

# Paper Cutting Guide

In the lists below, we have tried to compile the most common cutting material alphabetically. In order to make this list more clear, we have divided it in two groups. All values indicated in this list are based on our experience, which we have with high speed paper guillotines. The values for the clamping pressure refer to a pile of paper of medium height and more than 2/3 of the total cutting width of the guillotine. Higher and wider piles of paper need a higher pressure. Lower and narrower piles of paper need less pressure. Delicate materials (thin, soft) need a normal false clamp. Material which is unequal in height or wavy (cardboard, stritched brochures) have to be cut with a flexible false clamp (special device).

# Cutting Paper

Material	Knife	xx	xx	h (mm)	pressure in kg	Remarks
absorbent paper	standard	19			3000	false clamp
art paper	HSS	22	24	3.5	2500	
bible paper	standard	22			1000 - 1500	false clamp
blotting paper	standard	19			1500 - 2000	false clamp
carbon paper	standard	19			400	
copying paper	standard	19			3000 - 4000	false clamp
duplex paper	HSS	22	24	3.5	2500	
felt paper	standard	22			1500 - 2000	false clamp
grease proof paper	HSS	22	24	3.5	2500	flexible false clamp
gummed paper	HSS	22	24	3.5	2500	
imitation parchment	HSS	24			3000 - 4000	
label paper	HSS	22	24	3.5	2500	
metal paper	HSS	22	24	3.5	3000	
NCR - Reacto-paper	standard	19			200	false clamp
parchment paper	HSS	22	24	3.5	2500	false clamp
photo paper	HSS	24			2000 - 2500	
printing paper normal	standard	22			2000	
security printing (money, shares, etc.)	HSS	22			2500	
silk paper	standard	19			2000	false clamp
transparent paper	HSS	24			3000	
velour paper	standard	19			15000	false clamp
writing papers	standard	22			2000 - 2500	

## Cutting Cardboard / Card Stock

Material	Knife	xx	xx	h (mm)	pressure in kg	Remarks
bristol board	HSS	21	23	3.5	1500	flexible
carton board	HSS	22			2500	false clamp
Chromolux	HSS	22	24	3.5	1500 - 2000	
Duplex board	HSS	24			2500	false clamp
felt board	standard	22			1500 - 2000	flexible
fibre board	HSS	25			3000	false clamp
file board	HSS	22			2500	
Finnboard	HSS	19	22	3.5	2000	false clamp
grey board	standard	22			2500	flexible false clamp
leather board	HSS	22	24	3.5	2500	flexible false clamp
manila board	HSS	24			3000	
multiplex board	HSS	22	24	3.5	2000	
post cards	standard	22			2500	
Straw board	HSS	22			2500	false clamp
triplex board	HSS	22	24	3.5	2000	
wood cardboard soft	HSS	22			2500	false clamp