

CITO Cutting and Creasing Rules

- ProCut
- SuperBend
- SwordCut
- MasterCrease
- Specials

Cutting and Creasing Rules

Cutting Rules

| | HS CITO ProCut | HS CITO SuperBend | HS CITO 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 CITO 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

ES CITO Specials

ES CITO Specials 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.

| | ES CITO Flex (cutting rules) | ES CITO Crease (creasing rules) | ES CITO Lasercrease (round / flat top) | ES CITO CreaseCut (crease-cutting rules) | ES CITO Perfo (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° |

| | ES CITO Zipp (zipper rules) | ES CITO Wave (wave rules) | ES CITO GlueFlap (wave perforation rules) | ES CITO Strip (stripping rules) | ES CITO Tissue (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

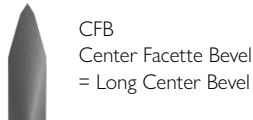
** other heights upon request

Types and Forms of delivery

Type of cutting bevels



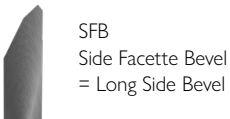
CB
Center Bevel



CFB
Center Facette Bevel
= Long Center Bevel

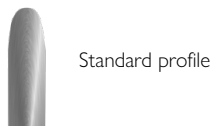


SB
Side Bevel



SFB
Side Facette Bevel
= Long Side Bevel

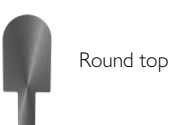
Profile types



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 | |

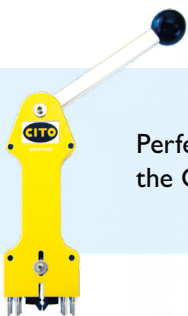
* Special rules upon request



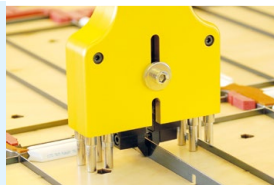
clockwise



anti-clockwise



Perfect in combination with
the CITO Rule Puller



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