Heinrich Envelope Corp
USA

schoen + sandt

schoen + sandt machinery GmbH

/American & Schoen MACHINERY COMPANY

Quotation No. G1207001-BEV/REV-B

Revision B of Mach 30.2015

- Second Hand Machine -

Electro-hydr. Crosshead Die Cutter Type 2071A

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www.schoen-sandt.de

schoen + sandt machinery GmbH
Lemberger Straße 82
D-66955 Pirmasens

Fax +49(0)6331-713100
Fax +49(0)6331-713129
E-Mail info@schoen-sandt.de

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1.0 General technical data

1.1 Electro-hydraulic Crosshead Envelope Die Cutter 2071A/180/550/250 kN

Welded steel construction.
With crosshead traversing underneath the beam between the support columns, powered by an electrically driven toothed belt.
Cutting stroke and return stroke are actuated hydraulically.

Specifications:

bed width:	1800	mm
bed depth:	550	mm
bed height:	850	mm
die height min.:	80	mm
die height max.:	100	mm

1.2 Stroke: 20 – 200 mm

1.3 Hydraulic Power Unit

The hydraulic power unit stands separate from the machine.
It contains pump, motor and hydraulic control valves, which are installed on a carrier plate covering the welded oil container

Specification:	60	cycle
cutting force:	250	kN
cutting speed closing:	160	mm/s
cutting speed return:	170	mm/s
motor drive:	11	KW
oil requirement:	400	ltr.(ISO VG46)
dimens. hydr. power unit:	810x710x1400	mm

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1.4 Guarding Equipment

via light curtain, horizontal installed between the console arms of the sliding table. Protection field depth: 750 mm.

1.5 Crosshead drive via servo motor

The crosshead is driven via servo motor and ball lead screw. With positioning via the resolver of the servo motor.

positioning speed:	max. 800	mm/s
typ. repeat accuracy:	+/- 0,1	mm
driving force:	10,5	Nm

1.6 Mechanical low point limits

for absolute stroke low point limitation with 2 diagonally opposed stops. Manually adjustable, including cutting platen descend without pressure.

1.7 Cutting platen

with electro permanent die mounting plate

dimensions: 650 x 650 mm

1.8 Cutting platen with 45 degrees

cut corners

1.9 Rotation drive via servo motor

The rotation of the cutting platen is actuated by a servo motor and with positioning via the resolver of the servo motor.

rotation speed:	max. 360	degrees/s
typ. repeat accuracy:	+/- 0,1	degree
driving force:	7,0	Nm

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1.10 Pneumatic Ejector

for holding down the material and /or ejecting the cut blanks.

Ejecting force:	max. 4,7	kN
Diameter: 80/150		mm

1.11 Positioning Bars

in connection with a magnetic die mounting plate, for exact positioning of a cutting die.

1.12 Plastic Base Board

Dimensions:	1460 x 1070 x 30	mm
Quality:	D 85	

1.13 Plastic Cutting Board

Dimensions:	1460 x 1070 x 10	mm
Quality:	D 71 green	

1.14 Automatic Steel Board Sliding Table

The automatic sliding table equipment consists of support arms, which are mounted to a cutting machine and of a steel board. The steel board is motorized and via ball lead screw moved into or out of the machine cutting area.

Specifications:

bed width:	1800	mm
sliding table size:	1600 x 1310	mm
useable table size:	1410 x 1020	mm
steel board hardness:	49+3	HRC

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1.15 Table Drive, Controls and Operation

With servo motor and with positioning via the resolver of the servomotor.
The drive of the sliding table movement is actuated by the control cabinet of the cutting machine.
The operating components are arranged on the table.

transport speed:	max. 600	mm/s
repeat accuracy:	+/- 0,1	mm
driving force:	10,5 Nm	

1.16 Automatic Cutting Board Oscillation for sliding tables

For oscillating the cutting board several degrees after each complete program sequence. This prevents the die from cutting into the same lines all the time, increasing the service life of the cutting board.

Oscillating radius r = approximately: 25 mm

1.17 Material Holding Device

With pneumatic retractable clamps for holding the material to be cut. Lower pincer jaws with blow nozzles.
Cutting die protection to prevent major die damages by immediately stopping the cutting stroke when the die makes contact with metall.
Across the total sliding table width there is a hole pattern for mounting the clamps in various positions. Closing, opening, advance and retraction of the clamps: is automatically actuated by the program.
Clamping range 0-65 mm.

with 4 clamps

1.18 Material Stops

Stops, spring suspended and tiltable, mounted on the table.
Across the total sliding table width there is a hole pattern for mounting of clamps in various positions.
Stop height 65 mm.

with 3 stops

1.19 Side Register Bar for sheet stacks

mounted to the machine base.
Spring supported, tiltable and pneumatically retractable. Pushes the stack back to the initial position after cutting.

1.20 Positioning Bar

The positioning bar pushes the stack against the stops. The cut stack can be pushed forward by the positioning bar after cutting. Sliding distance can be programmed as machine data.

1.21 Automatic Die Lubrication

for lubricating the cutting edge of the die by means of a parallel movable felt roller which is powered by an electric motor. Lubrication sequence to be programmed.

1.22 Smoothing Roller

Pneumatic descending of the smoothing roller onto the paper stack. Pressure adjustable. The table returns, thereby pressing the air out of the paper stack. Smoothing process to be programmed – after each cut or after each row.

1.23 Pneumatic Stripping Equipment

for raising the cut stacks of blanks out of the waste.
Table size 1600 x 1050 mm.

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1.24 IPC-Controls

The electric controls are installed in a separate control cabinet.
The door of the cabinet contains the Industrial-PC and the operator's and control components.
Industrial-PC with fiber-optic cable and intelligent decentral input and output modules, controls the complete program flow and is used for program storage.
With alpha-numeric keyboard.
With random or simplify program input.
Programs for discs and rectangular blanks are automatically calculated, considering optimum material yield, based on input of material and cutting die dimensions.
With zero-point adjustment for all coordinates.
With operator's guidance.
With connection for a telephone modem.
With clear text error display.
The electric control cabinet is built according to the EN-rules 60204.

1.25 Interface for CAD connection

1.26 Fault analysis display

All operations of the instructors and limit switches can be shown on the display screen.
With clear text error display in automatic mode.

1.27 De-stacking Unit Type 3141A

for automatically removing of paper reams from the stack.
All movements are electro-motorized. De-stacker table plate designed as air table.
The pull-in pincer closes pneumatically, with drive, for transporting the stack on the de-stacker table plate. With quick adjustable stack guide.

Paper size:	max. 1400 x 1000 mm
paper stack height:	max. 1700 mm
de-stacking height, adj. from	15 – 120 mm
weight, approx:	1200 kg