

Model overview

Die-cutting machine A, A+P, AL

For smaller runs, especially for labels



Die-cutting machine B, B+P

For larger cutting sizes with
increased punching power



Die-cutting machine BL, BLS

For large sizes, with high punching
power and light barrier activation
of the cutting stroke



Die-cutting machine CL

For large-sized products
up to 330 x 380 mm



Die-cutting machine A, A+P and AL

Series A is used for small and medium runs, mostly for labels. These models offer a cutting size up to 180 x 180 mm.

Machine construction and function of the three models are identical except for 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.

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

Activation of the cutting stroke:

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

A+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.

AL by activating the electronic light barrier. The cutting stroke is activated automatically after the operator has inserted the stack of material and his/her hand has been withdrawn from the punching section. The throughput of the machine increases due to the quicker feeding sequence. The machine stops if the operator breaks the light-barrier during the cutting process or during the backward run of the punching ram. The die-cutter therefore has no protective door.

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



Die-cutting machine A

The pneumatic counter-pressure unit GD-A, suitable for all A series machines is easy to fit onto the tray support instead of the delivery tray. The protective hood remains in place. Refitting will take approx. 10 minutes.

The die is especially manufactured for counter-pressure cutting with a movable matrix of plastics 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)



Fitted counter-pressure unit



AL with counter-pressure unit

Die-cutting machine A, A+P, AL

Model		A	A+P	AL
Max. die-cut size	mm	180x180	180x180	180x180
Min. die-cut size	mm	17 x 17 ¹⁾	17 x 17 ¹⁾	17 x 17 ¹⁾
Min. die-cut size with counter-pressure	mm	30 x 30	30 x 30	30 x 30
Max. diameter for circular products	mm	180	180	180
Max. stack height (height of cutting die 60 mm)	mm	200	200	200
Die-cutting pressure	kg	2.500	2.500	2.500
Die-cutting strokes ²⁾	per min	11	13	15
Machine output ²⁾ (inserting 1.000 sheets/80gsm)	sheets/h	660.000	780.000	900.000
Weight	kg	570	575	575

¹⁾ One measure can be reduced to 10 mm with reinforced die back

²⁾ Max. achievable output. Die-cutting with counter-pressure reduces the output approx. by half

Counter-pressure unit GD-A

Model		GD-A
for die-cutting machines A, A+P, AL		
Pneumatic connection:		
Max. compressed air requirements	nl/min	12
Counter-pressure, adjustable	bar	0-8 (250 kg)
Measurements: Length x width x height	mm	315 x 60 x 325
Weight	kg	10

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