

SCANDIE

STEEL RULES

HIGH QUALITY FOR PROFESSIONALS



Produced with
latest technology standards.

Evolution never stops.

SCANDIE steel rules.
 A brand with outstanding possibilities.

Why you can count on us. Our main brand values.

SCANDIE is a leading manufacturer of high quality strip steel for die-making in the packaging industry and focuses on supporting customers with value effective solutions. We offer steel rules for any die-cutting operation and help diemakers and converters improve their processes in difficult applications.

Apart from our expertise in metallurgy our own inhouse Research and Development Center supports our customers in their daily business. Our experts can help to attain highest levels of rule specification, advising on key factors such as body and edge hardness, height, point size, bevel type and edge angle. SCANDIE customers will feel very confident when running jobs with complexity for various materials like laminated solid board, cigarette packs, plastics, LCD screens, gaskets or electronic media.

Quality management

SCANDIE has quality management systems approved by internationally recognized organizations. We manufacture our steel rule products in conformity with European quality standards: **EN ISO 9001:2008, EN ISO 14001:2004 and OHSAS 18001:2007.**



BEVEL TYPE

CB CENTER BEVEL	SB SIDE BEVEL	LCB LONG CENTER BEVEL	LSB LONG SIDE BEVEL

BEVEL FINISH

SHAVED EDGE		As a standard our cutting rules are supplied in shaved edge execution. These rules incorporate good bendability, high wear resistance and excellent performance for general die-cutting applications.
FINE GROUND EDGE (GF)		For successfully die-cutting tough materials, such as laminated boards and plastics (PE, PET, PVC), a sharpened cutting edge is required. Our fine ground edge is very sharp and ground to a smooth bevel finish. Offered for edge hardened products only.
BRIGHT EDGE (BX)		Bright has an extremely sharp edge and mirror-like bevel finish. It permits a clean cut at lowest pressure. Suitable for films and parts in the electronics industry. Offered for edge hardened products only.
ROBUST EDGE (RO)		The tip angle of 75° reduces the risk of cutting pressure overload, so the edge remains sharp longer and increases the rule lifetime. Offered for edge hardened products only.

Height	22 - 30 mm
Thickness	2pt, 3pt
Bevel type	CB, LCB
Edge angle	42°, 52°

NON EDGE HARDENED

	SCANDIE 400	SCANDIE 450	Suitable for short and medium die-cutting runs of solid and corrugated board. The hard body gives good stability, whilst the surface decarburization ensures excellent bendability.	
Body hardness	380 HV	450 HV		
Height	22 - 100 mm			
Thickness	2pt, 3pt, 4pt			
Bevel type	CB, SB, LCB, LSB			
Edge angle	42°, 52°			

EDGE HARDENED

The cutting edges of these rules are high frequency hardened and ensure longest lifetime in die-cutting. The soft body permits tight bends, while rules with a higher body hardness provide highest stability during die-cutting.

	SCANDIE 350 HF	SCANDIE 400 HF	SCANDIE 450 HF	SCANDIE 500 HF	
Body hardness	340 HV	380 HV	450 HV	500 HV	
Edge hardness	650 HV	650 HV	650 HV	670 HV	
Height	22 - 50 mm	22 - 50 mm	22 - 100 mm	22 - 50 mm	
Thickness	2pt, 3pt, 4pt				
Bevel type	CB, SB, LCB, LSB				
Edge angle	42°, 52°				

DEEP EDGE HARDENED

	SCANDIE 700 HFD	An extra deep hardened cutting edge improves cutting die lifetime. The medium-hard, stable body and decarburized surface give this rule a good level of bendability, so it is suitable for diecutting tough and abrasive products.	
Body hardness	400 HV		
Edge hardness	700 HV		
Hardening depth	plus 50%		
Height	22 - 50 mm		
Thickness	2pt, 3pt		
Bevel type	CB, SB, LCB, LSB		
Edge angle	42°, 52°		

LABEL RULES

For these rules the standard bevel finish is fine ground with best tip sharpness suitable for half-cutting. Offered in edge hardened versions to achieve longest lifetime and best cutting results.

	SCANDIE 350 HF	SCANDIE 400 HF	SCANDIE 450 HF
Body hardness	340 HV	380 HV	450 HV
Edge hardness	650 HV	650 HV	650 HV
Height	8 - 12 mm		
Thickness	1,3 pt (0,45 mm), 1,5 pt (0,53 mm)		
Bevel type	CB		
Edge angle	42°		

TOLERANCES

SCANDIE steel rules are 100% manufactured in AUSTRIA on state-of-the-art equipment, and in strict compliance with standards established by the European Diemaking Association (ESU).

Product Tolerances	
Height < 35 mm	+/- 0,020 mm
Height ≥ 35 mm	+/- 0,030 mm
Straightness	max. 0,5 mm / 1 m length
Camber / Dish	max 0,10% of height
Coil set	max. 5 mm / 1 m length *

* for cut lengths only

Thickness Tolerances		
Thickness mm	Thickenss pt	Tolerance in mm
0,45	1,3	+/- 0,012
0,53	1,5	+/- 0,014
0,71	2	+/- 0,015
1,05	3	+/- 0,020
1,42	4	+/- 0,028

Edge Coating

GLIDE (D)	DIAMOND (DO)
<p>This type of bevel coating is designed to reduce friction. Easy penetration allows for reduced cutting pressure and supports longer knife durability and minimized angel hair. Suitable for cutting recycled solid board and corrugated board. Available for edge-hardend products only.</p>	<p>With a coating hardness of approx 3.000 HV these cutting rules will perform best in long run jobs due to their extended durability. Suitable for long die-cutting runs on cigarette boxes and pharmaceutical packaging. Available for SCANDIE 350 HF and SCANDIE 400 HF rules.</p>

BENDABILITY

Radius R in mm	Radius R	SCANDIE 400	SCANDIE 450	SCANDIE 350 HF	SCANDIE 400 HF	SCANDIE 450 HF	SCANDIE 700 HFD	SCANDIE 350 HF FINE GROUND / BRIGHT	SCANDIE 400 HF FINE GROUND / BRIGHT	SCANDIE 450 HF FINE GROUND / BRIGHT	SCANDIE 350 / 400 HF GLIDE	SCANDIE 350 / 400 HF DIAMOND
		Radius for 1,5pt	0,35			40°	60°	80°		60°	60°	
Radius for 2pt	0,35	60°	60°	50°	80°	80°	90°	70°	80°	90°	80°	80°
Radius for 3pt	0,45	80°	80°	80°	90°	90°	90°	80°	90°	90°	90°	90°
Radius for 4pt	1,00	90°	90°	80°	90°	90°						
		non edge hardened			edge hardened			fine ground / bright			coatings	

CREASING RULES

The quality of creasing rules matters in diecutting. Best product quality in combination with tightest tolerances guarantee excellent creasing results in diecutting.		SCANDIE tempered	SCANDIE 400
	Body hardness	380 HV	380 HV
	Height	20,50 - 24,00 mm	
	Thickness	2pt, 3pt	4pt

SR SINGLE ROUND	DR DOUBLE ROUND	SRF SINGLE ROUND FINE	SH LASER CREASE SQUARE HEAD	RH LASER CREASE ROUND HEAD



PERFORATING RULES

Wide range of tooth/gap combinations in best quality for all kinds of packaging requirements.		SCANDIE 450	
	Body hardness	450 HV	
	Height	21,00 - 25,40 mm	
	Thickness	2pt, 3pt, 4pt	
	Bevel type	CB	
Spacing	Tooth / Gap		

CUT-CREASE RULES

With top quality machined crease sections. Available in numerous configurations to support easy folding in solid board diecutting.		SCANDIE 450	
	Body hardness	450 HV	
	Height	Cutting height Creasing height	
	Thickness	2pt, 3pt, 4pt	
	Bevel type	CB	
Spacing	Tooth / Gap		

ZIPPER RULES

The ideal solution for shelf ready packaging.		SCANDIE 450	
	Body hardness	450 HV	
	Height	22,00 - 25,40 mm	
	Thickness	2pt, 3pt	
	Bevel type	CB	
Tooth spacing	6 - 12 mm		

STRIPPING RULES

The best option for ejecting waste after the diecutting process.		SCANDIE 400	
	Body hardness	380 HV	
	Height	30 - 55 mm	
	Executions	<ul style="list-style-type: none"> • standard, flat • waved • flat with teeth 	

PACKAGING

Forms of Delivery

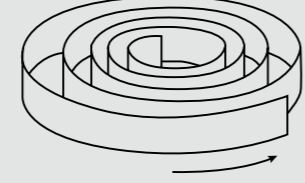
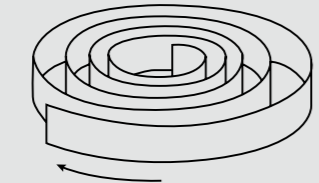
SCANDIE steel rules are packed in suitable corrugated boxes for straight lengths and coils, for easy use and safe transport and storage. In addition, the steel rules are wrapped in anti-corrosion paper to prevent rusting. The standard for cut lengths is 1 meter.

Please see pack quantities for coils and lengths in the table below.



Thickness pt	1,3 / 1,5	1,3 / 1,5	2	2	3	3	4	4
Height mm	Coils	Lengths	Coils	Lengths	Coils	Lengths	Coils	Lengths
<= 23,80	100 m	100 m	100 m	100 m	60 m	60 m	50 m	50 m
30,00			100 m	35 m	60 m	25 m	50 m	17 m
31,75			100 m	35 m	60 m	25 m	50 m	17 m
32,00			100 m	35 m	60 m	25 m	50 m	17 m
38,10			100 m	35 m	60 m	25 m	50 m	17 m
40,00			100 m	35 m	60 m	25 m	50 m	17 m
50,00			100 m	35 m	50 m	25 m	50 m	17 m
60,00					50 m	25 m	25 m	17 m
70,00					25 m	25 m	25 m	17 m
80,00					25 m	25 m	25 m	17 m
100,00					25 m	25 m	25 m	17 m

Coils are available in clockwise and anti-clockwise direction.



LABELING

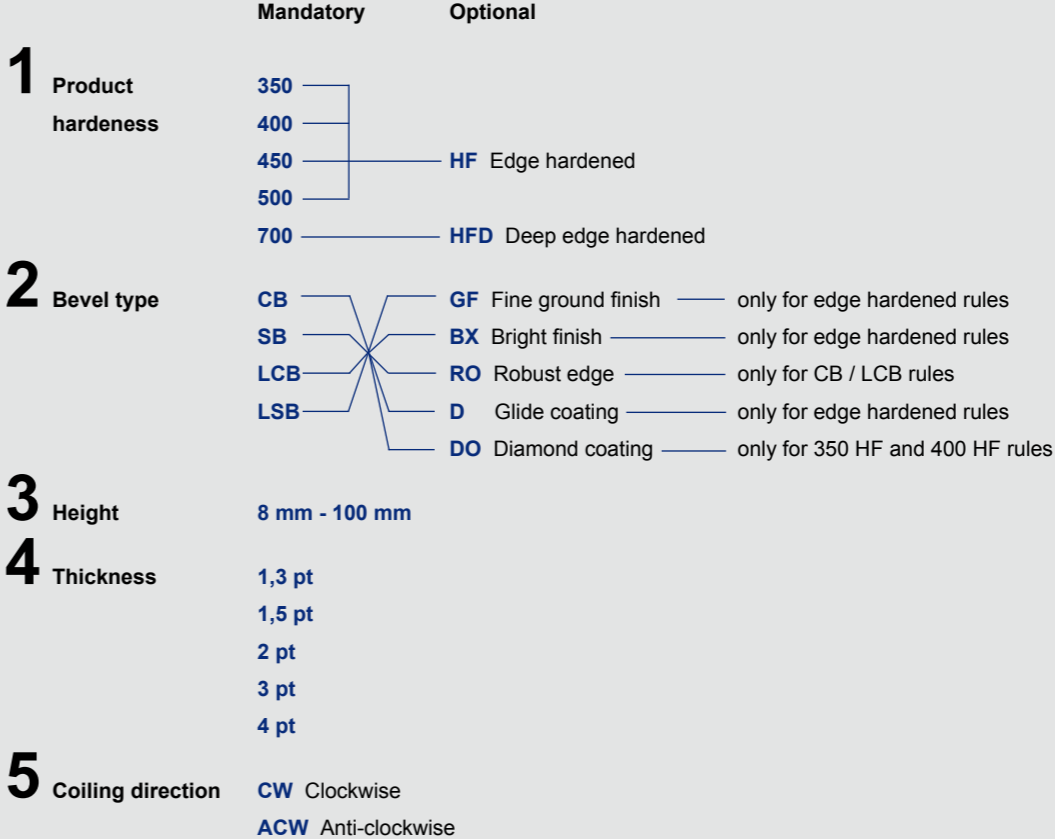


Box label



Printing on steel rule via inkjet

PRODUCT CODE - CUTTING RULES



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STEEL RULES

HIGH QUALITY FOR PROFESSIONALS



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