

## CITO Cutting and Creasing Rules

- ProCut
- SuperBend
- SwordCut
- MasterCrease
- Special Rules

# Cutting and Creasing Rules

## Cutting Rules

	HS <b>CITO</b> ProCut	HS <b>CITO</b> SuperBend	HS <b>CITO</b> SwordCut	
	An ideal hardness ratio between the edge and body guarantees outstanding stability and ensures the highest demands on service life.	The well-balanced hardening technology can cope with even the smallest bending angle. The hardened edges guarantee an excellent service life.	The precision-ground blade and maximum dimensional accuracy reduce the cutting pressure, prevent the formation of angel hairs and cutting dust.	
Thickness	2 pt.	2 pt. / 3 pt.	2 pt.	3 pt.
Body hardness	380 HV	350 HV	380 HV	350 HV
Edge hardness	630 HV	630 HV	630 HV	
Height	22.30 – 50.00 mm	22.30 – 50.00 mm	23.80 mm	
Type of cutting bevel	CB / CFB	CB / CFB	CB / CFB	
Finish of cutting bevel	drawn / ground	drawn / ground	precision ground	
Cutting angle	52° / 42°	52° / 42°	52° / 42°	

## Creasing Rules

	HS <b>CITO</b> MasterCrease		
	Excellent centricity and exact manufacturing technology for the highest demands on the perfect crease.		
Profile type	Standard		
Thickness	2 pt.	3 pt.	4 pt.
Body hardness	380 HV	350 HV	330 HV
Height	22.40 – 23.90 mm	21.00 – 23.90 mm	22.00 – 23.90 mm

### Color Coded

HS CITO MasterCrease Color Coded Creasing Rules facilitate the production and control of cutting dies. Creasing rule heights are clearly marked by a color code which allows the easiest of quality checks and avoids mistakes when inserting creasing rules into the plywood.

# Special Rules

Special Rules such as cutting and creasing rules, lasercrease, crease-cutting rules, perforation rules, zipper rules, wave rules, wave perforation rules, stripping rules and hand hole perforation rules are also available.

	Cutting rules	Creasing rules	Lasercrease (round / flat top)	Crease-cutting rules	Perforation rules
Thickness	0.5 pt. – 6 pt.	0.5 pt. – 6 pt.	2/3 pt. / 2/4 pt. 3/4 pt. / 3/6 pt. / 3/8 pt. 4/6 pt. / 4/8 pt.	2 pt. – 4 pt.	2 pt. – 4 pt.
Body hardness	350 HV *	380 HV *	380 HV *	350 HV *	350 HV *
Edge hardness	580 HV *				350 HV *
Height	from 6.00 mm	19.00 – 23.90 mm **	22.20 – 26.40 mm **	23.80 mm / 23.00 – 23.80 mm **	23.80 mm **
Geometry	CB / CBF / SB / SFB	one-sided / two-sided, round / flat	one-sided / two-sided, round / flat	round / flat	cut / ground
Finish of cutting bevel	drawn / ground				without edge hardening
Cutting angle	52° / 42°				52° / 42°

	Zipper rules	Wave rules	Wave perforation rule	Stripping rules	Hand hole perforation
Thickness	2 pt. / 3 pt.	2 pt. / 3 pt.	2 pt. / 3 pt.	2 pt. – 4 pt.	2 pt. / 3 pt.
Body hardness	350 HV *	350 HV *	350 HV *	350 HV *	350 HV
Edge hardness		580 / 350 HV *			580 HV
Height	23.80 mm **	23.80 mm **	23.00 – 23.80 mm **	50 mm **	23.80 mm **
Geometry	Standard = 2:1, 45° bent (other types of cutting bevels upon request)	CB / CFB	different waves and separations	smooth / perforated with different perforations	30° / 45°, right / left
Finish of cutting bevel		with / without edge hardening			
Cutting angle		52° / 42°			52° / 42°

\* other hardnesses upon request

\*\* other heights upon request

# Types and Forms of delivery

## Type of cutting bevels



CB  
Center Bevel



CFB  
Center Facette Bevel  
= Long Center Bevel

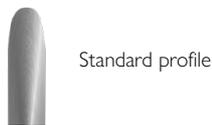


SB  
Side Bevel



SFB  
Side Facette Bevel  
= Long Side Bevel

## Profile types



Standard profile



Facet profile



Round top



Flat top

## Forms of delivery

Cutting and creasing rules and special rules\* are available in one metre lengths and coils.

Thickness	Contents metre-lengths	Contents coils
2 pt.	100 m	100 m
3 pt.	70 m	50 m
4 pt.	50 m	50 m
6 pt.	25 m	
2/3 pt. / 2/4 pt. 3/4 pt. / 3/6 pt. / 3/8 pt. 4/6 pt. / 4/8 pt.	30 m	

\* Special rules upon request



clockwise



anti-clockwise



Perfect in combination with  
the CITO Rule Puller



The CITO Rule Puller makes  
changing cutting, creasing and  
special rules child's play.