

Die Cutting Suggestions



For the best die cutting results, Rayonier A.M. Canada G.P. - Paperboard would like to suggest the following scoring techniques:

- To achieve a good crease profile, the female counter groove widths should be kept as narrow as possible. As a guide, the groove width should be equal to the sum of:

Machine direction: 1.3 x the board thickness + the width of the scoring rule;

Cross direction: 1.5 x the board thickness + the width of the scoring rule.

(Note: 2 pt. scoring rule width is 0.028")

- It may be desirable, depending on the end application, to increase the female counter height by 0.002" to further enhance the crease profiles.
- The height of the creasing rule is dependent on the thickness of the paperboard and the type of counter being used.

If further information is required concerning the die cutting of the Kallima® grade, please contact your Rayonier A.M. Canada G.P. - Paperboard Account Manager.

Imperial Units				
Board Thickness (Inches)	Groove Width MD (Inches)	Groove Width CD (Inches)	Groove Depth (Inches)	Creasing Rule
.010	.041	.043	.010 - .012	2 pt.
.012	.044	.046	.012 - .014	2 pt.
.014	.046	.048	.014 - .016	2 pt.
.016	.049	.052	.016 - .018	2 pt.
.018	.051	.055	.018 - .020	2 pt.

Metric Units				
Board Thickness (Microns)	Groove Width MD (mm)	Groove Width CD (mm)	Groove Depth (Microns)	Creasing Rule
254	1.0	1.1	250 - 300	2 pt.
305	1.1	1.2	300 - 350	2 pt.
356	1.2	1.2	350 - 400	2 pt.
406	1.2	1.3	400 - 450	2 pt.
457	1.3	1.4	450 - 500	2 pt.

Contact Us:

1-800-411-7011

samples.paperboard@rayonieram.com

kallimapaper.com