



C&T

CHANNEL

ORIGINAL

STEEL BASED MATRIX

THE WORLD'S MOST
ADVANCED CREASING
MAKE-READY SYSTEM

www.channel-matrix.com

ORIGINAL

STEEL BASED MATRIX

CENTRED

Color	Depth	Width	Length
Gold	0.38 *	0.56	1/1.5
Orange	0.38 *	0.8	2/3
Buff	0.38 *	1.0	2/3
Cloud	0.38 *	1.3	2/3
White	0.43 *	1.3	2/3
Sky	0.45 *	1.4	2/3
Lime	0.43 *	1.5	2/3
Yellow	0.48 *	1.5	2/3
Violet	0.48 *	1.7	2/3
Mauve	0.53 *	1.7	2/3
Olive	0.53 *	1.9	2/3
Green	0.58 *	1.9	2/3
Pink	0.58 *	2.1	2/3
Maroon	0.63 *	2.1	2/3
Red	0.68 *	2.3	2/3
Blue	0.79 *	2.7	2/3
Brown	1.0 ▲	3.0	3/4/6
Grey	1.3 ▲	3.8	3/4/6
Black	1.6 ▲	5.0	3/4/6
Cream	2.0 ▲	6.3	3/4/6

OFF CENTRE

Color	Depth	Width	Length
Orange	0.38 *	0.8	2/3
Buff	0.38 *	1.0	2/3
White	0.43 *	1.3	2/3
Sky	0.45 *	1.4	2/3
Lime	0.43 *	1.5	2/3
Yellow	0.48 *	1.5	2/3

MULTI CREASE

Color	Depth	Width	Length
3.00	0.38 ▲	1.0	2/3
3.50	0.38 ▲	1.0	2/3
4.00	0.38 ▲	1.0	2/3
5.00	0.38 ▲	1.0	2/3
3.00	0.43 ▲	1.3	2/3
3.50	0.43 ▲	1.3	2/3
4.00	0.43 ▲	1.3	2/3
5.00	0.43 ▲	1.3	2/3
3.00	0.48 ▲	1.5	2/3
3.50	0.48 ▲	1.5	2/3
4.00	0.48 ▲	1.5	2/3
5.00	0.48 ▲	1.5	2/3

EXTRA DEEP

Color	Depth	Width	Length
Black	0.55 *	1.30	2/3
Brown	0.70 *	1.50	2/3
Grey	0.80 *	1.90	2/3
Orange	0.90 *	2.30	2/3
Yellow	1.30 ▲	3.00	3/4/6
Green	1.60 ▲	3.80	3/4/6
Red	2.00 ▲	5.00	3/4/6



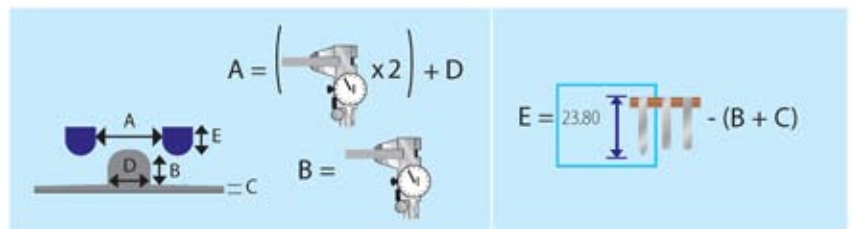
KEY

- ★ < 7mm base / 24 metres per box
- < 9.5mm base / 18 metres per box
- ▲ < 12mm base / 12 metres per box

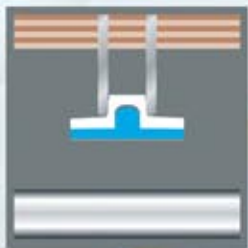
REVERSE BEND

The reverse bend matrix can be used where creasing on both sides of the board is required. In this application, the two creasing rules are inserted in the die to form the channel and the ridge on the matrix which acts as a creasing rule.

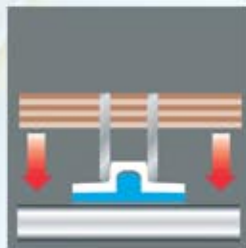
	CALIPER	DISTANCE BETWEEN CREAMING RULE	HEIGHT OF NIB	BASE THICKNESS	WIDTH OF NIB	CREASING RULE HEIGHT
						
RB1 Red	300-550 ▲	2.0	0.5	0.3	0.7	23.00
RB2 Yellow	550-750 ▲	2.7	0.7	0.3	1.0	22.80
RB3 Buff	750 - 1000 ▲	4.0	0.9	0.3	1.5	22.60
RB4 Green	1000-1300 ▲	4.5	1.1	0.3	2.0	22.40
RB5 Blue	1300-1600 ▲	5.0	1.3	0.3	2.0	22.00
RB6 Violet	1600 - 2000 ▲	6.0	1.8	0.3	3.0	21.7



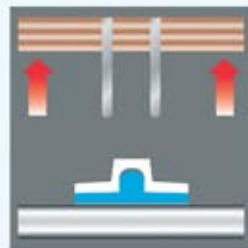
SELF LOCATING



1
APPLY CUT LENGTHS OF CHANNEL REVERSE BEND TO THE GAP BETWEEN THE CREAMING RULES AND REMOVE THE BACKING TAPE



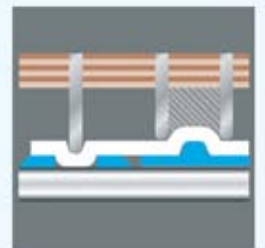
2
OPERATE THE PRESS FOR ONE COMPLETE CYCLE TO FIX MATRIX TO THE CUTTING PLATE



3
AT THE END OF THE CYCLE, THE CREAMING RULES EXTRACT THEMSELVES FROM THE MATRIX LOCATOR



4
PEEL OFF THE LOCATOR STRIP TO REVEAL THE MATRIX IN EXACT REGISTER FOR A PERFECT REVERSE BEND



5
REVERSE BEND IS USED FOR CREAMING BOARD FROM BOTH SIDES IN ONE PASS

*AFTER REMOVAL OF LOCATOR, A SAFE EJECTOR RUBBER OR SPONGE MAY BE REQUIRED TO PREVENT CRACKING.

NORMAN HAYNES LTD.

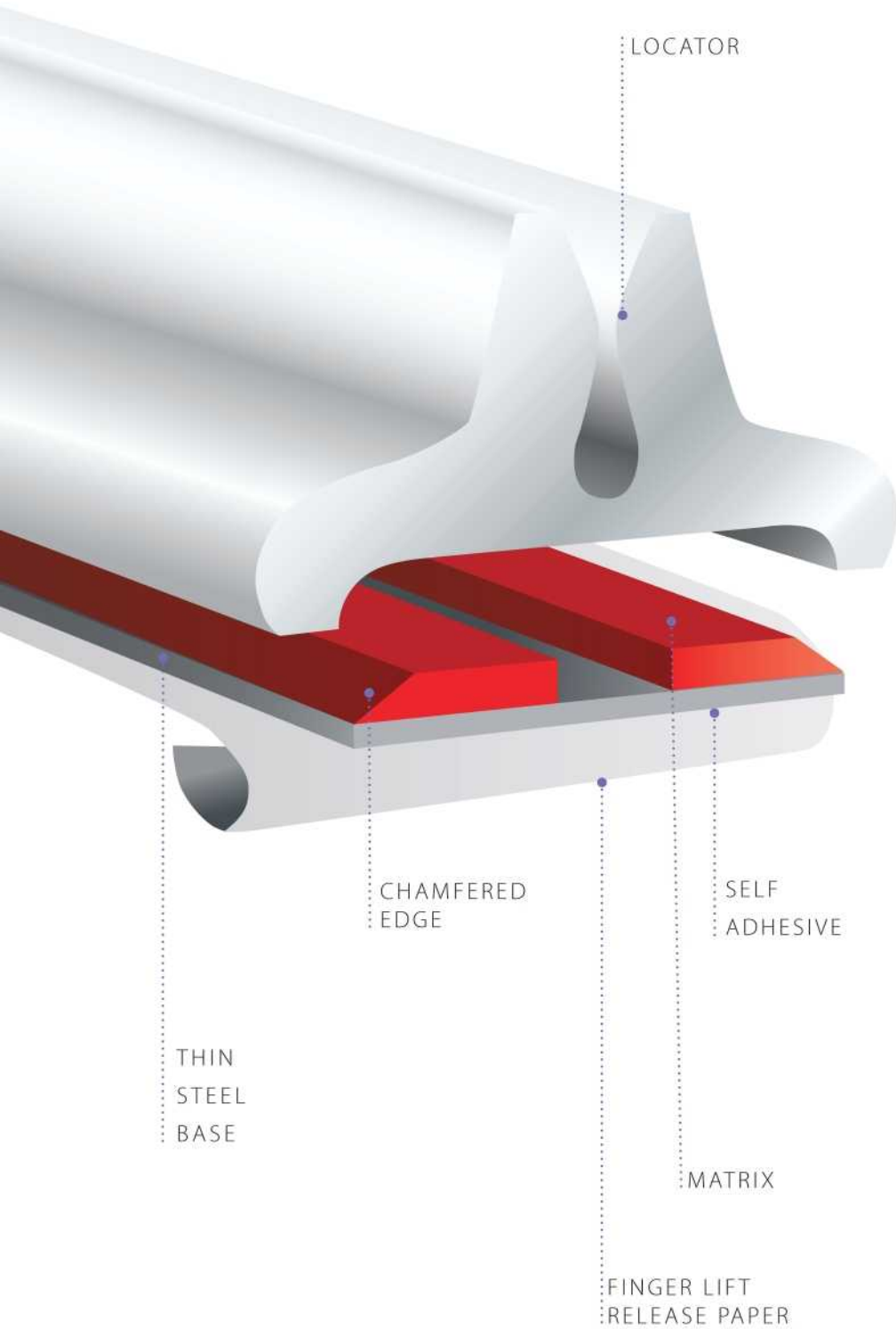
PRINT FINISHING SYSTEMS AND SOLUTIONS

Fairweather Green Works, 900 Thornton Road, Bradford, West Yorkshire, BD8 0JG

Tel. 01274 545115 - Fax. 01274 545113

Email. info@normanhaynes.co.uk

www.normanhaynes.co.uk



LOCATOR

CHAMFERED
EDGE

SELF
ADHESIVE

THIN
STEEL
BASE

MATRIX

FINGER LIFT
RELEASE PAPER

ORIGINAL STEEL BASED MATRIX

YOUR SIMPLE GUIDE TO
CHOOSING YOUR MATRIX

BASED ON 23.80mm CUTTING RULE HEIGHT
& 0.1mm THIN FILM BASE MATRIX

Measure your board thickness

$$D = \text{[] mm}$$

(100µm = 0.1mm)

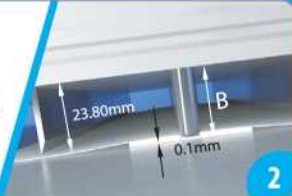


1

Work out your
Creasing Rule height

$$B = 23.80 - \text{[]} - 0.1$$

$$B = \text{[] mm}$$



2

The height of the Matrix is
equal to the depth of the board

$$\text{Height} = \text{[] mm}$$



3

Calculate the channel width
using a 0.7mm, 2pt rule

$$1.5 \times \text{[]} + 0.7$$

$$= \text{[] mm}$$



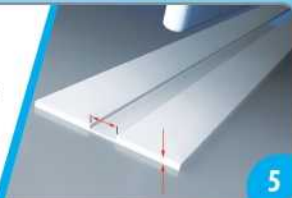
4

for < 600 microns x 1.5
for > 600 microns x 2.0

My matrix size is:

$$\text{Height} = \text{[] mm}$$

$$\text{Width} = \text{[] mm}$$



5

Your local distributor is:

Norman Haynes Ltd.
Fairweather Green Works, 900 Thornton Road,
Bradford, West Yorkshire, BD8 0JG
Tel. 01274 545115 - Fax. 01274 545113
Email. info@normanhaynes.co.uk
www.normanhaynes.co.uk



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

01/10

MAK156/06/11

UK ORDERS 0800 1382182 EMAIL sales@channel-matrix.com

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