



Die Cutting | Perforation | Scoring | Stripping | Surface Cutting

Die cutting is the piercing of paper or other substrates (i.e. plastic, board stock, foam core) with a knife - edge steel rule blade. These can be straight single cuts, slots, holes or various other shapes and configurations. This process is done using a steel rule die which usually is made with 1/32" thick steel rule blades (or rules), cut and bent to specific patterns and mounted in a wooden base. This steel is generally .937" high and has knife-like cutting edges. To accomplish die cutting, the press exerts enough pressure so that the cutting die forces itself into the stock creating a cutting impression.

Sheet Size	Minimum 3" x 4 1/2"	Maximum 36 1/4" x 49 1/2"
Die Cutting Area		

Dies

Lead-time for manufacturing varies with complexity and can take from one to several working days to produce a die. Our quotes assume normal turnaround and normal costs. If your job is time sensitive, please call to discuss lead time for your particular die and any potential additional costs.

Required for Die Making:

- AI files in .PDF and/or .EPS format

Quality Control

Required for set up and quality control:

- Press sheet with gripper (Gripper margin of 1/2" minimum, Tail margin of 1/4", Side margin of 1/4") and side guide indicated*
- Mock up or sample of finished piece* (if re-run)
- Include additional sheets for waste and make ready
- Instructions for boxing

Recommendations for Successful Results

- Call us for design assistance
- When perforating is requested, advise us of the end use of your product (i.e., a mailer, to be used in laser printer, etc.)

** Please mark each item with your job number and your company name.*

Tooling

As of January 1, 2021, MCD will store all customers' tooling for 6 years of no activity. At that time, tooling will be purged.



Glossary of Die Cutting Terms

Scoring: Creasing a material to facilitate folding. It should be made in the same direction as the grain of the paper when ease of folding is of prime concern. For greater strength, a score can be made perpendicular to the paper grain.

Cut Score: Process of scoring heavy stock by cutting partially through the paper, breaking the fiber to attain a crease for folding.

Perforating: A form of die cutting using a special type of steel rule with a pattern of teeth. This is generally used for such things as mailers, reply cards, etc. in which the paper need to be pulled apart easily without tearing.

Surface Cutting: (Also known as kiss cutting) A form of die cutting using a steel rule die to cut through a surface label stock, but not through the attached backer sheet (i.e. labels, stickers).

In-line Stripping: The removal of interior waste on press after the die cutting has been done (i.e. removing report cover windows automatically).

Scrap Out: The removal of exterior waste off press after the die cutting has been done manually.

Nicking: Process of nicking cutting rule with a grinder or chisel in order to hold the die cut piece in the press sheet when die cutting.

Gripper Edge: The edge of the sheet to be die cut which is pushed or pulled against a pre- determined stop on the press. For registering purposes, this same designated edge is used during all press applications on the sheet.

Side Guide: On press, a side-to-side positioning guide perpendicular to, and used in conjunction with the gripper stop to assure registration during the various press operation.