



Martin Miller Steel Rule

Available Rule Thicknesses:

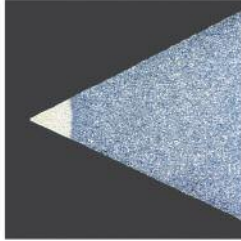
1-1pt / 0.40mm • 1.3 pt / 0.45mm • 1.5 pt / 0.53mm • 2 pt / 0.71mm • 3 pt / 1.05mm
• 4 pt / 1.42mm • 6 pt / 2.13mm • 8 pt / 2.84mm

Heights:

7mm • 8mm • 10mm • 12-100mm



Edge Hardened Cutting Rules



HP Plasma Hardened

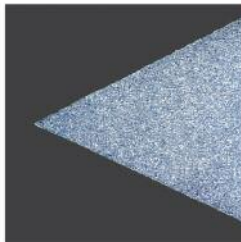
HP Properties

- Edge-hardened by plasma process
- Long Die Life, edge hardness of 70 HV (60 HRC)

HP Applications

- Small to medium size runs/number of cuts
- Dust reduction
- Optimized for tight bends

Through Hardened Cutting Rules



MM Through Hardened

MM Properties

- Same hardness of cutting edge and body
- Good bendability due to soft and ductile surface layer

MM Applications

- Small to medium size runs/number of cuts
- Dust reduction
- All purpose rule (carton, corrugated)

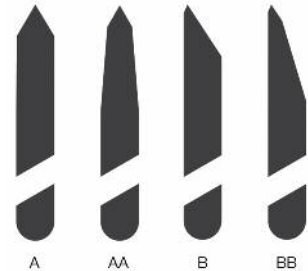
Cutting Edge Geometry

Bevels

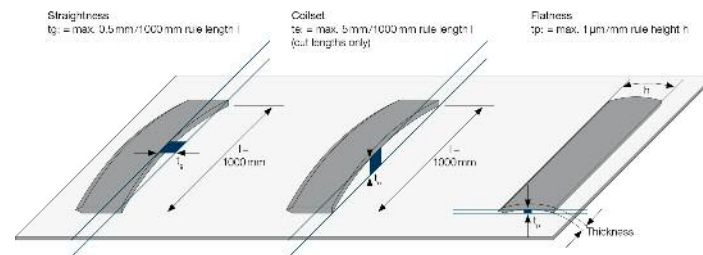
- A – Center bevel
- AA – Long center bevel
- B – Side bevel
- BB – Long side bevel

Standard angle of the bevel: 54°
(for all bevel-types)

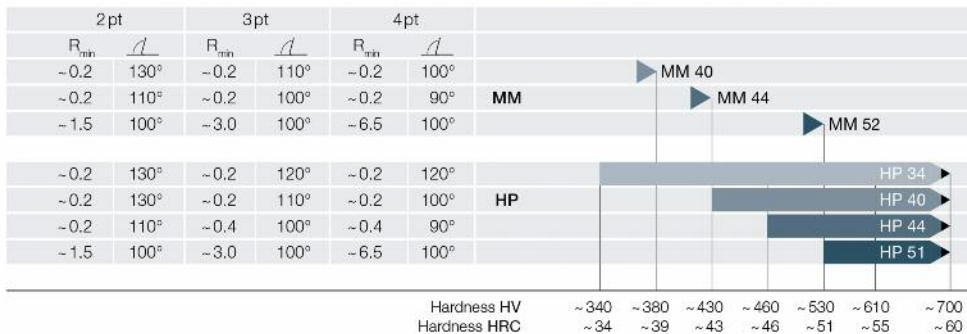
Other possible angles of the bevel:
30°/35°/40°/42°/50°/60° (A-bevel only)



Straightness / Coilset / Flatness



Bendability / Hardness Scale



Continued next page...



2041 Elm Court, Ontario, CA 91761
Local: 909-947-3044 • Fax: 909-923-7809



827 S. Great S'west Pkwy., Grand Prairie, TX 75051
Local: 214-630-4695 • Fax: 214-630-5425



960 Industrial Drive, Elmhurst, IL 60126
Local: 630-782-6230 • Fax: 630-782-6220

800-423-4478 TOLL-FREE ALL LOCATIONS!

www.wagnerdiesupply.com
sales@wagnerdiesupply.com



Martin Miller Steel Rule (continued)

Bevel Types



Shaved bevel - standard
Martin Miller cutting rules have a shaved bevel edge as standard which offers a very high degree of accuracy and edge straightness as well as excellent bending properties.



ExtraSharp ES bevel - rectangular ground
Micro-teeth on the bevel provides good cutting results on plastics, rubber and laminates. High sharpness and low friction reduces dust and "angel hair."



Reflexion R - special bevel
Reflexion R has a very smooth bevel structure which greatly improves bendability when compared to rules with a sharpened edge. The rounded transition area between the bevel and the body allows for better workability on all rule processing tools. Reflexion R is good for cutting synthetic materials as well as paper.

Optional Edge Refinements



Molykote Mo
A special coating process that adds a thin molykote film to the cutting bevel and fills the small pores providing a smooth edge surface.

- Great for self-adhesive or materials with PSA
- Low dust
- Minimizes friction between the bevel and the material being cut



Tinit Ti
A 2400HV hard Tinit-coating that is only 0.002 mm on the hardened cutting bevel, while retaining the bendability, structure and cutting edge geometry of edge-hardened rule.

- Increased efficiency and cutting quality
- Reduced cling when cutting adhesive materials
- Reduces dust and increases die life

Supra Z



Supra Z is ideal for:

- Plastic
- Blister
- Laminated or coated carton boards
- Labels

Supra Z. Plastic Cutting Rule

Thickness	2pt (0.71 mm)
	3pt (1.05 mm)
Height	23.80 mm / 23.80 mm

Supra Z. Label Cutting Rule

Thickness	1.3pt (0.45 mm)
	1.5pt (0.53 mm)
Height	8mm / 12 mm

Supra Z edge & specifications



View on Supra Z cutting edge under electron microscope, 30-times magnified.

Execution	HP 40
Body hardness	~ 380HV (40HRC)
Edge hardness	~ 700HV (~ 60HRC)
Cutting edge geometry	A / AA
Bevel surface	fine ground
Bevel angle	42°

Microtop - The cutting rule with more power!



Microtop combines the proven properties of HP Plasma Hardening with the advantages of higher bevel strength reduced deformation through a special bevel geometry.

- Saves makeready time, reduced angel hair
- Longer die life, even on very long runs
- Improved pressure distribution, lower surface pressure and higher shape durability



Execution	HP-54
	HP-40
Thickness	0.71 mm (2pt)
	1.05 mm (3pt)
Height	23.80 mm
Cutting edge geometry	A / AA
Bevel surface	shaved
Bevel angle	54° / 70°

The comprehensive strength of the Microtop rule is 10x higher in comparison to a rule with standard A bevel. If the hardness of the bevel is the same, the rule stays longer in shape due to the higher pressure resistance through the unique bevel design.

4ec-Bend



Tight thickness tolerances, extraordinary straightness, and accurate flatness for precise performance in automatic cutting/bending machines. Top performance with minimal adjustment/corrections on your automatic equipment.

Continued next page...



2041 Elm Court, Ontario, CA 91761
Local: 909-947-3044 • Fax: 909-923-7809



827 S. Great S'west Pkwy., Grand Prairie, TX 75051
Local: 214-630-4695 • Fax: 214-630-5425



960 Industrial Drive, Elmhurst, IL 60126
Local: 630-782-6230 • Fax: 630-782-6220

800-423-4478 TOLL-FREE ALL LOCATIONS!

www.wagnerdiesupply.com
sales@wagnerdiesupply.com



Martin Miller Steel Rule (continued)

M = 1 m and 1.5 m lengths
 I = 762mm (30") lengths

Steel Rule Packaging in Strips

Rule Thickness			Packing units (in pieces) for heights of:				
			6.35–27 mm	>27–40 mm		>40–100 mm	
[pt]	[mm]	[inch]		M	I	M	I
1.3	0.45	0.018"	150				
1.4	0.50	0.020"	140				
1.5	0.53	0.021"	140				
2	0.71	0.028"	100	35	70	35	
3	1.05	0.041"	70	25	50	25	24
4	1.42	0.056"	50	17	34	17	16
6	2.13	0.084"	30	12	24	12	
8	2.84	0.056"	25				

Steel Rule Coil Configurations

Form of Delivery		Standard	Special
In lengths	rule length	1 m / 762 mm (30")	1.5 m / 2 m or on request
	coil length	2 pt – 100 m · 3 pt – 70 m · 4 pt – 50 m · 6 pt – 30 m	
	inner coil	356 mm	400 mm
In coils	winding direction	coil end on top left hand "ø"	coil end on top right hand "6"
	(view on bevel)	(RU: counter-clockwise)	(R: clockwise)
	marking of rule	inside the coil	outside the coil

Thickness Tolerances

Rule Thickness			Thickness Tolerance	
[pt]	[mm]	[inch]	[mm]	[inch]
1.1	0.40	0.016"	±0.015	±0.0006"
1.3	0.45	0.018"	±0.015	±0.0006"
1.4	0.50	0.020"	±0.015	±0.0006"
1.5	0.53	0.021"	±0.015	±0.0006"
2	0.71	0.028"	±0.015	±0.0006"
3	1.05	0.041"	±0.020	±0.0008"
4	1.42	0.056"	±0.020	±0.0008"
6	2.13	0.084"	±0.025	±0.0010"

Height Tolerances

Rule Height h		Height Tolerance	
[mm]	[inch]	[mm]	[inch]
8.00–25.40	0.315"–1.000"	±0.020	±0.0008"
>25.40–50.80	>1.000"–2.000"	±0.025	±0.0010"
>50.80–76.20	>2.000"–3.000"	±0.030	±0.0012"
>76.20–100.00	>3.000"–3.937"	±0.035	±0.0014"
Height tolerances for creasing rules:			
20.30–24.40	0.800"–0.960"	+0/-0.040	+0/-0.0016"

For the latest product information, please visit our website:
www.wagnerdiesupply.com



2041 Elm Court, Ontario, CA 91761
 Local: 909-947-3044 • Fax: 909-923-7809



827 S. Great S'west Pkwy., Grand Prairie, TX 75051
 Local: 214-630-4695 • Fax: 214-630-5425



960 Industrial Drive, Elmhurst, IL 60126
 Local: 630-782-6230 • Fax: 630-782-6220

800-423-4478 TOLL-FREE ALL LOCATIONS!

www.wagnerdiesupply.com
sales@wagnerdiesupply.com