

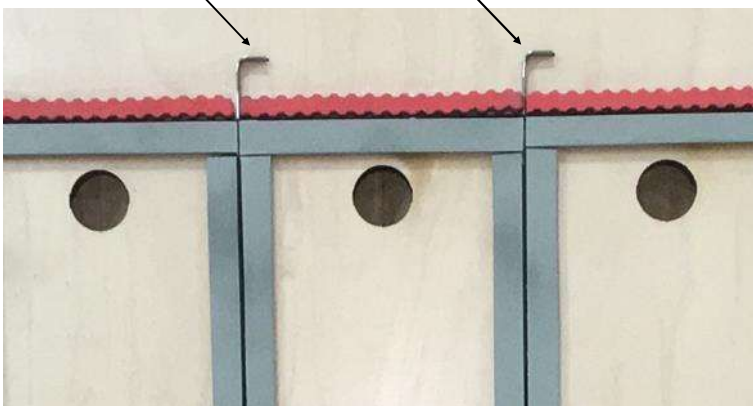
Waste Design & Breaker Knife

One of the key areas to building a successful Baysek cutting die is to pay particular attention to how the waste areas of the substrate will be ejected and extracted up into the waste hood of the machine. Larger areas of waste near the lead edge of each part should be allowed to be connected to smaller areas of waste to aid in extracting the smaller areas out.

General Rules:

- Less is better, the waste extraction process works best with large pieces of waste connected to smaller areas of waste. If the substrate waste board thickness allows it to bend or fold up when it passes under the waste removal hood it will be extracted from the die. If the board thickness does not allow it to bend or fold up under the waste removal hood, then scrap breaker knives will be required.
- Scrap breaker dimensions by substrate thickness: (for waste wider than 3/4" across the machine)
 - Single wall, E & F flutes seldom require any scrap breakers.
 - Single wall, B & C flutes if required at 4.00" (102mm) intervals in the through direction, and at 15.00" (381mm) intervals going across the cutting die.
 - Double wall, if required at 4.00" (102mm) intervals in the through direction, and at 10.00" (254mm) intervals going across the die.
- Rule Supports

These are NOT scrap breakers



Note: Rule supports can be added to the trail edge knife to stiffen its construction, and prevent tagging of finished parts caused by separation at the joint. Part design and material may create need to add rule supports on lead edge.