Emboss notes

What I learned making blind embossed business cards, so you can skip my mistakes.

My biggest mistake was wetting the paper. Dry works better.

01 PAPER

Use thick cotton paper. It takes the shape without tearing.

Worked: Portofino cotton, 300 g/m². Weaker: 200 g/m². Failed: office paper.

02 DEPTH

Less depth gives a sharper result.

My first mold was 1.1 mm deep and tore. Final: 0.64 mm centre, 0.16 mm corners.

03 GEOMETRY

Round every inner corner. Sharp corners cut the fibres.

Crest radius 0.03 to 0.12 mm, paper gap 0.26 to 0.33 mm, flanks 22° to 40°.

04 PRESSING

Press dry, once, and hold.

Hold about 45 seconds. Dry gives a cleaner edge, and the print does not run.

05 THE MOLDS

Print the molds fine and flat.

0.2 mm nozzle, 0.08 mm layers, ironing on, 100 % infill under the pattern.

06 BOTH SIDES

Never glue it between flat plates. Use two female molds.

Clear bookbinding glue, thin on the middle layer. Clamp 30 minutes, then cut.

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Designed and engineered in Graz.