

## Did You Know? - Cutting Dies & Die Cutting

Among the many types of finishing services we provide, die-cutting is one of the most common. Below is information about cutting dies and die-cutting that we hope you will find useful.

**Gussets** - commonly used in pocket folders. We can do 1/8", 3/16", 1/4", and any gusset width above 1/4".

**Rule distance** – the closest two pieces of cutting/scoring/perfing rule can be to each other in a cutting die is 3/32" (1/8" is recommended though).

**Perfs** – used to allow a portion of a piece to be torn away.

The number of teeth in a perfing die can vary based on stock type and thickness.



Typically, 1/16" x 1/16" (every other 16th is a cut) will be used for perfs on a fold.

If a perf will be used on rounded corners, fully cut corners will be substituted if the corner radius is 1/4" or less. Micro-perfs cannot be used on round corners regardless of radius.

Please see the next page for examples of the perfs we can do.

**Punches** - used to put smaller holes in a sheet when normal cutting rule cannot be used. There are two types of punches:

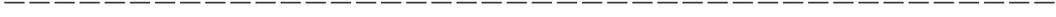
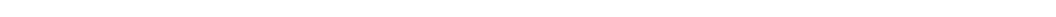
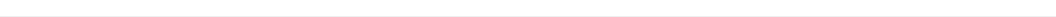
**Self-Cleaning Punches** – machined punches that after punching the paper, the chad falls out.

**Spring Punches** – machined punches that contain a spring that after punching the paper, the chad remains in the sheet to be removed by hand later.

**Full Perimeter Cuts** – any shape with a full perimeter cut (a circle for example) may require us to make small nicks in the die to help hold the shape in the press sheet after die cutting. This results in tiny bumps at different points in the shape. We will always strive to keep the number of nicks to a minimum.



## Perforating and Specialty Rules

2 teeth per inch	0.032" space	
3 teeth per inch		
4 teeth per inch		
6 teeth per inch		
8 teeth per inch		
10 teeth per inch		
12 teeth per inch		
17 teeth per inch		
1/32" tooth x 1/32" space		
1/16" tooth x 1/16" space		
1/8" tooth x 1/8" space		
30 teeth per inch - 0.012" space		
50 teeth per inch - 0.010" space		
Deckle		
Zipper	