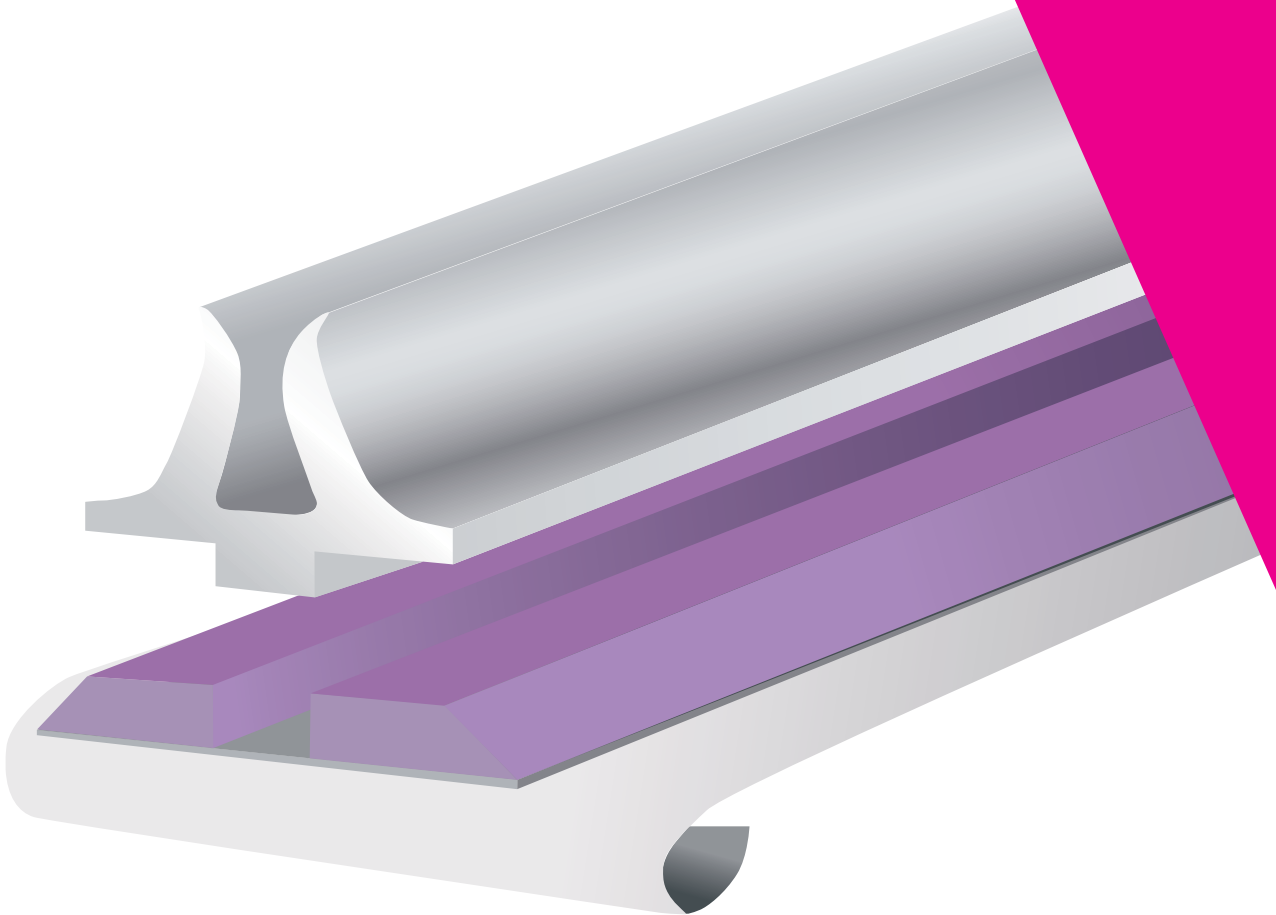


# CHANNEL

THE WORLD'S MOST  
ADVANCED CREASING  
MAKE-READY SYSTEM

## XTC

SYNTHETIC MATRIX



## STANDARD MATRIX

0.3	0.6	2/3	150 mic
0.3	0.8	2/3	
0.3	1.0	2/3	
0.3	1.1	2/3	
0.3	1.2	2/3	
0.3	1.3	2/3	to
0.3	1.4	2/3	
0.3	1.5	2/3	
0.3	1.6	2/3	
0.3	1.7	2/3	
0.3	1.9	2/3	350 mic
0.4	0.6	2/3	350 mic
0.4	0.8	2/3	
0.4	1.0	2/3	
0.4	1.1	2/3	
0.4	1.2	2/3	
0.4	1.3	2/3	to
0.4	1.4	2/3	
0.4	1.5	2/3	
0.4	1.6	2/3	
0.4	1.7	2/3	
0.4	1.9	2/3	450 mic
0.45	0.8	2/3	400 mic
0.45	1.0	2/3	
0.45	1.1	2/3	
0.45	1.2	2/3	
0.45	1.3	2/3	to
0.45	1.4	2/3	
0.45	1.5	2/3	
0.45	1.6	2/3	
0.45	1.7	2/3	
0.45	1.9	2/3	500 mic
0.5	0.8	2/3	450 mic
0.5	1.0	2/3	
0.5	1.1	2/3	
0.5	1.2	2/3	
0.5	1.3	2/3	
0.5	1.4	2/3	
0.5	1.5	2/3	to
0.5	1.6	2/3	
0.5	1.7	2/3	
0.5	1.9	2/3	
0.5	2.1	2/3	
0.5	2.3	2/3	550 mic
0.55	0.8	2/3	500 mic
0.55	1.0	2/3	
0.55	1.2	2/3	
0.55	1.3	2/3	
0.55	1.4	2/3	
0.55	1.5	2/3	to
0.55	1.6	2/3	
0.55	1.7	2/3	
0.55	1.9	2/3	
0.55	2.1	2/3	
0.55	2.3	2/3	600 mic

0.6	1.0	2/3	550 mic
0.6	1.1	2/3	
0.6	1.2	2/3	
0.6	1.3	2/3	
0.6	1.4	2/3	
0.6	1.5	2/3	
0.6	1.6	2/3	to
0.6	1.7	2/3	
0.6	1.9	2/3	
0.6	2.1	2/3	
0.6	2.3	2/3	
0.6	2.5	2/3	
0.6	2.7	2/3	
0.6	3.0	2/3	
0.6	3.2	3/4	
0.6	3.5	3/4	
0.6	4.0	3/4	
0.6	5.0	3/4	
0.6	6.0	3/4	
0.6	7.0	3/4	
0.6	8.0	3/4	650 mic
0.65	1.3	2/3	600 mic
0.65	1.4	2/3	
0.65	1.5	2/3	
0.65	1.6	2/3	
0.65	1.7	2/3	
0.65	1.9	2/3	
0.65	2.1	2/3	
0.65	2.3	2/3	
0.65	2.5	2/3	to
0.65	2.7	2/3	
0.65	3.0	2/3	
0.65	3.2	3/4	
0.65	3.5	3/4	
0.65	4.0	3/4	
0.65	4.5	3/4	
0.65	5.0	3/4	
0.65	6.0	3/4	
0.65	7.0	3/4	
0.65	8.0	3/4	700 mic
0.7	1.3	2/3	650 mic
0.7	1.4	2/3	
0.7	1.5	2/3	
0.7	1.6	2/3	
0.7	1.7	2/3	(+ Microflute and E flute)
0.7	1.9	2/3	
0.7	2.1	2/3	
0.7	2.3	2/3	
0.7	2.5	2/3	
0.7	2.7	2/3	
0.7	3.0	2/3	
0.7	3.2	3/4	to
0.7	3.5	3/4	
0.7	4.0	3/4	
0.7	4.5	3/4	
0.7	5.0	3/4	
0.7	6.0	3/4	
0.7	7.0	3/4	
0.7	8.0	3/4	750 mic

0.8	1.5	2/3	750 mic
0.8	1.6	2/3	
0.8	1.7	2/3	
0.8	1.9	2/3	
0.8	2.1	2/3	(+ E flute and B flute)
0.8	2.3	2/3	
0.8	2.5	2/3	
0.8	2.7	2/3	
0.8	3.0	2/3	
0.8	3.2	3/4	
0.8	3.5	3/4	
0.8	4.0	3/4	to
0.8	4.5	3/4	
0.8	5.0	3/4	
0.8	6.0	3/4	
0.8	7.0	3/4	
0.8	8.0	3/4	900 mic
1.0	2.3	2/3	900 mic
1.0	2.5	2/3	
1.0	2.7	2/3	
1.0	3.0	2/3	(+ B flute and C flute)
1.0	3.2	3/4	
1.0	3.5	3/4	
1.0	4.0	3/4	
1.0	4.5	3/4	
1.0	5.0	3/4	to
1.0	6.0	3/4	
1.0	7.0	3/4	
1.0	8.0	3/4	1100 mic
1.2	3.0	3/4	1100 mic
1.2	3.2	3/4	
1.2	3.5	3/4	(+ B flute and C flute)
1.2	4.0	3/4	
1.2	4.5	3/4	
1.2	5.0	3/4	
1.2	6.0	3/4	to
1.2	7.0	3/4	
1.2	8.0	3/4	1300 mic
1.4	3.0	3/4	1300 mic
1.4	3.2	3/4	
1.4	3.5	3/4	
1.4	4.0	4/6	(+ C flute)
1.4	4.5	4/6	
1.4	5.0	4/6	
1.4	6.0	4/6	to
1.4	7.0	4/6	
1.4	8.0	4/6	1500 mic
1.6	3.0	3/4	1500 mic
1.6	3.2	3/4	
1.6	3.5	3/4	
1.6	4.0	4/6	
1.6	4.5	4/6	(+ C flute)
1.6	5.0	4/6	
1.6	6.0	4/6	to
1.6	7.0	4/6	
1.6	8.0	4/6	1700 mic

## U BEND

0.6	5.0	3	550 mic to
0.6	8.0	5	650 mic
0.7	5.0	3	650 mic to
0.7	8.0	5	750 mic
0.8	5.0	3	750 mic
0.8	5.0	3.7	
0.8	5.0	4	to
0.8	6.0	5	
0.8	7.0	5	900 mic
1.0	5.0	3	900 mic to
1.0	6.0	5	
1.0	8.0	7	1100 mic

## MULTICREASE

0.4	1.0	3.0	350 mic
0.4	1.0	4.75	
0.4	1.2	4.0	
0.4	1.3	3.5	to
0.4	1.3	4.0	
0.4	1.3	5.0	
0.4	1.3	6.35	
0.4	1.5	6.35	450 mic
0.45	1.3	3.5	450 mic to
0.45	1.3	4.0	
0.45	1.3	5.0	500 mic
0.5	1.0	3.0	450 mic
0.5	1.0	4.75	
0.5	1.2	4.0	
0.5	1.3	3.5	to
0.5	1.3	4.0	
0.5	1.3	5.0	
0.5	1.3	6.35	
0.5	1.5	6.35	550 mic

## STANDARD LOCATOR SIZES

Any size matrix is available with any size locator but must be indicated at the time of ordering.

Guidance to usage given in this publication is based on the detailed experience of our technical department, but cannot be guaranteed. Customers should consider board density, coatings, etc. and assure themselves as to the suitability of products for a particular purpose.

## OFF CENTRE

				Min Centre Off Centre
0.3	0.6	2/3	150 mic	4 mm
0.3	0.8	2/3		4 mm
0.3	1.0	2/3		4 mm
0.3	1.1	2/3		4 mm
0.3	1.2	2/3		4 mm
0.3	1.3	2/3	to	4 mm
0.3	1.4	2/3		4 mm
0.3	1.5	2/3		4 mm
0.3	1.6	2/3		5 mm
0.3	1.7	2/3		5 mm
0.3	1.9	2/3	350 mic	5 mm
0.4	0.6	2/3	350 mic	4 mm
0.4	0.8	2/3		4 mm
0.4	1.0	2/3		4 mm
0.4	1.1	2/3		4 mm
0.4	1.2	2/3		4 mm
0.4	1.3	2/3	to	4 mm
0.4	1.4	2/3		4 mm
0.4	1.5	2/3		4 mm
0.4	1.6	2/3		5 mm
0.4	1.7	2/3		5 mm
0.4	1.9	2/3	450 mic	5 mm
0.45	0.8	2/3	400 mic	4 mm
0.45	1.0	2/3		4 mm
0.45	1.1	2/3		4 mm
0.45	1.2	2/3		4 mm
0.45	1.3	2/3	to	4 mm
0.45	1.4	2/3		4 mm
0.45	1.5	2/3		4 mm
0.45	1.6	2/3		5 mm
0.45	1.7	2/3		5 mm
0.45	1.9	2/3	500 mic	5 mm
0.5	0.8	2/3	450 mic	4 mm
0.5	1.0	2/3		4 mm
0.5	1.1	2/3		4 mm
0.5	1.2	2/3		4 mm
0.5	1.3	2/3		4 mm
0.5	1.4	2/3		4 mm
0.5	1.5	2/3	to	4 mm
0.5	1.6	2/3		5 mm
0.5	1.7	2/3		5 mm

				Min Centre Off Centre
0.5	1.9	2/3		5 mm
0.5	2.1	2/3		5 mm
0.5	2.3	2/3	550 mic	5 mm
0.55	0.8	2/3	500 mic	4 mm
0.55	1.0	2/3		4 mm
0.55	1.2	2/3		4 mm
0.55	1.3	2/3		4 mm
0.55	1.4	2/3		4 mm
0.55	1.5	2/3	to	4 mm
0.55	1.6	2/3		5 mm
0.55	1.7	2/3		5 mm
0.55	1.9	2/3		5 mm
0.55	2.1	2/3		5 mm
0.55	2.3	2/3	600 mic	5 mm
0.6	1.0	2/3	550 mic	4 mm
0.6	1.1	2/3		4 mm
0.6	1.2	2/3		4 mm
0.6	1.3	2/3		4 mm
0.6	1.4	2/3		4 mm
0.6	1.5	2/3		4 mm
0.6	1.6	2/3	to	5 mm
0.6	1.7	2/3		5 mm
0.6	1.9	2/3		5 mm
0.6	2.1	2/3		5 mm
0.6	2.3	2/3		5 mm
0.6	2.5	2/3		5 mm
0.6	2.7	2/3		6 mm
0.6	3.0	2/3	650 mic	6 mm
0.65	1.3	2/3	600 mic	4 mm
0.65	1.4	2/3		4 mm
0.65	1.5	2/3		4 mm
0.65	1.6	2/3		5 mm
0.65	1.7	2/3		5 mm
0.65	1.9	2/3	to	5 mm
0.65	2.1	2/3		5 mm
0.65	2.3	2/3		5 mm
0.65	2.5	2/3		5 mm
0.65	2.7	2/3		6 mm
0.65	3.0	2/3	700 mic	6 mm

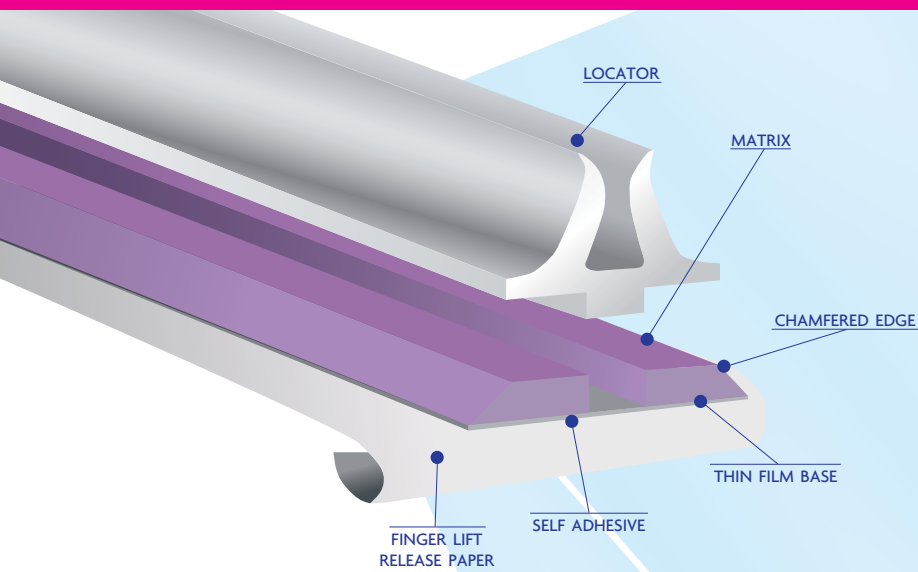
				Min Centre Off Centre
0.7	1.3	2/3	650 mic	4 mm
0.7	1.4	2/3		4 mm
0.7	1.5	2/3		4 mm
0.7	1.6	2/3		5 mm
0.7	1.7	2/3		5 mm
0.7	1.9	2/3	(+ Microflute and E flute)	5 mm
0.7	2.1	2/3		5 mm
0.7	2.3	2/3	to	5 mm
0.7	2.5	2/3		5 mm
0.7	2.7	2/3		6 mm
0.7	3.0	2/3	750 mic	6 mm
0.8	1.5	2/3	750 mic	4 mm
0.8	1.6	2/3		5 mm
0.8	1.7	2/3		5 mm
0.8	1.9	2/3	(+ E flute and B flute)	5 mm
0.8	2.1	2/3		5 mm
0.8	2.3	2/3		5 mm
0.8	2.5	2/3		5 mm
0.8	2.7	2/3	to	6 mm
0.8	3.0	2/3	900 mic	6 mm
1.0	2.3	2/3	900 mic	5 mm
1.0	2.5	2/3		5 mm
1.0	2.7	2/3		6 mm
1.0	3.0	2/3	to	6 mm
1.0	3.5	3/4		6 mm
1.0	4.0	3/4		7 mm
1.0	5.0	3/4		8 mm
1.0	6.0	3/4	1100 mic	9 mm
1.2	3.2	3/4	1100 mic	6 mm
1.2	3.5	3/4		6 mm
1.2	4.0	3/4		7 mm
1.2	4.5	3/4	to	7 mm
1.2	6.0	3/4		9 mm
1.2	8.0	3/4	1300 mic	11 mm
1.4	3.0	3/4	1300 mic to	6 mm
1.4	5.0	4/6	1500 mic	8 mm
1.6	4.0	4/6	1500 mic to	7 mm
1.6	5.0	4/6	1700 mic	8 mm

## INTERNAL CHAMFER

				Min Centre Off Centre
0.3	1.3	2/3	150 mic	
0.3	1.4	2/3		
0.3	1.5	2/3	to	
0.3	1.6	2/3		
0.3	1.7	2/3		
0.3	1.9	2/3	350 mic	
0.4	1.3	2/3	350 mic	
0.4	1.4	2/3		
0.4	1.5	2/3	to	
0.4	1.6	2/3		
0.4	1.7	2/3		
0.4	1.9	2/3	450 mic	
0.45	1.3	2/3	400 mic	
0.45	1.4	2/3		
0.45	1.5	2/3		
0.45	1.6	2/3	to	
0.45	1.7	2/3		
0.45	1.9	2/3	500 mic	
0.5	1.3	2/3	450 mic	
0.5	1.4	2/3		
0.5	1.5	2/3		
0.5	1.6	2/3	to	
0.5	1.7	2/3		
0.5	1.9	2/3		
0.5	2.1	2/3		
0.5	2.3	2/3	550 mic	
0.55	1.3	2/3	500 mic	
0.55	1.4	2/3		
0.55	1.5	2/3	to	
0.55	1.6	2/3		
0.55	1.7	2/3		
0.55	1.9	2/3		
0.55	2.1	2/3		
0.55	2.3	2/3	600 mic	
0.6	1.3	2/3	550 mic	
0.6	1.4	2/3		
0.6	1.5	2/3		
0.6	1.6	2/3		
0.6	1.7	2/3		
0.6	1.9	2/3		
0.6	2.1	2/3		
0.6	2.3	2/3	to	
0.6	2.5	2/3		
0.6	2.7	2/3		
0.6	3.0	2/3		
0.6	3.2	3/4		
0.6	3.5	3/4		
0.6	4.0	3/4		
0.6	5.0	3/4		
0.6	6.0	3/4		
0.6	7.0	3/4		
0.6	8.0	3/4	650 mic	

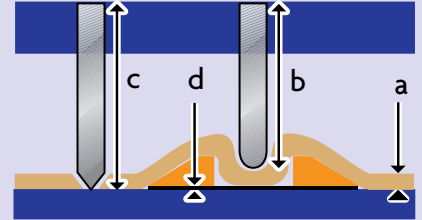
				Min Centre Off Centre
0.65	1.3	2/3	600 mic	
0.65	1.4	2/3		
0.65	1.5	2/3		
0.65	1.6	2/3		
0.65	1.7	2/3		
0.65	1.9	2/3		
0.65	2.1	2/3		
0.65	2.3	2/3		
0.65	2.5	2/3	to	
0.65	2.7	2/3		
0.65	3.0	2/3		
0.65	3.2	3/4		
0.65	3.5	3/4		
0.65	4.0	3/4		
0.65	4.5	3/4		
0.65	5.0	3/4		
0.65	6.0	3/4		
0.65	7.0	3/4		
0.65	8.0	3/4	700 mic	
0.7	1.3	2/3	650 mic	
0.7	1.4	2/3		
0.7	1.5	2/3		
0.7	1.6	2/3		
0.7	1.7	2/3		
0.7	1.9	2/3	(+ Microflute and E flute)	
0.7	2.1	2/3		
0.7	2.3	2/3		
0.7	2.5	2/3		
0.7	2.7	2/3		
0.7	3.0	2/3		
0.7	3.2	3/4	to	
0.7	3.5	3/4		
0.7	4.0	3/4		
0.7	4.5	3/4		
0.7	5.0	3/4		
0.7	6.0	3/4		
0.7	7.0	3/4		
0.7	8.0	3/4	750 mic	
0.8	1.5	2/3	750 mic	
0.8	1.6	2/3		
0.8	1.7	2/3		
0.8	1.9	2/3		
0.8	2.1	2/3		
0.8	2.3	2/3	(+ E flute and B flute)	
0.8	2.5	2/3		
0.8	2.7	2/3		
0.8	3.0	2/3		
0.8	3.2	3/4		
0.8	3.5	3/4		
0.8	4.0	3/4	to	
0.8	4.5	3/4		
0.8	5.0	3/4		
0.8	6.0	3/4		

				Min Centre Off Centre
0.8	7.0	3/4		
0.8	8.0	3/4	900 mic	
1.0	2.3	2/3	900 mic	
1.0	2.5	2/3		
1.0	2.7	2/3		
1.0	3.0	2/3		
1.0	3.2	3/4	(+ B Microflute and C flute)	
1.0	3.5	3/4		
1.0	4.0	3/4		
1.0	4.5	3/4		
1.0	5.0	3/4		
1.0	6.0	3/4		
1.0	7.0	3/4		
1.0	8.0	3/4	1100 mic	
1.2	3.0	3/4	1100 mic	
1.2	3.2	3/4		
1.2	3.5	3/4	(+ B Microflute and C flute)	
1.2	4.0	3/4		
1.2	4.5	3/4		
1.2	5.0	3/4		
1.2	6.0	3/4		
1.2	7.0	3/4		
1.2	8.0	3/4	1300 mic	
1.4	3.0	3/4	1300 mic	
1.4	3.2	3/4		
1.4	3.5	3/4		
1.4	4.0	4/6	(+ C flute)	
1.4	4.5	4/6		
1.4	5.0	4/6	to	
1.4	6.0	4/6		
1.4	7.0	4/6		
1.4	8.0	4/6	1500 mic	
1.6	3.0	3/4	1500 mic	
1.6	3.2	3/4		
1.6	3.5	3/4	(+ C flute)	
1.6	4.0	4/6		
1.6	4.5	4/6	to	
1.6	5.0	4/6		
1.6	6.0	4/6		
1.6	7.0	4/6		
1.6	8.0	4/6	1700 mic	



### Choosing correct rule height

$$\begin{aligned} \text{Creasing Rule Height} \\ (b) &= c - a - d \\ (d) &= 0.009'' / 0.225\text{mm} \end{aligned}$$



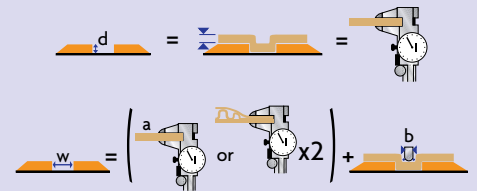
### MATRIX SELECTOR

Based on 23.80mm cutting rule & thin film base matrix

BOARD THICKNESS/WEIGHT		CREASING RULE		MATRIX mm
Micron	GSM	Width	Height mm	Trax or XTC
150	150	2pt	23.60 or 23.65	0.30 x 0.80
200	175	2pt	23.55 or 23.60	0.30 x 1.00
250	200	2pt	23.50 or 23.55	0.30 x 1.10
300	225	2pt	23.45 or 23.50	0.30 x 1.10 or 0.30 x 1.20
350	250	2pt	23.40 or 23.45	0.30 x 1.20 or 0.30 x 1.30
400	275	2pt	23.35 or 23.40	0.40 x 1.30 or 0.40 x 1.40
450	300	2pt	23.30 or 23.35	0.50 x 1.40 or 0.50 x 1.50
500	335	2pt	23.25 or 23.30	0.50 x 1.40 or 0.50 x 1.50
550	365	2pt	23.20 or 23.25	0.60 x 1.50 or 0.60 x 1.70
550	365	3pt	23.20 or 23.25	0.60 x 1.70 or 0.60 x 1.90
600	400	2pt	23.15 or 23.20	0.60 x 1.70 or 0.60 x 1.90
600	400	3pt	23.15 or 23.20	0.60 x 1.90 or 0.60 x 2.10
650	435	3pt	23.10 or 23.15	0.70 x 2.10 or 0.70 x 2.30
700	465	3pt	23.05 or 23.10	0.70 x 2.10 or 0.70 x 2.30
750	500	3pt	23.00 or 23.05	0.80 x 2.30 or 0.80 x 2.50
750	500	4pt	23.00 or 23.05	0.80 x 2.50 or 0.80 x 2.70
800	535	3pt	22.95 or 23.00	0.80 x 2.50 or 0.80 x 2.70
800	535	4pt	22.95 or 23.00	0.80 x 2.70 or 0.80 x 3.00
900	600	4pt	22.85 or 22.90	1.00 x 3.00 or 1.00 x 3.20
1000	665	4pt	22.75 or 22.80	1.00 x 3.00 or 1.00 x 3.20
1100	700	4pt	22.65 or 22.70	1.20 x 3.20 or 1.20 x 3.50
1200	750	4pt	22.55 or 22.60	1.20 x 3.50 or 1.20 x 4.00
1200	750	6pt	22.55 or 22.60	1.20 x 4.00 or 1.20 x 5.00
1300	800	6pt	22.45 or 22.50	1.40 x 4.00 or 1.40 x 5.00
1400	850	6pt	22.35 or 22.40	1.40 x 4.00 or 1.40 x 5.00
1500	900	6pt	22.25 or 22.20	1.60 x 5.00 or 1.60 x 6.00

Please note these sizes are suggestions only

### How to calculate matrix depth & width



Your local distributor is:



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