Prefabricated creasing counterparts

Width of creasing grooves

Each groove must be centered in relation to the creasing rule. *Due to the varying reactions of the board, ideal creasing conditions may not be attained solely by application of the following rules.* Nevertheless, the width of the grooves is generally defined like this:

Grooves perpendicular to the sheet fibers

The width of groove **b** is equal to **1.5 times** the thickness of the sheet **e** plus the thickness of the creasing rule **f**.

For corrugated board, use **twice** the thickness of the board creased **e** plus the thickness of the creasing rule **f**.

Grooves parallel to the sheet fibers

The groove is therefore narrower when it follows the fibers. In practice, it is usually accepted that grooves running parallel with the fibers are **0.1 mm** narrower than those running across the fibers.

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Thickness of the prefabricated counterparts

Thickness of counterpart **d** is equal to thickness of board **e** increased by thickness of channel bottom **a**.

Note: For E-flutes measure first the thickness of the crushed flute, then the same formula is applied.



Cutting die



Counterpart sizes





060009 3452 0203

00095322

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E00 08 7



Cutting die

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