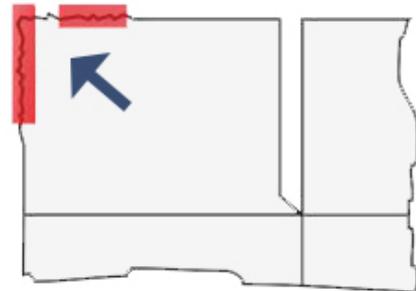


Excursus: How to patch up properly

1. Keep distance

By overlapping (= double make-ready height) at e.g. cutting rule corners, the cutting pressure at the edge rule increases enormously and the cutting rules become blunt over time. In addition, the neighbouring area can't be cutted correctly any longer and further make-ready will be necessary.

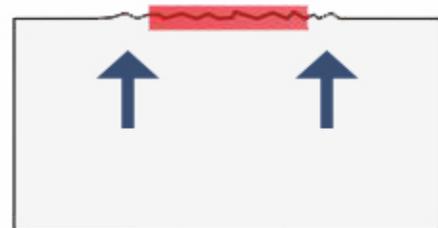
When patching up it is therefore important to ensure that the ends of the make-ready tapes are not patched upon the adjacent tapes. Better leave 2 to 3 mm space between the tapes, because the distance between the Profitapes is bridged by the flow forces of the frame plate.



2. Note length

Basically it has to be ensured that the non-cutting area is not patched up into the cutting area (overlength), because then these areas would completely raise the entire make-ready area.

So always patch up shorter than the non-cutting area. Because here, too, the flow force of the plates guarantee that the whole section is cut.



3. Narrow slots

In the case of very narrow slots, patching up only one cutting rule leads to a mutual influence of the die-cutting process and thus to an unsatisfactory cutting result.

A perfect result is achieved here with a wider make-ready tape. Hereby both cutting rules are patched up with one single tape. This not only saves make-ready time, but also protects the cutting rules.

