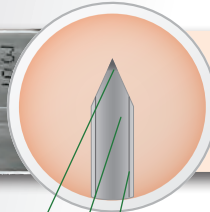


Freeman offers a comprehensive line of flat cutting and creasing rule for a multitude of diecutting applications. These are our most popular and highest quality flat rules offered by Bohler™, Martin Miller/Viking™, and Helmold™.

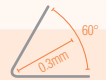


## Bohler Universal

bohlerstrip 23,80 / .937 / 23,80 / .937 / 23 UNIVERSAL-CF 23,80X0,71-9



**Thickness** 1.5pt, 2pt, 3pt, 4pt  
**Heights** 0.918" – 2.00"  
**Bendability** 2pt bends 60° max w/Radius of 0.3mm



58 HRC cutting edge

35 HRC body

Soft & ductile skin

Bohler Universal cutting rule is Voestalpine's #1 selling rule, featuring a soft bendable body with a hardened knife edge. The excellent bending properties and years of proven long runs on press make this rule your ideal choice for most applications. Available in shaved, ground, and polished.

✓ Paperboard

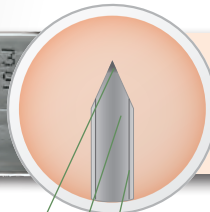
✓ Corrugated board

✓ Labels

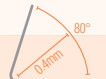
✓ Postcards

## Bohler Universal 60

bohlerstrip 23,80 / .937 / 23,80 / .937 / 23 UNIVERSAL-60 23,80X0,71-9



**Thickness** 1.5pt, 2pt, 3pt, 4pt  
**Heights** 0.918" – 3.00"  
**Bendability** 2pt bends 80° max w/Radius of 0.4mm



58 HRC cutting edge

45 HRC body

Soft & ductile skin

Bohler Universal 60 incorporates the harder body of Bohler Top with the proven edge hardness of Bohler Universal. The result is higher rule stability and extended service life. Available in shaved, ground, and polished.

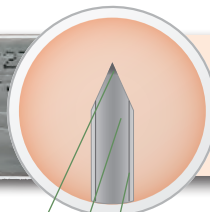
✓ Thicker materials

✓ Puzzles

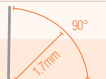
✓ Hard & durable body for tough applications

## Bohler Universal 75

bohlerstrip 23,80 / .937 / 23,80 / .937 / 23 UNIVERSAL-75 23,80X0,71-9



**Thickness** 2pt, 3pt  
**Heights** 0.918" – 2.00"  
**Bendability** 2pt bends 90° max w/Radius of 1.7mm



60 HRC cutting edge

51 HRC body

Soft & ductile skin

Bohler Universal 75 has a harder body than Universal 60 with the same proven edge hardness of all Universal rules. The 51 HRC body offers even more stability for cutting heavy materials. Available in shaved, ground, and polished.

✓ Sandpaper

✓ Gaskets

✓ Plastics


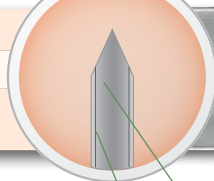
✓ Laminates

✓ Felt

# STEEL RULE

## Bohler Top

<b>Thickness</b>	1.5pt, 2pt, 3pt, 4pt
<b>Heights</b>	0.937" – 2.00"
<b>Bendability</b>	2pt bends 80° max w/Radius of 0.3mm

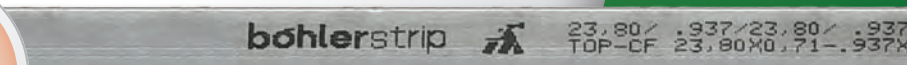



45 HRC edge & body

Soft & ductile skin


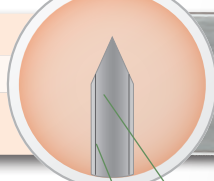
Bohler Top is an economical through-hardened cutting rule that is best suited for shorter runs and clicker die applications. Top offers good bendability and stability of a harder body. Available in shaved bevel finish.

- ✓ Clicker dies
- ✓ Paperboard
- ✓ Corrugated board
- ✓ Shorter runs



## Bohler H-75

<b>Thickness</b>	2pt, 3pt
<b>Heights</b>	0.918" – 1.50"
<b>Bendability</b>	2pt bends 85° max w/Radius of 1.7mm

51 HRC edge & body

Soft & ductile skin


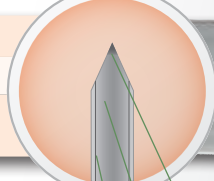
Bohler H-75 is through-hardened similar to Top, but even harder at 51HRC throughout. The stiffer body reduces flex and is ideal for use on thicker materials like cork, rubber and felt. Available in shaved bevel finish.

- ✓ Rubber
- ✓ Gaskets
- ✓ Felts
- ✓ Reduced flex & increased stability



## Bohler Extra

<b>Thickness</b>	2pt, 3pt
<b>Heights</b>	0.937"
<b>Bendability</b>	2pt bends 90° max w/Radius of 1.7mm

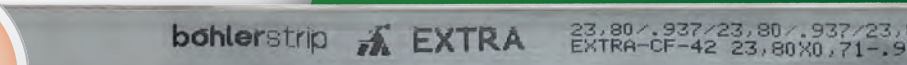
61 HRC cutting edge

40 HRC body

Soft & ductile skin

The secret of this problem-solving rule is an extra-deep hardening just beyond the tip that supports the knife edge, resulting in extremely long runs. The 42° bevel penetrates plastics with ease, yet lasts because of the extra-deep hardening. Available in shaved, GX ground, and polished.

- ✓ Composites
- ✓ Plastics
- ✓ Economical alternative to Plast-X

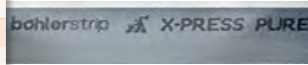


# BOHLER PROBLEM-SOLVING RULE

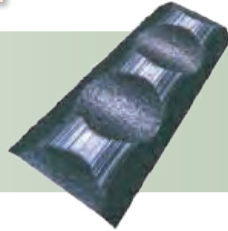
## Bohler X-Press Pure

Bohler X-Press Pure is a patented self-leveling rule, designed for quick make-ready, and extremely long runs. The micro-serrated rule back deforms under pressure and self-levels. This reduces wear on the knife edge and improves knife service life.

<b>Hardness</b>	Body 35 HRC, Edge 58 HRC
<b>Thickness</b>	2pt, 3pt
<b>Height</b>	23.8mm
<b>Bevel Angle</b>	53°, 42°
<b>Bevel Finish</b>	Shaved, Polished, Supreme



- ✓ Patented self-leveling design
- ✓ Quicker make ready
- ✓ Extremely long runs



## Plast-X

Bohler Plast-X was developed for diecutting PET, PE, PVC, PP, Blister Packs and Thermoplastics. Utilizing razorblade technology, the knife edge undergoes a slow-feed wet grind. This results in a razor-sharp rule for plastics that reduces friction and cutting force. The harder



<b>Hardness</b>	Body 40 HRC, Edge 60 HRC
<b>Thickness</b>	2pt, 3pt
<b>Height</b>	23.8mm
<b>Bevel Angle</b>	42°, 53°

body and extra deep hardening underneath the extremely sharp knife edge is why this rule drastically improves diecutting performance on plastics.

- ✓ Ultimate rule for plastics
- ✓ Razorblade technology - slow-feed wet grind
- ✓ Extra-deep edge hardening
- ✓ Extremely sharp cutting edge

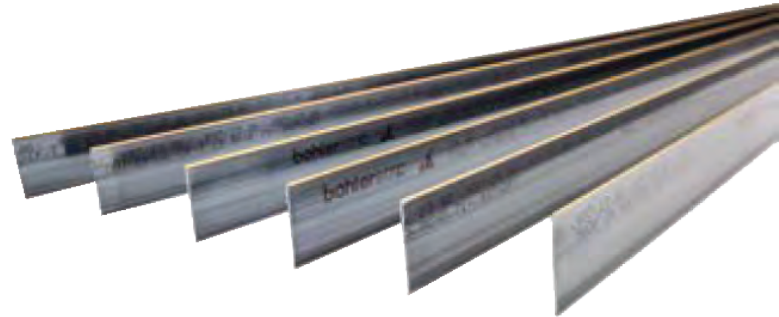
# BOHLER COATINGS



## Bohler Universal Supreme Dust Killer Coating

Bohler Universal Supreme features a molybdenum anti-friction coating on the knife edge. This coating fills microscopically small pores which reduces friction and ultimately reduces dusting. Additional benefits include prevention of glue adhering to rule when diecutting labels and extended knife life.

- ✓ Reduced dusting
- ✓ Label diecutting
- ✓ Reduced friction on diecut material
- ✓ Extended rule life



## Bohler Titanium Nitride (TiN) Coating

Bohler TiNiT rule is coated with a thin layer of Titanium Nitride. Titanium Nitride is a gold colored ceramic material that is 4 times harder than the original steel knife edge. The TiN coating dramatically extends knife life without affecting bendability or cutting profile.

- ✓ Same bendability
- ✓ Increased wear against diecutting abrasives
- ✓ Extends knife life
- ✓ Offers tremendous productivity gains

# BOHLER CREASING RULE



Folding box design and the precision of final products are becoming more demanding, which requires the application of high quality creasing rules with tight tolerances.

## Bohler Single Round Creasing Rule

Bohler Single Round Creasing Profiles have a perfectly radiused profile and very tight tolerances with a flat back.

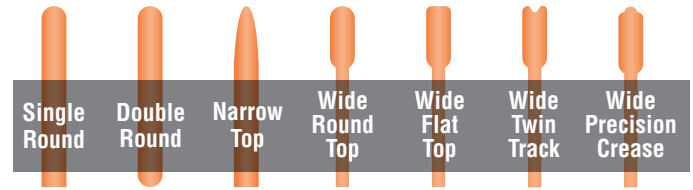
## Bohler Double Round Creasing Rule

Bohler Double Round Creasing Profile have a perfectly radiused profile and very tight tolerances.

## Bohler Specialty Profile Crease

Wide variety of crease profiles to solve difficult diecutting applications.

## Creasing Rule Profiles



To see all creasing rule heights and types, visit our website at [www.DieBoard.com](http://www.DieBoard.com).

# BOHLER SPECIALTY RULE

## Bohler Perforating Rule (Cut-Skip)

Bohler Perforating Rule offer a wide range of thicknesses and tooth-gap combinations.



## Bohler Stripping Rule

Bohler Stripping Rule are the optimum solution for ejecting the waste material after the die-cutting process.



## Bohler Combination Rule (Cut-Crease)

With cut-crease rule, there is no need to insert individual parts of cutting and creasing rule. Bohler Cut-Crease rule are produced in standard punched (CF), or in round machined executions for high-quality jobs (CF / FT and CF / SR).



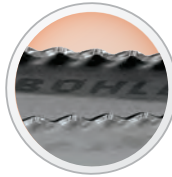
## Bohler Spacer Rule

Spacer Rule fill gaps between steel rule and wider laser cuts within the die board or backfill unwanted laser cuts within an existing die. The rule show a square cross sectional profile. Bohler Spacer Rule are available in all common wood sizes used in the die making industry.



## Bohler Wave Edge Rules

The main application for wave edge rule is in the production of safety cutting edges on solid and corrugated board boxes, to avoid injuries during box handling.



# SPEEDI-TEAR™ RULE\*

**Speedi-Tear™** is the absolute best perf rule for knock-out panels on Shelf-Ready Packaging. Scientific principles applied to tooth and gap design results in an easy rip-out panel for shelf displays, yet maintains critical carton strength for shipping pallets of stacked boxes.

- ✓ #1 Requested Tear-Out rule!
- ✓ Scientific tooth/gap design
- ✓ Panels rip-out easily and cleanly
- ✓ Unopened cartons maintain box strength for stacking



**A FREEMAN EXCLUSIVE!**

**Speedi-Fold™** solves the problem of difficult to fold box flaps without compromising box strength integrity.

**Speedi-Flare™** solves the problems associated with standard 1/8" x 1/8" and 1/4" x 1/4" perf. It provides a more refined fold and tear.

**Speedi-Micro Nick™** is a 2pt rule with .007" nicks. Available in 4, 8, or 16 nicks per inch.

**Speedi-Micro Perf™** is the best on the market. Extra deep .030" spaces allow for perforating thicker stocks. Bohler base steel is of highest quality. Available in 15, 25, 30, 36, 50, 60, and 70 teeth per inch.

\*Not a voestalpine product.



# MARTIN MILLER RULE

▶ *Plasma technology: Martin Miller's secret. A few seconds at a temperature of approximately 10,000°C ensures a precise hardening process, without affecting the body hardness like other methods do. The result: extreme edge hardness for extreme rule lifetime.*

## Martin Miller Cutting Rules

Martin Miller cutting rules are renowned for bendability and sharpness.



### MM Style

- ✓ Similar to Bohler Top for shorter runs where a stiffer body rule is needed
- ✓ Through hardened rule with either 40 or 44 HRC throughout
- ✓ Clicker dies



### HF Style

- ✓ High Frequency edge hardening process mimics Bohler Universal
- ✓ 34 or 40 HRC body, 57 HRC tip
- ✓ Edge hard rule with great bendability



### HP Style

- ✓ Plasma edge hardening for longer life and great bendability
- ✓ 34 or 40 HRC body, 60 HRC tip
- ✓ Long run diecutting



### HP+ Style

- ✓ Extra Deep Plasma edge hardening fully supports the rule tip for extreme life
- ✓ 40 HRC body, 67 HRC tip
- ✓ Extremely long runs

## Martin Miller Glue Flap Rule

This unique perf profile roughens the glue flap to achieve better adhesion.



## Martin Miller Stripping Rules

Stripping rule is used in place of stripping pins. The high rule has tiny teeth that grab the scrap for dynamic stripping.



## Did You Know?



Voestalpine (Bohler/Martin Miller) manufactures their own steel and controls the process from iron ore to steel rule. This ensures the absolute highest quality and consistency, and why Voestalpine rule is the market leader worldwide.

The in-house R&D center includes state-of-the-art production technology and expert staff. This ensures you receive the best problem-solving steel rule solutions for your applications.

# HELMOLD RULE

## Helmold Flat 65 Hard, Ultraflex, and Helmex Rule

These through-hardened cutting rule have the same body and edge hardness. They are all made with a specially formulated steel to produce an extremely durable cutting edge and enough ductility to create sharp bends. They offer good life and are an excellent all-purpose utility rule. Available with bevels of 42, 53, or 60 and shaved edge, ground edge, or buffed edge.



## Helmold Flat 70 Hard Rule

This rule is made with a specially formulated steel to produce an extremely durable cutting edge and enough ductility to create sharp bends. Available with bevels of 42, 53, or 60 and shaved edge, ground edge, or buffed edge.



## Helmold Flat 80 Hard & 85 Hard Rule

These products are used in applications where no bending is needed. These though-hard cutting rule have excellent wearability and are mostly used as slitter blades and where other straight cuts are needed. Available with bevels of 42, 53 and 60 and shaved edge, ground edge, or buffed edge.



## Helmold Flat Lazer Blade Rule

This premium rule offers a softer body with a hardened edge, a great combination for many Kiss Kut applications for cutting paper or other substrates. They all offer good bendability as well as long wearing edge sharpness, which allows for less down time on the press. Available with bevels of 42, 53, or 60 and shaved edge, ground edge, or buffed edge.

**Lazer Blade** *Good for long runs*



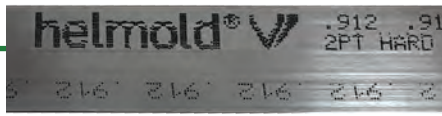
**Lazer Blade H** *Good for harder materials*



**Lazer Blade D** *Deeper edge hardening, good for long runs*

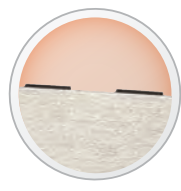


**Lazer Blade HD** *Good for harder materials and long runs*



## Helmold Creasing Rule

Helmold Creasing Rule is available in both double round or single round. The smooth radiused top produces well defined scores and inhibits board cracking. High-quality height tolerances also mate perfectly with matrix and counterplates to ensure perfect folds in paperboard and corrugated packaging. Helmold Illinois is able to manufacture custom heights of crease that may not be stocked in our Bohler line.



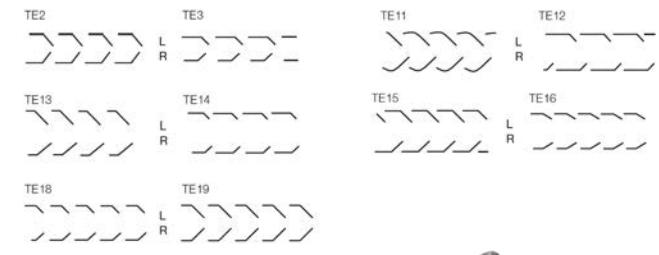
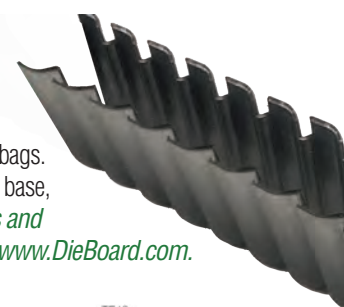
## Helmold Perf Rule

Freeman stocks over 100,000 ft. of Helmold perf rule in a wide variety of tooth configurations. This high-quality rule is used in folding carton, corrugated, business forms, and label industries. The superior high-carbon steel results in longer press life, and an advanced manufacturing process produces a clean precise space or crease. Helmold can manufacture almost any configuration of perf. *To see our vast inventory of in-stock perf, visit our website, [www.DieBoard.com](http://www.DieBoard.com).*

For the business form and carton industries		For the corrugated industry (Fractional tooth width and spacing)	

## Helmold Tear-Edge Zipper Rule

Tear-edge, also known as Zipper rule, is used to produce the "zipper opening" in packaging like facial tissue, aluminum foil, and plastic garbage bags. Helmold Zipper rule is bent from the bevel to the base, making it extremely strong. *For full dimensions and a printable actual size PDF, visit our website, [www.DieBoard.com](http://www.DieBoard.com).*



## Specialty Helmold Wave Rule

Helmold's Wave Rules feature a wave shape over the complete height of the rule, giving it a very exact form and a very precise line in the center and a much higher stability.



# FREEMAN LOCATIONS

## Branch Locations and Public Warehouses

Freeman has strategically placed satellite locations across North America with customer service representatives ready to help. Thousands of products are stocked at these locations as well as public warehouses to reduce your shipping costs.

## Strategic & Effective Stocking

Freeman's inventory staff constantly monitors sales and stocking data across the country to properly provide the right amount of products at each location.

## Worldwide Shipping

Freeman ships orders all across the globe and has various international distributors available to supply customers with top-quality products.



### OHIO (HEADQUARTERS)

1101 Moore Road  
Avon, OH 44011  
TEL 800-321-8511  
TEL 440-934-1902  
FAX 440-934-7200

### ILLINOIS

727 N. Larch Avenue  
Elmhurst, IL 60126  
TEL 800-628-6971  
FAX 440-934-7200

### ONTARIO

3600B Laird Road Unit 8  
Mississauga, ON L5L 6A7  
TEL 800-345-9259  
FAX 586-774-1019

### QUEBEC

3475 boul Pitfield  
Montreal, QC H4S 1H3  
TEL 800-263-7699  
TEL 514-335-3530  
FAX 514-335-3225

### CALIFORNIA

5525 S. Soto St.  
Vernon, CA 90058  
TEL 800-325-2100  
FAX 440-934-7200

### KENTUCKY

917 Landis Lane  
Mt. Washington, KY 40047  
TEL 502-955-5535  
FAX 440-934-7200

### OREGON

15745 N. Lombard St., Ste. 100  
Portland, OR 97203  
TEL 800-558-0866  
FAX 262-789-5407

### TEXAS

3152 S.E. Loop 820  
Fort Worth, TX 76140  
TEL 800-792-1047  
TEL 817-551-7301  
FAX 817-568-0908

### GEORGIA

5060 N. Royal Atlanta Dr. Ste. 6  
Tucker, GA 30084  
TEL 770-493-4131  
FAX 440-934-7200

### KANSAS

5755 S. Hoover Road Bldg. #5  
Wichita, KS 67215  
TEL 800-792-1047  
FAX 817-568-0908

### NORTH CAROLINA

101 Bailey Street  
Mocksville, NC 27028  
TEL 800-321-8511  
FAX 440-934-7200

### WISCONSIN

4921 South 2nd St.  
Milwaukee, WI 53207  
TEL 800-558-0866  
TEL 262-789-9800  
FAX 262-789-5407

### MICHIGAN

27655 Groesbeck Highway  
Roseville, MI 48066  
TEL 800-345-9259  
TEL 586-774-1210  
FAX 586-774-1019

### PENNSYLVANIA

203 Enterprise Rd.  
Lititz, PA 17543  
TEL 800-631-4230  
TEL 717-653-5300  
FAX 717-653-7372

# TERMS & CONDITIONS

### Returned Goods

To save transportation charges, and facilitate handling of merchandise upon our receipt, we request that no merchandise be returned without prior written authorization.

### Damaged Goods

Merchandise given to a transportation firm is their responsibility to deliver in satisfactory condition. If merchandise is delivered damaged, the customer should note as such on freight bill and file a claim with the delivering carrier. Regulations require that hidden damage, identified upon unpacking, must be reported within ten (10) days of delivery in order to file a proper claim.

### Liability/Warranty Statement

Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. Nothing herein shall constitute a warranty, expressed or implied, including any warranty or merchantability or fitness, nor is protection from any law of patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is replacement of our materials and in no event shall we be liable for special, incidental, or consequential damages.

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