

SYMBOL PACK

Creasing normally comes after different and expensive conversions like printing, hot foil embossing or blind embossing. In Fedrigoni we know how important this final step on the folding boxes manufacturing process is to get the best result and especially to avoid extra costs or material waste.

The creasing process has dozens of possibilities for one single thickness, but only one guarantees the perfect result. Fedrigoni is the world leader in special papers, we are experts on paper manufacturing but not in creasing, for that reason we have worked together with CITO, the European leader of creasing tools for getting the perfect combination for our papers.

Thanks to CITO's technology we have tested each one of our grammages with more than 100 different setups and have checked all of them at a microscopical level looking for the perfect shape.

The mentioned sizes are recommendations only. Other factors can influence the material and thus have an effect on the choice of the counterpart or the creasing rule.

We also would like to emphasize that the result was achieved with original CITO creasing matrix. Other creasing matrix can differ in the dimensions leading to different results. While the result for the milled steel counter plate shall remain the same.

Machine: BOBST SP 104 ER

Creasing Matrix: CITO ULTIMATE

Milled channels at steel counter: conical 15-20°

INTRODUCTION

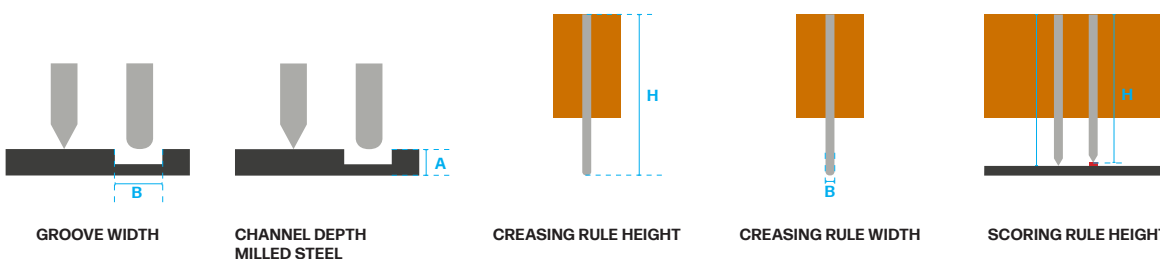
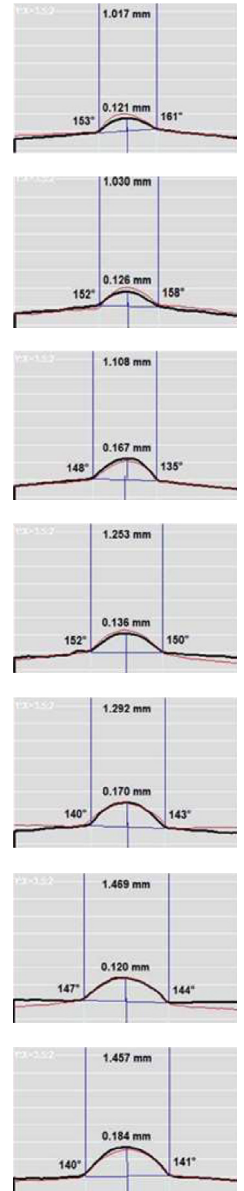
IDEAL SCENARIO

TRIAL SCENARIO

SYMBOL PACK

g/m ²	Paper Thickness (um)	Creasing Rule (mm)		Creasing Matrix (mm) CITO ULTIMATE along and against the grain	Scoring Rule (mm)	
		Height	Width		Height	Width
230	255	23.55	0.71 / 2 Pt.	0.3 × 1.0	23.65	0.71 / 2 Pt.
250	280	23.50	0.71 / 2 Pt.	0.3 × 1.1	23.65	0.71 / 2 Pt.
280	315	23.50	0.71 / 2 Pt.	0.3 × 1.1	23.65	0.71 / 2 Pt.
310	345	23.45	0.71 / 2 Pt.	0.3 × 1.2	23.65	0.71 / 2 Pt.
330	380	23.45	0.71 / 2 Pt.	0.4 × 1.3	23.60	0.71 / 2 Pt.
360	420	23.45	0.71 / 2 Pt.	0.4 × 1.3	23.60	0.71 / 2 Pt.
400	450	23.35	0.71 / 2 Pt.	0.5 × 1.4	23.60	0.71 / 2 Pt.

CREASING MATRIX PHENOLIC COUNTER

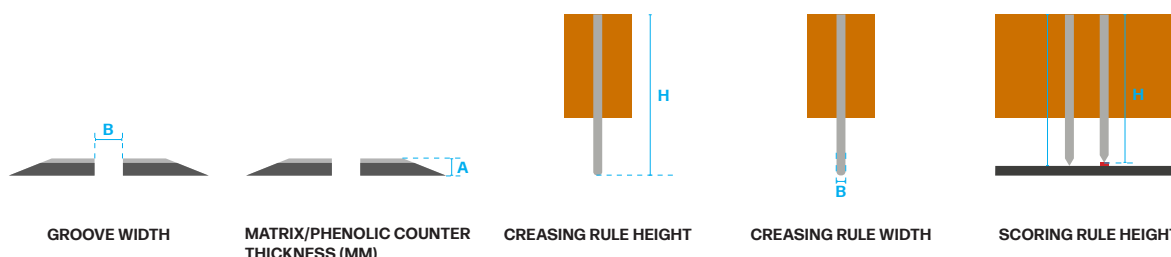


LEGENDA

SYMBOL PACK

g/m ²	Paper Thickness (um)	Creasing Rule (mm)		Channel (mm) along and against the grain	Scoring Rule (mm)	
		Height	Width		Height	Width
230	255	23.85	0.52 / 1.5 Pt.	0.6 / 1.0	23.65	0.71 / 2 Pt.
250	280	23.80	0.71 / 2 Pt.	0.6 / 1.1	23.60	0.71 / 2 Pt.
280	315	23.80	0.71 / 2 Pt.	0.6 / 1.2	23.60	0.71 / 2 Pt.
310	345	23.80	0.71 / 2 Pt.	0.6 / 1.3	23.60	0.71 / 2 Pt.
330	380	23.80	0.71 / 2 Pt.	0.6 / 1.3	23.60	0.71 / 2 Pt.
360	420	23.80	0.71 / 2 Pt.	0.6 / 1.4	23.60	0.71 / 2 Pt.
400	450	23.80	0.71 / 2 Pt.	0.6 / 1.4	23.60	0.71 / 2 Pt.

MILLED STEEL COUNTER PLATE



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