

# GUILLOTINING

## Guillotining

The JAC adhesive DURO 2000, which has been developed specially for JAC papers in sheets, makes guillotining easy: no sticking together if the guillotine is set and used properly. This is quite astonishing if we consider that the cutting of 400 sheets takes the guillotine blade through 8 mm of adhesive. Other special-purpose adhesives, especially adhesives of low viscosity or thickly coated adhesives, necessitate more careful measures.

### For example:

- Very sharp guillotine blade.
- Grind the blade to an acute angle, e.g. 21°. Blade replacement is necessary, for example, after cutting cardboard.
- Clamping bar pressure as low as possible. Rule of thumb: 1 kp per mm cutting thickness, e.g. 500 kp = 500 mm.
- Rub the blade, especially the back, with silicone oil or hard-grained soap prior to guillotining.
- Guillotine only small quantities at a time, e.g. 200 sheets.
- Repeat the blade rubbing operation – with silicone oil or soap – as often as required during the entire guillotining process.
- Should any residues of adhesive collect on the blade during cutting, simply wipe them off with a cloth soaked in a suitable cleansing agent (e.g. petroleum spirit).

- Whilst the backs of guillotine blades used to be provided with a grid pattern which served to prevent the build-up of adhesive residues, modern blades are manufactured from hardened stainless steel and feature smooth backs which are equally effective to this end.

Should the sheets tend to stick together after guillotining, simply fan them out and rub their cut edges with a cloth and French chalk.

## Printing

If you have cut smaller sheets from the original format prior to printing (e.g. 35 x 50 cm from 50 x 70 cm), proceed as follows:

- Stack the sheets in the sheet feeder with the freshly cut edges toward the rear.

This will not only reduce the risk of two sheets being fed into the printing machine at the same time but also prevent any dust generated by the guillotining process from being blown onto the printing surface. For large print runs, rub the slide guides of the sheet feeder and the sheet delivery, the grippers and the lay gauges with silicone oil, or line them with silicone paper. This will prevent the formation of adhesive deposits which could adversely affect registration or cause stoppages and breakdowns.



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## Die-cutting of peel-off tabs.

Die-cut peel-off tabs constitute the fastest and most convenient means of removing the sticker from the silicone backing paper. **No other device or method permits removal of the entire sticker in one single operation!**

JAC self-adhesive papers and films in sheets can be readily die-cut in any platen and letterpress printing machine. Magnetic cylinders, onto which die plates are fixed, are now being used more and more for in-line die-cutting applications. The laminate is cut in such a way that only the print carrier and the layer of adhesive are penetrated by the cutting die, but not the siliconized backing paper, which is extremely compact and resilient.

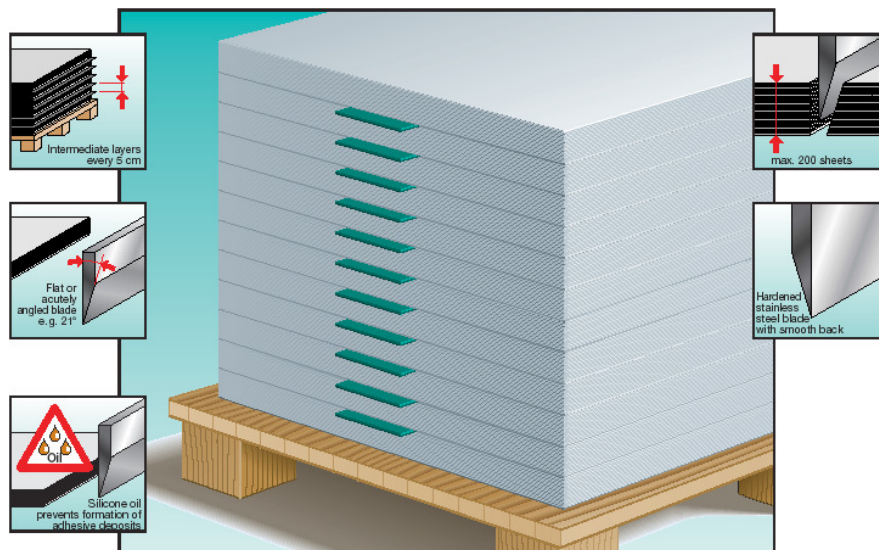
This is much easier than it sounds. Many thousands of printers use this method.

Here are three useful tips:

- Perform the die-cutting operation with an underlay consisting of a sheet of pressboard or a metal plate or cylinder.
- Any unevenness in the cutting depth should be compensated, for example, by sticking tissue paper to the underside of the underlay.
- It is often better to cut too deeply, i.e. to slightly penetrate the silicone paper. If the cut does not go deep enough, the adhesive layer will not be severed and your customer will have problems – and these problems will soon be yours, too!

Have you any queries?

If so, please contact your paper wholesaler or our Technical Marketing Department.



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