



Graphic Specialties, Inc.

# Die-Cutting

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## Equipment:

	Maximum Sheet	Minimum Sheet
SBL (with automatic stripping)	29" X 41"	16" x 22"
Thompson Saroglia Foil-Embosser	22" x 29"	8 1/2" x 11"
Kluge EHE Foil-Embosser	14" x 22"	4" x 4"
(2) Kluge EHD Foil-Embosser	14" x 22"	4" x 4"
Heidelberg SBD	25" x 35"	10" x 13"
Heidelberg	18" x 25"	5" x 5"
Heidelberg Cylinder	18" x 22 1/2"	5" x 5"
Kluge (inker)	13" x 19"	4" x 4"

## Specifications:

Presses that can accommodate : 4" x 4" to 29" x 41"

## Tips and Information:

- Always clearly mark proper lot changes.
- Uncut press sheets are more consistent and easier for us to die cut than trimmed paper edges.
- We prefer head-to-head layouts for two-up pocket folders.
- Minimum of 3/8" gripper edge is recommended. If you need less, consult us first.
- Clearly mark gripper and side guide on an uncut press sheet.
- Include detailed artwork, accurate die line, and/or samples with positioning.
- Any type of film layout will do. A press sheet is helpful for exact dimensions so that we can hit color breaks and other critical areas.
- When tight registration is indicated, position the grip and guide as close to the image as possible.
- Scoring on stocks less than 6 point is not recommended.
- Placing a die cut closer than 1/4" from the edge will weaken the sheet.
- Do not remove large areas from pieces that will have to withstand a lot of handling or that must go through a printer.
- Letter press creasing (matrix or hot scoring) finishes a job with the best quality.
- Take into consideration bleeds and wrap-arounds.
- Always include a ruled up press sheet.
- Provide us with your production counts.

## Terms:

### Gripper Edge:

The edge that will be pushed or pulled against the top on the press.

### Guide:

The sides of an uncut press sheet.

### Grain:

Always indicate grain direction, even if it looks obvious. Main final fold works best with the grain. However, greater strength can be achieved with a score made perpendicular to the grain.

### Scoring:

Facilitates crisp, clean folds.

### Perfing & Micro Perfing:

Perforating. Slotted seams allowing portions of the stock to be torn out. Great for tear out reply cards, business cards, or laser forms. Let us know your end use so that we can make recommendations.

### Kisscutting:

For flat sheet labels and stickers.