

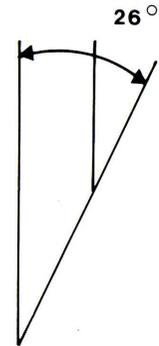
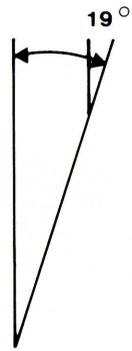
All of these features are programmable on most modern guillotines, including clamp pressure for automatic compensation.

Do not ignore the grip and lay edges. Always knock up the work and put the grip edge to the back so that the first cut is opposite this. The second cut should be opposite the lay edge. If you put an unknocked edge up to the back stop of the guillotine, inaccuracy of cut will occur sheet-to-sheet. It is best to use a jogger for printed material.

Having the correct knife with the proper angle, etc, can all be ruined if the operator does not have the right clamp pressure for the job in hand. Generally, soft stock requires high and hard stock low clamp pressure, but never set it higher than is necessary.

If the pressure is too low then, depending on the sharpness of the knife, there is likely to be an undercut. If too high pressure is exerted on hard stock, a rigid block will be formed along the cutting line and the blade will take the line of least resistance, resulting in an overcut. The clamp pressure should always be more than the pressure presented to the stock by the knife.

The correct clamp pressure depends on the pile height, the cutting length, the sharpness of the cutting edge and the material being cut. Since the sharpness of the knife varies with time, the operator must gain a feel for what is correct in each case - *Oscar Friedheim*.



Always use the correct knife angle for the stock being cut.