



**Machine series B offers a larger cutting size up to 230 x 230 mm and greatly increased punching power. All types of material, especially plastics, can be cut. The machines are used for small and medium runs.**



## Die-cutting machine B and B+P

The compact and robust design reflects the increased punching power. The construction and function of both models are identical except the method of releasing the cutting stroke, as specified below.

The machines are supplied with 5 adjustable clamping arms, waste slitters and holders which are fitted into the clamping arms – thus being able to reach any required position for slitting the waste. The number of waste slitters needed is determined by the material, size and contour of the product to be die-cut.

Once the stack of material is manually inserted the cutting stroke is activated by different functions according to the machine model.

### Activation of the cutting stroke:

**B** by manual closure of the protective door, secured by auto-controlled limit switches. The door opens automatically when the punching ram runs backwards.

**B+P** by pneumatic closure of the protective door after pressing a push-button on the control panel. The function is secured by auto-controlled limit switches. The door opens automatically when the punching ram runs backwards.

The finished products are pushed onto the delivery tray for removing.



Die-cutting machine B+P

The pneumatic mobile counter-pressure unit for model B or B+P is easy to fit to the die-cutter in place of the delivery tray. The trolley facilitates the removal and storage of the delivery tray which can be refitted quickly for jobs without counter-pressure. Changeover time approx. 20 minutes.

The die is especially manufactured for counter-pressure cutting with a movable matrix of plastic or aluminium inside the die. The counter-pressure unit is connected to a compressed air supply. The material is placed in front of the die with the projecting matrix and is held vertically in the die for stabilizing during the hydraulic cut. When the ram reaches the end of its stroke, the finished material is pushed back into the feeding tray by the pneumatic counter-pressure cylinder, from where it is removed. This reduces the throughput of the machine by approx. half.

See also page 7 (Description of die-cutting with counter-pressure)



B+P with counter-pressure unit and waste conveyor (see ancillary equipment)



Trolley

Die-cutting machine B, B+P

Model		B	B+P
Max. die-cut size	mm	230 x 230	230 x 230
Min. die-cut size	mm	10 x 10	10 x 10
Min. die-cut size with counter-pressure	mm	30 x 30	30 x 30
Max. diameter for circular products	mm	235	235
Max. stack height (height of cutting die 60 mm)	mm	170	170
Die-cutting pressure	kg	5.700	5.700
Die-cutting strokes <sup>1)</sup>	per min	11	13
Machine output <sup>1)</sup> (inserting 1.000 sheets/80gsm)	sheets/h	660.000	780.000
Weight	kg	855	860

<sup>1)</sup> Max. achievable output. Die-cutting with counter-pressure reduces the output approx. by half

Counter-pressure unit GD-1

Model		GD-1
for die-cutting machines B, B+P		
Pneumatic connection:		
Max. compressed air requirements	nl/min	55
Counter-pressure, adjustable	bar	0-8 (630 kg)
Measurements: Length x width x height	mm	1.100 x 610 x 1.380
Weight	kg	305

**The use of a counter-pressure unit is recommended**

- when die-cutting embossed paper and plastics (PP or PE foil) for small-sized in mould labels and similar articles to minimise stretching or movement of the material during the cutting process
- when cutting tempered and varnished aluminium foil, e.g. for neck labels
- where tight tolerances are required