

# TECHNICAL BULLETIN

## PRESSURE SENSITIVE CUTTING RECOMMENDATIONS

### Knives

Many printers use a standard single bevel knife at 22° for guillotining. For pressure sensitive constructions, we recommend newly ground knives of high quality steel that are double beveled. A primary bevel of 24° or 26° with 1/8" width and a secondary bevel of 22° to 24° are a good starting combination.

Nicks in the knife or dull knives cause loose or detached fibers on the cutting edge of the stock. These particles can then be carried to the center of the sheet during printing causing quality problems. Be sure to check sharpness of the blades before starting cutting.

### Cutting

- Keep clamp pressure at a minimum – around 25 to 35 psi should be sufficient.
- Keep lifts at a minimum – 1 to 2 inches maximum.
- Cut through the back of the stock with the face down. This allows the knife to contact the liner and release, then the adhesive and face stock.
- Use chipboard on top and bottom when cutting.
- Wipe (not spray) a silicone substitute on the knife to prevent adhesive build-up. Be careful not to use large amounts or spray directly on the knife.
- Make certain stock is not exposed to extreme changes of moisture and temperature. Let stock acclimate to press room conditions prior to cutting.
- If some adhesive particles remain on the edges after cutting, take a same piece of pressure sensitive adhesive and simply blot or wipe the edges clean.

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