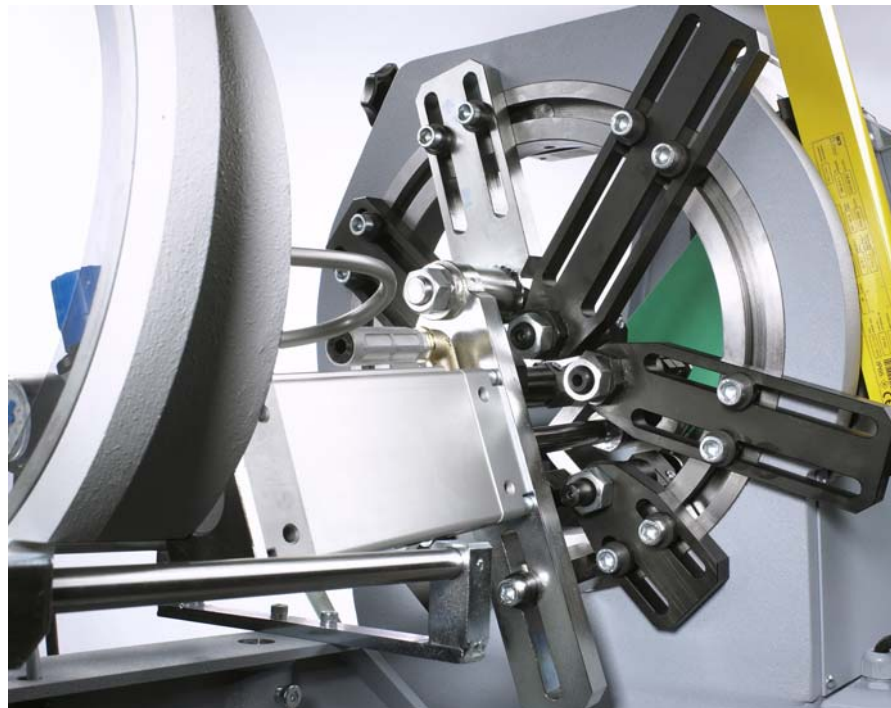


## Counterpressure Device GD-A for BUSCH punching machines A, A+P and AL

Counterpressure punching is used to ensure accuracy of the product, especially for in-mould labels and related products.

- Easy installation
- The protection hood of the punch is used also for counterpressure punching
- Counterpressure adjustable by control valve



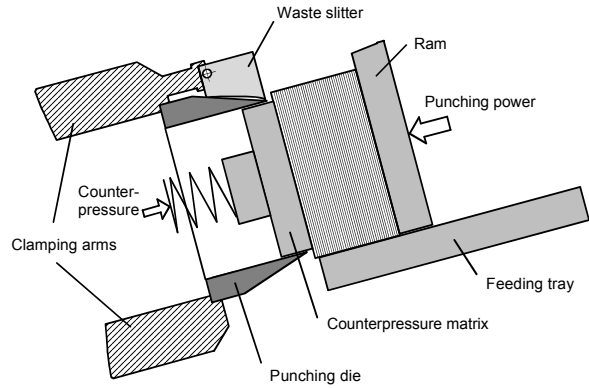
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- without engagement -  
April 2004

## Punching principle

The rectangular pre-cut stacks are pressed through the cutting die using hydraulic pressure; at the same time they are pressed against a pneumatic driven counterpressure matrix, which is located in the cutting die. The material is straightened and pressed before the much stronger hydraulic pressure overcomes the pneumatic pressure and presses the stacks through the cutting die.



This yields highly precise punching results, which cannot be achieved with any other system. The output is lower, but the system is used when extreme accuracy is required and when modern materials (PE or PP foil) are punched. There is no need to use a base-board when punching.

## Technical Data

<p>The pneumatic counterpressure device is fitted to the punching machine after dismantling the delivery tray. Connection to the central plant for compressed air is necessary.</p>	
<p><b>Counterpressure device</b></p>	<p><b>GD - A</b></p>
<p>for BUSCH punching machines</p>	<p>A, A+P, AL</p>
<p>Max. punching size with counterpressure Min. punching size with counterpressure</p>	<p>7.1 x 7.1 inch 1.2 x 1.2 inch</p>
<p>Max. infeeding height of material with counterpressure</p>	<p>4.7</p>
<p>Punching die</p>	<p>with grooves (0.2 x 1.15 inch) at outer contour for the location of the retention pins</p>
<p>Counterpressure matrix</p>	<ul style="list-style-type: none"> <li>- material: aluminium or plastics</li> <li>- (thickness 1.2 inch)</li> <li>- outer contour (on all sides) 0,1-0,2 mm smaller than the punching line of the label</li> </ul>
<p><b>Pneumatic connection</b> Max. air requirement Max. working pressure Counterpressure adjustable by control valve</p>	<p>1.5 USgpm 116 p.s.i. 0 – 116 p.s.i.</p>