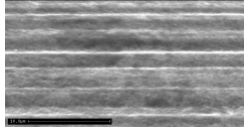
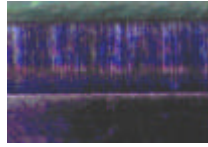


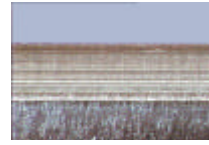
# Flat Bed Steel Finishes



**Drawn edge**



**Ground Edge**



**Polished Edge**

**Shaved (Drawn) Cutting Edge (S):** The standard condition of Böhler cutting rules is a precision drawn, high surface quality cutting edge.

The cutting rule has a smooth surface with a sharp cutting edge, which maximizes the formation of dust during application and ensures an easy penetration into the material being cut.

**Sharpened (Ground) Cutting Edge (G):** For efficient cutting of plastics, rubber, laminates and coated materials, a ground cutting edge has proved the best.

We recommend for this application our induction hardened cutting rules (UNI, UNI 60 and UNI 75) in the ground finish.

The bend-ability, compared to rules with a drawn edge is slightly reduced.

**Polished Edge (P):** Polished cutting rules represent a technology which combines the advantages of a shaved (drawn) and a ground (sharpened) execution. Due to the very smooth surface the following advantages can be achieved:

- Lower friction due to reduced cutting pressure during the die cutting process, causing a further decrease of dust to build up
- Cleaner cutting faces
- Eliminates damage to the board coating
- High quality cutting performance when cutting plastics, foils, laminates...
- Improved bending properties due to the smooth surface compared to ground cutting rules
- Increased tool life

Polished cutting rule is recommended when clean cutting faces are required and when dust formation is a problem:

- Food
- Pharma
- Plastics
- HQ packaging

The rounding at the transition of the bevel to body offers advantages during cutting to lengths and when bending on automatic process equipment. This execution is also available with **polished long bevel (PL)** as well as in SF and SFDB bevels.