

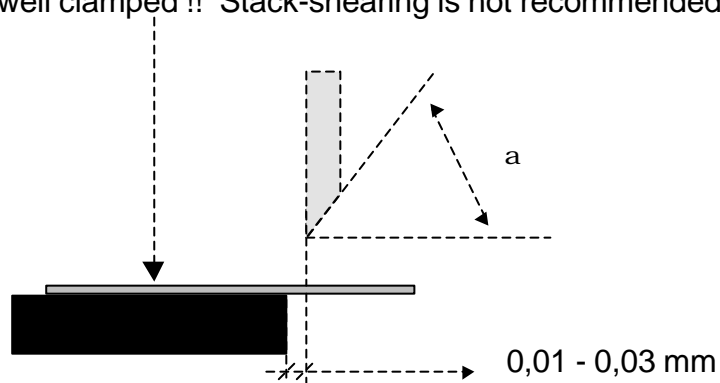
## Veralite® - Shearing and diecutting

### 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

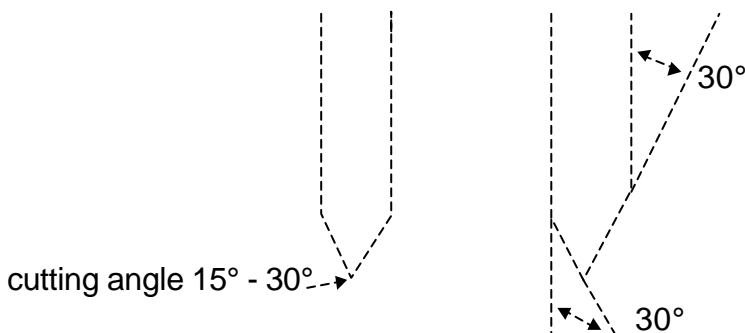
The sheet needs to be well clamped !! Stack-shearing is not recommended.



### 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 <sup>o</sup> 100	Veralite <sup>o</sup> 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.

---

*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**