bohlerstrip®

ROTARY DIE STEEL – LASTING IMPRESSIONS.

voestalpine Precision Strip GmbH
www.voestalpine.com/precision-strip

voestalpine
ONE STEP AHEAD.

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

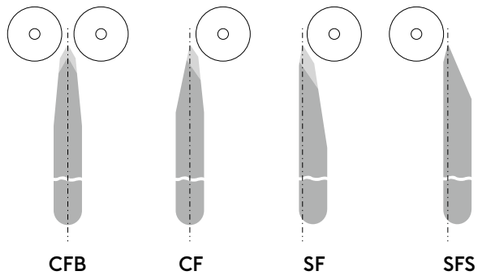
Rule stability – all our curved rotary rules receive mechanical and thermal stress relief to avoid fatigue cracking

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



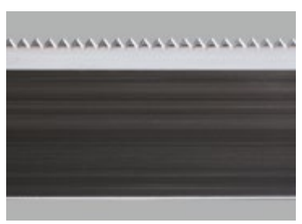
» Provide uniform edge appearance
» Ideal for automated rule processing equipment

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

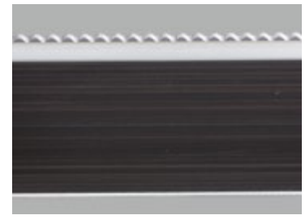
SWC 8

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

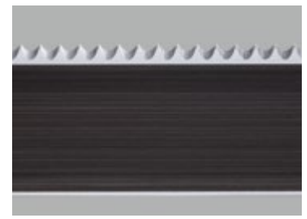
bohlerstrip SWC 10 performs superbly, in both directions, on 32 ECT and above singlewall corrugated board. SWC 10 can also be used on longer lead and trail edges to reduce cutting pressure and deflection. To see the benefit of the reduced gullet and anvil wear it is recommended to increase the creasing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

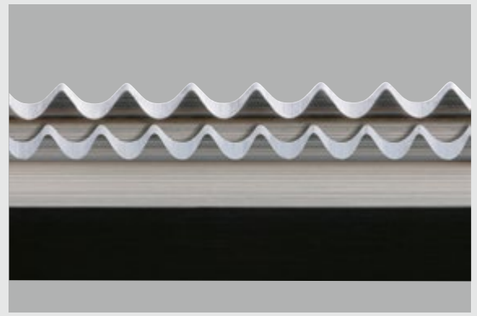
PROCUT –
THE RULE THAT STANDS STRONG ABOVE THE REST.

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, bohlerstrip 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

bohlerstrip 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

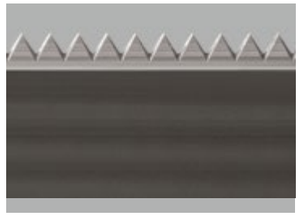
The great success of PROCUT 8 has led to the development of a 10 tooth version. bohlerstrip PROCUT 10 has been specifically designed for improved cutting performance on single wall corrugated materials.

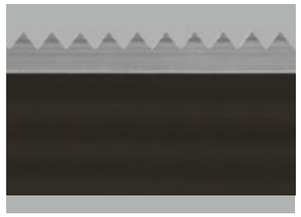
Quality		UNIVERSAL
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness		4 pt / 1.42 mm
Heights		24.64 / 25.15 / 25.40 / 25.80 / 25.98 / 26.16 / 26.40 / 28.80 mm
		0.970″ / 0.990″ / 1.000″ / 1.016″ / 1.023″ / 1.030″ / 1.039″ / 1.134″
Bevel type		CFB
Applications		single wall
Teeth		10 tpi

CENTER BEVEL SERRATED CUTTING RULES – FOR SPECIAL APPLICATIONS.

ST 5 / STC 5

STC 5





ST 5 – view to rear side

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

USC 8

bohlerstrip USC 8 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.

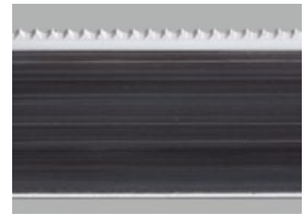
Quality		TOP 36
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Quality		UNIVERSAL
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness		4 pt / 1.42 mm
Heights		24.64 mm (.970″) – 26.16 mm (1.030″)
Bevel type		CFB

STC 8

bohlerstrip STC 8 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

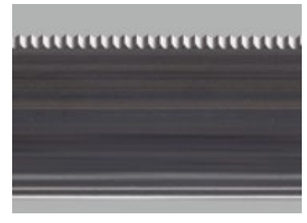
US 10



bohlerstrip US 10 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

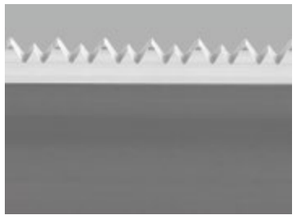
CF / CC 14



bohlerstrip CF / CC 14 provides a shallow gullet along with an extremely sharp cutting edge. This combination achieves great cutting performance for fiberous 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

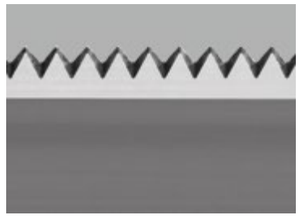
BSC – Big tooth-small tooth



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

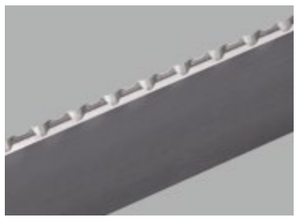
HC – Honeycomb



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.

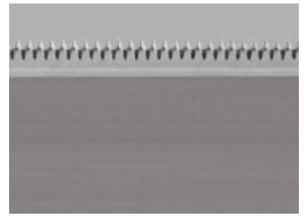
Quality		TOP 36
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Quality		UNIVERSAL
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness		4 pt / 1.42 mm, 6 pt / 2.13 mm
Heights		24.80 mm (.937″) – 32.00 mm (1.26″)
Bevel type		CFB
Tooth		8 tpi

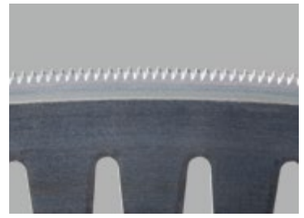
ST 20 / STC 20

bohlerstrip STC 20 is a symmetrically ground 20 TPI rule. This sharp tipped rule cuts light weight paper and microfluted corrugated with ease. bohlerstrip ST 20 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

STC 20





ST 20

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.

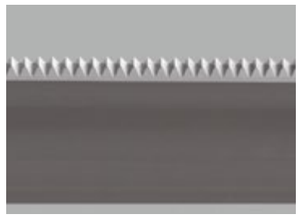
Quality		TOP 36
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 340 HV (35 HRC)
Quality		UNIVERSAL
Hardness	Body	~ 340 HV (35 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness		3 pt / 1.05 mm
Heights		23.80 mm (.937″) – 27.00 mm (1.063″)

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

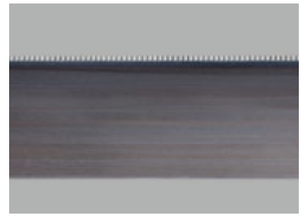
bohlerstrip SFSTE is designed for mechanical stripping rotary dies. Custom designed back bevel allows for better scrap retention and extraction. This profile also has very sharp tips that allow for easy penetration. Universal-H has a harder edge hardness for more durability.

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

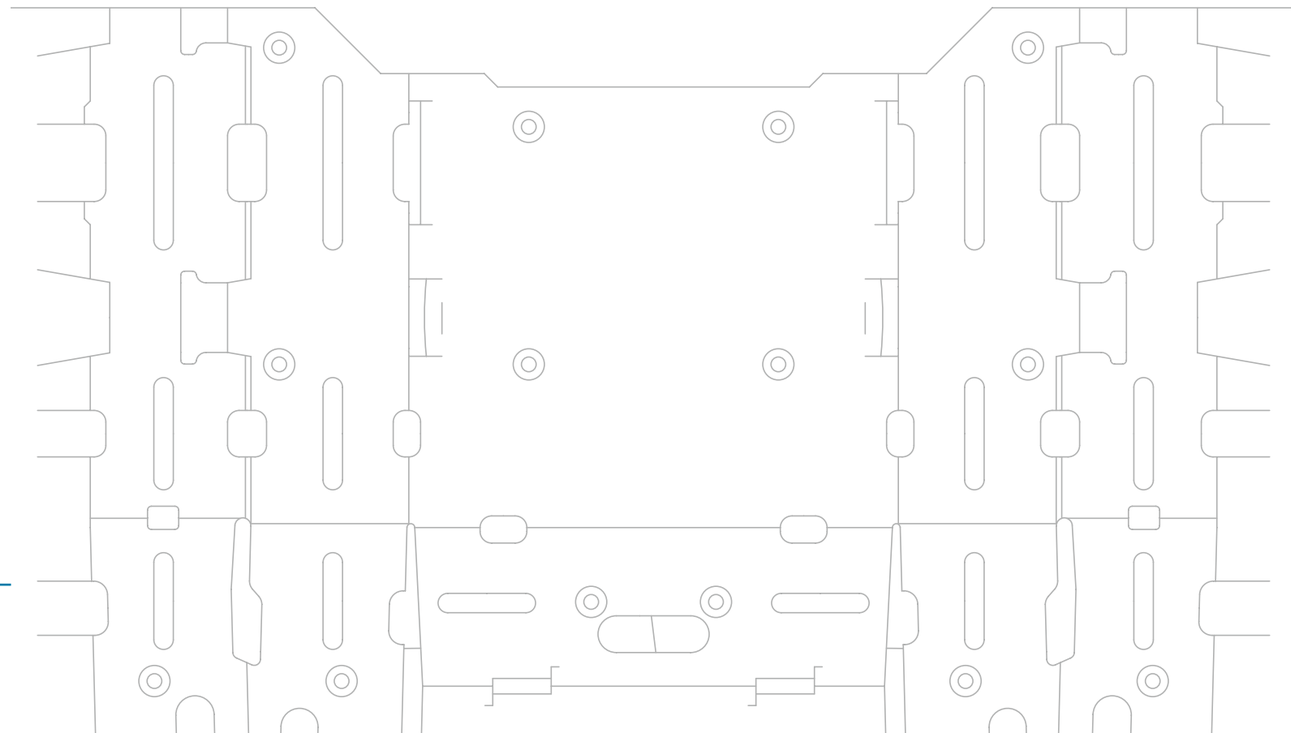
SIDE BEVEL SERRATED CUTTING RULES – FOR SPECIAL APPLICATIONS.

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.



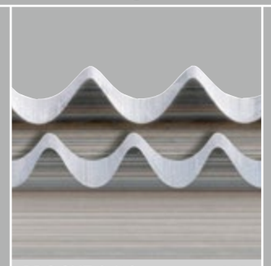
Quality		UNIVERSAL 60
Hardness	Body	~ 450 HV (45 HRC)
	Edge	~ 500 HV (49 HRC)
Thickness		3 pt / 1.05 mm
Heights		23.80 mm (.937″)
Bevel type		SFS



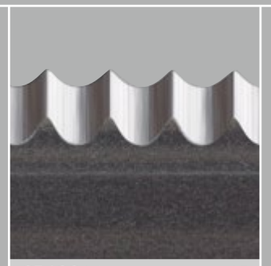
OVERVIEW

Cutting Rules

USC 10 CFB

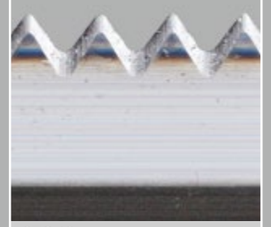


PROCUT 8 / 10 CFB

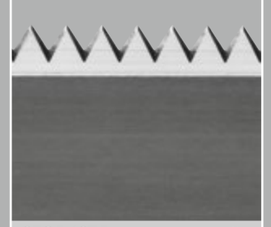


CF / CC 14 CF

BSC CFB

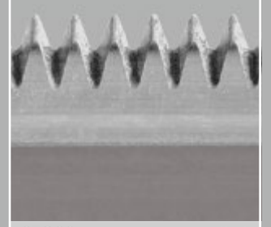


STC 12 CFB

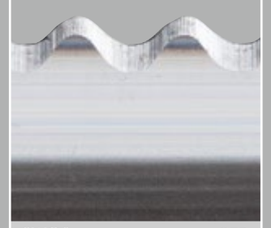


STC 5 / ST 5 CF

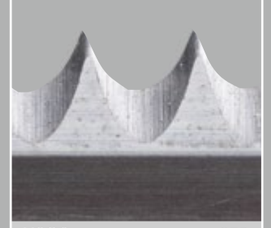
Shallow Profile CF



STC 20 CFB

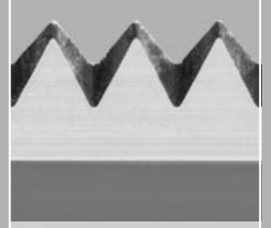


SWC 8 CFB

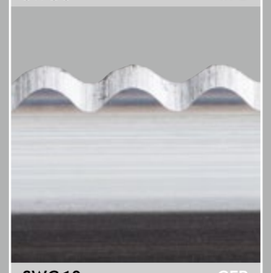


USC 8 CFB

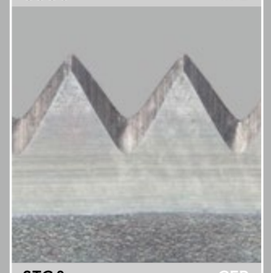
ST 20 CF



HC CF

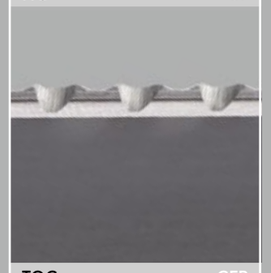


SWC 10 CFB



STC 8 CFB

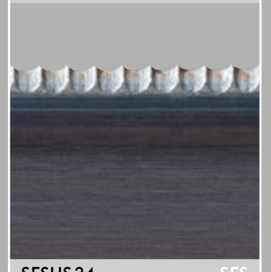
SFST 12 SF



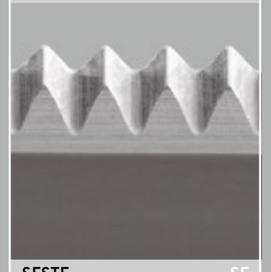
TOC CFB

US 8 CF

US 10 CF

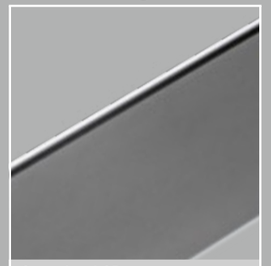


SFSUS 24 SFS



SFSTE SF

Creasing Rules

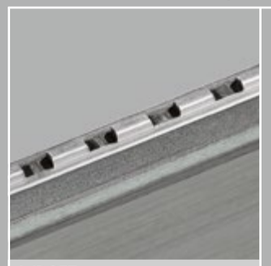


Standard SR

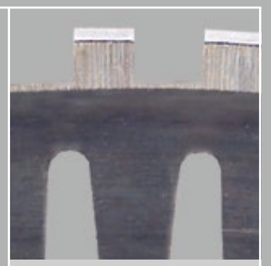
Rotary Wave

SR/K – Traction Crease

voestalpine Special Rules

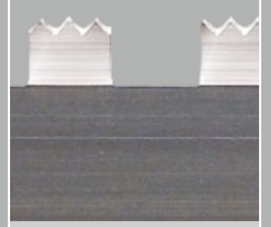


WPCFT



Non-serrated perforating

WRT – 14pt

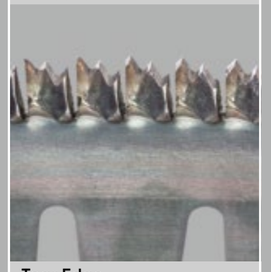


Serrated perforating

WFT – 14pt

Cut-Crease

BBreaker



Tear Edge

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 SR rotary creasing rules.

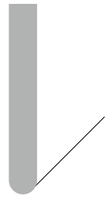
HT – Hardened and Tempered:
This process guarantees stability on creasing rules with thickness ≤ 3 pt.

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
bohlerstrip TOP 36	~ 340 HV (34 HRC)	✓	✓	on request
bohlerstrip HT	~ 380 HV (40 HRC)	✓	–	–
bohlerstrip HR	min. 265 HV (850 N / mm²)	–	✓	✓

ROTARY CREASING RULE

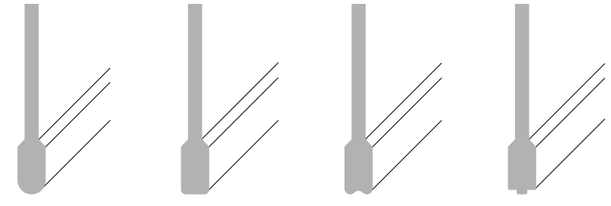
SR



Single Round	
SR	
[pt]	[mm]
3	1.05
4	1.42
6	2.13

voestalpine SPECIAL RULES

WRT WFT WTT WPC



Wide Top		Wide Top Specials	
WRT / WFT		WTT / WPC	
[pt]	[mm]	[pt]	[mm]
3 / 6	1.05 / 2.13	3 / 8	1.05 / 2.84
3 / 8	1.05 / 2.84	4 / 8	1.42 / 2.84
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.

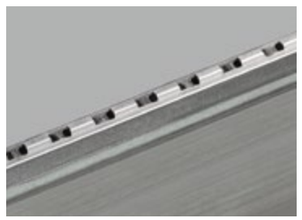
Quality	TOP 36
Thickness	4 pt / 1.42 mm
Wave width	8 pt / 2.84 mm
Wave length	6 mm
Heights	21.60 mm (.850″) – 23.80 mm (.937″)
	(others on request)

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)

voestalpine WPCFT – SPECIAL CREASING RULE 4/8PT

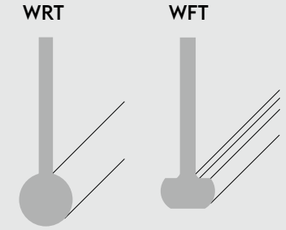


WPCFT is a specially designed version of WPC. The special top allows for better sheet control while reducing fracturing of the inner liner.

Quality	voestalpine HT 370
Tooth	2.50 mm
Gap	2.00 mm
Thickness	4 pt / 1.42 mm, 8 pt / 2.84 mm

THE LEADING EDGE FOR SPECIAL CREASING TASKS.

voestalpine 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 (14 pt). 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

voestalpine WRT – 14 pt Wide Round Top

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 particularly suitable for double and triple wall folding.

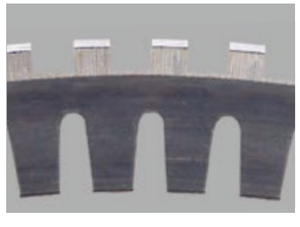
Quality	voestalpine HT 350
Thickness	4 pt / 1.42 mm, 14 pt / 5 mm
Heights	up to 35 mm / 1.377″

voestalpine WFT – 14 pt Wide Flat Top

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 can be used to replace close double creases. This profile is also good for double and triple wall creasing.

Quality	voestalpine HT 350
Thickness	4 pt / 1.42 mm, 14 pt / 5 mm
Heights	up to 35 mm / 1.377″

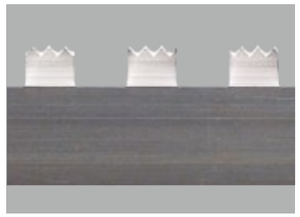
VOESTALPINE SPECIAL RULES



voestalpine NON-SERRATED PERFORATING RULES

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 (¼″). This will give a more stable and consistent rule.

Quality		voestalpine 350, voestalpine 350 / 500
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″
Standard gap depth *		4.75 mm (3/16″), 3.18 mm (1/8″)



voestalpine SERRATED PERFORATING RULES

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 (¼″) or larger. This will help reduce crushing and flaking on the finished product.

Quality		voestalpine 350, voestalpine 350 / 500
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″
Standard gap depth *		4.75 mm (3/16″), 3.18 mm (1/8″)

voestalpine CUT-CREASE RULES

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.

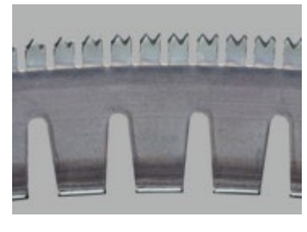
Quality		voestalpine 350, voestalpine 350 / 500
Thickness		4 pt / 1.42 mm
Heights		23.80 (.937″) – 25.40 mm (1.000″)
Standard configuration *	Europe:	6 x 6 mm, 10 x 10 mm, 12 x 12 mm
	USA:	1/4″ x 1/4″, 3/8″ x 3/8″, 1/2″ x 1/2″

* others on request

voestalpine SPECIAL PERFORATING RULES “BUNDLE-BREAKER”

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.

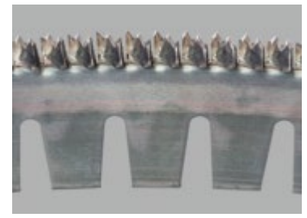
Quality	voestalpine 350
Thickness	4 pt / 1.42 mm
Heights	24.64 (.970″) – 26.16 mm (1.030″)
Standard tooth design	CFSTC12
Minimum gap width	1.42 mm
Gap depth	6 mm
Back notch depth (N3)	9.5 mm
Available tooth/gap combinations on request	
Available in SNN & N3C execution	



voestalpine TEAR EDGE RULES

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	voestalpine 350
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 diamter for notch designs N2C / N7C	487 mm
Available in SNN & N7C execution	



FORMS OF DELIVERY

STRAIGHT EXECUTION (AXIAL USE)

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

SNN

straight, no notches

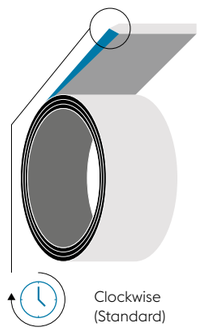
SN7

straight, with tapered notches

SN2

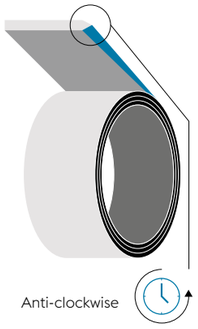
straight, with parallel notches

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

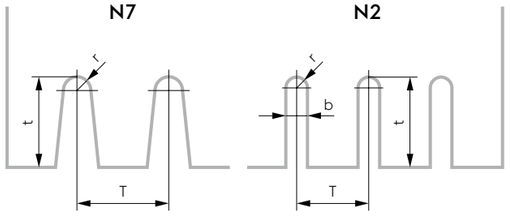


Dispenser boxes (available only in SNN):
Dispenser boxes allow easy rule pull-out of the box for just the rule length required, thus minimizing rule waste. These boxes also protect the rule and are a safe way of storage.
Standard coil length: 30.5 m (100 ft)
Attention: Coils packed in dispenser boxes are not wrapped in anti-corrosion paper!

Coiling directions and strip marking:
» **FA:** Anti-clockwise winding direction: view on cutting bevel “ò” – outside printing
» **F:** Clockwise winding direction: view on cutting bevel “6” – outside printing

NOTCH-DIMENSIONS

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



CURVED EXECUTION (RADIAL USE)

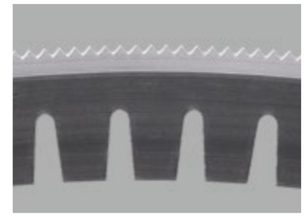
Curved rules are required for radial use (Executions: N2C / N7C / NNC).
Curved rotary rules are always delivered in coils.

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 fatique 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)!



N2C / N7C

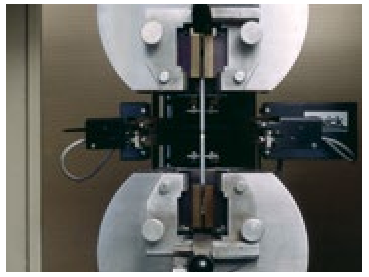
NNC

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.

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 precison strip for different applicationse.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

voestalpine Precision Strip GmbH
Waidhofner Strasse 3
3333 Boehlerwerk, Austria, Europe
T. +43/7442/600-0
www.voestalpine.com/precision-strip

voestalpine
ONE STEP AHEAD.