

# THE NEW GENERATION

BÖHLER 

## 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.

Böhler 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 micro-serrated rule back design serves as ‚pre-programmed‘ compensation zone which leads to quick self levelling 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 one year in many locations in different countries in Europe has proven that patching time and make-ready cost can be reduced by up to 80 %.

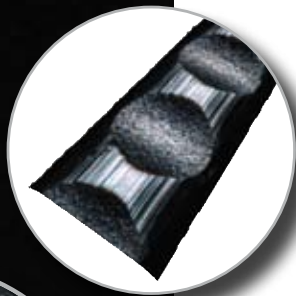
## Impact of the market

As nowadays packaging designs have a shorter life cycle, the number of sheets cut for one job has gone down constantly over the years.

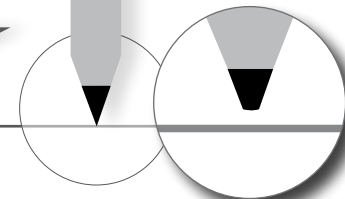
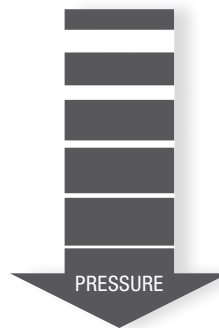
At the same time the number of re-runs for a die has steadily increased. X-PRESS supports all of these trends.

Illustration below:

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



+ X-PRESS cutting rule:  
Back is weak part



— Standard cutting rule:  
Edge is weak part

## Experience from the field



- successfully introduced and continuously used for one year 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 life time of knives
- up to 5.4 m sheets cut with original set of knives

## Availability:

- UNIVERSAL CF 53° or 42° and “polished” 23.80x0.71 mm or 23.60x0.71 mm (other dimensions and executions upon request)
- In coils of 100 m each (clockwise / anti-clockwise)
- in lengths of 1,000 mm each
- for solid or corrugated board
- Available from stock

# Everyone benefits from the new cutting rule X-PRESS

## Cost Saving

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 56 %**

-56%



initial order	Standard	X-PRESS
surcharge		50.00 €
time consumed	60 minutes	20 minutes
costs	200.00 €	66.00 €
<b>re-runs</b>		
time consumed	6 x 15 minutes	6 x 5 minutes
costs	300.00 €	100.00 €
<b>total cost</b>	<b>500.00 €</b>	<b>216.00 €</b>

## Benefits

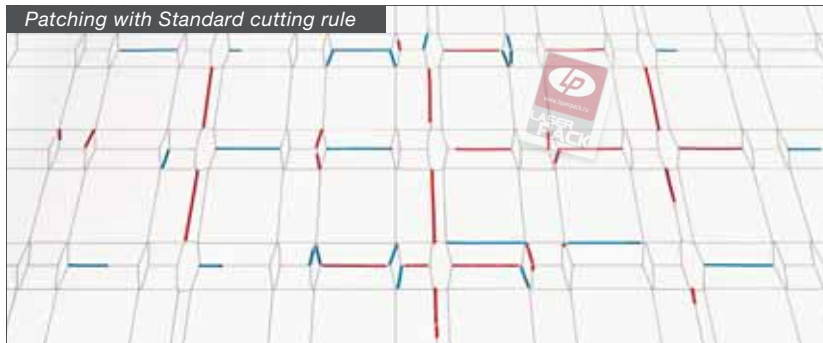
### for diemakers:

- standard processing on autobenders
- all processing steps possible without change
- door opener to high quality converting industry
- diemakers can offer state-of-the-art technology to their customers
- cost savings attractive as sales argument for converters

### for converters:

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

Patching with Standard cutting rule



Patching with X-PRESS cutting rule



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