

Processing instructions DIE CUTTING / PUNCHING

FOAM-X[®] new can be used on all well-known die cutting machines.

For smaller quantities, it is advisable to use a small semiautomatic die punching unit or stamp. Depending on the application either straight or fine-toothed blades are used on the die cutting plate.

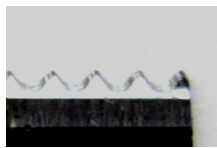
FOAM-X[®] new has a relatively soft core and therefore requires special attention.

TO PRODUCE EDGES THAT DO NOT TAPER OFF (MEMORY EFFECT)

Use fine-toothed knives

Feature:

- Edges do not taper off



The die has to be completely fixed with plate rubber, so that the tops of the fine-toothed knives are covered by 1mm. On the table it is recommended to use a strong, but pliable hard rubber material. The points of the knives should sink into this underlay.

Screen printed boards should be stored for at least 24 hours before die cutting, to allow their moisture content to reach equilibrium with the cutting shop environment.

TO PRODUCE EDGES THAT TAPER OFF (PILLOW EFFECT / NON MEMORY)

Use straight-edged blades

Feature:

- Edges taper off



FOAM-X [®] new Sheet thickness	Plate rubber thickness	Cutting knife height above the board material	Bloc/Plate thickness approx.
3 mm	8 mm	5 mm	18 mm
5 mm	10 mm	8 mm	15 mm

Thickness of blade: 0,7mm (maximum)

Type of blade: V-shaped

Hardness of foam rubber: 20-25 shore

Placing your plate rubber:

Cover the block including the placed blades, which you get from your die cut tool supplier with the recommended rubber that has at least an overlap towards the edges of min. 3cm.

Cover the rubber first with glue on the direction of the bloc / plate.

After the first punch the cut out, glued rubber parts will be fixed on the plate.

Put cardboard on the punching table to achieve a better result.

All results depend on an optimal adjusted die cutting machine!