

# ORIGINAL STEEL BASED MATRIX

YOUR SIMPLE GUIDE TO  
CHOOSING YOUR MATRIX

BASED ON 23.80mm CUTTING RULE HEIGHT  
& 0.1mm THIN FILM BASE MATRIX

Measure your board thickness

$D = \text{[ ] mm}$   
(100µm = 0.1mm)

1

Work out your  
Creasing Rule height

$B = 23.80 - \text{[ ]} - 0.1$   
 $B = \text{[ ] mm}$

2

The height of the Matrix is  
equal to the depth of the board

Height =  $\text{[ ] mm}$

3

Calculate the channel width  
using a 0.7mm, 2pt rule

$1.5 \times \text{[ ]} + 0.7$   
 $= \text{[ ] mm}$

4

for < 600 microns x 1.5  
for > 600 microns x 2.0

My matrix size is:

Height =  $\text{[ ] mm}$   
Width =  $\text{[ ] mm}$

5

Your local distributor is:



Manufactured under a quality system certified as complying with ISO 9001 by an accredited certification body.

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MAK156/06/11

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[www.channel-matrix.com](http://www.channel-matrix.com)



# C&T CHANNEL

## ORIGINAL STEEL BASED MATRIX

THE WORLD'S MOST  
ADVANCED CREASING  
MAKE-READY SYSTEM

[www.channel-matrix.com](http://www.channel-matrix.com)

# ORIGINAL

## STEEL BASED MATRIX

**CENTRED**

Color	Caliper	Distance	Height
Gold	0.38 *	0.56	1/1.5
Orange	0.38 *	0.8	2/3
Buff	0.38 *	1.0	2/3
Cloud	0.38 *	1.3	2/3
White	0.43 *	1.3	2/3
Sky	0.45 *	1.4	2/3
Lime	0.43 *	1.5	2/3
Yellow	0.48 *	1.5	2/3
Violet	0.48 *	1.7	2/3
Mauve	0.53 *	1.7	2/3
Olive	0.53 *	1.9	2/3
Green	0.58 *	1.9	2/3
Pink	0.58 *	2.1	2/3
Maroon	0.63 *	2.1	2/3
Red	0.68 *	2.3	2/3
Blue	0.79 *	2.7	2/3
Brown	1.0 ▲	3.0	3/4/6
Grey	1.3 ▲	3.8	3/4/6
Black	1.6 ▲	5.0	3/4/6
Cream	2.0 ▲	6.3	3/4/6

**OFF CENTRE**

Color	Caliper	Distance	Height
Orange	0.38 *	0.8	2/3
Buff	0.38 *	1.0	2/3
White	0.43 *	1.3	2/3
Sky	0.45 *	1.4	2/3
Lime	0.43 *	1.5	2/3
Yellow	0.48 *	1.5	2/3

**MULTI CREASE**

Color	Caliper	Distance	Height
3.00	0.38 ▲	1.0	2/3
3.50	0.38 ▲	1.0	2/3
4.00	0.38 ▲	1.0	2/3
5.00	0.38 ▲	1.0	2/3
3.00	0.43 ▲	1.3	2/3
3.50	0.43 ▲	1.3	2/3
4.00	0.43 ▲	1.3	2/3
5.00	0.43 ▲	1.3	2/3
3.00	0.48 ▲	1.5	2/3
3.50	0.48 ▲	1.5	2/3
4.00	0.48 ▲	1.5	2/3
5.00	0.48 ▲	1.5	2/3

**EXTRA DEEP**

Color	Caliper	Distance	Height
Black	0.55 *	1.30	2/3
Brown	0.70 *	1.50	2/3
Grey	0.80 *	1.90	2/3
Orange	0.90 *	2.30	2/3
Yellow	1.30 ▲	3.00	3/4/6
Green	1.60 ▲	3.80	3/4/6
Red	2.00 ▲	5.00	3/4/6

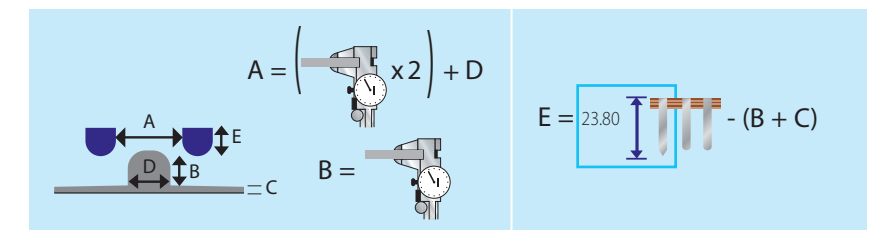
### KEY

- ★ < 7mm base / 24 metres per box
- < 9.5mm base / 18 metres per box
- ▲ < 12mm base / 12 metres per box

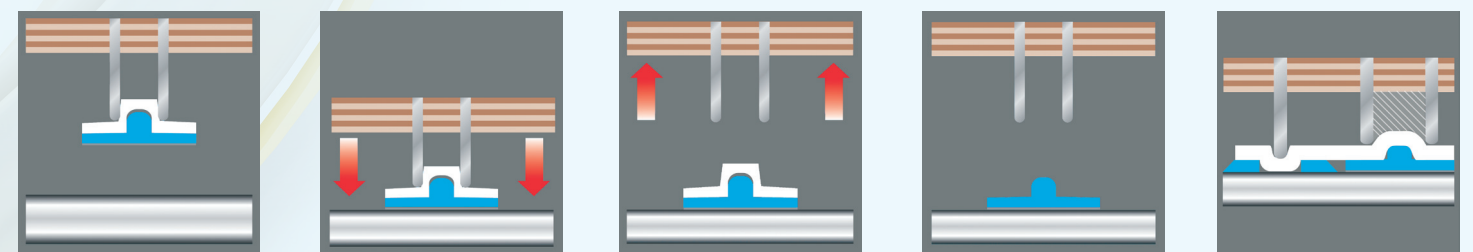
## REVERSE BEND

The reverse bend matrix can be used where creasing on both sides of the board is required. In this application, the two creasing rules are inserted in the die to form the channel and the ridge on the matrix which acts as a creasing rule.

Color	CALIPER	DISTANCE BETWEEN CREAMING RULE	HEIGHT OF NIB	BASE THICKNESS	WIDTH OF NIB	CREASING RULE HEIGHT
RB1 Red	300-550 ▲	2.0	0.5	0.3	0.7	23.00
RB2 Yellow	550-750 ▲	2.7	0.7	0.3	1.0	22.80
RB3 Buff	750 - 1000 ▲	4.0	0.9	0.3	1.5	22.60
RB4 Green	1000-1300 ▲	4.5	1.1	0.3	2.0	22.40
RB5 Blue	1300-1600 ▲	5.0	1.3	0.3	2.0	22.00
RB6 Violet	1600 - 2000 ▲	6.0	1.8	0.3	3.0	21.7



## SELF LOCATING



- 1 APPLY CUT LENGTHS OF CHANNEL REVERSE BEND TO THE GAP BETWEEN THE CREAMING RULES AND REMOVE THE BACKING TAPE
- 2 OPERATE THE PRESS FOR ONE COMPLETE CYCLE TO FIX MATRIX TO THE CUTTING PLATE
- 3 AT THE END OF THE CYCLE, THE CREAMING RULES EXTRACT THEMSELVES FROM THE MATRIX LOCATOR
- 4 PEEL OFF THE LOCATOR STRIP TO REVEAL THE MATRIX IN EXACT REGISTER FOR A PERFECT REVERSE BEND
- 5 REVERSE BEND IS USED FOR CREAMING BOARD FROM BOTH SIDES IN ONE PASS

\*AFTER REMOVAL OF LOCATOR, A SAFE EJECTOR RUBBER OR SPONGE MAY BE REQUIRED TO PREVENT CRACKING.