

Cutters

January 2015

The information below reflects the standards for this equipment. Please contact department manager for questions on projects that may fall outside of the standard. If you are unsure about any of the information, please check with manager or estimating.

- (1) **Polar 78 Computerized:** 30" Max sheet width
 - (2) **Polar 115 Computerized:** 45-1/4 Max sheet width
 - (1) **Polar 137 ED System computerized:** 54" Max sheet width
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Modifiers

Name	MR Time	MR Waste	Run Speed	Run Waste
Additional Helper	N/A	N/A	N/A	N/A
Additional MR Sheets	N/A	Enter Additional Sheets	N/A	N/A
Dutch Cut	N/A	N/A	Reduce 20%	N/A
Variable	N/A	N/A	Reduce 20%	N/A

Specific Estimating Cutting Rules:

Magnetic Stocks: reduce *lift height to 1"* (modify run speed x 4)

Synthetic Stocks: reduce lift height to **2"** (modify run speed x 2)

Plastic/Vinyl Stocks: reduce lift height to **1"** (modify run speed x 4)

Stock w/ Remoist: reduce lift height to **1"** (modify run speed x 4)

Helpers:

Only use for cutting Web sheets

Variable/Lasered pieces etc – DO NOT USE

NOTE: We will NOT estimate with a sort at cutter – Table Sort in LS sort as needed

Calculations:

Cutting = 30 sec/cut Plus 60 sec base

Example: 14 cuts = 420 sec + 60 sec = 480 sec = 8min/lift

Cutting with Lamination = Caliper of stock + Total Caliper of Lamination /Stock Caliper

Example: 15pt + 1.7 min 2 sides = 18.4/15 = +22.67%

4up Base = 5.5 min x 22.67% = 6.75 = 7 min in Print Stream

See next page for Print Stream Number Up w/ Minutes per Lift

Post-Press Cut NO Bleed

Refer to the tables below to get the correct time(minutes) per lift. This will come in to play if you have more than 30 pieces up on a sheet and are cutting. You will need to change the minutes per lift after you have calculated.

## UP	TIME/LIFT	## UP	TIME/LIFT	## UP	TIME/LIFT
1	4	11	6.25	21	7.25
2	4.25	12	6.5	22	7.25
3	5.5	13	6.5	23	7.5
4	5.5	14	6.5	24	7.5
5	5.5	15	7	25	7.5
6	6	16	7	26	7.5
7	6	17	7	27	7.5
8	6.25	18	7	28	8
9	6.25	19	7	29	8
10	6.25	20	7.25	30	8

Post Press Cut WITH BLEED

## UP	TIME/LIFT	## UP	TIME/LIFT	## UP	TIME/LIFT
1	4	11	7.5	21	9
2	4.5	12	8	22	9
3	6	13	8	23	9
4	6.5	14	8	24	9.5
5	6.5	15	8	25	9.5
6	6.5	16	8.5	26	9.75
7	7	17	8.5	27	10
8	7	18	8.5	28	10.25
9	7	19	8.5	29	10.5
10	7.5	20	9	30	11

Document owner to approve spec sheet. After approval, deliver to Estimating Manager for final review. Approval by document owner and Estimating Manager is needed for update of controlled form.