

Title (en)

Process for manufacturing a counter-die for blanking cardboard

Title (de)

Verfahren zur Herstellung einer Gegenmatritze für das Zuschneiden von Karton

Title (fr)

Procédé pour la manufacture d'une contre matrice pour la coupe de carton

Publication

**EP 2036659 B1 20101201 (EN)**

Application

**EP 07425562 A 20070912**

Priority

EP 07425562 A 20070912

Abstract (en)

[origin: EP2036659A1] The present invention concerns a method for the set-up of a counter-die, which can be combined with the die of equipment for die-cutting/crease of sheets made of cardboard or card, for example. The method comprises the phases of preparing a supporting plate and at least one insert made of a hard material which can be fixed to the surface of the plate and obtaining one or more grooves on the surface of each insert. Each insert has the function of accommodating at least partly a corresponding blade of the die at the level of a cutting or perforating line of the relative blank. Unlike the traditional solutions, the phase of obtaining the grooves on the insert is performed subsequently to fixing of the insert to the supporting plate of the counter-die and not before fixing of the insert to the plate. Machining of the grooves is performed by computer numeric control (CNC) machines on the basis of geometric references present on the supporting plate.

IPC 8 full level

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CPC (source: EP)

**B26F 1/44** (2013.01); **B26F 2001/4445** (2013.01)

Cited by

DE102008034764A1; ITUA20163721A1; US2019294145A1; CN108237581A; US9102818B2; WO2017203373A1; US10816956B2; US8708881B2; US8777828B2; US11447631B2

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