MARBACH DIE SUPPLIES.
MATERIALS & EQUIPMENT.

PACKAGING.
PERFORMANCE.
YOU.
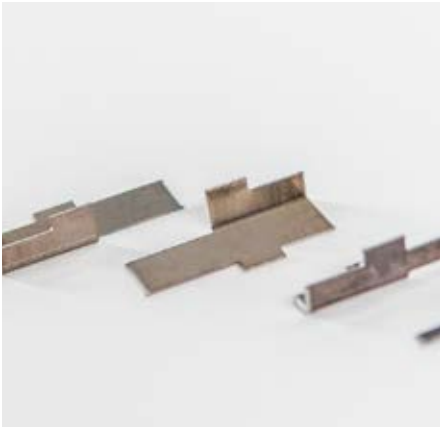
MARBACH

MATERIALS & EQUIPMENT.
SUITABLE FOR EVERYONE.

Marbach produces tools for the global packaging industry: Cutting-dies, stripping and blanking tools for paperboard and corrugated board production. What many do not know: Marbach Die Supplies also offers a comprehensive range of materials and equipment.

The product portfolio of Marbach Die Supplies is very wide-ranging. It offers the right solution for every requirement.

From A like aluhammer. Over C as in creasing channels. F like finishing tape. To R like rubber strips. At Marbach, we have numerous materials and tools in our product range that are needed by a packaging manufacturer.

The product range also includes Marbach developments that make your daily work easier: Nick setters, small tools, rule pullers, pliers, measuring devices as well as original spare parts for the maintenance of your tools. But also in-house developments such as mpower cutting rules or marbastrip claws are available from us. As a Marbach customer you will not only benefit from materials meeting your requirements but also from individual advices by your Marbach experts.

Use the materials of Marbach. Benefit from more than 100 years of experience of the world market leader. For best performance in the production of your packaging.

All products from our catalog are available at Marbach Die Supplies: supplies@marbach.com.

Notes regarding this catalog:
Packaging units are subject to change | Marbach General Terms and Conditions apply (marbach.com/en/daten/general-terms-and-conditions) | Pictures without guarantee | Item properties may vary | Further items and designs on request.

MAKE-READY MATERIALS.
SELF-ADHESIVE TAPES.

Make-ready tape, paper

Name	Item no.	Version	PU
blue	03030	30μ, 3 mm width	40 pcs.
blue	05830	30μ, 6 mm width	25 pcs.
blue	12030	30μ, 12 mm width	12 pcs.
red	03050	50μ, 3 mm width	40 pcs.
red	05850	50μ, 6 mm width	25 pcs.
red	12050	50μ, 12 mm width	12 pcs.
yellow	03080	80μ, 3 mm width	40 pcs.
yellow	05880	80μ, 6 mm width	25 pcs.
yellow	12080	80μ, 12 mm width	12 pcs.

Make-ready tape, stainless steel

Name	Item no.	Version	PU
stainless steel	07399	30μ, 6,5 mm width	10 m/roll
stainless steel	07401	50μ, 6,5 mm width	10 m/roll
stainless steel	07402	100μ, 6,5 mm width	10 m/roll
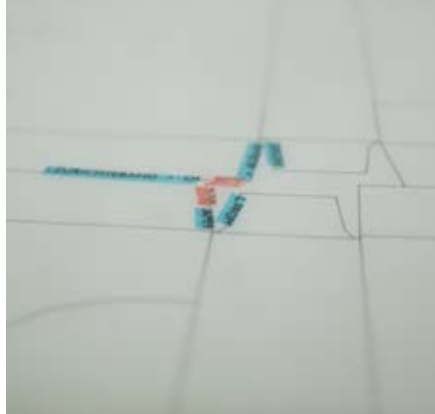
MAKE-READY MATERIALS.
TECHNICAL PAPERS.

Make-ready paper

Item	Item no.	Type	Version	PU
silk paper, white	09735	sheets	30µ, 100 cm x 75 cm	1,000 pcs.

Make-ready sheets, plotter foil and carbon paper

Item	Item no.	Type	Version	PU
make-ready sheet, 3-layers	14604	50 m roll	100µ, 130 cm width	1 pc.
make-ready sheet, 2-layers	14507	50 m roll	150µ, 152 cm width	1 pc.
plotter foil, one side matt	00655	30 m roll	90µ, 122 cm width	1 pc.
one-time carbon paper	07060	950 m roll	74.5 cm width	1 pc.
one-time carbon paper	17050	sheets	430 x 610 mm	1,000 pcs.
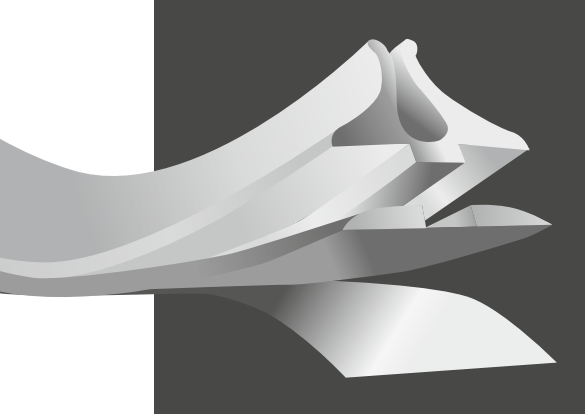
COUNTER PLATES.
Marbach Creasing Channels (MCC).

Marbach Creasing Channels (MCC) – the creasing channels from Marbach. This allows you to design your counter plate individually: Simply cut to size, attach to the creasing rule, remove adhesive foil, put into the machine, make impression, pull off clip-on profile, die-cut, done. MCC are available in various sizes. As is the matching cutting plate.

Properties:

- High quality synthetic material
- Highest precision, long service life
- Perfect adhesion, no slipping during use
- Easy handling thanks to finger-lift technology

Usage:

- Creasing matrix for corrugated board and paperboard

Packaging Unit:

- 6 mm / 10 mm: 36 stripes with 70 cm each (total length: 25.2 m)
- 12 mm: 30 stripes with 70 cm each (total length: 21.0 m)

MARBACH

MARBACH CREASING CHANNELS (MCC).
THE SMART CREASING CHANNEL FOR CLEVER MINDS.

MCC: The smart creasing channels from Marbach. Durable. Extremely good adhesion.
And easy to handle thanks to the special finger-lift technology. Simply the best solution for short runs.
www.marbach.com

Width MCC [B]	Crease channel width [L]	Creasing channel height (H) in mm									
		For rule thicknesses: 2 pt / 3 pt						For rule thicknesses: 3 pt / 4 pt			
		0.30	0.40	0.45	0.50	0.60	0.70	0.80	0.90	1.00	1.20
10 mm | 6 mm	0.80	X	X		X						
	1.00	X	X		X						
	1.10	X	X		X						
	1.20	X	X	X	X						
	1.30	X	X	X	X						
	1.40	X	X	X	X	X	X				
	1.50	X	X	X	X	X	X				
	1.60	X	X	X	X	X	X				
	1.70	X	X		X	X	X	X			
10 mm	1.80	X	X		X	X	X	X			
	1.90	X	X		X	X	X	X			
	2.00	X	X		X	X	X	X			
	2.10	X	X		X	X	X	X			
	2.20	X	X		X	X	X	X			
	2.30	X	X		X	X	X	X	X	X	
	2.40	X	X		X	X	X	X	X	X	
	2.50	X	X		X	X	X	X	X	X	
	2.60	X	X		X	X	X	X	X	X	
	2.70	X	X		X	X	X	X	X	X	X
12 mm	2.80	X	X		X	X	X	X	X	X	X
	2.90	X	X		X	X	X	X	X	X	X
	3.00	X	X		X	X	X	X	X	X	X
	3.20				X	X	X	X	X	X	X
	3.30						X	X	X	X	X
	3.50						X	X	X	X	X
	4.00							X	X	X	X
	4.50									X	X
	5.00									X	X
	5.50									X	X
	6.00									X	X

COUNTER PLATES.
rillma|+.

Pertinax material rillma|+ *	Full format (1,070 mm x 1,070 mm)	
Thickness	Item no.	PU
0.30 mm	09645	1 plate
0.40 mm	09646	1 plate
0.45 mm	09643	1 plate
0.50 mm	09647	1 plate
0.55 mm	09681	1 plate
0.60 mm	09650	1 plate
0.65 mm	09602	1 plate
0.70 mm	09651	1 plate
0.75 mm	09644	1 plate
0.80 mm	09652	1 plate

Pertinax material rillma|+ *	Half format (1,070 mm x 535 mm)	
Thickness	Item no.	PU
0.30 mm	09653	1 plate
0.40 mm	09654	1 plate
0.45 mm	09683	1 plate
0.50 mm	09655	1 plate
0.55 mm	09810	1 plate
0.60 mm	09656	1 plate
0.65 mm	09611	1 plate
0.70 mm	09657	1 plate
0.75 mm	09615	1 plate
0.80 mm	09658	1 plate

*without adhesive film; item available with adhesive film

Accessories for rillma and steel counter plates

Item	Item no.	Version	PU
rillma pin standard	07094	5 x 18 mm; bevel max. 0.5 mm double-sided	1,000 pcs.
rillma pin plastic	08919	head Ø 5.5 mm; base Ø 8 mm; 21 mm long	100 pcs.
mecosol glue spray universal	07093	500 ml bottle	1 pc.
puller	07067	200 mm, grinded	1 pc.
puller	07156	200 mm, standard	1 pc.
steel counter plate socket	15013	for mulitplex dies	100 pcs.
steel counter plate socket	14312	for duramar dies	100 pcs.
spring pins	07085	Ø 6 mm x 20 mm, lightweight	500 pcs.
moose rubber rings**	07088	light grey, extra strong, Ø 6 mm x 5 mm	1,190 pcs.
laminating film rillma	43027	roll 50 m x 1,050 mm x 40 µm	1 pc.

**further rubber rings on request
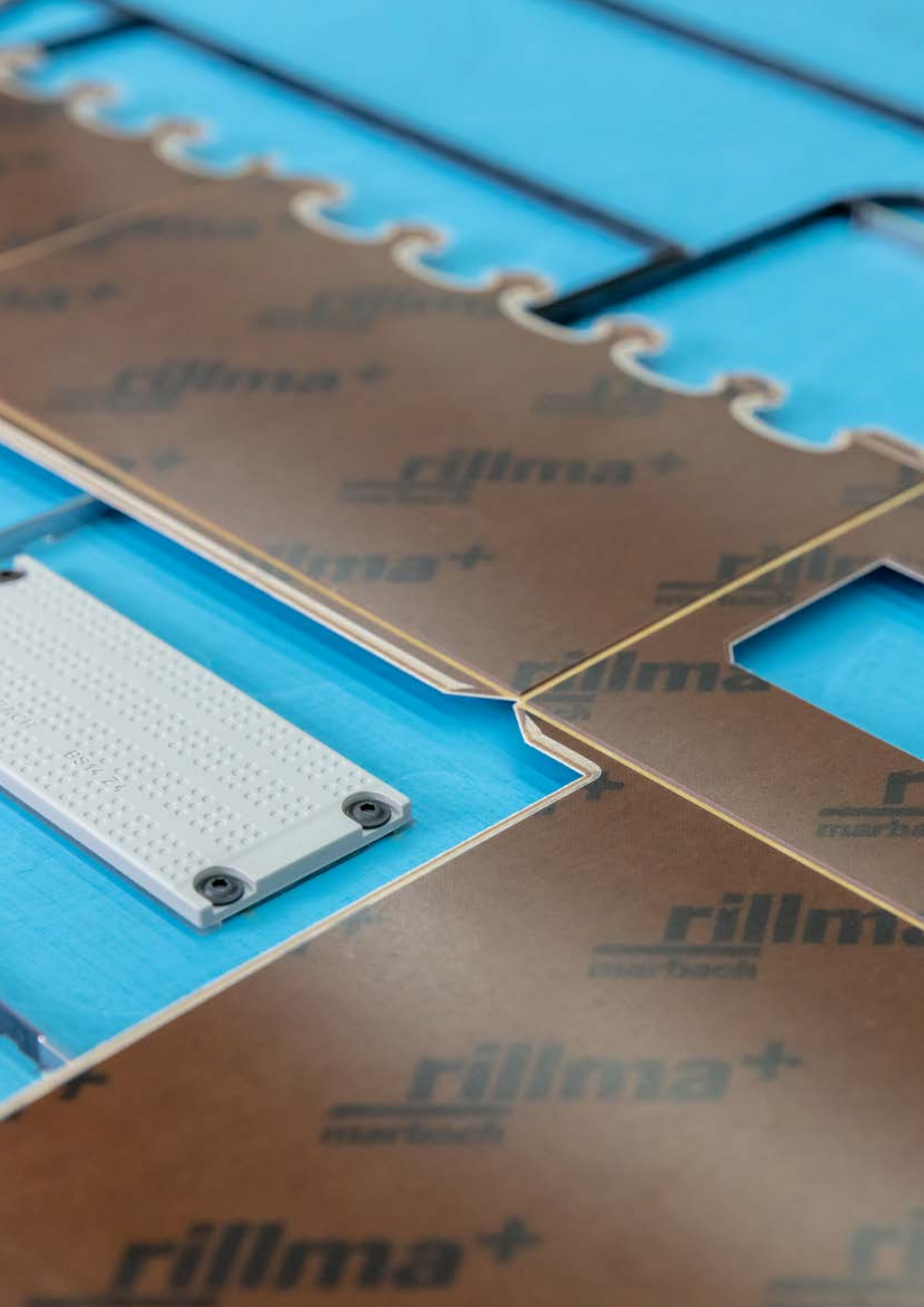
COUNTER PLATES.
CUTTING PLATES.

We cut cutting plates to the contour you require. Suitable for one or more machines. Marbach cutting plates are available in different designs and degrees of hardness. Medium hard (35 HRC) and hard (48 HRC), in different thicknesses. For every requirement.

Packaging unit medium hard plates: 10 pcs. | Packaging unit hard plates: 5 pcs.
Further versions as well as milled steel counter plates on request.

Paperboard processing machines	Item no.
76	M-4900
102	M-4900
104	M-4900
106	M-4900
130	M-4900
142	M-4900
145	M-4900
162	M-4900

Corrugated board processing machines	Item no.
1600	M-4900
1700	M-4900
2000	M-4900
2100	M-4900

Further sizes on request

CUTTING CHASE.
COVER PLATES.

With the cutting chase cover plates, you protect your make-ready sheet. And ensure optimum conditions in your platen area. For minimum make-ready times and maximum productivity.

Machine	Item no.	Thickness
102	M-0750	1 mm
104	M-0750	1 mm
106	M-0750	1 mm
130	M-0750	1 mm
142	M-0750	1 mm
145	M-0750	1 mm
162	M-0750	1 mm
1600	M-0750	6 mm
1700	M-0750	6 mm
2000	M-0750	6 mm
2100	M-0750	6 mm

Accessories

| Item no.	Item	Content
08965	marbaclean (for chase frame base plate)	200 ml
07223	marba|cleaner (for DZL|plate and cover plates)	500 ml	spray bottle
07227	marba|cleaner (for DZL|plate and cover plates)	5 l	refill canister

Digital zone levelling.
MAKE-READY TIME REDUCTION.

Compensation of machine-related tolerances

No zone make-ready necessary

Quick and easy to implement
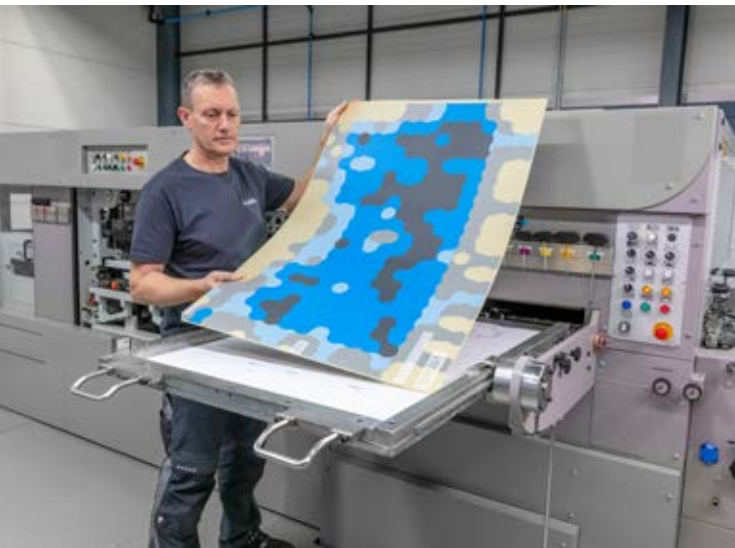
The die-cutting machine is subject to tolerances caused by wear and tear. For this reason, it was previously necessary to fill worn out zones with make-ready paper when setting up an order. This effort was required for every single order. With digital zone levelling, the process is much more efficient. This zone make-ready only needs to be done once. And then holds on for months to come.

DZL|plate		DZL|plateXL	
Item no.	Machine	Item no.	Machine
M-0770	76-106er	M-0735	Mastercut2.1
M-0770	130-145er	M-0735	Mastercut2.1R
M-0770	162er	M-0735	Mastercut1.7
M-0770	1600er	M-0735	Mastercut1.7R
M-0770	2000er	M-0735	SPO 203 Amatic
M-0770	1700er	M-0735	SPO 2000
M-0770	2100er	M-0735	SPO 160 Amatic / 1600 / 160-APR
		M-0735	SPO 160-S

Increased machine productivity

Shorter make-ready times

Easy handling
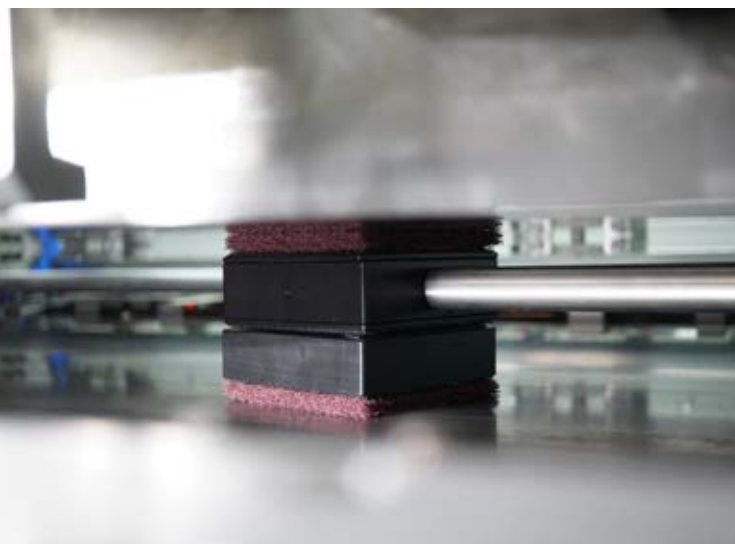
mplaten|cleaner-smart.
CLEAN DIE-CUTTING.

For maximum output when die-cutting. The mplaten|cleaner-smart is a device for cleaning the die-cutting machine platen. This enables the machine operator to clean the platen efficiently and increase the productivity of the machine. The mplaten|cleaner-smart is easy to handle and inexpensive to purchase. Suitable for all flatbed corrugated board machines and various paperboard machines.

Item no.	Version
G-2255	mplaten|cleaner-smart
09977	cleaning set (1 year)
07231	Marbach polishing paste

NICK GRINDING.
GRINDING DISCS.

For the use of a nick grinder you need the appropriate grinding discs. Diamond for a long lifetime. Or the cheaper version mafix, for variety in all sizes. Our grinding discs are available with different hole diameters.

Grinding discs	mafix (50 mm/6 mm hole diameter)	Diamond (50 mm/6 mm hole diameter)
Thickness	**Item no.**	**Item no.**
0.2 mm	07002	912242
0.3 mm	07003	912243
0.4 mm	07004	912244
0.5 mm	07005	912245
0.6 mm	07006	912246
0.7 mm	07007	912247
0.8 mm	07008	912248
0.9 mm	07009	912249
1.0 mm	07010	912250
1.1 mm	07011	912251
1.2 mm	07012	912252
1.3 mm	07013	912253
1.4 mm	07014	912254
1.5 mm	07015	912255
1.6 mm	07016	912256
1.7 mm	07017	912257
1.8 mm	07018	912258
1.9 mm	07019	912259
2.0 mm	07020	912260
2.5 mm	07025	912261
3.0 mm	07000	912262

Nick grinder.
THE EFFECTIVE ONE.

Transport nicks should be ground in. For maximum strength. We have the right solution for every requirement.

Item no.	Name
G-2135	nick grinder with rechargeable battery
G-2136	spare battery for G-2135
	further nick grinders available on request

marbanick|2+.
THE FAST ONE.

For the subsequent optimization of waste nicks, the marbanick|2+ is the optimal solution. With its different impact levels, it combines the functionality of 3 devices in one. And impresses with its integrated quick-change function. And four different wedge sizes (0.3, 0.4, 0.5 and 0.6 mm). These features make the marbanick|2+ extremely flexible and cost-efficient.

Item no.	Name
34162	marbanick|2+

Nick changing system.
THE FLEXIBLE ONE.

Flexibility is important when it comes to nicks. That's what the nick changing system for corrugated board applications is for. With it, a cutting-die can be perfectly set-up for different material characteristics in the least possible time.

**Note**: Special preparation of the cutting-die is necessary.

Item no.	Name
04900	nick changing system case with accessories for flat corrugated board
04900	nick changing system case with accessories for rotary corrugated board

mcut|multi.
THE ALLROUNDER.
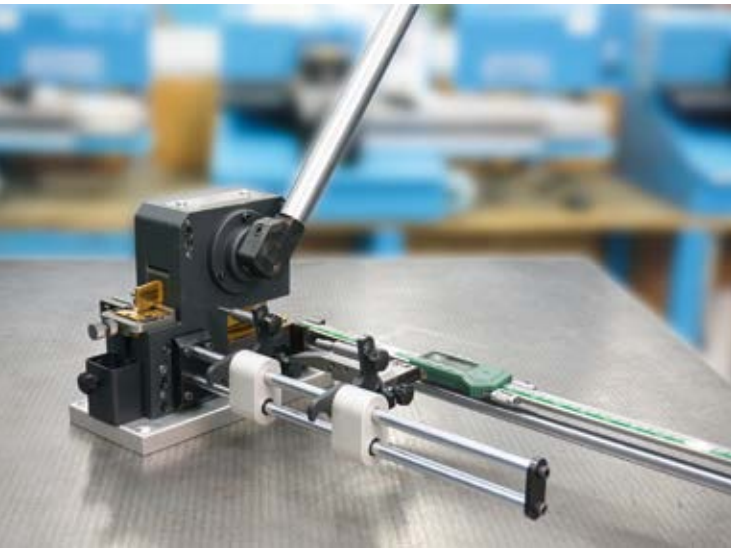
An indispensable handheld device. 3 devices in one. Multi-functional and with digital gauge. The mcut|multi can not only cut rules, but also lips. And it can also notch. For rule materials from 2 pt to 3 pt. It cuts steel quickly and without deformation. And it does so with a very small footprint.

$h1 = 20\ mm\ |\ w = 3 - 8\ mm$

$h2 = 8-50\ mm$
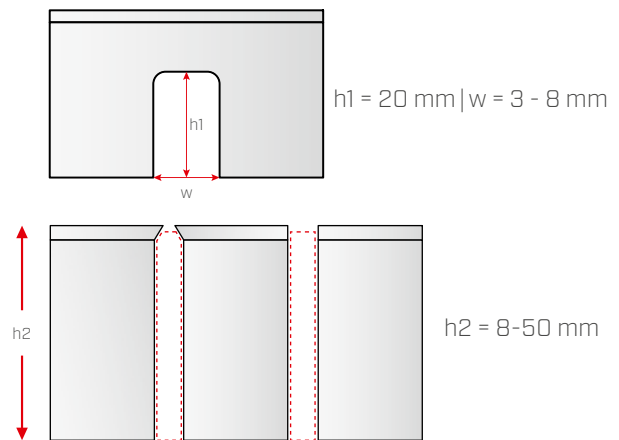
Item no.	Name
G-2920	mcut|multi

mbend.
THE MANIFOLD.

The mbend. A manual bending device for optimum bending processes. And for precisely bent rules. Robust, variable and easy to handle. For rule thicknesses from 1.5 to 4 pt. And rule heights from 8 to 50 mm. With an extensive range of standard bending forms. With the special scale, depth setting is quick and accurate. The possibility of locking ensures precise repeatability.

Item no.	Name
G-2330	mbend
G-2331	25-piece bending insert set (1.5 pt - 3 pt)
G-2332	102-piece bending insert set (1.5 pt - 3 pt)

mcut|round.
THE DEFINED ONE.

Simple and clever. That is the mcut|round. This special handheld device rounds off the ends of flat or rotary creasing rules in a defined manner. In consistent quality, from the first to the last creasing rule. This prevents the paperboard from bursting at the creasing ends. The mcut|round cuts radii of 3 or 5 mm. Its cutting elements are wear-resistant, and repeated regrinding is possible. The mcut|round stands for high durability and best creasing performance.

Item no.	Name
G-2730	mcut|round

mcut|matrix.
THE PRECISE ONE.

The mcut|matrix cuts creasing channels. Fast, precise and safe. It is a flexible, ergonomic, very robust handheld device that is perfectly adapted to the conditions in production. The infinitely variable gauge can be used for a wide variety of creasing geometries. Thus, it not only ensures exact cutting results, but also maximum flexibility. The special design of the mcut|matrix ideally reduces the required cutting force. For little effort when cutting creasing channels.

Item no.	Name
G-2740	mcut|matrix

mrule|extractor.
THE SAFE ONE.

The rule puller mrule|extractor is indispensable as an effective helper on the die-cutting machine. It is used whenever damaged knives need to be safely removed from a cutting-die and replaced with replacement knives. With the mrule|extractor, rules are drawn easily, in a controlled, precise and safe manner. Safe for the user and safe for the cutting-die. The optimum pre-requisite for a perfect fit of the replacement knives.

Item no.	Name
G-3300	mrule|extractor	optionally with clamping jaw set 3pt - 8pt

mbench|smart.*
THE CLEVER ONE.

Maximum flexibility and efficiency: With the mobile repair workstation mbench|smart you will be prepared for all situations. For reworking the cutting-die, e.g. directly at the die-cutting machine. Its smooth-running heavy-duty wheels ensure safe and quick transport to its place of use. Due to the optional equipment with important rule processing devices such as the hand bender mbend or the multifunctional device mcut|multi for cutting to length, notching and lipping, it will become an indispensable companion in your production. The 5 integrated drawers offer plenty of space for your accessories. The rear panel includes 6 shelves for different cutting rules, easily accessible via a central access opening.

mbench|smart. Your mobile companion for fast and cost-saving on-site repair of your tools.

Item no.:	G-2180
Dimensions (lxwxh):	1,500 x 700 x 1,100 mm
	(Back panel: 1,500 mm)
Drawers:	5 pcs., width > 1,000 mm
Rear wall:	with 6 shelves
Work surface:	anti-slip rubberized surface
Wheels:	lockable heavy duty wheels

*Now also available with full equipment. Please contact us.

mbench|pro.*
THE UNIVERSAL ONE.

mbench|pro. The professional assembly table for your tool preparation. It is larger than the mbench|smart. And even more versatile. A complete workstation with assembly surface. In the 9 drawers you have plenty of space for accessories and important equipment for processing your cutting dies. Of course, the mbench|pro can also be equipped with the most important rule processing equipment. And just like the mbench|smart, it has smooth-running heavy-duty wheels for maximum mobility.

The mbench|pro. Your mobile assembly table for maximum performance in your die preparation.

Item no.:	G-2181
Dimensions (lxwxh):	1,340 x 1,340 x 1,000 mm
Drawers:	9 pcs., width > 1,000 mm
Mounting plate:	700 x 1,000 mm
Work surface:	steel plate and anti-slip rubberized surface
Wheels:	lockable heavy duty wheels

*Now also available with full equipment. Please contact us.

LED WORK LIGHT.
THE FLEXIBLE ONE.

High luminosity

Flexibly adjustable

Best visibility at the workplace

Our special LED work light provides optimum illumination of your tool processing surface. With its strong luminosity of 1,250 lumens, the LED work light is very bright. And it does so with low energy consumption. In addition, it is very flexible: because it can be magnetically attached to any place on your work table and also has an arm that can be adjusted in all directions. This means that the LED light can always be used to optimally illuminate the desired area. For the best visibility when machining your tools.

Item no.	Name
51170	LED work light

Available as single position or complete system

In 6 different heights

Including shimfoils & rubber

trimknife|multi.
THE SPECIAL ONE.

trimknife|multi. These screw-on separation knives are the solution when the tool's waste separation knives need to be replaced or extended. Available as a single item or as a complete set including accessories. The special feature: you can have the right length of separation knife in no time at all. Simply divide the cutting rule at the perforation with a kink. And that's it. In this way, a 100 mm long knife can be turned into different knife lengths (64, 40, 35 and 25 mm).

Item no.	Name	Dieboard	Rule height
04355	trimknife|multi	15 mm	23.80 mm
04367	trimknife|multi	18 mm	23.80 mm
04368	trimknife|multi	12 mm	23.80 mm
04369	trimknife|multi	15.87 mm	23.80 mm
04377	trimknife|multi	18 mm	23.60 mm

Tool Organizer Set 1.

THE TIDY ONE.

The Marbach Tool Organizer Set 1 keeps your die-cutting machine tidy. It consists of special magnetic rails, which are equipped with wrenches and magnetic hooks for make-ready tapes. For immediate access directly at the die-cutting machine. This reduces walking distances and search times.

Organize your workplace – and save valuable time in the production of your packaging.

Item no.	Name
44251	Tool Organizer Set 1

Tool Organizer Set 2.
THE TIDY ONE.

The Tool Organizer Set 2 provides even more order at the workplace and consists of a magnetic tape dispenser and two adhesive tapes: The transparent one ensures that the edges of the make-ready sheet are protected, the light blue one secures it in the cutting chase. For immediate access directly at the die-cutting machine. This saves you walking distances and search times.

Organize your workplace – and save valuable time when producing your packaging.

Item no.	Name
44252	Tool Organizer Set 2

TOOLS.

Scissors

Different versions of scissors. To cut rubber easily and safely.

- combo scissors, red, 190 mm length (13018)

- small scissors, yellow, 160 mm length (13109)

Item no.	Name
13018	combo scissors, red
13109	scissors small, yellow

Bevelling scissors

Special scissors to cut creasing channels and rubber in the right angle. With exchangeable spare blades (PU = Pack of 5).

Item no.	Name
15639	bevelling scissors

Gripping pliers

Special gripping pliers with tip for quick and easy removal of rules or rubber. Also suitable for narrowest areas.

Item no.	Name
06099	gripping pliers DIN ISO 9655

Pliers

Assembly pliers in different versions. Ideal for the assembly of cutting-dies. In daily use at Marbach. The inexpensive alternative to rule pullers.

Item no.	Name
07067	assembly pliers (red handle)
04902	assembly pliers long

marbaglue

Adhesive for applying rubber on cutting-dies. Available in different versions depending on requirements: 06092 for flat paperboard dies, 06093 for rotary corrugated board dies and 06094 for flat and rotary corrugated board dies.

Item no.	Name
06092	plug cap (paperboard)|20g
06093	twist cap (corrugated board)|20g
06094	twist cap (corrugated board)|50g

PU (Packing unit) = 1 pc. each

Aluminum hammer with exchangeable head

Aluminum hammer with exchangeable heads. For assembly of rules in folding carton cutting-dies. Optimal for mpower cutting rules and for creasing rules.

Item no.	Name
08498	alu hammer Ø 25 mm
00234	set interchangeable heads

Polyurethane hammer

Special polyurethane hammer for the assembly of rules in rotary corrugated board cutting-dies. Robust, durable and for best force transmission. Very pleasant to handle due to its easy detachment from the rule.

Item no.	Name
08986	Ø 50 x 125 mm; 400 g
08731	Ø 70 x 115 mm; 710 g

Soft face hammer

Hammer with a special soft head for the assembly of very sharp cutting rules in folding box and corrugated board cutting-dies. Easily replaceable nylon spare heads available.

Item no.	Name
08366	soft face hammer Ø 25 mm
08495	set interchangeable heads

Aluminum hammer

Hammer with aluminum head for mounting rules in folding box and corrugated board cutting-dies. Optimally suited for mpower cutting rules and for creasing rules.

Item no.	Name
08498	40 x 75 mm; 250 g
08499	40 x 100 mm; 350 g

Adjustment fork

Adjustment fork for exact alignment of rules at the rule joints. Simple and quick. With impact protection.

Item no.	Name
10200	adjustment fork

PU (Packing unit) = 1 pc. each

DIEBOARD-MATERIAL.

Dieboards, made of high quality birch wood. With very uniform surface. Perfectly laserable. This is the base for your cutting-die. In various sizes and thicknesses. Varnished or unvarnished. For flat or rotary cutting-dies. The right solution for every requirement.

Flat plywood

Item no.	Thickness (mm)
on request	6.5 varnished
on request	9.0 varnished
on request	12.0 varnished
on request	15.0 unvarnished
on request	15.0 unvarnished
on request	18.0 unvarnished

other sizes and thicknesses on request

Rotary half shells

Item no.	Thinkness (mm)	Length (mm)	Diameter (mm)
on request	13	1,900	Ø 177
on request	13	1,700	Ø 270
on request	13	2,100	Ø 270
on request	13	2,100	Ø 381
on request	13	2,000	Ø 487
on request	13	2,100	Ø 487
on request	13	2,500	Ø 487

other sizes and diameters on request

CUTTING RULES.
PIECE BY PIECE. OR BY THE COIL.

For perfect die-cutting results, the rule material is of great importance. The selection depends on your individual requirements.

Marbach has an extensive portfolio of rule materials. For every application and for every need. Whether short or long runs. No matter what needs to be die cut: Coated or uncoated material. Plastic or foam. The right rule for every application. Meter pcs. (all item numbers with "M" at the end) for manual and roll material for machine processing.

mpower. The original.

A standard developed by Marbach. The mpower cutting rule. The trick: a rounded cutting edge that compensates tolerances and eliminates angel hair. Which is almost immune to overpressure. For the shortest make-ready times. Simply for maximum die-cutting performance from the first to the last sheet.

Item no.*	Thickness	Chamfer	PU/Roll
01212	2 pt	center bevel	100 m
01977	2 pt	center bevel 42°	100 m
01986	3 pt	center bevel	75 m
01252	3 pt	long center bevel	75 m

*item also available by the meter

r=0.02

mpower   standard
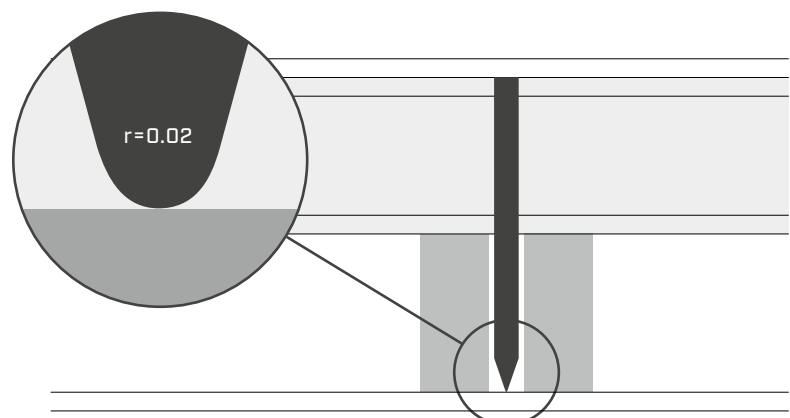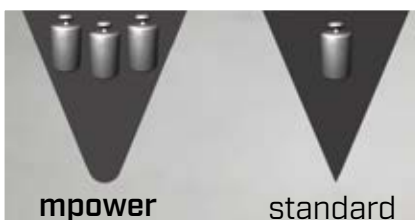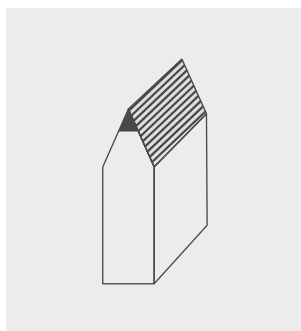
Cutting edge

Shaved cutting edge
Precisely processed.
Reliable over many years.
The standard.
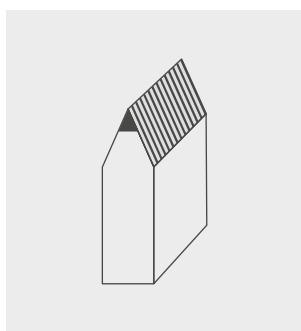
Ground cutting edge
Precise cutting edges.
Reduced cutting pressure.
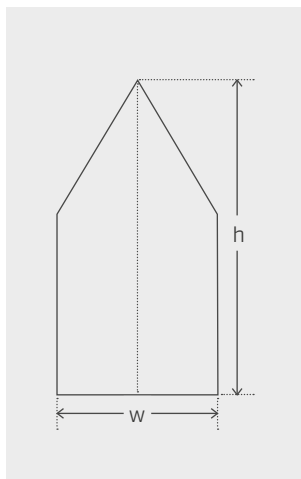Penetrates easily through
the material.

Winding direction

Knife side up
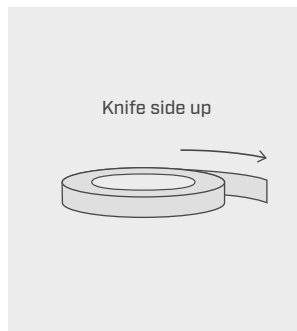
Clockwise
The correct winding direction.
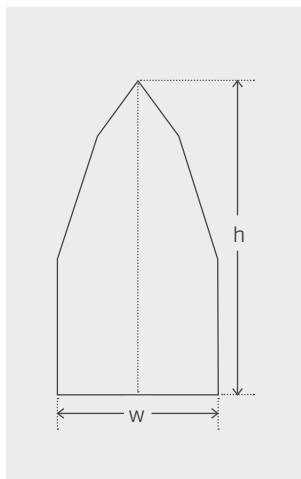For your bending machine.
And your application. Clock-
wise.

Knife side up

Anti-clockwise
The correct winding direction.
For your bending machine.
And your application. Anti-
clockwise.

Cutting edge geometries

D – center bevel
The standard for cutting
paperboard. Also available as
side bevel.

D4 – long center bevel
For thick materials. The
standard for corrugated
board. Also available as
side bevel.
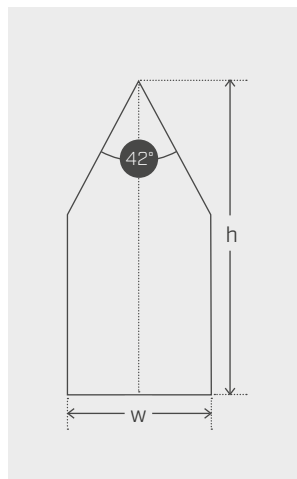
Cutting angle

42° cutting angle
The cutting rule penetrates
easily into the material. Lower
cutting pressure is needed.
The standard in America.
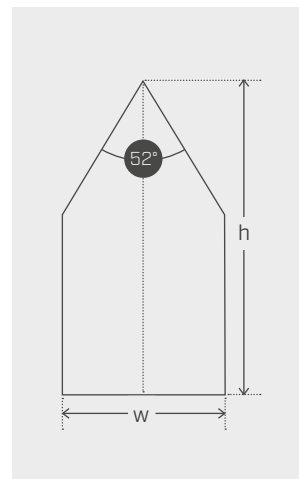
52° cutting angle
The cutting rule is very robust.
It has a long service life. The
standard in Europe and Asia.

mhard.

THE HARDENED ONE.

mhard has a hardened edge. The advantages of mhard: it distinguishes itself by providing a long service life and high stability. With little abrasion. The mhard is a great fit for medium runs.

Item no.*	Thickness	Chamfer	PU/Roll
00985	2 pt	center bevel	100 m
01045	2 pt	long center bevel	100 m
02505	3 pt	center bevel	75 m
01073	3 pt	long center bevel	75 m

*item also available by the meter

mgold.

THE SPECIAL ONE.

The special cutting rule mgold. Impressive hardness. mgold has a 42° cutting edge. Therefore it is very sharp and works perfectly for cut scores. mgold is optimal for long runs and critical material. Also for cutting metallized cartons and thin metal foils.

Item no.*	Thickness	Chamfer	PU/Roll
20010	2 pt	center bevel; 55 HRC	100 m
20011	2 pt	center bevel; 60 HRC	100 m

*item also available by the meter

mpower|s.
THE DURABLE ONE.

mpower|s. For very special requests. mpower|s has the same cutting geometry as mpower. mpower|s is very hard and therefore resistant to abrasive wear and tear. This makes it very durable. Its main use: die-cutting of cosmetic packaging and corrugated board.

Item no.*	Thickness	Chamfer	PU/Roll
10084	2 pt	center bevel	100 m
10085	3 pt	long center bevel	75 m

*item also available by the meter

mgold|+.
THE VERY SPECIAL ONE.

Like its little brother mgold, this cutting rule has a 42° edge. Due to this and its special coating, it is not only very sharp but also very hard and therefore suitable for the highest demands. It is extremely resistant to abrasion and is thus used when maximum tool life is required for die-cutting critical materials.

| Item no.*	Thickness	Chamfer	PU/Roll
20020	2 pt	center bevel; 60 HRC	100 m

*item also available by the meter

mhard|r.

Special rotary cutting rule for processing corrugated board. It protects the counter material and ensures waste-free die-cutting. For best productivity. Available in different height and diameter versions.

Item no.	Name	PU
08430	1.42 x 25.40 mm	curved Ø 487 mm; 8 TPI	30.5 m
08431	1.42 x 25.40 mm	straight; 8 TPI	30.5 m
08535	1.42 x 24.60 mm	straight; 8 TPI	30.5 m
08536	1.42 x 24.60 mm	curved Ø 487 mm; 8 TPI	30.5 m
08533	1.42 x 23.80 mm	straight; 8 TPI	30.5 m
08534	1.42 x 23.80 mm	curved Ø 487 mm; 8 TPI	30.5 m
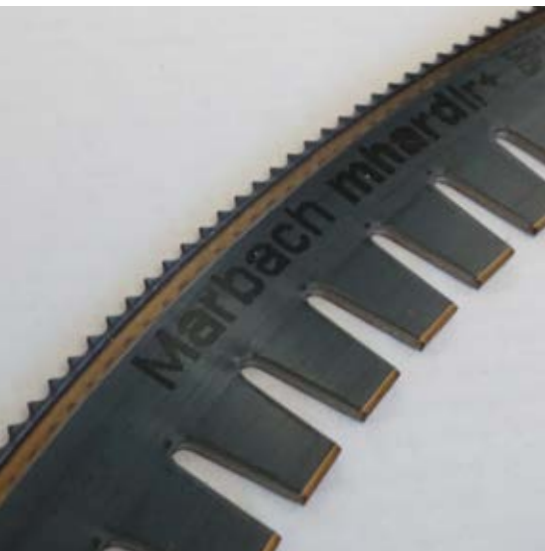
mhard|r+.

New generation of rotary cutting rules. Due to its unique knife hardening and its special corrugated grinding technology, the mhard|r+ cuts the corrugated board very easily. For a smooth die-cutting result – even with high grammages and heavy corrugated board.

Item no.	Name	PU
52911	1.42 x 25.40 mm	straight; 8 TPI	30.5 m
52914	1.42 x 25.40 mm	curved Ø 487 mm; 8 TPI	30.5 m
52916	1.42 x 25.40 mm	curved Ø 645 mm; 8 TPI	30.5 m
52913	1.42 x 26.40 mm	straight; 8 TPI	30.5 m
52917	1.42 x 26.40 mm	curved Ø 487 mm; 8 TPI	30.5 m
52912	1.42 x 26.40 mm	curved Ø 645 mm; 8 TPI	30.5 m

Sawtooth rule.

Rotary cutting rule in special sawtooth version for processing corrugated board. Available in straight and curved versions.

Item no.	Name	PU
10682	1.42 x 25.80 mm	straight; 20 TPI	40.0 m
09404	1.42 x 25.80 mm	curved Ø 487; 20 TPI	30.5 m

Perforation rule.

Rotary perforation rule for corrugated board packaging. Ensures exact and easy folding of the blanks. And functional opening mechanisms.

Name
rotation-perforation rule; 1.42 x 23.8 mm; different gaps/cuts
rotation-perforation rule; 1.42 x 24.6 mm; different gaps/cuts
rotation-perforation rule; 1.42 x 25.4 mm; different gaps/cuts

other combinations on request.

Creasing rule.

Standard creasing rule for creasing thin corrugated board. For good creasing results. And functioning folding mechanisms.

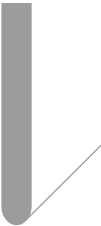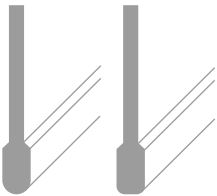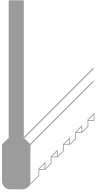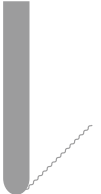| Item no.	Name	PU
08208	22.80 x 1.42 mm	curved Ø 487 mm	30.5 m
08269	22.10 x 1.42 mm	curved Ø 487 mm	30.5 m
01466	23.00 x 1.42 mm	45.7 m
01467	23.10 x 1.42 mm	45.7 m
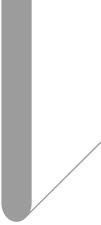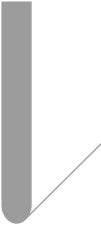
Reduced body creasing rule.

Rotary creasing rule in special version for heavy corrugated board types. And double flute. Provides best results with 180° folds.

Item no.	Name	PU
08422	22.10 x 3.00 x 1.42 mm I curved Ø 487 mm; flat head	30.5 m
08578	23.00 x 3.00 x 1.42 mm I curved Ø 487 mm; flat head	30.0 m
08669	22.60 x 3.00 x 1.42 mm	straight; flat head	25.0 m
08468	23.00 x 3.00 x 1.42 mm	straight; flat head	25.0 m

Creasing rules.
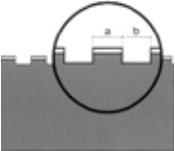
	Item no.	Thickness	Height	PU
2 pt (0.71 mm)	01359	2 pt	23.20 mm	20 m
	01360	2 pt	23.25 mm	20 m
	01361	2 pt	23.30 mm	100 m
	01363	2 pt	23.40 mm	100 m
	01365	2 pt	23.50 mm	100 m
	01366	2 pt	23.60 mm	100 m
	01368	2 pt	23.80 mm	20 m
	on request	2 pt	22.00-23.90 mm	20 m
3 pt (1.05 mm)	01425	3 pt	22.60 mm	20 m
	01428	3 pt	22.80 mm	20 m
	01405	3 pt	23.00 mm	20 m
	01407	3 pt	23.20 mm	20 m
	01408	3 pt	23.30 mm	60 m
	01409	3 pt	23.40 mm	50 m
	01410	3 pt	23.50 mm	68 m
	01411M	3 pt	23.60 mm	75 m
	on request	3 pt	21.50-23.90 mm	20 m
4 pt (1.42 mm)	01306	4 pt	21.70 mm	20 m
	01314	4 pt	22.60 mm	20 m
	01483	4 pt	22.80 mm	20 m
	01466	4 pt	23.00 mm	20 m
	01468	4 pt	23.20 mm	20 m
	on request	4 pt	21.50-27.00 mm	20 m
WRT WFT	on request	3/6 pt	22.20–23.40 mm WRT/WFT	20 m
	on request	3/8 pt	22.20–23.40 mm WRT/WFT	20 m
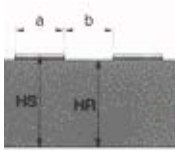
	Item no.	Thickness/ Name	Height x Thickness [mm]	PU
Crease TT 2pt (0.71mm)	50268	TT	23.60 mm x 2 pt	20 m
	50267	TT	23.70 mm x 2 pt	20 m
Crease NT 2pt 2/1pt (0.71/0.36 mm) 2/1.5 pt (0.71/0.53 mm)	01544M	NT 2/1pt	23.00 mm x 2 pt	20 m
	01545M	NT 2/1pt	23.10 mm x 2 pt	20 m
	01546M	NT 2/1pt	23.20 mm x 2 pt	20 m
	01548M	NT 2/1pt	23.30 mm x 2 pt	20 m
	01562	NT 2/1pt	23.85 mm x 2 pt	20 m
	04165	NT 2/1,5 pt	23.60 mm x 2 pt	20 m
	01527	NT 2/1,5 pt	23.85 mm x 2 pt	20 m
Headcrease	08860	Headcrease	22.80 mm x 4/8 pt	20 m
	10472	Headcrease	23.00 mm x 4/8 pt	20 m
	08722	Headcrease	22.60 mm x 4/8 pt	20 m
	50343	Headcrease	23.00 mm x 4/8 pt	20 m
Multicrease	50312	Multicrease	22.80 mm x 4/8 pt	20 m
	50311	Multicrease	23.00 mm x 4/8 pt	20 m
	50307	Multicrease	22.60 mm x 4/8 pt	20 m
	50308	Multicrease	22.80 mm x 4/8 pt	20 m
	50315	Multicrease	23.00 mm x 4/8 pt	20 m
Wave crease	01168	Wave crease	22.40 mm x 3 pt	20 m
	01166	Wave crease	22.60 mm x 3 pt	20 m
	01164	Wave crease	23.00 mm x 3 pt	20 m
	01163	Wave crease	23.20 mm x 3 pt	20 m
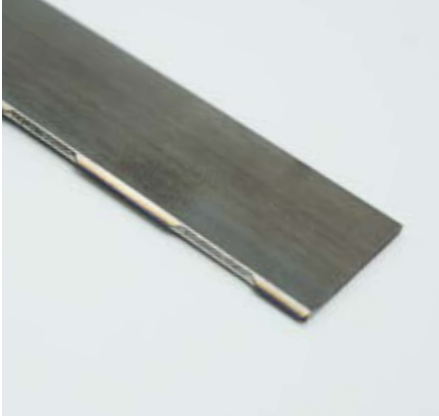
Crease-cut combination rules.
PERFORATION RULES.

Perforation rules are available in different versions. In the thicknesses 2 pt, 3 pt or 4 pt. All rules are available by the meter. For completely individual perforations.

Perforation	Thickness	PU
	2 pt	20 m
	3 pt	20 m
	4 pt	20 m

Combo-perforation	Thickness	PU
	2 pt	20 m
	3 pt	20 m
	4 pt	20 m

Tear perforation rules.

Tear perforation rules are available in different versions. Left or right. In thicknesses of 2 pt or 3 pt. For tear open mechanisms that work. All rules are available by the meter.

Fishbone rule

Item no.	Thickness	Height	PU
10549M	2 pt	3 pt	23.80 mm	20 m
10548M	2 pt	3 pt	23.80 mm	20 m
10547M	2 pt	3 pt	23.80 mm	20 m
10540M	2 pt	23.80 mm	20 m

further tear perforation rules on request

Sharklinie

Item no.	Thickness	Height	PU
01446M	2 pt	23.80 mm	20 m
01433M	3 pt	23.80 mm	20 m

further tear perforation rules on request

Wave rule.

Special rule with waved edge. This is used when the packaging should be equipped with safe cutting edges. For increased safety when finished products are assembled.
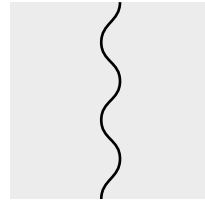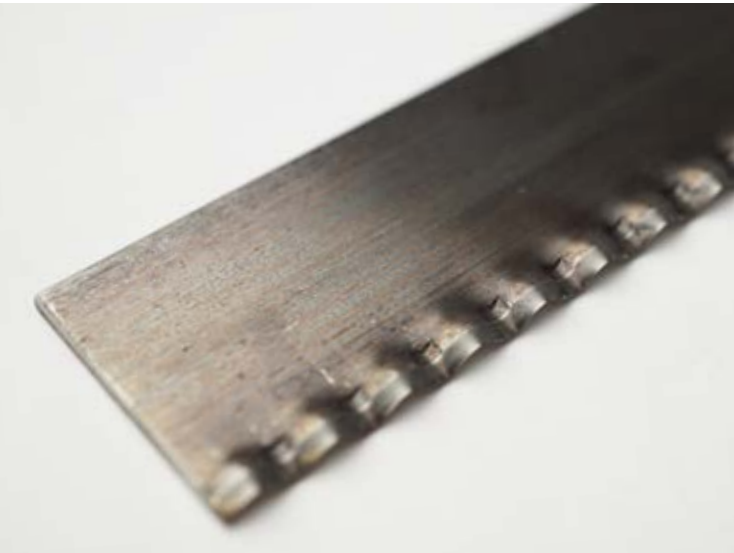
Item no.	Type	Thickness	Height	PU
01102	2.0 mm	3 pt	23.80 mm	20 m
01102M	2.0 mm	3 pt	23.80 mm	20 m
01101	3.5 mm	3 pt	23.80 mm	20 m
01101M	3.5 mm	3 pt	23.80 mm	20 m
01162	5.0 mm	3 pt	23.80 mm	20 m
01162M	5.0 mm	3 pt	23.80 mm	20 m

Deckle edge rule.

Special rule with edge for stamped outer contour. When cut with a deckle edge rule the produced packaging gets an attractive look and convinces with it's aesthetic look.
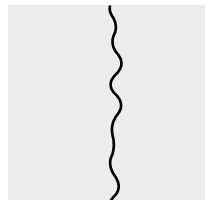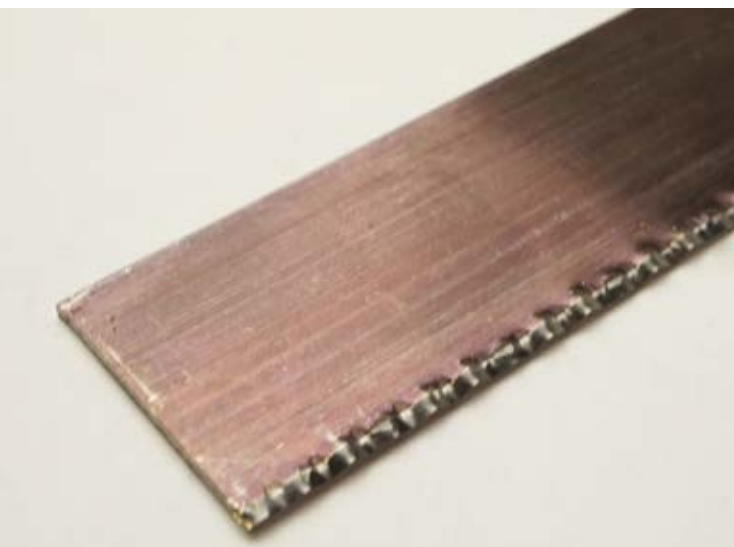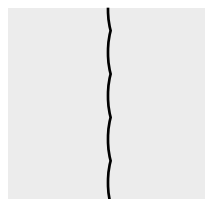

Item no.	Name	PU
01832M	1.05 x 23.80 mm	20 m
01934M	1.05 x 23.80 mm	20 m

Special geometric rule.

Further development of the wave rule for flat tools. Optimized cutting edge protection for users. Resulting in highest safety when assembling finished products. The cutting result is similar to a rotary cut packaging with mhard|r.

Item no.	Name	PU
01121	1.05 x 23.80 mm	20 m

Special rule.

A special cutting knife for optimal reverse cutting of the paperboard material. Highly precise and very sharp. For tear mechanisms that not only work perfectly, but are also visually attractive.
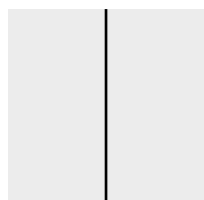
| Item no.	Name	PU
01995M	reverse cutting plate 12x 1,000 mm/ 0.8 mm/ 0.3 mm Angle 70°	from 10 m
01997M	reverse cutting plate-perforations	on request

HOLE PUNCHES.
BENT CUTTING CIRCLES.

To cut perfect round circles, there are several options: Bent cutting circles or hole punches. For small diameters up to 10 mm, ready-made hole punches are the perfect solution. For diameters of 11 mm and more, we recommend bent mpower cutting circles made of hardened steel. With brass ejector and adjustable pressure spring.

Bent cutting circles	Item no.	Ø	Height
	02472	11	23.80 mm
	02473	12	23.80 mm
	02474	13	23.80 mm
	02475	14	23.80 mm
	02477	15	23.80 mm
	02476	16	23.80 mm
	02478	17	23.80 mm
	02870	18	23.80 mm
	02871	19	23.80 mm
	02865	20	23.80 mm
	02864	21	23.80 mm
	02863	22	23.80 mm
	02872	23	23.80 mm
Finished parts mpower	02862	24	23.80 mm
	02860	25	23.80 mm
	02866	26	23.80 mm
	02873	27	23.80 mm
	02867	28	23.80 mm
	02861	30	23.80 mm
	02875	31	23.80 mm
	02868	32	23.80 mm
	02874	34	23.80 mm
	02869	35	23.80 mm

Hole punches Types	Item no.	Ø	Height
	02172	3	23.80 mm
	01145	4	23.80 mm
	01147	5	23.80 mm
	01149	6	23.80 mm
	01173	7	23.80 mm
	01177	8	23.80 mm
	01179	9	23.80 mm
FB*	01183	10	23.80 mm

*on request available up to 23 mm

	Item no.	Ø	Height
	02799	1	23.80 mm
	02801	2	23.80 mm
	02803	3	23.80 mm
	02805	4	23.80 mm
	02807	5	23.80 mm
	02809	6	23.80 mm
	02811	7	23.80 mm
	02813	8	23.80 mm
G**	02815	9	23.80 mm
	02817	10	23.80 mm
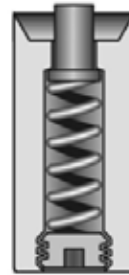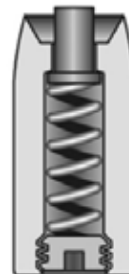
**on request available up to 20 mm

SAFETY CUTS.
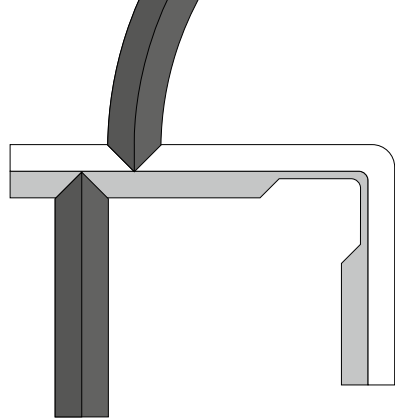
Safety cuts ensure secure closure of folding boxes. With strip steel elements equipped with a special bend-free grind, their execution in the packaging always succeeds. This is because it ensures an exact rule height, even at a bent angle. All sizes are available in left and right versions.

Item no.	Description	Dimensions (L x W)	Bending site	PU
02905	Safety cut no. 5	5 x 5 mm	right	3,000 pcs.
02925	Safety cut no. 5	5 x 5 mm	left	3,000 pcs.
02906	Safety cut no. 6	6 x 5 mm	right	3,000 pcs.
02926	Safety cut no. 6	6 x 5 mm	left	3,000 pcs.
02907	Safety cut no. 7	7 x 5 mm	right	2,100 pcs.
02927	Safety cut no. 7	7 x 5 mm	left	2,100 pcs.
02908	Safety cut no. 8	8.5 x 5 mm	right	1,900 pcs.
02928	Safety cut no. 8	8.5 x 5 mm	left	1,900 pcs.
02909	Safety cut no. 9	10 x 5 mm	right	1,600 pcs.
02929	Safety cut no. 9	10 x 5 mm	left	1,600 pcs.
02910	Safety cut no. 10	11 x 5 mm	right	1,500 pcs.
02930	Safety cut no. 10	11 x 5 mm	left	1,500 pcs.
02911	Safety cut no. 11	12 x 5 mm	right	1,300 pcs.
02931	Safety cut no. 11	12 x 5 mm	left	1,300 pcs.

CORRUGATED BOARD RUBBERING.
FORM PARTS FOR FLAT DIE-CUTTING.

Flat die-cutting of corrugated board requires a rubbering perfectly matched to the material. Our extensive rubber range ensures productivity in the production of your packaging. As sheet material, profiles or form parts.

Form parts

Item no.	Name	Dimensions	Hardness	Color
15819CF-10	cellrubber softpower	10 x 10 x 500 mm	20 shore	black
15819CF-10A	cellrubber softpower	10 x 10 x 500 mm	20 shore	black
03345CF-13	cellrubber softpower	13 x 13 x 500 mm	20 shore	black
03345CF-13A	cellrubber softpower	13 x 13 x 500 mm	20 shore	black
03312CF-10	marbaject	10 x 10 x 500 mm	20 shore	black
03350CF-13	marbaject	13 x 13 x 500 mm	20 shore	black

CORRUGATED BOARD RUBBERING.
PROFILES FOR FLAT DIE-CUTTING.

Profiles

Item no.	Name	Dimensions	Hardness	Color	Profile
20094	C3 flat	7 x 12.5 x 1,000 mm	60 shore	black	
00388	C3-0	7.5 x 12.5 x 1,000 mm	65 shore	red	
20042	profile rubber hard	9.1/7.0 x 5 x 1,000 mm	75 shore	white	
00436	profile rubber hard	8.5/7.5 x 5 x 1,000 mm	75 shore	white	
00415	profile rubber hard	11/9 x 5 x 1,000 mm	75 shore	white	
00390	profile rubber easy crease	8 x 15 x 600 mm	20 shore	black	
00413	profile rubber easy crease	9 x 15 x 600 mm	55 shore	black	
00412	profile rubber easy crease	11 x 15 x 600 mm	55 shore	black	
20090	G 2.5 – C11 soft red	11 x 12.5 x 1,000 mm	25 shore	red	
10969	profile Vulkollan®	14 x 14 x 530 mm	40 shore	yellow	
00442	profile Vulkollan®	10 x 10 x 480 mm	40 shore	yellow	
03542	wedge profile Vulkollan®	12 x 16 x 500 mm	40 shore	yellow	
03543	wedge profile Vulkollan®	14 x 16 x 500 mm	40 shore	yellow	
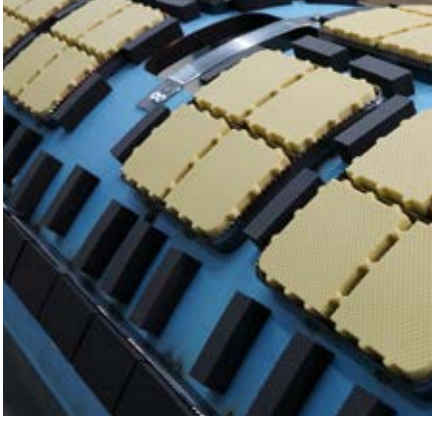
CORRUGATED BOARD RUBBERING.
FORM PARTS FOR ROTARY DIE-CUTTING.

When rotary die-cutting corrugated board, the ejector function is particularly important. We know exactly which rubber should be used at which place. And have an extensive range of rubber materials. The choice is yours.

Form parts

Item no.	Name	Dimensions	Hardness	Color
15821C-1230	cellrubber softpower	12 x 12 x 30 mm	20 shore	black
15821C-1240	cellrubber softpower	12 x 12 x 40 mm	20 shore	black
15822C-1430	cellrubber softpower	14 x 14 x 30 mm	20 shore	black
15822C-1440	cellrubber softpower	14 x 14 x 40 mm	20 shore	black
15822CF-14	cellrubber softpower	14 x 14 x 500 mm	20 shore	black
15822CF-14A	cellrubber softpower	14 x 14 x 500 mm	20 shore	black
06596	marbaject	12 x 12 x 40 mm	20 shore	black
03596CF-25	marbaject	7 x 25 x 1,000 mm	15 shore	black
03597CF-25	marbaject	10 x 25 x 1,000 mm	15 shore	black
03328C-14	marbaject	14 x 14 x 500 mm	20 shore	black
06593	marbaject	16 x 16 x 30 mm	20 shore	black

CORRUGATED BOARD RUBBERING.
PROFILES FOR ROTARY DIE-CUTTING.

Profiles

Item no.	Name	Dimensions	Hardness	Color	Profile
09775M	profile Vulkollan®	10 x 12 x 500 mm	35 shore	yellow	
10969	profile Vulkollan®	14 x 14 x 530 mm	40 shore	black	
03354	marbaprofile|cushion	6.35 x 20 mm	70 shore	black	
03355	marbaprofile|cushion	6.99 x 20 mm	70 shore	black	
03356	marbaprofile|cushion	7.50 x 20 mm	70 shore	black	
03358	marbaprofile|cushion	8.50 x 20 mm	70 shore	black	
03360	marbaprofile|cushion	9.65 x 20 mm	70 shore	black	
03363	marbaprofile|cushion	9.40 x 20 mm	70 shore	black	
03357	marbaprofile|cushion	8.00 x 20 mm	70 shore	black	
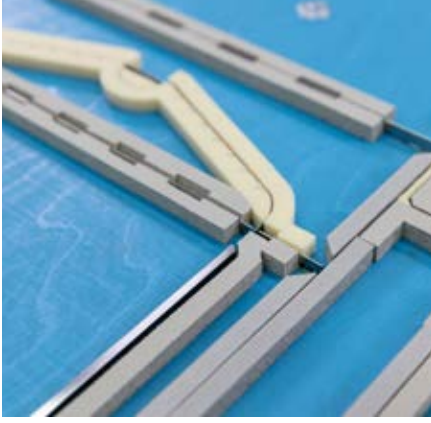
RUBBERING PAPERBOARD.
FORM PARTS & PROFILES
FOR FLAT DIE-CUTTING.

When die-cutting paperboard, the rubbering plays an important role in the die-cutting process. Different paperboard materials require different rubbering. For optimum functionality, the rubbering must be individually adapted to the requirements of the job. The rubbering materials used by Marbach are diverse. And all from carefully selected suppliers. Many even produced exclusively for us. This ensures a long service life and best functionality.

Form parts

Item no.	Name	Dimensions	Hardness	Color
03044CF-07	moose rubber	7 x 7 x 500 mm	35 shore	grey
03007CF-07	Vulkollan®	7 x 7 x 500 mm	40 shore	yellow
03014CF-07	Vulkollan®	7 x 7 x 500 mm	55 shore	yellow
03074CF-07	cellrubber	7 x 7 x 500 mm	15 shore	black

Profiles

Item no.	Name	Dimensions	Hardness	Color	Profile
03477	profile cork	7 x 7 x 1,000 mm	65 shore	brown	
00384	profile rubber NRB	7.3 x 8 x 1,000 mm	70 shore	white	
03309	profile cork; R4.5 strongly rounded	7 x 7,3 x 1,000 mm	65 shore	brown	
03478	profile cork; T-profile rounded	7 x 5 x 1,000 mm	65 shore	brown	
03308	profile cork; CD-profile rounded	7 x 7 x 1,000 mm	65 shore	brown	
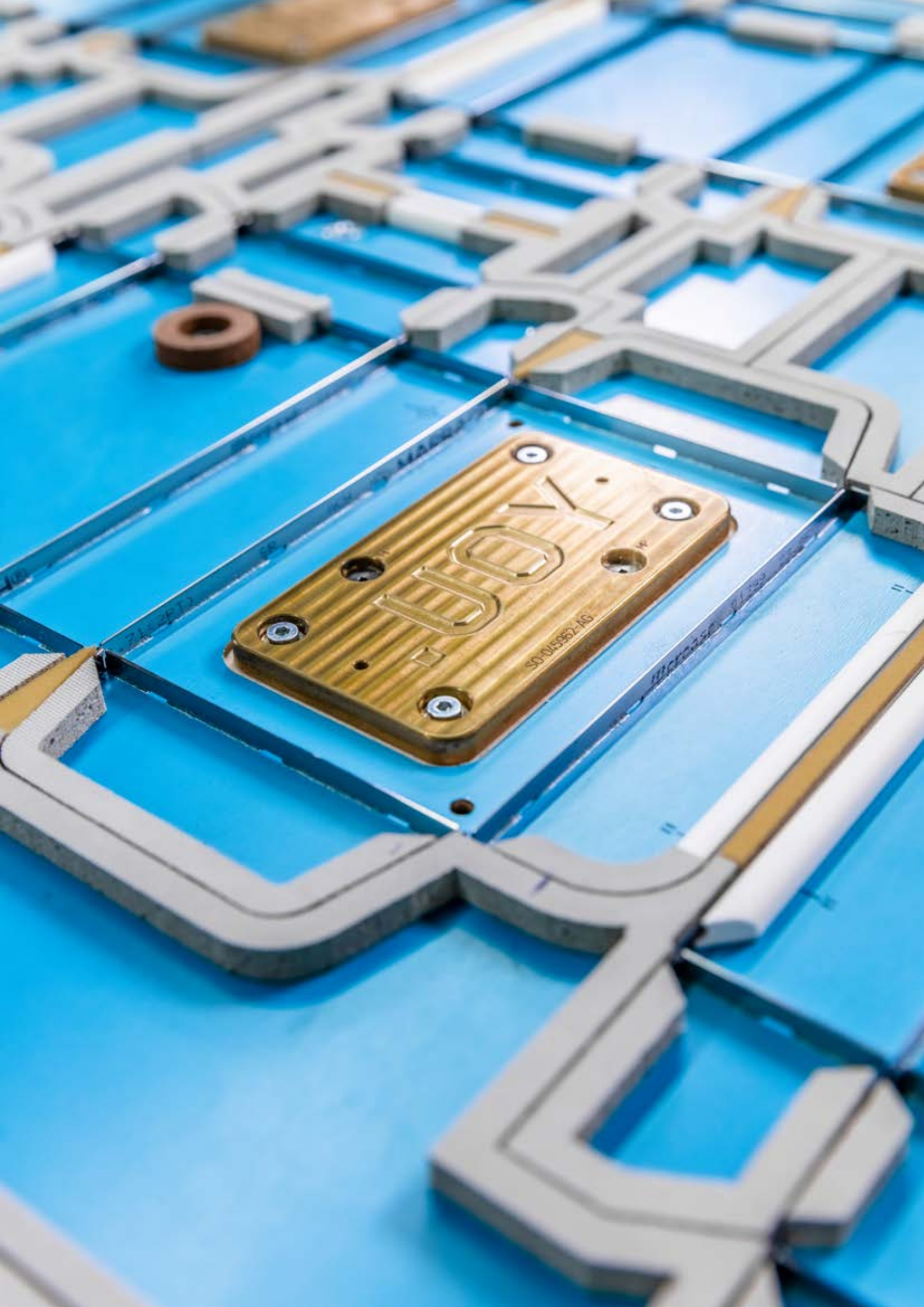
RUBBER PLATES.
CORRUGATED BOARD AND PAPERBOARD.

Item no.	Name	Dimensions	Hardness	Color	PU
15883	cellrubber softpower	7 x 500 x 1,200 mm	20 shore	black	1 plate
15874	cellrubber softpower	8 x 500 x 1,200 mm	20 shore	black	1 plate
15819	cellrubber softpower	10 x 500 x 1,200 mm	20 shore	black	1 plate
15821	cellrubber softpower	12 x 500 x 1,200 mm	20 shore	black	1 plate
03345	cellrubber softpower	13 x 500 x 1,200 mm	20 shore	black	1 plate
15822	cellrubber softpower	14 x 500 x 1,200 mm	20 shore	black	1 plate
15823	cellrubber softpower	16 x 500 x 1,200 mm	20 shore	black	1 plate
15058	cellrubber softpower	18 x 500 x 1,200 mm	20 shore	black	1 plate
03340	marbaject	7 x 500 x 500 mm	20 shore	black	1 plate
03312	marbaject	10 x 500 x 500 mm	20 shore	black	1 plate
03327	marbaject	12 x 500 x 500 mm	20 shore	black	1 plate
03350	marbaject	13 x 500 x 500 mm	20 shore	black	1 plate
03328	marbaject	14 x 500 x 500 mm	20 shore	black	1 plate
06593	marbaject	16 x 500 x 500 mm	20 shore	black	1 plate
03313	marbaject	7 x 500 x 500 mm	35 shore	grey	1 plate
03351	marbaject	10 x 500 x 500 mm	40 shore	yellow	1 plate
03352	marbaject	13 x 500 x 500 mm	40 shore	yellow	1 plate
03353	marbaject	14 x 500 x 500 mm	40 shore	yellow	1 plate
05107	marbaject	16 x 500 x 500 mm	40 shore	yellow	1 plate
03321	marbaject	18 x 500 x 500 mm	40 shore	yellow	1 plate
03007F	Vulkollan®	7 x 250 x 500 mm	45 shore	yellow	1 plate
03207	Vulkollan®	7 x 500 x 250 mm	35 shore	yellow	1 plate
03210	Vulkollan®	10 x 500 x 250 mm	35 shore	yellow	1 plate

Item no.	Name	Dimensions	Hardness	Color	PU
03007	Vulkollan®	7 x 500 x 250 mm	45 shore	yellow	1 plate
03010	Vulkollan®	10 x 500 x 250 mm	45 shore	yellow	1 plate
03014	Vulkollan®	7 x 500 x 250 mm	55 shore	yellow	1 plate
03260	Vulkollan®	10 x 500 x 250 mm	55 shore	yellow	1 plate
03122	rubber cork	7 x 500 x 1,000 mm	65 shore	brown	1 plate
03123	rubber cork	10 x 500 x 1,000 mm	65 shore	brown	1 plate
03552	Aclathan®	9.2 x 500 x 250 mm	65-70 shore	amber	1 plate
32005	elastopower	10 x 500 x 500 mm	20 shore	yellow	1 plate
32006	elastopower	10 x 500 x 500 mm	40 shore	orange	1 plate
32011	elastopower	12 x 500 x 500 mm	15 shore	white	1 plate
32007	elastopower	14 x 500 x 500 mm	15 shore	white	1 plate
32004	elastopower	16 x 500 x 500 mm	45 shore	brown	1 plate

partly available with adhesive film on request

EMBOSSING.
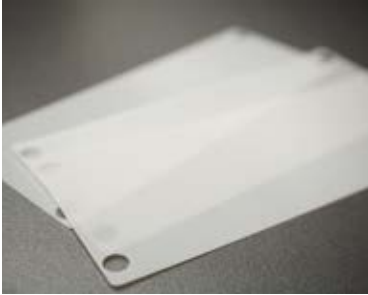
Shim foils

Pressure-resistant foils in defined thicknesses. For accurate and fast make-ready.

PU = 50 m roll

Item no.	Name
00670	0.05 x 600 mm
00673	0.10 x 610 mm
00671	0.20 x 600 mm

Torx screwdriver

Screwdriver for embossings and crease plates. Torx version. For best power transmission.

Item no.	Name
44212	Tx8
44211	Tx20
44215	Tx8 x 60

Memo pin system

Special pins for archiving the embossing position in the blank.

PU = 100 pcs.

Item no.	Name
14065	M4 x 12 allen
14080	disc for M4
14059	M3 x 12 allen
14081	disc for M3
13040	M4 x 8 torx for 3 mm female plate
13041	M4 x 8 allen for 3 mm female plate
15005	memopin

CREASE PLATES.

Flat screw sockets

Screw sockets for flat head screws. For secure fastening of crease plates. And easy positioning. In different versions.

Item no.	Name
13082	11.5/17.5/Ø 8.0 mm
13089	11.5/17.5/Ø 8.5 mm

Flat screws and washers

Special screws for the assembly of crease plates. Torx version. Suitable for flat screw sockets item no. 13082 and 13089.

Item no.	Name
13040	M4 x 8 Torx
13041	M4 x 8 hexagonal
14085	disc 4 x 8 x 0.5 mm
44212	screwdriver Tx8

Fitting pins and sockets

For crease plates with flat sockets and embossing register system.

Item no.	Name
14369	Marbach 5 mm pins Ø 5 x 50 mm
55794	crease plate fixation
14176	drill socket, length 12 mm

Countersunk screw sockets

Special countersunk screw sockets. Without pins. User-friendly and space-saving. No additional cutout in the crease plate necessary. For narrow places. And fast and easy positioning of the creasing plate.

Item no.	Name
55797	11.5/20/Ø 8.0 mm

Countersunk screws

Special countersunk screws for screwing crease plates. Torx version. With extremely flat head. Suitable for countersunk screw sockets item no. 55797.

Item no.	Name
42801	M4 x 10 Tx20
44211	screwdriver Tx20

Brass sockets for crease plates

Sockets for mounting brass thread inserts of embossings into the crease plate. In two versions: M3 and M4.

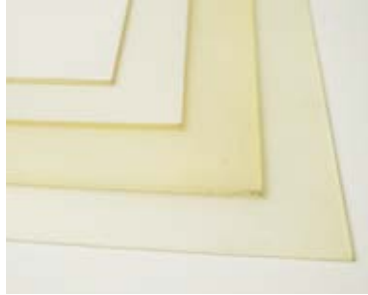| Item no.	Name
14325	thread inserts M3
14326	thread inserts M4

BRAILLE.

Braille female embossing die

Standard marbabraille female embossing dies in different versions. As a counterpart to marbasteel male embossing dies. For optimal shaping of braille dots. And an optimal braille result.

on request

Elastomer segments

Elastic base as raw material. For cutting to size. For elastic embossing.

Item no.	Dimensions
09789	480 x 250 x 1.45 mm
09790	480 x 250 x 1.40 mm
09791	160 x 300 x 1.05 mm
09792	160 x 300 x 1.55 mm

Screws and pins

Fixing elements for marbabraille female embossing dies on the cutting-die.

PU = 100 pcs.

Item no.	Name
14236	lens head screw M 3x5
06607	rectangular bolt 5 x 5 x 19.50 mm

Shim foils

Pressure-resistant foils in defined thicknesses. For accurate and fast make-ready.

PU = 50 m roll

Item no.	Name
00670	0.05 x 600 mm
00673	0.10 x 610 mm
00671	0.20 x 600 mm

Adhesive foils

Double-sided adhesive foil for lamination. For various purposes of application.

Item no.	Name
44011	0.10 mm x 25 m
44101	0.13 mm x 50 m
44012	0.20 mm x 10 m
44103	0.25 mm x 10 m
00586	magnetic foil 0.65 x 615 mm x 30 m

Digimes

Digital measuring device for determining the height of braille dots on the male embossing die and on the paperboard. Fast and safe. According to DIN EN 15823.

- Measuring range: 0-10 mm
- Resolution: 0.01 mm
- Switching inch/mm

Item no.	Name
G-1750	Digimes

STEEL AND WOODEN RAILS.

Wooden rails multiplex natural, lower part stabilization

Item no.	Name	Application	Version	PU
L-HLZ25	25 mm	paperboard processing machines	15 mm | 18 mm	50 pcs.
L-HLZ35	35 mm	paperboard processing machines	15 mm | 18 mm	50 pcs.
L-HLZ50	50 mm	corrugated board processing machines	12 mm | 15 mm	50 pcs.

Steel rails, lower part stabilization

Item no.	Name	Application	Version	PU
L-STL25	25 mm	paperboard processing machines	4 mm | 6 mm	50 pcs.
L-STL35	35 mm	paperboard processing machines	4 mm | 6 mm	50 pcs.
L-STL50	50 mm	corrugated board processing machines	2 mm | 3 mm | 4 mm	50 pcs.

Fixing elements for steel rails

Item no.	Name	Application	Version	PU
07481	mounting angle steel	rail fixation wood and steel	20 x 25 x 25 mm	500 pcs.
13280	flat head screw	mounting steel rails (angle)	M6 x 12 mm	100 pcs.
00738	pan head screw	mounting wooden rails claw	M6 x 25 mm	100 pcs.
04986	drive-in nut	assembly lower part with angle	M5 x 8 mm	1,000 pcs.
13284	flat head screw	assembly lower part with angle	M5 x 10 mm	100 pcs.
14284	claw plastic	assembly with rails	25 mm	100 pcs.

Cross stabilization SPO

Item no.	Name	Application	Version	PU
19028	stabilization tube	assembly with wooden rails	2,000 mm	25 pcs.
09158	clamping block standard	assembly pipe with lower part	45 x 15 x 39 mm	100 pcs.
09157	clamping block end piece	assembly of pipe with lower part	25 x 30 x 39 mm	100 pcs.
14163	lens head screw	assembly of clamping blocks	M5 x 30 mm	100 pcs.

STRIPPING.

Speed Lift and Speed Lift-S

Sheet lifter for stripping tools. Retrofittable. In 2 sizes. The Speed Lift Precision drill drills the appropriate cut-outs.

PU = 500 pcs.

Item no.	Name
13045	Speed Lift Ø 40 mm
13046	Speed Lift Precision drill
13091	Speed Lift-S Ø 20 mm
13092	Speed Lift-S Precision drill

Easy-Fix and Easy-Fix-S

Transport locks for tools. One-piece, making them fast and safe to handle. Available in the two versions Easy-Fix (stripping lower and upper part) and Easy-Fix-S (guillotine with tool).

PU = 1,000 pcs.

Item no.	Name
07450	Easy-Fix blue*
06900	Easy-Fix-S blue*

*only as long as stock lasts

Precision lower pin for Marbach lower pin unit

Specially developed: This precision lower pin ensures stable and safe stripping processes in the Marbach lower pin unit during packaging production.

PU = 50 pcs.

Item no.	Name
00371	standard (Ø 4 mm)
00370	reduced diameter (Ø 2 mm)

Precision lower pin

Special precision lower pins for stable stripping processes in packaging production. It is manufactured extremely precisely from high-quality materials and is very accurate in position due to its narrow guide tolerances. Re-adjustment in the die-cutting machine is not necessary. For trouble-free and waste-free stripping processes.

PU = 50 pcs.

Item no.	Name
20371	standard (Ø 4 mm)
20370	reduced diameter (Ø 2 mm)

Bottom pin

The standard bottom pin for stripping: 4 mm. And for the smallest waste parts, a special bottom pin. Turned down to 2 mm. So that even the smallest waste parts can be stripped safely and stably.

PU = 50 pcs.

Item no.	Name
10841	reduced diameter (Ø 2 mm)
10840	standard (Ø 4 mm)

marbapoint

The precision set-up aid for a highly efficient stripping process. So set-up of the stripper in the cutting machine is easy as pie.

Item no.	Name
09966	marbapoint set
09984	marbapoint
914706	replacement battery
15048	recording socket
09971	magnet holder marbapoint

Stripping claws

Unique. For dynamic stripping. The waste is held in place with the claw tips. And pressed through the lower tool. The special support technology in the lower tool ensures a controlled stripping of the waste. Available in various sizes. Left and right.

PU = 500 pcs.

Item no.	Name
09502	4 mm left
09503	4 mm right
09504	6 mm left
09507	6 mm right
09508	8 mm left
09509	8 mm right
09501	10 mm left
09511	10 mm right
09512	12 mm left
09513	12 mm right
09515	15 mm left
09516	15 mm right
09520	20 mm left
09521	20 mm right

further claw types on request

marbafly|c

Sheet lifting aid for corrugated board.

PU = 100 pcs.

Item no.	Name
08968	marbafly|c

Crown pins

They firmly fix the waste. And are used in places where a claw does not fit. Especially useful for tiny waste pieces. And small side waste. Available in various sizes.

PU = 1,000 pcs.

Item no.	Name
42421	Ø 1.8 mm
42399	Ø 2.2 mm
42422	Ø 3.0 mm
42423	Ø 5.0 mm

marbafly|s

Sheet lifting aid for paperboard. The paperboard sheet. It flies through the stripping station. Thanks to the marbafly. This special lifting aid supports the smooth transport of the paperboard sheet during the stripping process.

PU = 100 pcs.

Item no.	Name
09232	marbafly|s

Assembly aid

Simple. But effective. Special assembly aid for the assembly of crown pins. Or marbastrip claws.

PU = 1,000 pcs.

Item no.	Name
10456	Ø 1.8 mm
10455	Ø 2.2 mm
10458	Ø 3.0 mm
10457	Ø 5.0 mm
09708	claws

Spring elements

Special telescope spring elements for Marbach stripping tool masterstrip|plate. In 2 versions.

Item no.	Name
07703	threaded
14920	M6 x 16 mm
07706	pin
14072	3 x 16 mm

BLANKING.

Jogger tape

Jogger tapes for guiding the blanks during the blanking process. With steel insert. They ensure safe stacking of the blanks.

Item no.	Dimensions
14157	19.0 mm; 16.5 m
44030	25.4 mm; 16.5 m
07550	steel insert 12.7 x 0.10 mm; 5 m

Center block

Center block for insertion into the blanking tool. Ensures fast and accurate positioning of the tool in the die-cutting machine. For fast set-up times.

PU = 100 pcs.

Item no.	Name
07427	center block
	further versions on request

Distance element

Distance element for stripping and blanking tools. Provides best stability due to its extra large contact surface.

PU = 100 pcs.

Item no.	Name
14425	bolt (30 mm)
50203	sleeve (30 mm)

Pusher Spot

Conventional spot presser that can be used to fix the waste separation grid in place during blanking. Stable and secure.

Item no.	Name
34148	Pusher Spot
13220	M6 x 35 mm for mounting pusher

Pusher for bar

Conventional surface presser for use with a presser bar. This is used to fix the edge waste in place during the blanking process. Stable and secure.

Item no.	Name
34150	Pusher for bar
19073	bar blue
14328	M5 x 10 mm mounting bar
13220	M6 x 35 mm for mounting pusher

Pusher for plate

Conventional presser for use with an order-related presser plate. For flat fixation of the entire waste during the blanking process. Stable and secure.

Item no.	Name
34149	Pusher for plate
15043	M6 x 20 mm for mounting plate
13220	M6 x 35 mm for mounting pusher

Joggers

For optimum guidance of the sep-arated blanks in the trim area. Lightweight, stable and inexpen-sive. Available in various lengths. Individually adaptable.

PU = 100 pcs.

Item no.	Name
99072	standard
13189	4.5 x 25 mm
44213	4.5 x 15 mm
99073	version long
09927	version small
13190	5 x 20 mm
13191	5 x 35 mm

marbapusher|p

This presser is an all-rounder. It can be used for both presser pla-tes and custom-shaped presser bars. And it saves storage space as it doesn't stand out on the back of the tool.

PU = 100 pcs.

Item no.	Name
34134	marbapusher|p
14072	3 x 16 mm
44213	4.5 x 15 mm (for plate/rail)

marbapusher|s

The Marbach telescopic press-er. Lightweight, economical and space-saving. Flush to the back of the tool. Fits even where there is little room.

PU = 100 pcs.

Item no.	Name
34147	marbapusher|s
14072	3 x 16 mm

marbapusher set

Pressers designed by Marbach. Lightweight, versatile and eco-nomical. Quick and safe assembly in seconds. Set of 25 pcs. with fit-ting keys. Without screws.

Item no.	Name
34159	marbapusher set

marbapusher

Pusher developed by Marbach for the selective fixation of waste ar-eas. Lightweight, flexible to use and inexpensive. Quickly mounted and easy to handle.

PU = 100 pcs.

Item no.	Name
34158	marbapusher

SMALL COMPONENTS.

T-nuts

T-nuts for die fixing in the counter chase. With and without thread.

PU = 500 pcs.

Item no.	Name
14045	M10 x 13 mm
04988	M8 x 11 mm
14039	M6 x 12 mm
14051	M6 x 9 mm
04981	M6 x 14 mm
14052	M5 x 12 mm
04986	M5 x 18 mm
04993	M4 x 12 mm
04989	M4 x 8 mm

Speed mounts

Elements for attaching rotary cutting-dies to the die-cutting cylinder. For a secure connection. In two different versions. Round hole for precise positioning. Slotted hole for flexible use. In aluminum version for even more stability.

PU = 100 pcs.

Item no.	Name
08548	round hole
08545	slotted hole

Lock-up chase screws

Countersunk head screws for fast mounting of the cutting-die in the cutting chase. Available in sizes M5 (for corrugated board) and M4 (for paperboard).

PU = 100 pcs.

Item no.	Name
14251	M5 x 20 mm
14366	M4 x 20 mm
14367	M4 x 18 mm

Corner protection

Special elements to protect the edges of the tool. For a long service life. And to ensure that the tool slides into the machine.

PU = 100 pcs.

Item no.	Name
09226	18 mm
09225	15 mm
09200	12 mm

Center notch reinforcement

Plastic elements that prevent the notch of your cutting-die from getting loose. And thus to ensure dimensional stability and fast and precise tool positioning. Permanently and safe.

PU = 100 pcs.

Item no.	Name
07479	center reinforcement black

Mini perfatypes

Perforation marks for numbering of ups.

PU = 25 pcs.

Item no.	Name
19300	perfatype 0
19301	perfatype 1
19302	perfatype 2
19303	perfatype 3
19304	perfatype 4
19305	perfatype 5
19306	perfatype 6
19307	perfatype 7
19308	perfatype 8

Standard perfatypes

PU = 25 pcs.

Item no.	Name
08396	perfatype -
08347	perfatype /
08301	perfatype 0
08302	perfatype 1
08303	perfatype 2
08304	perfatype 3
08305	perfatype 4
08306	perfatype 5
08307	perfatype 6
08308	perfatype 7
08309	perfatype 8
08321	perfatype A
08322	perfatype B
08323	perfatype C
08324	perfatype D
08325	perfatype E
08326	perfatype F
08327	perfatype G
08328	perfatype H
08329	perfatype I
08330	perfatype J
08331	perfatype K
08332	perfatype L
08333	perfatype m
08334	perfatype N
08301	perfatype O
08336	perfatype P
08337	perfatype Q
08338	perfatype R
08339	perfatype S
08340	perfatype T
08341	perfatype U
08342	perfatype V
08343	perfatype W
08344	perfatype X
08345	perfatype Y
08346	perfatype Z

Special perfatypes

Special perfatype "RESY" label and "green point" label. For insertion into the cutting-die. For rotation with notch on the back.

Item no.	Name
07051	RESY label
07065	mini RESY label
08368	green point label

Perfatype mounting rail

Mounting rails for perfatypes. Fast exchange of digits. The right rail for every kind of perfatype.

Item no.	Name
55600	green for type 3.0
55601	red for type 1.8
55602	blue for type 2.5
55603	black for type 3.5

Handles for rotary dies

Special handles for rotary half-shells. For optimized handling and higher work safety.

PU = 100 pcs.

Item no.	Name
42411	plastic, blue

Quick-release clamps

Quick locking system for rotary machines. For reduced set-up times.

PU = 50 pcs.

| Item no.	Name
08348	Ø 487.3 mm
08349	Ø 366.2 mm
08351	Ø 270.2 mm
09617	Ø 240.9 mm
08450	Ø 177.0 mm
03270	washers

MDSS.
PERFECTLY STORED.

Good in-house logistics saves you time. Store your cutting-dies in the Marbach Die Storage System (MDSS). The MDSS is available for flat and for rotary cutting-dies.

In the MDSS the dies are stored safely, can be found quickly and are accessible at any time. Due to its modular design, it can be configured according to your individual requirements. Depending on the MDSS version, various handling systems are available to transport the dies quickly and safely to their place of use.

Item no.	Name
G-6000	modular system, price depends on number and size of cassettes or shell diameters
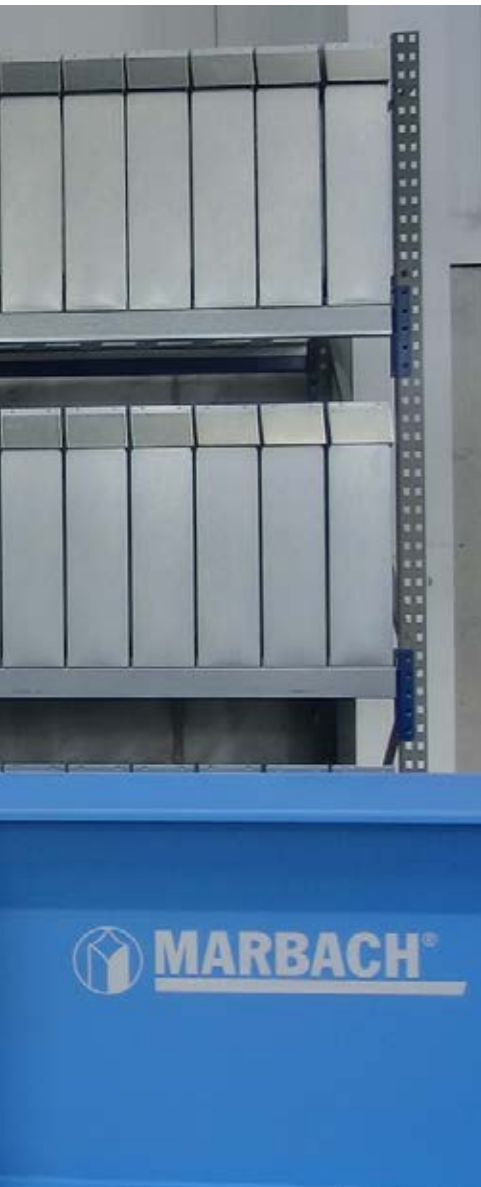
CREASE BEND TESTER.
MEASURING PAPERBOARD SAMPLES.

The packaging has to fit. To the product and to the filling process. For optimum packaging quality, you need a suitable control system. A system with which you can reliably measure the crease values and the folding resistance of a package. A system that makes no mistakes. A system that ensures maximum machine speeds and a smooth packaging process for your customers.

The crease bend tester is a quality assurance system for your entire packaging process: from the initial tests in the laboratory to continuous tests during packaging production. All the way to the final inspection before the packaging is delivered to your customer. But that's not all. The crease bend tester is also the device of choice for optimizing repeat orders and checking incoming material deliveries.

Item no.	Name
G-4100	crease bend tester

SAMPLE CUTTER.
CUT AND CREASE PAPERBOARD SAMPLES.
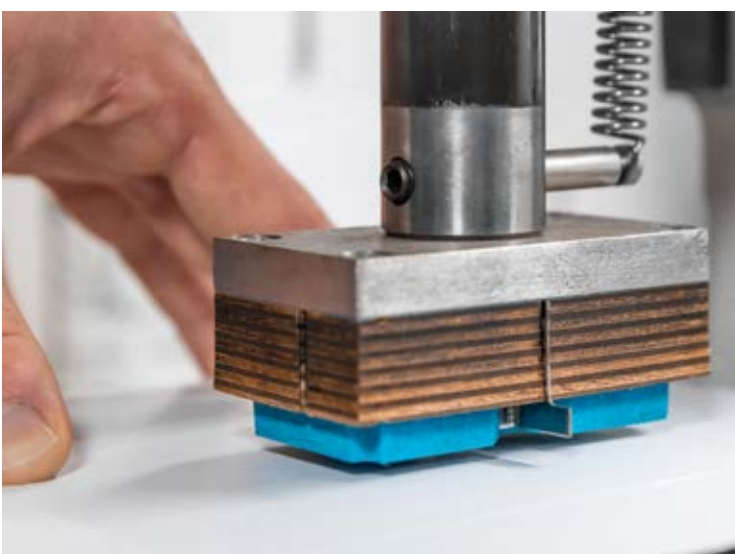
For an easy production of test samples for the crease bend tester it is recommended to use the sample cutter. With this, samples with the size 60 mm x 25 mm can be cut. The sample cutter and suitable tools are equipped with a visual aid. This ensures the correct position for cutting the paperboard strips quickly and precisely.

Item no.	Name
G-4010	sample cutter

HYDRAULIC PRESS.
CREATE CREASED SAMPLES.
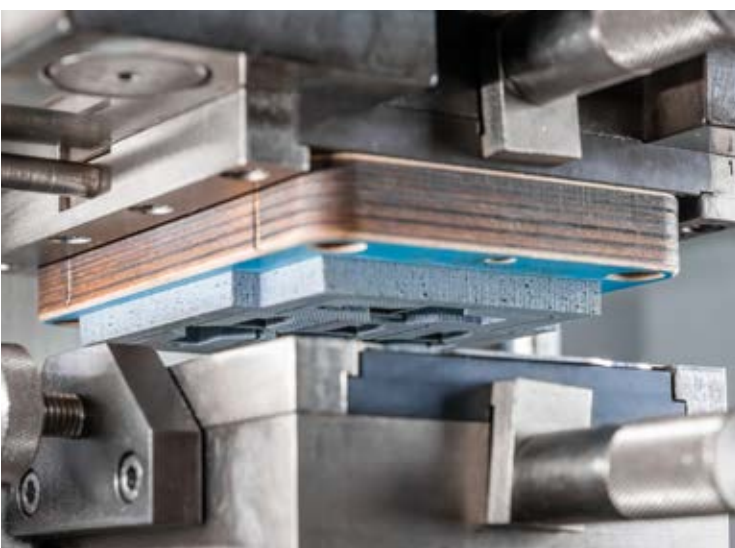
The hydraulic press allows you to easily create a number of creased samples with different specifications of creasing rules and creasing channels. After creasing, the visual control of the samples itself gives useful information about the characteristics of the material. The hydraulic unit of the press can create a pressure of up to 60 kN.

Item no.	Name
G-4040	hydraulic press

MARBACH ACADEMY.
FOR YOUR MAXIMUM PERFORMANCE.

More knowledge. More skills.

Benefit from Marbach. And more than 100 years of experience.

- In the production of cutting-dies. For folding boxes. For corrugated board packaging. And cigarette packaging.
- In the application of cutting-dies. In die-cutting. In stripping. In blanking. And refining.

MAXIMUM PERFORMANCE.

Under the motto "More knowledge. More skills." we share our experience. With all who want to optimize their die-cutting process. Aim for maximum performance in the production of their packaging. That expect tips and tricks that can be put into practice immediately. And last but not least, have all the same goal: to optimize the die-cutting process. To work efficiently and productively. To reduce costs. And to produce great packaging for success at the point of sale.

IN THEORY AND PRACTICE.

All Marbach trainings have one thing in common: they do not only provide theoretical knowledge. But always show the application in practice. Operated by trainers who have to know it: Application engineers and packaging technicians. All of them with decades of experience. In theory and practice.

TRAINING PROGRAMME

The following training courses are offered at the Marbach Acadamy:

Paperboard

- Compact course. Die-cutting and refining of paperboard. (FS-02-E)
- Intensive course. Die-cutting of paperboard. (FS-INT-E)
- Compact course. For paperboard manufacturers. (M-KHS-E)

Tobacco

- Intensive course - offline. Die-cutting of cigarette packaging. (Z-INT-E)

Corrugated board

- Compact course. Die-cutting and refining of corrugated board. (WP-02-E)

Individual training courses

- Choose between new different modular training courses or your own favourite topic.

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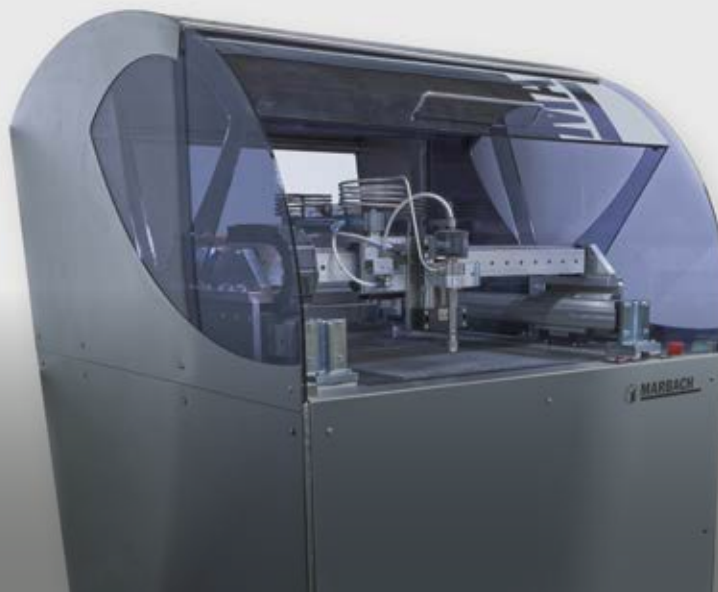**Marbach Academy. More knowledge. More skills.**
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