

Technical Information

A. Flat Cutting Rule

| NO. | Hardness (HV) | | Standard Spec.(mm) | | | | Available Bevel Form | Angle of Edge | Coating | Cut Edge Hardening Method | Minimum bend Radius | Max. Angle at the Mini. Bend Radius | Available Spec. (mm) | |
|-----|---------------|------|--------------------|----------------|---------------|------------|----------------------|---------------|----------------|---------------------------|---------------------|-------------------------------------|----------------------|-------------|
| | Body | Edge | Thickness | Height | Edge Type | Bevel Form | | | | | | | Thickness | Height |
| 1 | 340 | 620 | 0.71 (2pt.) | 23.80 (0.937") | Shaved | CB CFDB | CB CFDB | 42 /52 | Rust Inhibitor | Laser | 0.3 | 130 | 0.71~1.05 | 23.60~50.00 |
| | | | 1.05 (3pt.) | | | | | | | | | | | |
| 2 | 380 | 620 | 0.71 (2pt.) | 23.80 (0.937") | Shaved | CB CFDB | CB CFDB | 42 /52 | Rust Inhibitor | Laser | 0.4 | 130 | 0.71~1.05 | 23.60~50.00 |
| | | | 1.05 (3pt.) | | | | | | | | | | | |
| 3 | 400 | 620 | 0.71 (2pt.) | 23.80 (0.937") | Shaved | CB CFDB | CB CFDB | 42 /52 | Rust Inhibitor | High Frequency /Laser | 0.5 | 120 | 0.71~1.05 | 23.60~50.00 |
| | | | 1.05 (3pt.) | | | | | | | | | | | |
| 4 | 440 | 620 | 0.71 (2pt.) | 23.80 (0.937") | Shaved | CB CFDB | CB CFDB | 42 /52 | Rust Inhibitor | High Frequency /Laser | 0.5 | 120 | 0.71~1.05 | 23.60~50.00 |
| | | | 1.05 (3pt.) | | | | | | | | | | | |
| 5 | 340 | 680 | 0.45 | 8.00 | Ground | CB | CB CFDB SB SFDB | 42 /52 | Rust Inhibitor | Laser | 0.3 | 130 | 0.45~0.71 | 8.00~23.80 |
| | | | 0.45/0.53 | 12.00 | | | | | | | | | | |
| | | | 0.53/0.71 | 23.80 | | | | | | | | | | |
| 6 | 380 | 680 | 1.05(3pt.) | 30.00 | Shaved Ground | CFDB | CB CFDB SB SFDB | 42 /52 | Rust Inhibitor | High Frequency | 1.5 | 90 | 1.05~1.42 | 23.80~50.00 |
| | | | | 31.75 | | | | | | | | | | |
| | | | | 40.00 | | | | | | | | | | |
| | | | | 50.00 | | | | | | | | | | |
| | | | 1.42(4pt.) | 30.00 | | | | | | | | | | |
| | | | | 40.00 | | | | | | | | | | |
| | | | | 50.00 | | | | | | | | | | |

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B. Creasing Rule

| NO. | Edge Round | Standard Hardness(HV) | | Standard Packing | Standard Spec. (mm) | | Available Spec. (mm) | | |
|-----|--------------|-----------------------|------|------------------|---------------------|------------------------|----------------------|-----------------|--------------|
| | Type | Body | Edge | | Thickness | Height | Thickness | Height | Hardness(HV) |
| 1 | Double Round | 400 | 400 | 100M | 0.71 (2pt.) | 23.10/23.30/23.60 | 0.71 (2pt.) | 8.00~50.00 | 240~440 |
| | Single Round | | | | | (0.909"/0.917"/0.929") | | (0.315"~1.968") | |
| 2 | Double Round | 400 | 400 | 70M | 1.05 (3pt.) | 22.00/22.80/23.10 | 1.05 (3pt.) | 8.00~50.00 | 240~440 |
| | Single Round | | | | | (0.865"/0.898"/0.909") | | (0.315"~1.968") | |
| 3 | Double Round | 400 | 400 | 50M | 1.42 (4pt.) | 22.00/22.80 | 1.42 (4pt.) | 8.00~50.00 | 240~440 |
| | Single Round | | | | | (0.865"/0.898") | | (0.315"~1.968") | |

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C. Perforating Rule & Cut crease (Combined) Rule

| NO. | ITEM | Hardness(HV) | | Thickness | Width | Size | | |
|-----|-------------|--------------|------|----------------|-------------------|-----------------------|------------------------|------------------|
| | | Body | Edge | | | Tooth (Cut length) | Gap (Crease length) | Crease Height |
| 1 | Perforating | 380 | 380 | 0.71 (2pt.) | 23.80 (0.937") | 1 | 1 | |
| 2 | | | | | | 1.5~10.0 | 1.5~10.0 | |
| 3 | | | | | | 1.5 | 1.5 | |
| 4 | | | | | | 2.0~10.0 | 2.0~10.0 | |
| 5 | Cut-Crease | 380 | 380 | 0.71 (2pt.) | 23.80 (0.937") | 5~10 | 5~10 | 22.8~23.3 |
| 6 | | | | | | 5~10 | 5~10 | 22.8~23.3 |

D. Wave Rule & Zipper Rule

| NO | ITEM | Hardness(HV) | | Thickness | Width | Size |
|----|-------------|--------------|------|----------------|-------------------|-----------|
| | | Body | Edge | | | (Pitches) |
| 1 | Wave Rule | 340 | 620 | 0.71 (2pt.) | 23.80 (0.937") | 2P |
| 2 | | | | | | 3P,4P,5P |
| 3 | | | | | | 2P |
| 4 | | | | | | 3P,5P |
| 5 | Zipper Rule | 340 | 620 | 0.71 (2pt.) | 23.80 (0.937") | 3-4 ~ 3-8 |

Technical Information

E. Body and edge hardness

| BODY HARDNESS HRC | BODY HARDNESS HV | EDGE HARDNESS HRC | EDGE HARDNESS HV |
|-------------------|------------------|-------------------|------------------|
| 35 | 340 | 56 | 620 |
| 39 | 380 | 59 | 680 |
| 41 | 400 | | |
| 44 | 440 | | |

F. product tolerance

| RULE THICKNESS | | | THICKNESS TOLERANCE | |
|----------------|------|-------|---------------------|---------|
| pt | MM | Inch | MM | Inch |
| 1.3 | 0.45 | 0.018 | ±0.015 | ±0.0006 |
| 1.4 | 0.5 | 0.02 | ±0.015 | ±0.0006 |
| 1.5 | 0.53 | 0.021 | ±0.015 | ±0.0006 |
| 2 | 0.71 | 0.028 | ±0.015 | ±0.0006 |
| 3 | 1.05 | 0.041 | ±0.020 | ±0.0008 |
| 4 | 1.42 | 0.056 | ±0.020 | ±0.0008 |

G. Height tolerance

| RULE HEIGHT | | HEIGHT TOLERANCE | |
|----------------|------------------|------------------|---------|
| MM | Inch | MM | Inch |
| 8.00 – 25.40 | 0.315 – 1.000 | ±0.020 | ±0.0008 |
| >25.40 – 50.80 | > 1.0000 – 2.000 | ±0.025 | ±0.0010 |

H. Tolerace of form

| | |
|---------------------|---------------------|
| Straightness | Max 0.5mm / 1,000mm |
| Flatness | Max 5mm / 1,000mm |
| Cross Camber | Max 0.1% for Width |