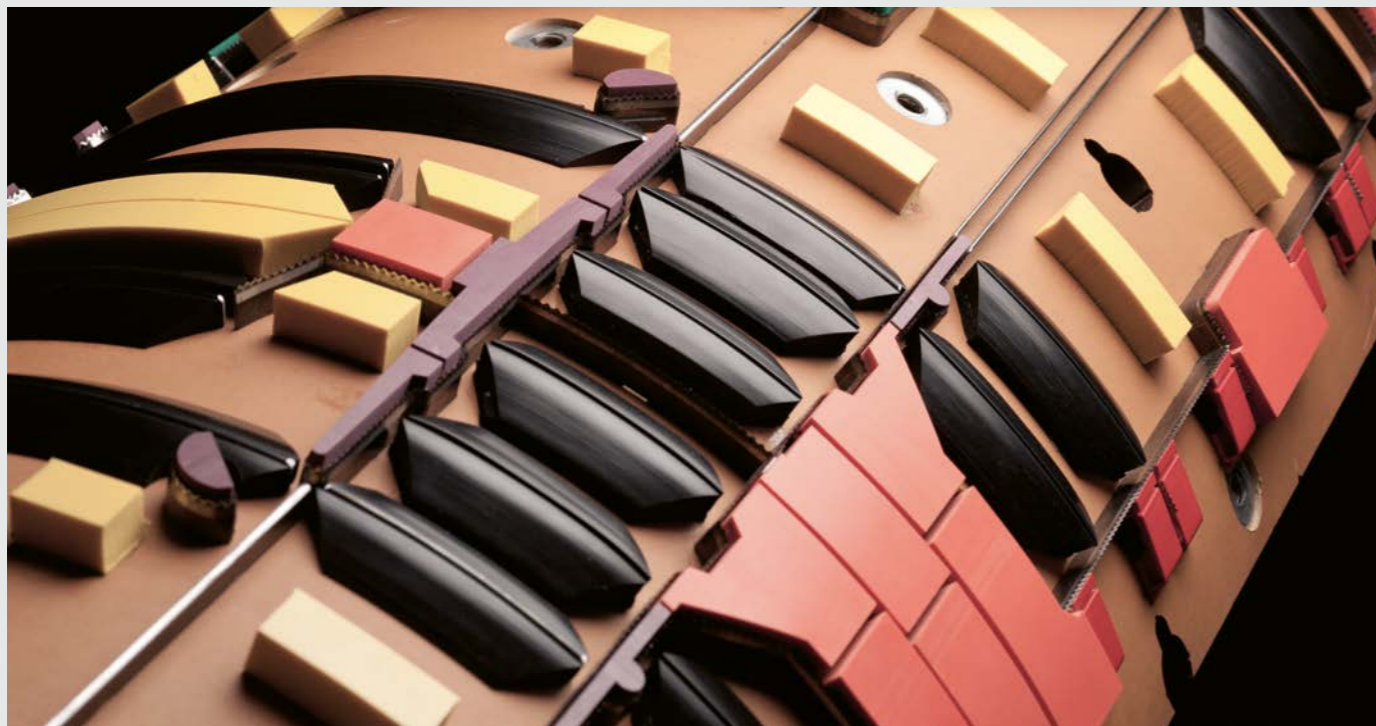
Specifically suitable for fruit and vegetable boxes made of corrugated board, the market requires improved box stability and yet better, more-enhanced printing graphics. To support this trend, boehlerstrip has developed a new generation rotary cutting rule to address many of these challenges pertaining to the die cutting of new-age corrugated boards – the PROCUT!

Benefits

- » Reduced anvil cover wear
- » Low dusting risk
- » Reduced cracking risk when bending narrow angles
- » Cleaner – finished cut appearance due to true center bevel

Features

- » Deeper hardened edge
- » Thermally distressed curved rule
- » Fine-ground bevels
- » Radius gullet
- » Hybrid tooth geometry – sharp but not too aggressive
- » Symmetric edge profile



PROCUT 8

boehlerstrip PROCUT 8 is perfect to die-cut triple wall and double wall corrugated materials. The higher body hardness results in an increased rule stability.

Quality	UNIVERSAL 40	
Hardness	Body	~ 390 HV (40 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	4 pt / 1.42 mm	
Heights	25.15 / 25.40 / 25.80 / 25.98 / 26.16 / 26.40 / 28.80 mm / 31.75 mm	
	0.990" / 1.000" / 1.016" / 1.023" / 1.030" / 1.039" / 1.134" / 1.25"	
Bevel type	CFB	
Applications	double / triple wall	
Teeth	8 tpi	

PROCUT 10

The great success of PROCUT 8 has led to the development of a 10 tooth version. boehlerstrip PROCUT 10 has been specially designed for improved cutting performance on single wall corrugated materials.

Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	4 pt / 1.42 mm	
Heights	24.64 / 25.15 / 25.40 / 25.80 / 25.98 / 26.16 / 26.40 / 28.80 mm	
	0.970" / 0.990" / 1.000" / 1.016" / 1.023" / 1.030" / 1.039" / 1.134"	
Bevel type	CFB	
Applications	single wall	
Teeth	10 tpi	

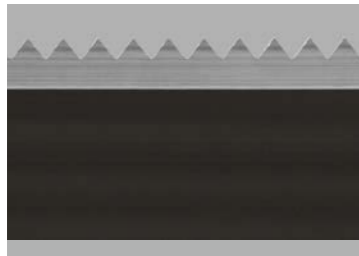
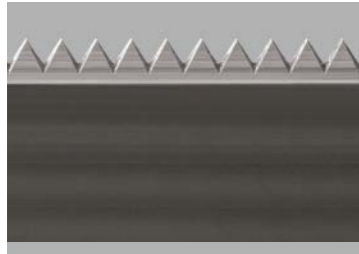
CENTER BEVEL SERRATED CUTTING RULES – FOR SPECIAL APPLICATIONS.

ST5 / STC5

bohlerstrip ST5 and STC5 are designed to cut heavy duty packaging materials. Big size precision ground teeth secure easy penetration. Also used for nicking and removable windows in corrugated containers.

Quality	TOP	
Hardness	Body	~ 450 HV (45 HRC)
	Edge	~ 450 HV (45 HRC)
Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")–101.60 mm (4")	
Bevel type	CF	

STC5



ST5 – view to rear side

USC8

bohlerstrip USC8 is an aggressive profile that permits minimal cutting pressure on thicker materials. The barbed tips and sharp gullets ensure easy penetration and shearing of the toughest materials.

Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)

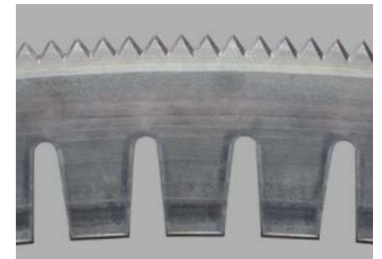
Thickness	4 pt / 1.42 mm	
Heights	24.64 mm (.970")–26.16 mm (1.030")	
Bevel type	CFB	



STC8

bohlerstrip STC8 has very sharp "V" shaped teeth that permit easy penetration through the toughest of corrugated materials. This provides easy and clean cutting on all double and triple wall board weights. Made from standard rotary tempered rule, this rule has good bendability to match many designs. For long runs edge hardened rules are available.

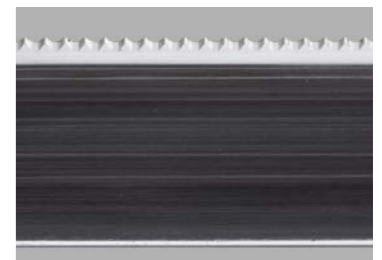
Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")–26.16 mm (1.030")	
Bevel type	CFB	



US10

bohlerstrip US10 has a shaved execution on one side whereas the opposing side is ground. This smooth side supports reduced edge crush on the finished product. The edge tip is still precisely in the center which is very important to sustain dimensional accuracy when cutting multiple-out designs.

Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")–26.16 mm (1.030")	
Bevel type	CF	



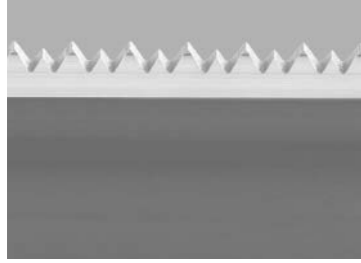
CF/CC14

bohlerstrip CF/CC14 provides a shallow gullet along with an extremely sharp cutting edge. This combination achieves great cutting performance for fibrous materials, plastics, and microfluted corrugated boards. While this rule works to cut multiple materials it is recommended to cut against uniform and leveled anvils. Also suitable for soft anvil roller diecutters.

Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	4 pt / 1.42 mm	
Heights	24.64 mm (.970")–26.16 mm (1.030")	
Bevel type	CF	



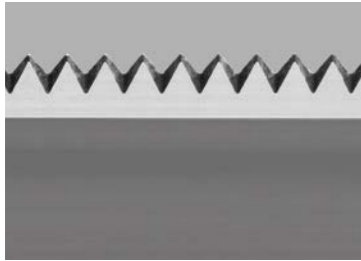
BSC – Big tooth-small tooth



bohlerstrip BSC – Big tooth-small tooth is a patent pending rule profile that is designed to reduce cutting pressure. The unique profile allows heavy double and triple wall corrugated to be diecut with less pressure and reduced anvil wear. This profile also works well for nicking on soft anvil applications and it creates clean cutting edges and reduces dust.

Quality	TOP 40	
Hardness	Body	~ 390 HV (40 HRC)
	Edge	~ 390 HV (40 HRC)
Quality	UNIVERSAL 40	
Hardness	Body	~ 390 HV (40 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")–27.15 mm (1.069")	
Bevel type	CFB	

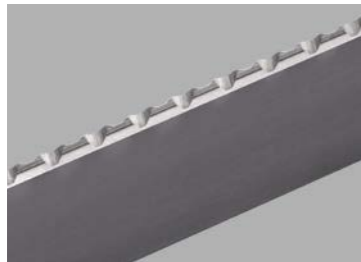
HC – Honeycomb



bohlerstrip HC – Honeycomb is an 8 tooth flat die profile designed to diecut honeycomb and similar materials. The sleek profile is designed to cut with less pressure and impression than the standard rules used to cut honeycomb.

Quality	TOP	
Hardness	Body	~ 450 HV (45 HRC)
	Edge	~ 450 HV (45 HRC)
Quality	UNIVERSAL 60	
Hardness	Body	~ 450 HV (45 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	3 pt / 1.05 mm, 4 pt / 1.42 mm	
Heights	30.00 mm (1.181")–101.60 mm (4")	
Bevel type	CF	

TOC – Tough-Cut



bohlerstrip TOC – Tough Cut is a flat die cutting rule designed for cutting heavy chipboard paper. This shallow gullet rule has very strong teeth to tackle heavy weight and thick boards and it can be used as a substitute for wave edge cutting rules.

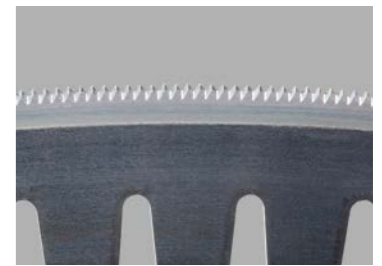
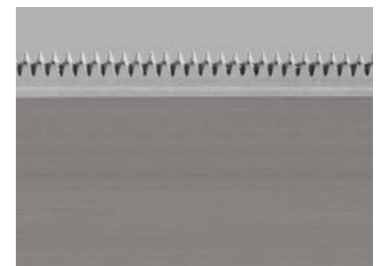
Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	4 pt / 1.42 mm, 6 pt / 2.13 mm	
Heights	24.80 mm (.937")–32.00 mm (1.26")	
Bevel type	CFB	
Tooth	8tpi	

ST20 / STC 20

bohlerstrip STC20 is a symmetrically ground 20 TPI rule. This sharp tipped rule cuts light weight paper and microfluted corrugated with ease. bohlerstrip ST20 is designed for cutting microflute corrugated board (E-, F-, N-flutes). It has also achieved an excellent reputation in the automotive industry. This rule is the perfect selection when a clean product edge is required. A uniform and leveled anvil is required when using this material.

Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")–26.40 mm (1.039")	
Bevel type	CF	
Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")–26.40 mm (1.039")	
Bevel type	CF	

STC20

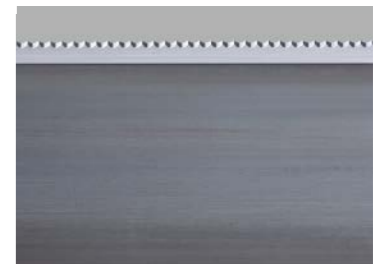


ST20

Shallow Profile 14

bohlerstrip Shallow Profile 14 has a unique gullet profile that requires minimal penetration on various substrates. While this rule cuts many materials with little impression, a uniform and leveled anvil is strongly recommended. This is also a good option for soft anvil roller diecutters and higher durometer soft anvils.

Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Quality	UNIVERSAL	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	3 pt / 1.05 mm	
Heights	23.80 mm (.937")–27.00 mm (1.063")	



SIDE BEVEL SERRATED CUTTING RULES – FOR STANDARD APPLICATIONS.

SFST 12

bohlerstrip SFST 12 is the original profile for rotary diecutting. This profile was the standard cutting rule when rotary diecutting began. Today SFST 12 performed well for cutting light-weight singlewall and microflute corrugated paper as well as many types of foam.

Quality	TOP 36	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")-27.00 mm (1.063")	
Bevel type	SF	

SFSTE –

Side-bevel for dies with mechanical stripping

bohlerstrip SFSTE is designed for mechanical stripping rotary dies. Custom designed back bevel allows for better scrap retention and extraction. This profile also has very sharp tips that allow for easy penetration. Universal-H has a harder edge hardness for more durability.

Quality	UNIVERSAL-H	
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 625 HV (57 HRC)
Thickness	4 pt / 1.42 mm	
Heights	23.80 mm (.937")-27.00 mm (1.063")	
Bevel type	SF	
Tooth	12 tpi; 8 tpi and 10 tpi on request	

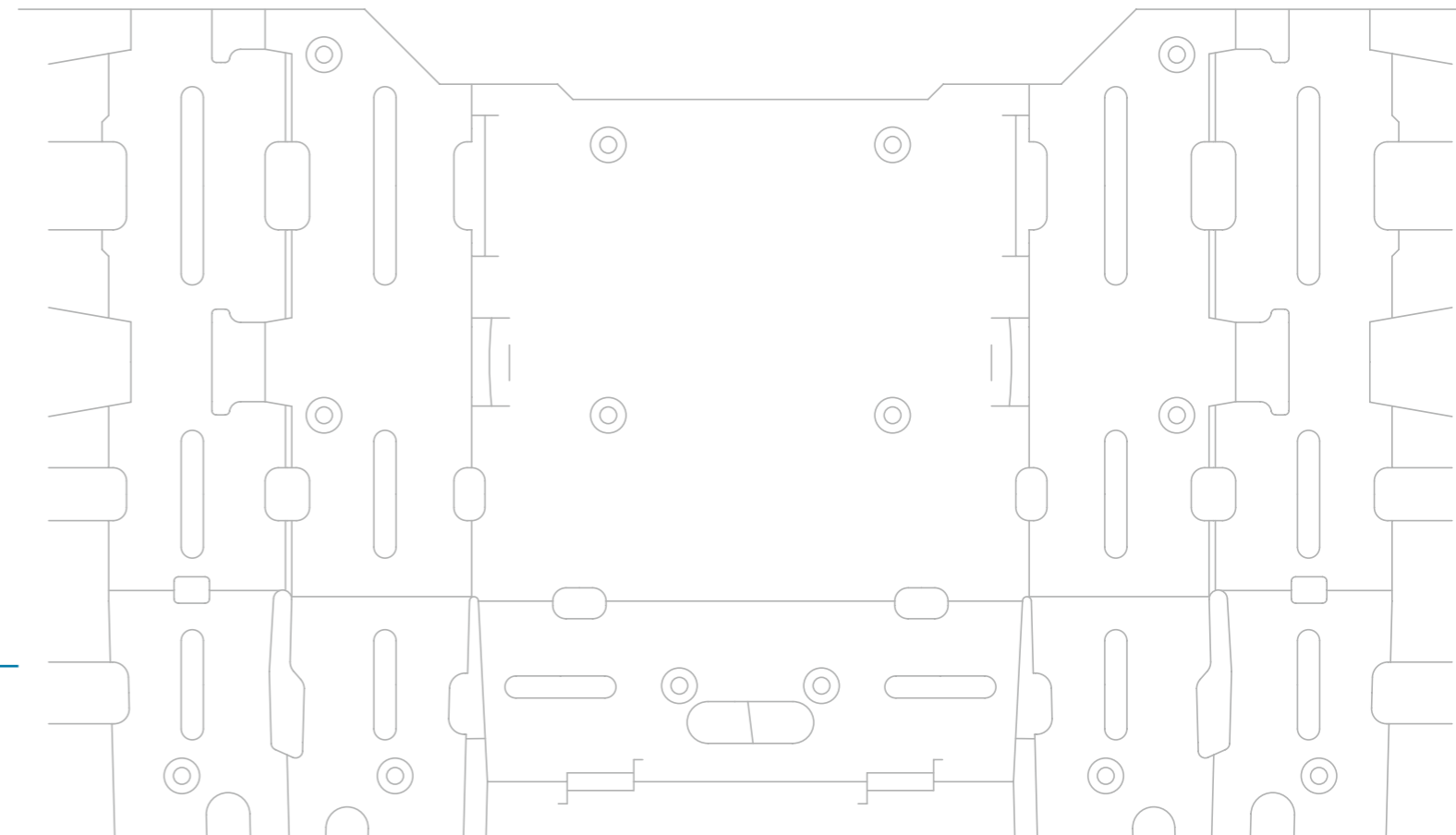
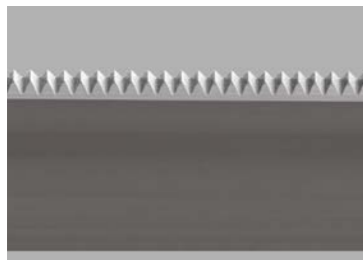
SIDE BEVEL SERRATED CUTTING RULES – FOR SPECIAL APPLICATIONS.

SFSUS 24

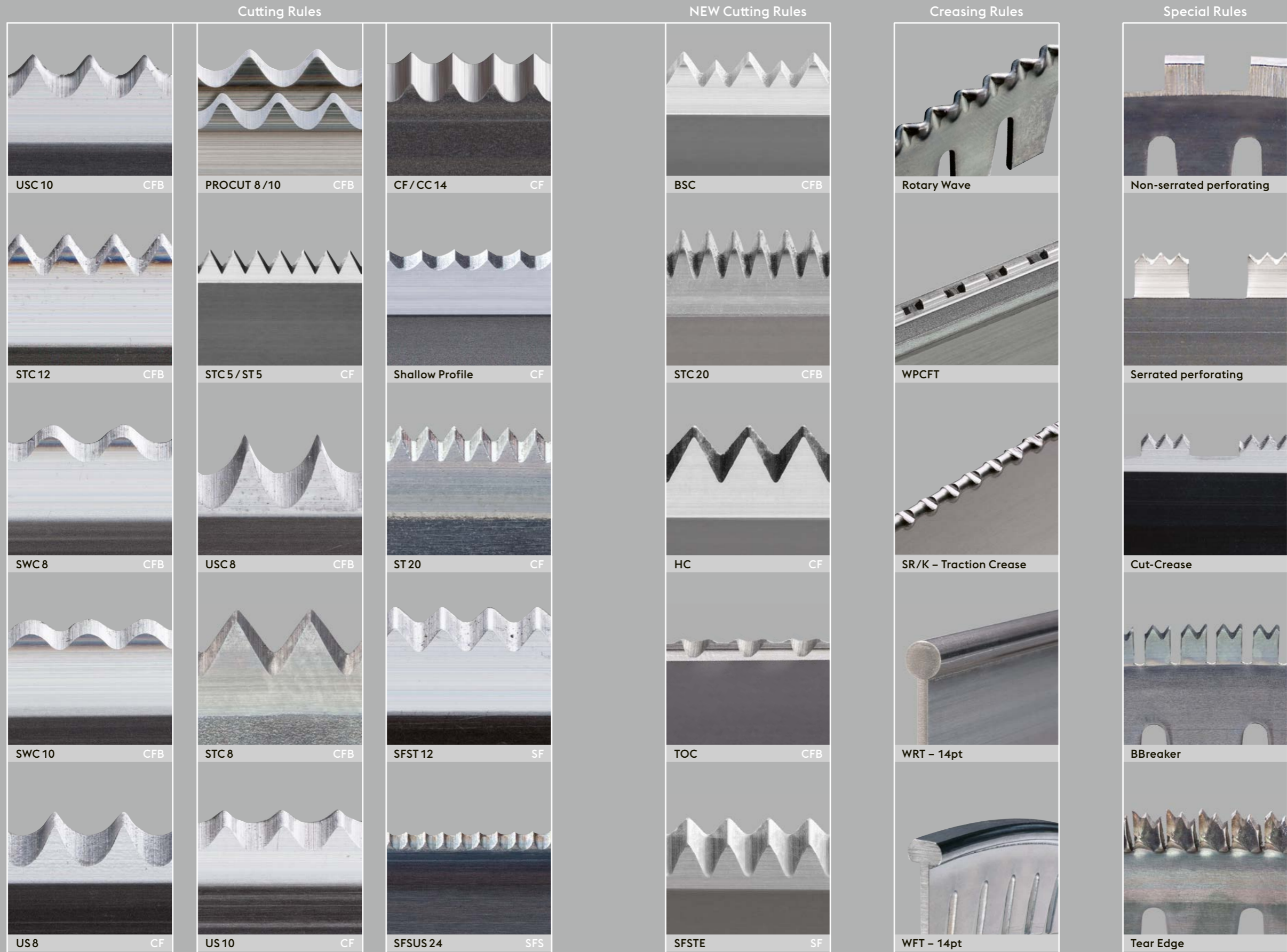
This new rule has a unique side bevel tooth shape with micro points (24 TPI) that penetrate the surface of Foam-X® board. It allows for easy parting from low loads without damaging the delicate foam structure.

bohlerstrip's SFSUS24 extra sharp cutting edge and unique tooth shape provide unrivalled performance results on Foam-X® board. It outperforms conventional beveled rule, offering improved cosmetic finish to the cut foam composite board.

Quality	UNIVERSAL60	
Hardness	Body	~ 450 HV (45 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness	3 pt / 1.05 mm	
Heights	23.80 mm (.937")	
Bevel type	SFS	



OVERVIEW



BOHLERSTRIP ROTARY CREASING RULES

For creasing the flaps of boxes high precision creasing rules are required. Folding box design and the precision of final products are becoming more demanding, which requires the application of high quality creasing rules with tight tolerances.

Creasing rule tolerances have to be adjusted to the tolerances of cutting rules. This is essential for best creasing results.

bohlerstrip creasing rules offer:

- » Very smooth crease head surface
- » Perfectly radiused profile
- » Smooth transition from radiused profile to the side faces
- » Minimum excentricity
- » Minimum height and thickness tolerances

MANUFACTURING RANGE

TOP 36:

Standard grade for bohlerstrip rotary creasing rules.

HT – Hardened and Tempered:

This process guarantees stability on creasing rules with thickness ≤ 3 pt.

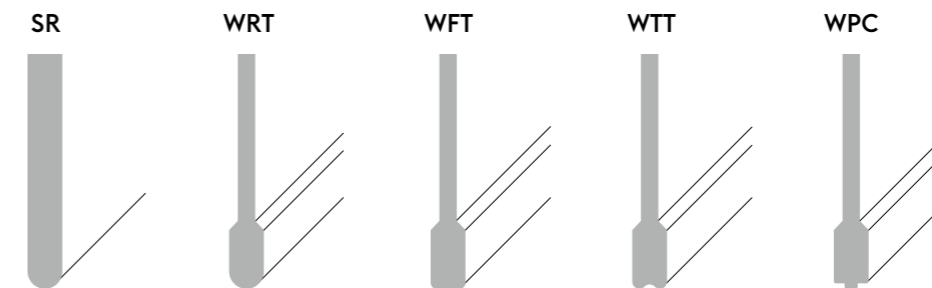
HR – Hard Rolled:

For rule thickness ≥ 4 pt.



Brand	Hardness	3 pt			4 pt			6 pt		
		1.05 mm	1.42 mm	2.13 mm	1.05 mm	1.42 mm	2.13 mm	1.05 mm	1.42 mm	2.13 mm
bohlerstrip TOP 36	~ 340 HV (34 HRC)	✓	✓	on request	✓	✓	on request	✓	✓	on request
bohlerstrip HT	~ 380 HV (40 HRC)	✓	–	–	–	–	–	–	–	–
bohlerstrip HR	min. 265 HV (850 N/mm ²)	–	✓	✓	–	✓	✓	–	✓	✓

CREASE RULE PROFILES



Single Round		Wide Top		Wide Top Specials	
SR		WRT / WFT		WTT / WPC	
[pt]	[mm]	[pt]	[mm]	[pt]	[mm]
3	1.05	3 / 6	1.05 / 2.13	3 / 8	1.05 / 2.84
4	1.42	3 / 8	1.05 / 2.84	4 / 8	1.42 / 2.84
6	2.13	4 / 6	1.42 / 2.13		
		4 / 8	1.42 / 2.84		
		4 / 14	1.42 / 5.00		

ROTARY WAVE CREASE

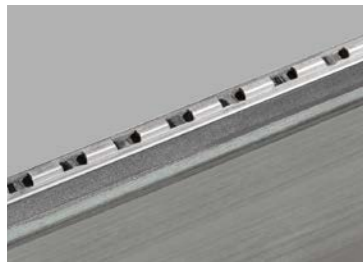
RWC has an 8 pt wide waved top with a 4 pt base. This profile allows for an accurate fold due to its wider crease top, while reducing wear on die-making equipment.

Quality	TOP 36
Thickness	4 pt / 1.42 mm
Wave width	8 pt / 2.84 mm
Wave length	6 mm
Heights	21.60 mm (.850") – 23.80 mm (.937") (others on request)





WPCFT – SPECIAL CREASING RULE 4/8PT



bohlerstrip WPCFT is a specially designed version of WPC. The special top allows for better sheet control while reducing fracturing of the inner liner.

Specification	
Tooth	2.50 mm
Gap	2.00 mm
Thickness	4 pt / 1.42 mm, 8 pt / 2.84 mm

SR/K – TRACTION CREASE



bohlerstrip Microtrack Creasing: The special surface design acts like a gear when feeding the material through the die-cutter and improves the dimensional accuracy of the corrugated boxes.

Quality	TOP 36
Thickness	4 pt / 1.42 mm
Heights	21.60 mm (.850")–23.80 mm (.937") (others on request)

WRT 14 & WFT 14 THE LEADING EDGE FOR SPECIAL CREASING TASKS.

WRT 14 & WFT 14

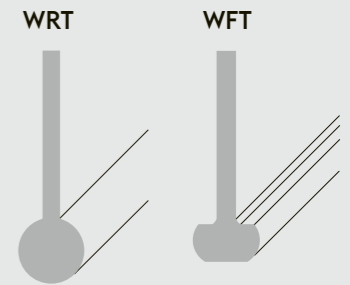
Creasing and folding of heavy corrugated materials are one of the remaining major issues in packaging. This unique laser creasing rule design has an extra wide top of 5mm (14pt). The wide top helps resolve creasing issues on thick corrugated board.

Benefits

- » Solves folding issues on thick corrugated materials
- » Wide profile relief to help folds that need to fold 180 degrees

Features

- » Extra Wide Top with 5 mm round steel wire welded onto 4 pt thick steel base



WRT – 14 pt Wide Round Top

bohlerstrip WRT – 14 pt Wide Round Top is a completely round 14 point laser crease with a 4 point base. This exclusive crease profile helps eliminate paper cracking. The wide profile is great for double and triple wall folding.

Specification	
Thickness	4 pt / 1.42 mm, 14 pt / 5 mm
Heights	up to 35 mm / 1.377"



WFT – 14 pt Wide Flat Top

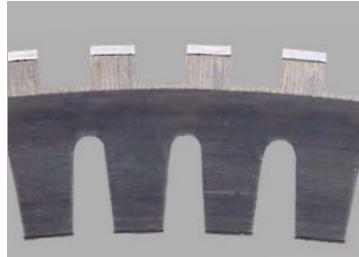
bohlerstrip WFT – 14 pt Wide Flat Top is a 14 point flat top laser crease. This exclusive profile provides a wide crease profile for 180 degree folds and to replace close double creases. This profile is also good for double and triple wall creasing.

Specification	
Thickness	4 pt / 1.42 mm, 14 pt / 5 mm
Heights	up to 35 mm / 1.377"



BOHLERSTRIP ROTARY SPECIAL RULES

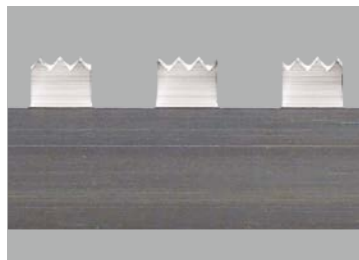
NON-SERRATED PERFORATING RULES



bohlerstrip non-serrated perforating rules are center-beveled without teeth and available in a wide range of tooth/gap combinations. For soft anvil diecutting standard perforating rule is recommended for tooth size under 6 mm (1/4"). This will give a more stable and consistent rule.

Thickness	4 pt / 1.42 mm	
Heights	23.80 (.937") - 25.40 mm (1.000")	
Standard configuration	Europe:	6 x 6 mm, 10 x 10 mm, 12 x 12 mm
	USA:	1/4" x 1/4", 3/8" x 3/8", 1/2" x 1/2"
	(others on request)	
Standard gap depth	4.75 mm (3/16"), 3.00 mm (1/8")	
	(others on request)	

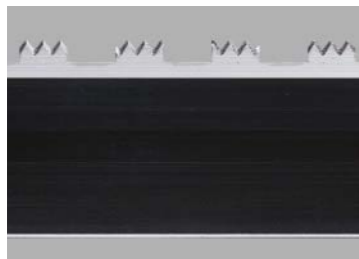
SERRATED PERFORATING RULES



bohlerstrip serrated perforating rules have a standard profile of STC 12 tpi. Serrated perforation is recommended for soft anvil diecutting and when the tooth is 6 mm (1/4") or larger. This will help reduce crushing and flaking on the finished product.

Thickness	4 pt / 1.42 mm	
Heights	23.80 (.937") - 25.40 mm (1.000")	
Standard configuration	Europe:	6 x 6 mm, 10 x 10 mm, 12 x 12 mm
	USA:	1/4" x 1/4", 3/8" x 3/8", 1/2" x 1/2"
	(others on request)	
Standard gap depth	4.75 mm (3/16"), 3.00 mm (1/8")	
	(others on request)	

CUT-CREASE RULE



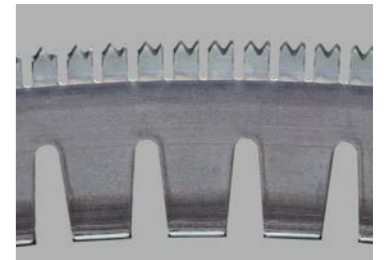
Cut-Crease rule is a shallow-gullet profiled rule that only perforates and creases the inner liner. Cut-Crease allows for an accurate fold line when folding in direction of the corrugated flutes.

Thickness	4 pt / 1.42 mm	
Heights	23.80 (.937") - 25.40 mm (1.000")	
Standard configuration	Europe:	6 x 6 mm, 10 x 10 mm, 12 x 12 mm
	USA:	1/4" x 1/4", 3/8" x 3/8", 1/2" x 1/2"
	(others on request)	

BBREAKER

bohlerstrip Rotary Pre-Nick rules are produced from the highest quality steel available. This line of rule helps control the corrugated sheet by consistently holding multiple-out diecuts together.

Quality	TOP 36	
Thickness	4 pt / 1.42 mm	
Heights	24.64 (.970") - 26.16 mm (1.030")	
Standard tooth design	CFSTC12	
Minimum gap width	1.42 mm	
Gap depth	6 mm	
Back notch depth (N3)	9.5 mm	
Available tooth/gap combinations on request		
Available in SNN & N3C execution		



TEAR EDGE

bohlerstrip Rotary Tear Edge rule is designed for detachable windows. This rule allows for a durable hold in shipping while still providing easy removal. Tear Edge is essential for today's shelf-ready packaging.

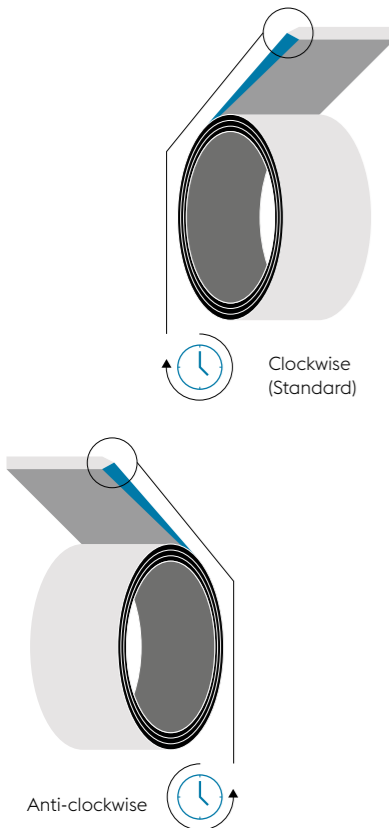
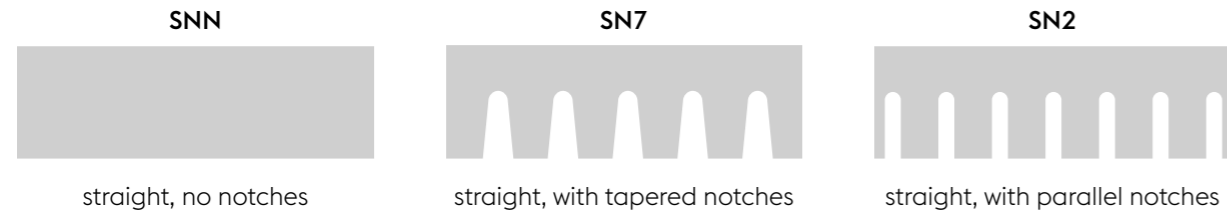
Quality	TOP 36	
Thickness	4 pt / 1.42 mm	
Heights	24.64 (.970") - 26.16 mm (1.030")	
Standard tooth design	CFSTC12	
Tooth spacing	4 mm	
	Left & right	
Smallest curving diameter for notch designs N2C / N7C	319 mm	
Available in SNN & N7C execution		



FORMS OF DELIVERY

STRAIGHT EXECUTION (AXIAL USE)

bohlerstrip rotary rules in straight execution are produced in cut lengths as well as in coils.



COILS

Material delivered in coils is packed in dispenser boxes or if steel strapped (radial) in corresponding coil packaging.

Standard coil boxes:

For automatic bending machines various types of coils are offered. Based on the machine type the inner diameter and winding direction have to be specified. The standard inner diameters are 400 mm and 445 mm. Further diameters are available upon request.

Standard coil length: 45.7 m (150 ft) for SNN execution

Dispenser boxes (available only in SNN):

Dispenser boxes allow easy rule pull-out of the box for just the rule length required, thus minimizing rule waste. These boxes also protect the rule and are a safe way of storage.

Standard coil length: 30.5 m (100 ft)

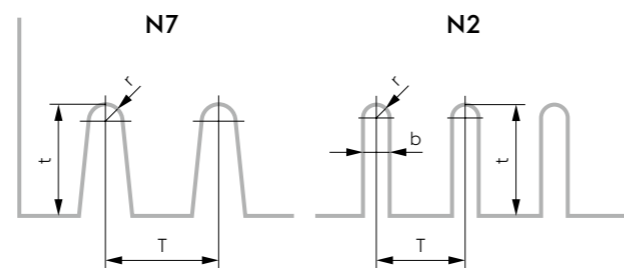
Attention: Coils packed in dispenser boxes are not wrapped in anti-corrosion paper!

Coiling directions and strip marking:

- » **FA:** Anti-clockwise winding direction: view on cutting bevel "ø" – outside printing
- » **F:** Clockwise winding direction: view on cutting bevel "ø" – outside printing

NOTCH-DIMENSIONS

	Tapered notches		Parallel notches	
	N7	N2	N7	N2
Spacing T	12.7 [mm] / 0.500" [inch]	10.0 [mm] / 0.394" [inch]	12.7 [mm] / 0.500" [inch]	12.2 [mm] / 0.480" [inch]
Depth t	12.7 [mm] / 0.500" [inch]	12.2 [mm] / 0.480" [inch]	1.6 [mm] / 0.063" [inch]	1.75 [mm] / 0.069" [inch]
Radius r	1.6 [mm] / 0.063" [inch]	1.75 [mm] / 0.069" [inch]	-	-
Width b	-	-	3.5 [mm] / 0.138" [inch]	-



CURVED EXECUTION (RADIAL USE)

Curved rules are required for radial use (Executions: N2C/N7C/NNC). Curved rotary rules are always delivered in coils.

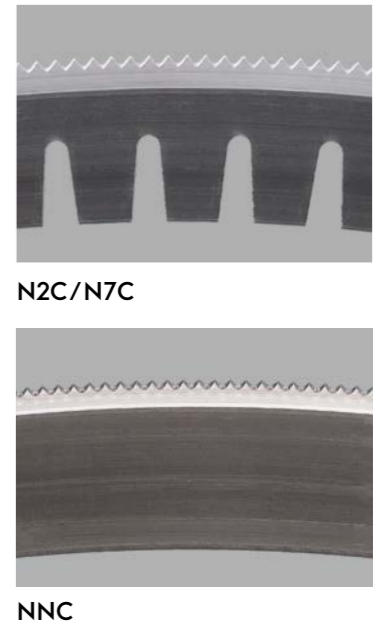
Standard inner diameters for different machine sizes vary from Ø 177 to 750 mm (7" – 29 1/2"). Starting from Ø 270 mm (14 3/16") we offer un-notched curved rotary rules (NNC). Wide Top Creasing rules can be made in diameter 360mm and larger.

All curved rotary rules are **thermally stress relieved** to eliminate stress generated during curving, reducing the risk of fatigue cracking during operation.

Standard coil length for curved execution is **30.5 m (100 ft)**.

For curving inner diameter (ID) < 300 mm = short coils only (15.2 m / 50ft).

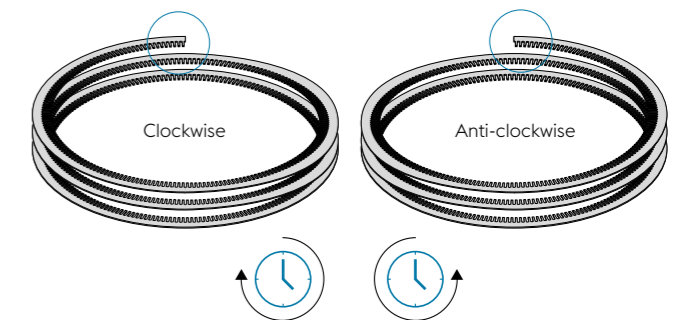
No dispenser boxes for curved rules (only in SNN)!



COILING DIRECTIONS

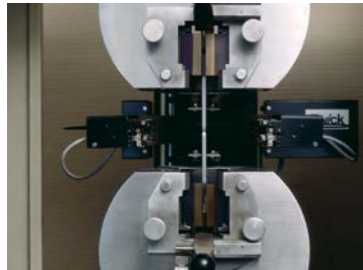
For curved material (N2C, N7C, NNC):

- » **U:** Clockwise (end of coil on the top to the right side)
- » **N:** Anti-clockwise (end of coil on the top to the left side)



QUALITY ASSURANCE

THERE ARE MANY WAYS TO DEFINE QUALITY – BUT ONLY ONE STANDARD THAT REALLY MATTERS: YOUR SATISFACTION!



OUR TARGET – QUALITY COMPETENCE

With almost 150 years of experience in converting steel into components for high-grade final products we honor the concept of a good partnership. For us the first step towards an optimum solution is to understand our customers' demands.

Quality is an essential part of our corporate culture, and this is reflected in all areas of our business activities. Close relationship with customers, reliability and quick decision-making are essential elements of our organisation. Many of our innovations and solutions are continuously improved for increased customer benefit.

voestalpine Precision Strip has the most up-to-date laboratory and testing knowledge. We are of course certified according to EN ISO 9001 and EN ISO 14001 (environmental approval). Strip Steel Technology since 1872.



THE COMPANY

Experience in steel manufacturing – from iron ore to serrated steel rule – the entire production chain is within our group.

Continuous innovation and investment to be one step ahead – we are world market leader in high quality flatbed and rotary steel rules manufacturing.

Short lead times and fast reaction to customer requirements – our additional small unit facilities in Austria, Spain and USA ensure best service.

Product developments and new solutions for market demands – our in-house R&D center with profound knowledge in steel processing and application guarantees our success.

Customer care and direct contact with the factory – our global distribution network and experienced outside sales staff take care of your specific issue.

Strip Steel Technology since 1872.



BOHLERSTRIP FACTS

WORDS ARE NICE. FACTS ARE BETTER.

The Precision Strip Group

Production locations in Austria, Sweden and United States.

Production in Europe's most modern cold rolling mill in Kematen an der Ybbs, Austria, since 2011.

Stockholding distribution offices in Austria, Sweden, China, United States and Spain.

Worldwide more than 1,100 employees.

Since 2007 member of the voestalpine AG, Austria.

Renaming in April 2015

from Boehler-Uddeholm Precision Strip GmbH to voestalpine Precision Strip GmbH

Core business

- » Steel rules for the packaging industry
- » Rule die steel for the leather and textile industry
- » Bimetal strip for the metal saw industry
- » Special precision strip for different applications e.g. for knives, springs, special saws, electronic parts, razor blades, scalpels and flapper valves
- » Wood band saw and circular saw steel
- » Stone saw steel for marble cutting
- » Coating and creping blades for the pulp and paper industry





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