



## General Conversion Information

### Saffguard Corrugated Sheets

#### 1. **Size**

When describing sheet sizes of Saffguard we always give the across flutes dimension first, the length of the flute second.

#### 2. **Registration**

As a result of the manufacturing process by SHISH. it is not possible to guarantee square cut sheets "off the line". THE two edges that run the length of the flutes are parallel, but the cross flute edges may be up to 5mm out of square. For this reason it is important to guide the sheets into conversion equipment by means of the parallel edges. The diagram (Coming Soon) shows an exaggerated view.

Note: The full size of the sheet ordered should always come out after squaring.

#### 3. **Surface treatment (corona discharge)**

Both surfaces are treated full width to accept certain types of inks and adhesives. Some care should be taken in storage and handling to protect this treatment. Handle the sheets as little as possible and keep them well covered to prevent dust and dirt from accumulating. Dirty or finger market sheets may result in adhesion problems.

#### 4. **Temperature**

Saffguard sheets are easier to convert when at room temperature -- always allow sheets which have been at low temperatures to warm up.

#### 5. **Die Cutting:** Cutting and creasing becomes easier as the temperature increases. At very low temperatures cutting and creasing properties are severely impaired.

#### 6. **Guillotining and Die Cutting**

Saffguard can be die cut or guillotined on standard conversion equipment. Depending on the length of the cut on a guillotine (and flute direction) it may be necessary to reduce the hold down pressure to a very low setting or to block the travel to allow it to just hold. Ten to 15 sheets can be cut at a time on most equipment.

Flat bed die cutters have been very successful with Saffguard. Rotary dies may require experimentation with rule types and high durometer blankets. Unlike paperboard, twin-wall plastic sheets must be cut through. Sharp beveled rule requires less pressure for the same cut. A good make-ready that will allow even cutting at minimum pressure will extend die life noticeably. The primary cause of a dull rule on Saffguard dies is the application of excess pressure to a whole die to make a problem spot cut better. Saffguard is more resilient than paperboard and generally requires a wider than usual creasing rule for across flute creasing. The height differential between cutting and creasing rule should also be less than normally used for cardboard especially across the flutes. To "set" a crease, the two skins must crush to touch each other and then have additional pressure applied.