

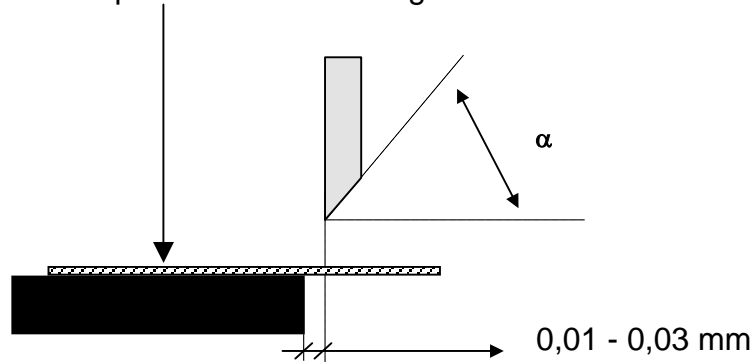
## Veralite® - Shearing and diecutting

### 1) Shearing :

Shearing possible up to :      1,0 mm for Veralite 100  
    1,5 mm for Veralite 200

Shearing angle $\alpha$	max 45°
Distance shearing-knife/table	0,01 - 0,03 mm

The sheet needs to be well clamped !! Stack-shearing is not recommended.



Always shear opposite to the extrusion direction.

Keep the clamping force as high as possible, to avoid vibrations in the pile of sheets.

Do not shear the sheets at temperatures lower than 15° C, it is always advised to do this at room temperatures (23°).

If shearing very small parts, be sure the length of the parts to be sheared is at least half of the length of the shearing knife (to avoid tension build up).

It is advised to shear the sheets always with the printed film facing the knife (topside).

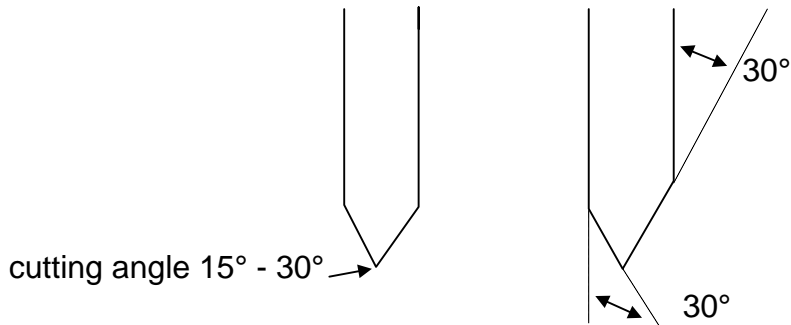
It is also important to have a nice equal adhesion of the film on the sheet, before shearing.

The pile of sheets to be sheared should be kept lower than 10mm height to obtain the best result.

## 2) Diecutting :

Veralite® can be diecut with steel rule dies. The steel rules must be sharp. If not, they have to be replaced or sharpened.

Advised thickness of steel ribbons	0,8 - 2,5 mm
Cutting angle (sharpened on one edge)	15° - 30°



Diecutting presses have to be programmed to cut completely through the Veralite® sheet with a stroke that will prevent damaging the cutting rule. Proper testing is advised before starting production.

The thickness of sheet that can be diecut varies on type of sheet and type of diecutting method used :

	Veralite® 100	Veralite® 200
Pneumatic diecutting	2,0 mm	3,0 mm
Table diecutting	not advised	2,0 mm

For diecutting of thicker sheet, please do appropriate testing.

Diecutting of printed sheets is more critical, and is preferably done with the printed side facing the cutting knives.

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*All above information is based on current knowledge and experience. The data does not imply any warranty from the manufacturer towards third parties. Users should consider the above data as a guideline and gather additional information, to make independant decisions regarding the proper use, disposal, safety towards other parties and the protection of the environment.*

*For more specific information, please feel free to contact our technical department :*

**I.P.B. nv**

**Steenovenstraat 30**

**8790 Waregem**

**BELGIUM**

**Tel.+32.56.60.79.19**

**Fax +32.56.61.08.85**