

## WORKING INSTRUCTIONS

### TOOL INSPECTION:

- Control die if X-PRESS rule is inside (cutting & compensation rules).
- Due to tight tolerances use BÖHLER creasing, perforating & cut-crease rules only.
- Apply new medium hard or hard counter plates.
- Increase initial diecutting force by approx. 10 % for first test cut compared with standard die. Cutting rules will self-level under pressure.
- Start zone patching to optimize X-PRESS effect.

### PATCHING:

- Use calibrated patching sheets only.
- Use calibrated patching tapes only.
- If necessary, increase gradually cutting force until clean cut is achieved.

For further instructions:

**Please contact your BÖHLER distributor!**