

Checklist for short make-ready times

Machine

- regular check of the machine condition (unevenness / wear)
- regular maintenance of the machine
- regular cleaning of the machine, e.g. with the m|platen|cleaner
- levelling the unevenness of a machine, e.g. with the DZL|plate

Cutting-die

- Quality of the installed cutting rules, e.g. m|power|+ with rounded cutting edge
- Removing impurities from the back of the cutting-die
- Fastening drill holes for chase back plate by the tool manufacturer
- Preventing dipping of the cutting rules at radii by channel grinding
- Optimum pressure distribution of the cutting-die (possibly balancing rules)

Counter cutting plate

- Check plane parallelism
- Optimum hardness & quality of the cutting plate for less wear and tear

Material to be die-cut

- High-quality paperboard material with few thickness tolerances

Make-ready materials

- Correct dimension of the make-ready sheet
- Make-ready sheet quality
- Make-ready sheet already supplied with cutting-die layout
- Quality silk paper
- Quality make-ready tapes
- Different thicknesses of make-ready tapes available and considered
- Good adhesive properties of the make-ready tapes

Machine operator

- Compliance with the make-ready rules
- Proper handling of machine and tools
- If necessary, training, e.g. at the Marbach Academy
- Optimal cutting pressure, if necessary m|power|+ package

Print shop

- Optimization of operations, e.g. through a process and environment analysis with the Marbach Performance Package
- Determination and monitoring of key figures, e.g. with the Marbach system solution CONNECT|M
- Purchasing department pays attention not only to the lowest price, but also to the quality of the tools & make-ready materials