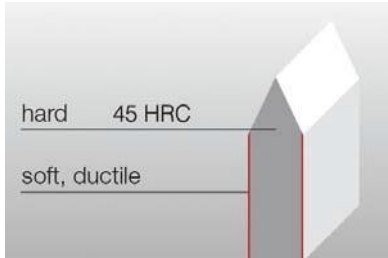
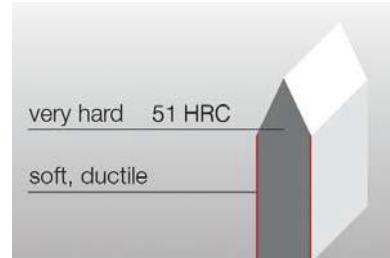


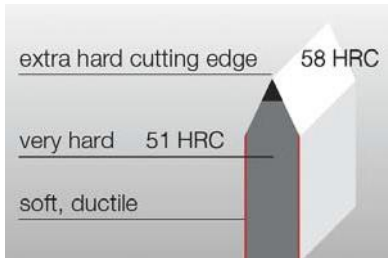
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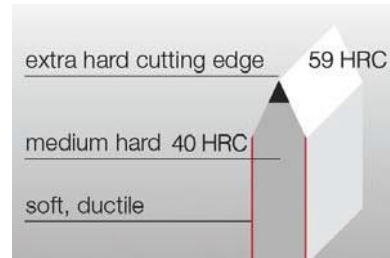
H75



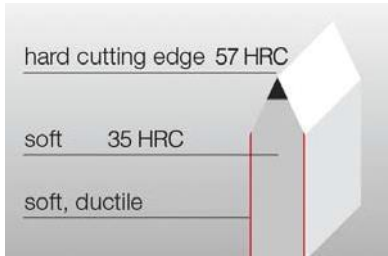
UNIVERSAL 75



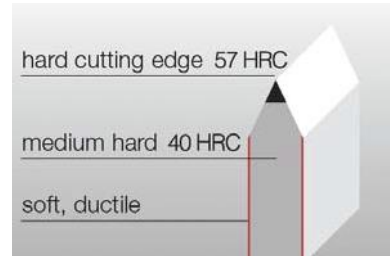
EXTRA



UNIVERSAL



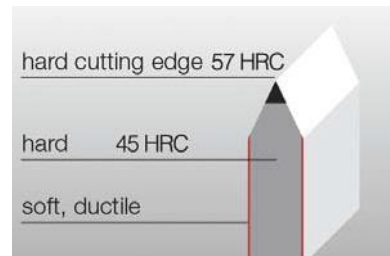
UNIVERSAL 40



K-Back

compensation back edge
Steel rules with flat rule
back generate tolerance
problems when bending
narrow angles due to
bulging effect on the rule
bottom.

UNIVERSAL 60





Böhler Cutting Rule TOP
Böhler Cutting Rule UNIVERSAL
Böhler Cutting Rule UNIVERSAL 60
Böhler Cutting Rule UNIVERSAL 75
Böhler Cutting Rule UNIVERSAL SUPER
Böhler Cutting Rule SUPREME
Böhler Cutting Rule H 75

Böhler Econo • Corr
Böhler Creasing Rule
Böhler Cut-Crease Rules TOP
Böhler Perforating Rules TOP
Böhler Glue Flap Rules TOP
Böhler Wave Edge Rules (TOP & UNIVERSAL)
Böhler Rotary

All Böhler Rules are laser accurate achieved through great precision of shape and dimensions.



Perforating Rules

Bohlerstrip perforating rules are available in a wide range of thicknesses and tooth/gap combinations. The spacing is usually given in mm. On request we also manufacture in point and inch spacings. Minimum gap / tooth width is defined by rule thickness.



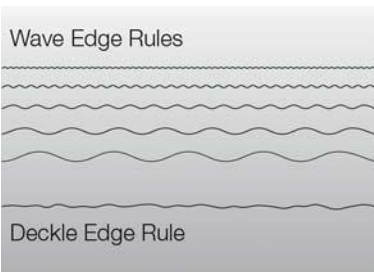
Combination Rules

With cut-crease rules there is no need to insert individual parts of cutting and creasing rules. Bohlerstrip cut-crease rules are produced in standard punched (CF), or in flat- or round machined executions for high-quality sales (CF / FT and CF / SR).



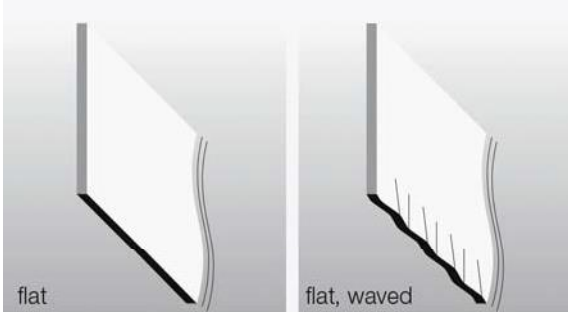
Glue Flap Rule

Glue flap rules are wave edge perforating rules, which are manufactured in the same heights as scoring rules. They are used to roughen the glue flaps on cardboard boxes to obtain a firm grip surface for the adhesive.



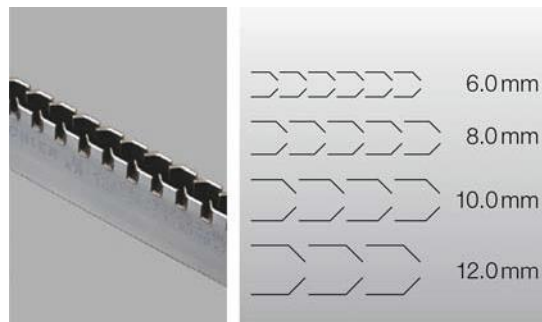
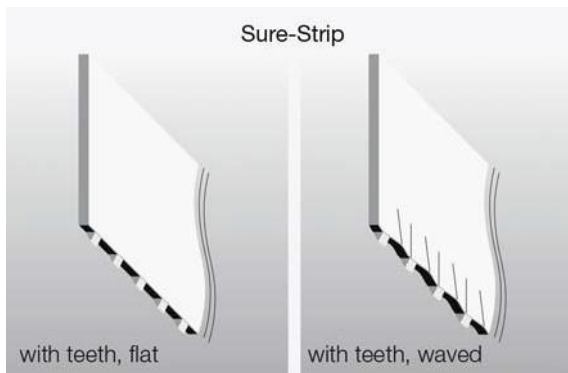
Wave Edge and Deckle Edge Rules

The main application for wave edge rules is in the production of safety cutting edges on solid and corrugated board boxes, to avoid injuries during box handling. Deckle edge rules are used to cut post cards, greeting and business cards.



Stripping Rules

Bohlerstrip stripping rules are the optimum solution for ejecting the waste material after the die cutting process. Perfect stripping ensures high die cutting speeds, therefore the quality of stripping rules is always an issue. Our production range includes:



Zipper Edge Rules

Zipper rules provide a tear-open solution especially for shelf ready packagings.



Spacer Rules

Spacer rules fill gaps between steel rules and wider laser cuts within the die board or backfill unwanted laser cuts within an existing die. The rules show a square cross sectional profile. Bohlerstrip spacer rules are available in all common wood sizes used in the die making industry.

Precision Cutting Rules

Brand	Body	Edge
TOP	-450 HV (45 HRC)	
H 75	-525 HV (51 HRC)	
UNIVERSAL	-340 HV (35 HRC)	- 640 HV (57HRC)
UNIVERSAL 40	-390 HV (40 HRC)	- 640 HV (57 HRC)
UNIVERSAL 60	-450 HV (45 HRC)	- 640 HV (57 HRC)
UNIVERSAL 76	-525 HV (51 HRC)	- 670 HV (58 HRC)
EXTRA	-390 HV (40 HRC)	- 700 HV (59 HRC)

Fine Ground X-Cutting Rules

Brand	Body	Edge
Label-X Soft	-340 HV (35 HRC)	- 625 HV (55 HRC)
Label-X	-390 HV (40 HRC)	- 635 HV (55 HRC)
Label-X Hard	-450 HV (45 HRC)	- 670 HV (58 HRC)
Plast-X Soft	-340 HV (35 HRC)	- 640 HV (57 HRC)
Plast-X	-390 HV (40 HRC)	- 700 HV (59 HRC)
Plast-X Hard	-450 HV (45 HRC)	- 700 HV (59 HRC)


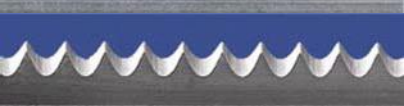
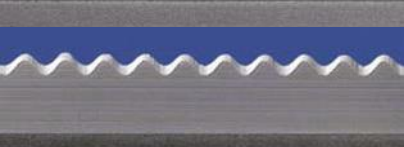
Brand	Body	Edge
Label-X Soft	-340 HV (35 HRC)	- 625 HV (55 HRC)
Label-X	-390 HV (40 HRC)	- 635 HV (55 HRC)
Label-X Hard	-450 HV (45 HRC)	- 670 HV (58 HRC)
Plast-X Soft	-340 HV (35 HRC)	- 640 HV (57 HRC)
Plast-X	-390 HV (40 HRC)	- 700 HV (59 HRC)
Plast-X Hard	-450 HV (45 HRC)	- 700 HV (59 HRC)

Edge Angle	Shaved	Ground	Polished
42° / 53°	CF / CFDB		
	SF / SFDB		
42° / 53°	CF / CFDB		
	SF / SFDB		
42° / 53°	CF / CFDB	CF / CFDB	CF / CFDB
	SF / SFDB		SF / SFDB
42° / 53°	CF / CFDB		CF / CFDB
	SF / SFDB		SF / SFDB
42° / 53°	CF / CFDB	CF / CFDB	CF / CFDB
	SF / SFDB		SF / SFDB
42° / 53°	CF / CFDB	CF / CFDB	
	SF / SFDB		
42° / 53°	CF / CFDB		
	SF / SFDB		

Edge Angle	Shaved	Fine Ground	Polished
42°		CF	
42°		CF	
42°		CF	
30° / 42° / 53°		CF / CFDB	
42° / 53°		CF / CFDB	
428 / 53°		CF / CFDB	

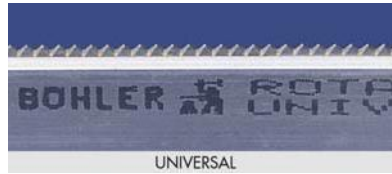


Tooth Shapes

ST	sharp teeth angular gullets		standard execution, usable for all cutting applications
US	extra sharp teeth round gullets		special tooth geometry, very aggressive in its cutting behavior (especially effective with symmetrical grinding)
SW	round teeth round gullets		wave tooth execution for pressure reduced cutting and less wear on the anvil covers or blankets

Grades

Brand	Hardness		is used	
	Body	Edge	axial	radial
Bohler Top 36	- 340 HV (34 HRC)		✓	✓
Bohler Universal	- 340 HV (34 HRC)	- 500 HV (49 HRC)	✓	✓



Profiles:

SR – single round

TT – twin-track

Laser Crease (HT):

WRT – wide round top

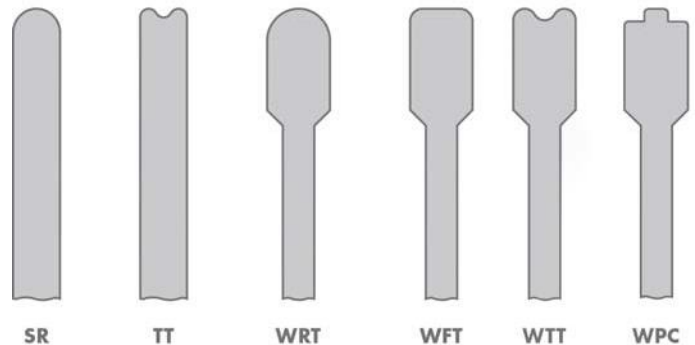
WFT – wide, flat top

WTT – wide twin-track

WPC – wide precision crease

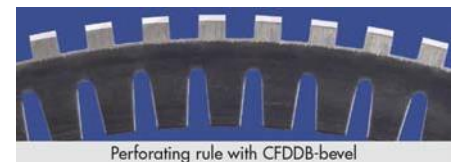
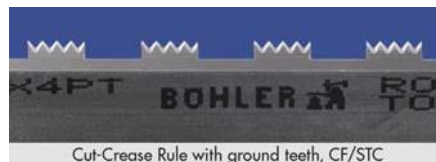
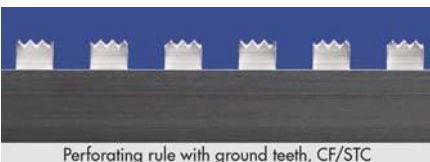
Advantage of Laser Crease:

- for the use of different crease thicknesses without the need to enlarge the laser slits in the wooden shells
- a wider creasing head facilitates the fold up of box flaps on heavier board (double-wall). We recommend: 4/8 pt



Types: 3/4, 3/6, 3/8, 4/6, 4/8 pt
 Heights: **20,32 – 24,38 mm** (0.800" – 0.960")
 Typical: 21,60 / 21,85 / 22,10 / 22,35 mm

Rotary Special Rules – Perforating and Cut Crease Rules



Special rules used for rotary applications are available in TOP 36. Executions with serrated cutting bevels (CF/STC) as well as non serrated bevels (CF and CFDDDB) are available.

When ordering please specify:

- serrated or non serrated
- tooth/gap combination
- gap depth