ROYO MACHINERY

CREASING MATRIX

Structure of creasing matrix

b
c
A
a
d
B

a.Shoulder b.Locating plastic strip c.Brute mighty bottom film   d.Protection film
A.Thickness of creasing matrix   B.Width of channel
The size of creasing matrix marked as A x B means the thickness of "the thickness of shoulders" x "the width of channel"

OUR PRODUCT

The model of creasing matrix

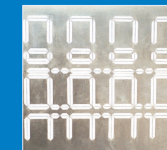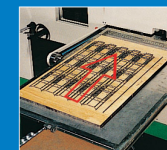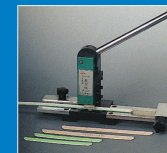SLB standard

SLZ mini

SLD off−center

SLK multiple
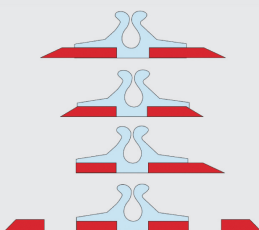
Mini model is used where the creasing rule is very close to cutting rule

Off-centre model is used where 2 cutting rules are very close to each other
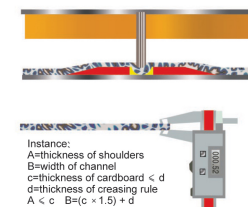
How to use the product correctly

The way to choose creasing matrix sizes for cardboard paper

Size table (subject to 23.8mm die-cutting rules)

Weight (g)	Thickness of Cardboard (mm)	The height of Creasing Rules (mm)						Commonly used domestic rules	
		23.50	23.40	23.30	23.20	23.10	23.00	23.24	22.9
200	0.28	0.5×1.0	0.4×1.0					0.5×1.0	
250	0.35	0.3×1.2	0.4×1.2	0.5×1.2				0.5×1.2	
300	0.42	0.3×1.3	0.4×1.3	0.5×1.4				0.5×1.4	
350	0.50		0.4×1.4	0.5×1.5	0.6×1.5			0.5×1.5	
400	0.56		0.5×1.6	0.6×1.6				0.5×1.6	0.8×1.6
450	0.63			0.5×1.7	0.6×1.7	0.7×1.7			0.8×1.7
500	0.70				0.7×1.7	0.8×1.7			0.8×1.7

Note: the specifications above are only recommendation , among which the specifications marked   with are recommended to choose firstly

For instance: the thickness of the cardboard: 0.52mm; the thickness of creasing rules: 0.71mm
According to calculation formula: A=0.52≈0.5(mm) B=0.52x1.5+0.71=1.49≈1.5(mm); So we should choose the size of 0.5x1.5

Instance:
A=thickness of shoulders
B=width of channel
c=thickness of cardboard ≤ d
d=thickness of creasing rule
A ≤ c   B=(c × 1.5) + d

The way to choose creasing matrix sizes for cardboard paper

Size table (subject to 23.8mm die-cutting rules)

Corrugated Paper	Thickness of corrugated paper after compression	Height of creasing rule	Choice of creasing matrix (thickness of creasing rule is 1.05mm)	Choice of creasing matrix (thickness of creasing rule is 1.42mm)
E-Flute	0.65mm	23.10mm	0.7×2.3	-
E- Flute	0.75mm	23.00mm	0.8×2.5	-
B- Flute	0.85mm	22.90mm	0.8×2.7	0.8×3.2
B- Flute	0.95mm	22.80mm	1.0×3.0	1.0×3.5
C- Flute	1.05mm	22.70mm	1.0×3.2	1.0×3.5
C- Flute	1.15mm	22.60mm	-	1.0×4.0

Remarks: the above blanks just for reference and the exact specification suitable for your job should be chosen according to your actual conditions.

Instance:
A=thickness of shoulders
B=width of channel
c=thickness of corrugated paper
d=thickness of creasing rule
e=thickness of corrugated paper after compression ≤ d A (e B=(e ×20)+d