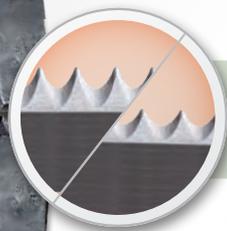
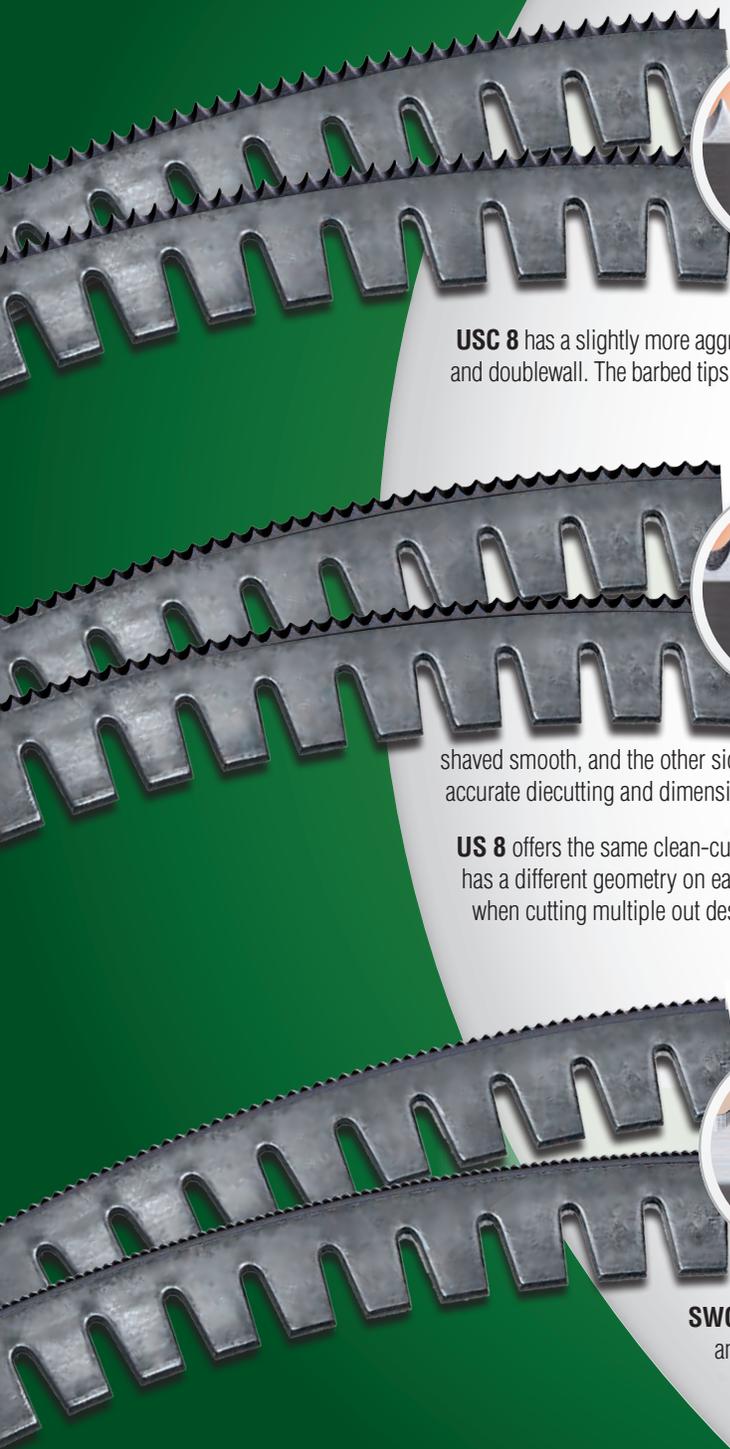


Converters love the cut quality and long life of Bohler rotary rule. The thermal and mechanical stress relief process during manufacturing prevent fatigue cracks. The Bohler-produced steel, special edge hardening options, and fine tooth grinding make these problem-solving rotary rule the best in the industry. Freeman's deep inventories mean you can get what you need when you need it.

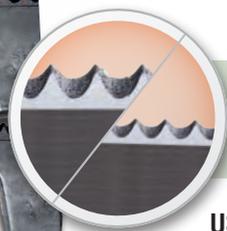


## Bohler USC 8/10

- ✓ USC 10 – most versatile 10 tooth
- ✓ USC 8 – for tough, thick board

**USC 10** is our most popular and versatile cutting rule. The 10-tooth geometry cuts extremely well on a variety of corrugated materials.

**USC 8** has a slightly more aggressive tooth geometry, that permits minimal cutting pressure on thicker board and doublewall. The barbed tips and sharp gullets ensure easy penetration of the toughest materials.

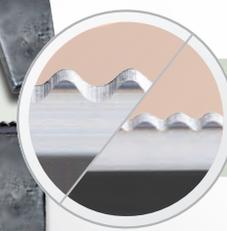


## Bohler US 8/10

- ✓ Leaves clean cut on product edge
- ✓ True center bevel for dimensional accuracy

**US 10** is most commonly known as "Clean Cut". US 10 was designed to leave a very clean cut on the product. One side is shaved smooth, and the other side has ground tooth geometry. Bohler's clean cut is still a true center bevel for accurate diecutting and dimensionally accurate boxes on multi-out dies.

**US 8** offers the same clean-cut geometry as US 10 but in an 8-tooth for heavy test board. Even though this rule has a different geometry on each side, the tip is still precisely centered, which enables dimensional accuracy when cutting multiple out designs.



## Bohler SWC 8/10

- ✓ Euro Cut geometry for minimal pressure
- ✓ Reduced gullet and anvil wear

**SWC 10** has a European tooth geometry commonly called Euro Cut. The shallow gullet and radiused tip performs superbly on singlewall corrugated, (especially on long lead and trail edge knives), and reduces anvil wear.

**SWC 8** offers the same Euro Cut tooth design for cutting heavyweight double and triplewall corrugated with minimal pressure. The shallow gullet reduces pressure and ultimately anvil wear.

# STEEL

# RULE

## Bohler STC 8/10/12

- ✓ STC 8 – deep V tooth penetrates tough board
- ✓ STC 10 Martin Miller – heavier singlewall board
- ✓ STC 12 – standard 12T for lightweight board & foam



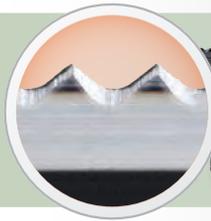
**STC 8** has a very sharp V tooth that easily penetrates doublewall and heavy test board.

**STC 10** from Martin Miller is for heavier singlewall.

**STC 12** is a standard center bevel cutting rule. This rule provides an enhanced finished product edge appearance for both light-weight singlewall and microflute corrugated board. This profile is also recommended for cutting a variety of foam materials.

## Bohler ProCut

- ✓ Proven USC tooth geometry – sharp but not too aggressive
- ✓ Harder body to prevent cracking and rollover
- ✓ Designed for produce boxes and heavy test board
- ✓ ProCut 10T – 35 HRC body, 49 HRC edge
- ✓ ProCut 8T – 40 HRC body, 49 HRC edge



**ProCut** was developed specifically to solve problems associated with diecutting produce boxes. Utilizing the proven USC 10 tooth geometry, with fine ground bevels and radiused gullets, Bohler strengthened the rule with a harder body, to prevent roll-over and cracking. ProCut is the industry's go-to problem-solving rule for heavy test corrugated. Available in 10 tooth and 8 tooth.

## Speedi-Tear™ Products\*

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



**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.

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

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

**Speedi-Break™** is a Superior Bundle Breaker Rule for high-speed corrugated box makers. Replaces common rule between multi-outs.

*\*Not a voestalpine product.*

# BOHLER ROTARY CUTTING RULE

## Bohler SFST 12

SFST 12 is the original 12-tooth side face rule profile for rotary diecutting. It is recommended for cutting lightweight singlewall and microflute. SFST 12 has also improved stripping on high-speed EVOL dies.



- ✓ Side bevel 12-tooth
- ✓ Improves stripping on EVOL dies
- ✓ Lightweight board

## Bohler SFST 8/10

SFST 8 cuts heavier corrugated stock and SFST 10 cuts medium corrugated stock. Both rule can be used in slots or tight areas allowing more room for ejection rubber, as well as scrap knives or lead edge as the bevel helps the product release easier for the die. They can also be used with EVOL dies on higher test boards.



- ✓ 8-tooth or 10-tooth
- ✓ Improves stripping on EVOL dies
- ✓ Medium & Heavy Corrugated

# BOHLER ROTARY 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. These rule offer very smooth crease head surfaces, perfectly radiused profiles, smooth transitions from radiused profile to side faces, minimum eccentricity, and minimum height and thickness tolerances.

### Bohler Single Round Crease

- ▶ Perfectly radiused profile
- ▶ Superior height tolerances

### WFT Wide Flat Top

- ▶ Flat Top provides crisp scores and rollovers
- ▶ 3/6, 3/8, 4/6, 4/8

### WTT Wide Twin Track

- ▶ Creates a double score on E-Flute
- ▶ Solves problems with Litho Labels
- ▶ 3/8, 4/8

### WRT Wide Round Top

- ▶ Round Top less prone to cracking
- ▶ 6/3, 8/3, 6/4, 8/4

### WPC Wide Precision Crease

- ▶ Beaded top excellent with corrugation direction
- ▶ 3/8, 4/8

**Bohler's unique 14/4 crease** has proven excellent on doublewall and triplewall corrugated. It scores deep and wide without cracking, and it greatly helps with folding.

### 14/4 Wide Round Top & 14/4 Wide Flat Top

- ▶ Developed for double wall and triple wall
- ▶ No cracking
- ▶ Available in straight and curved

### 8/4 RWC Rotary Wave Crease

- ▶ Improves folds w corrugation
- ▶ Less costly
- ▶ 8/4

# BOHLER ROTARY SPECIALTY RULE

## Bohler ST 5

ST 5 is a 5-tooth rule with a non-ground side that improves scrap ejection. It is most often used to accurately cut honeycomb and foam. The profile is precision ground for easy penetration. It can also be used for nicking and removable windows in corrugated containers.



- ✓ 5-tooth side bevel improves scrap ejection
- ✓ Ideal for honeycomb & foam
- ✓ Can be used for nicking & tear-out windows

## Bohler ST 20

ST 20 is a 20-tooth rule designed for cutting E flute and microflute corrugated board. The 20 teeth per inch profile provides a very clean product edge.



- ✓ 20-tooth for E & F flute
- ✓ Leaves very clean product edge

# BOHLER ROTARY PERFORATING RULE

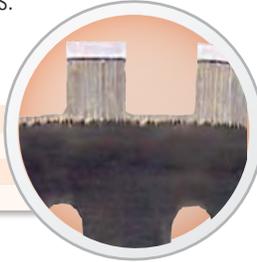


## Bohler Bundle Breaker Rule

Bohler Bundle Breaker Rule is a pre-nicked rotary rule that reliably holds multiple outs together. Available in Fine, Standard, Strong, and Heavy.

## Bohler Non-Serrated Perforating Rule

Bohler Non-Serrated Perforating Rule are made from center bevel rule with a wide variety of tooth/gap configurations. Each tooth is non-serrated, meaning the cutting rule does not have small teeth.



Thickness	4pt
Height	0.937" – 1.00"
Configuration	1/4" x 1/4", 3/8" x 3/8", 1/2" x 1/2"
Gap Depths	3/16" & 1/8"

## Bohler Serrated Perforating Rule

This profile offers STC 12 teeth per inch. Serrated perforation is recommended for soft anvil diecutting and when the tooth is 6mm (1/4") or larger. This helps reduce crushing and flaking on the finished product.



Thickness	4pt
Height	0.937" – 1.00"
Configuration	1/4" x 1/4", 3/8" x 3/8", 1/2" x 1/2"
Gap Depths	3/16" & 1/8"

### Fine Bundle Breaker

- ✓ 0.045" nick every 1/4"
- ✓ 18% hold is the lightest hold configuration

### Strong Bundle Breaker

- ✓ 0.045" nick every 1/8"
- ✓ 36% hold for shorter common knives and heavier board

### Standard Bundle Breaker

- ✓ 0.055" nick every 1/4"
- ✓ 22% hold for a wide range of corrugated materials

### Heavy Bundle Breaker

- ✓ 0.055" nick every 1/8"
- ✓ 44% hold provides a firm hold on any job

## Bohler Cut Crease Rule

This rule is made from 12-tooth rotary like cut/skip, except with a shallow depth of gap. The shallow gap is crease height, so it scores the board in the gaps between the teeth for a better fold, i.e. 1/4" x 1/4" 0.970" cut / 0.860" crease. It improves folding when perforating in the corrugated flute direction.



Thickness	4pt
Height	0.937" – 1.00"
Configuration	1/4" x 1/4", 3/8" x 3/8", 1/2" x 1/2"
Cut & Crease heights	vary by corrugated board

# MARTIN MILLER ROTARY RULE

## Martin Miller CF/CC 14

Commonly known as Clean-Cut and similar to Bohler US 10 CF/CC 14. This 14 tooth was designed to leave a very clean cut on the product. One side is shaved smooth, and the other side is ground tooth geometry. This rule is a true center bevel for accurate diecutting and dimensionally accurate boxes on multi-out dies.



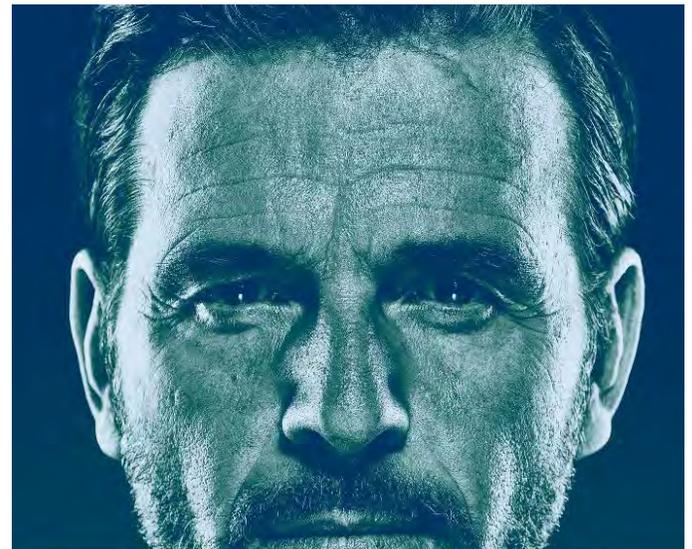
- ✓ Leaves clean cut on product edge
- ✓ True center bevel for dimensional accuracy
- ✓ Superior Voestalpine steel doesn't crack like other rule brands

## Shallow Profile

Also known as Martin Miller 14T Fine Cut, this rule has a shallow gullet. It is renowned for its problem-solving ability on many substrates, including foam, plastic corrugated, automotive liners and carpets, and more. It may be used in flat diecutting on roller-bed presses.



- ✓ Requires less impression to cut
- ✓ Ideal for foam, plastic corrugated, automotive materials
- ✓ Also great for flat dies on flat-bed roller presses



## Did You Know?

Bohler / Martin Miller rotary rule undergoes a thermal and mechanical stress relief to avoid fatigue cracks?

Combined with Bohler-produced steel, special edge hardening, and fine tooth grinding, it's easy to see why Bohler /Martin Miller is the absolute best rotary rule you can buy.

# 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.



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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

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Vernon, CA 90058  
TEL 800-325-2100  
FAX 440-934-7200

### KENTUCKY

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

### OREGON

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Portland, OR 97203  
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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

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Mocksville, NC 27028  
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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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