



# *Master Blanker*



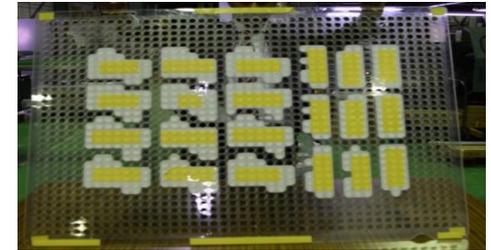
## Job changing (CBL/BLK)

The Master Blanker features a template system that sectionalizes the unit's upper and lower pins using paperboards. This makes it easy to create blanking templates with the help of dedicated CAD software and a cutting machine. Also, if suitable data is not available, the actual product can be used to create a template after die cutting.

Upper template



Lower template



Remove the upper/lower template which is in use and insert the new upper/lower template.



Job changing only takes **3** minutes !

## How to make template (CBL/BLK)

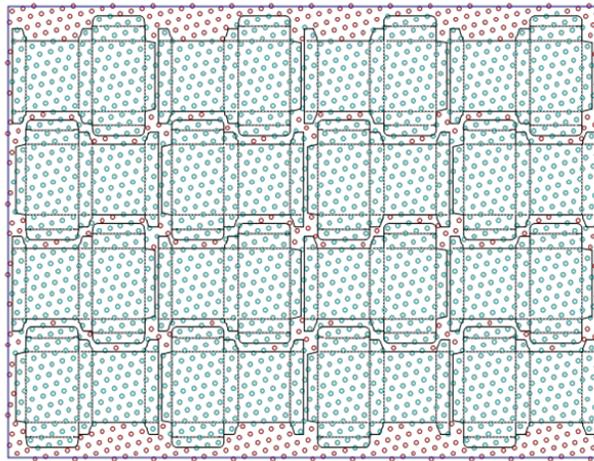
### 1. CAD software

We provide our Master Blanker models with our own developed CAD software MARK V.

- Import the die boards data (Dxf, Eps, CFF2, etc) to MARK V
- Display pin position
- Adjust pin position
- Change a layout if it need

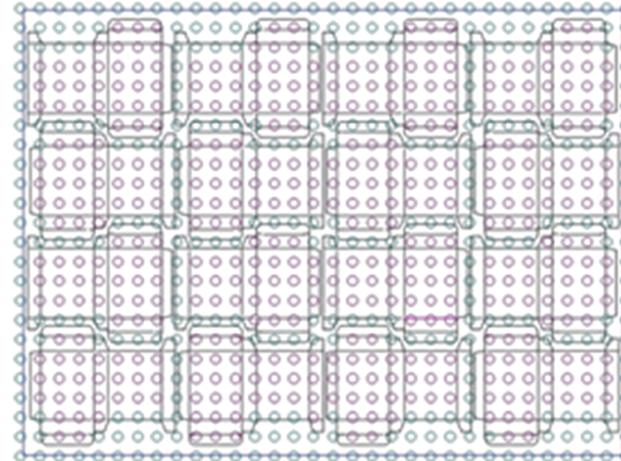
#### UPPER PINS

- using pins  
(pushing the wastes)
- not using pins



#### LOWER PINS

- using pins  
(Hold the products)
- not using pins



## 2. Plotter

Please prepare plotter on your own. (ex. bellow)

Out put the data which is made at first step to plotter and cut the sheets.



Place cut paper templates on job storing sheets and  
put upper/lower paper templates between upper/lower template cases.



### Necessary function of plotter

- Blanking size : Max 1100mm × 800mm  
Min 400mm × 400mm
- Tool : Cutting tool / Pen tool
- Import data : Dxf / HPGL



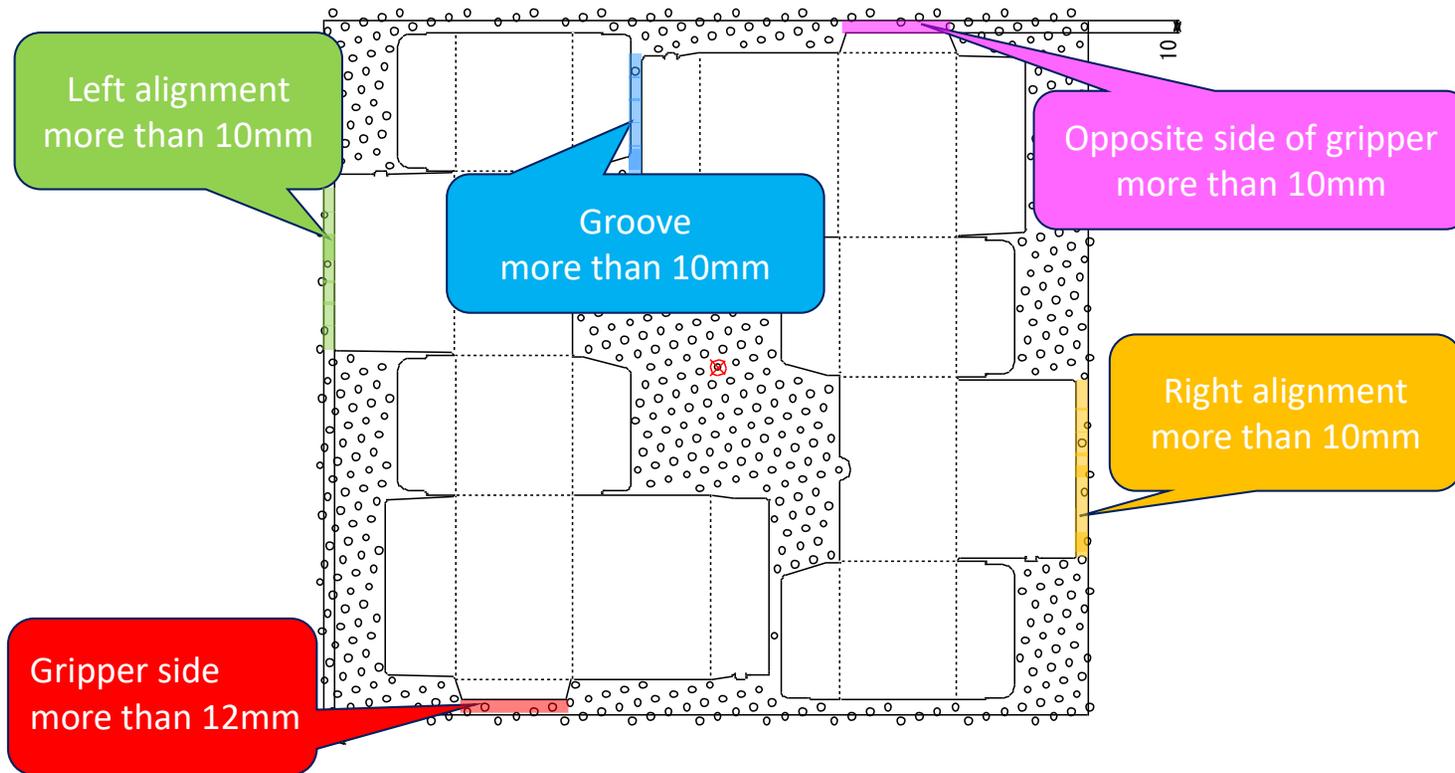
Upper template



Lower template

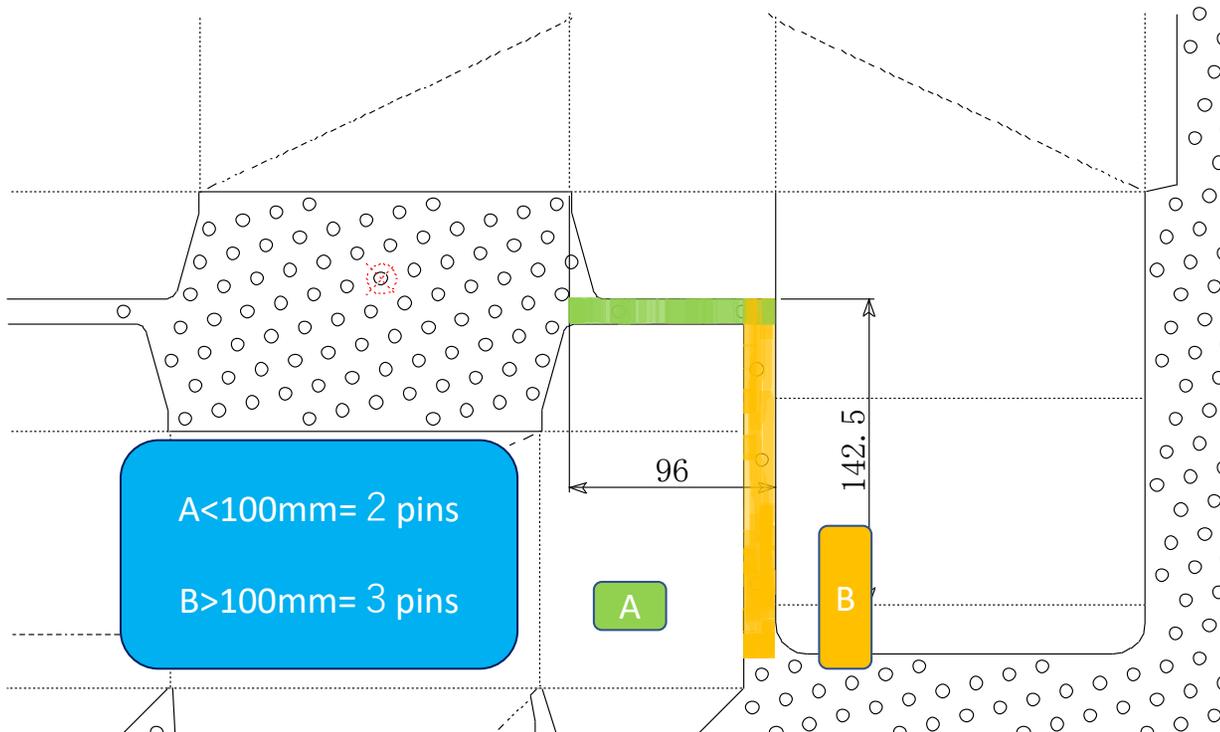
# Layout

- Basic rules (preferable) -



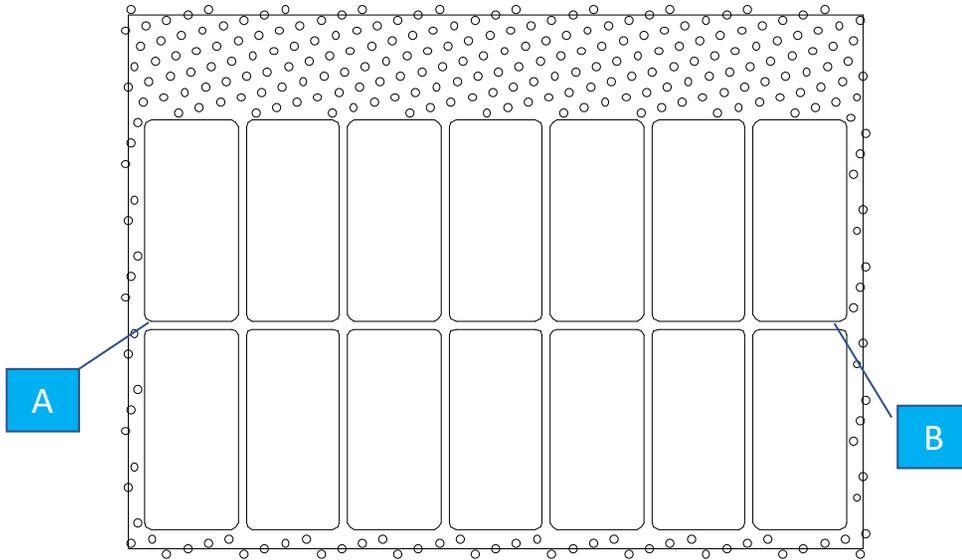
## Layout2

- Basic rules2 (preferable) -

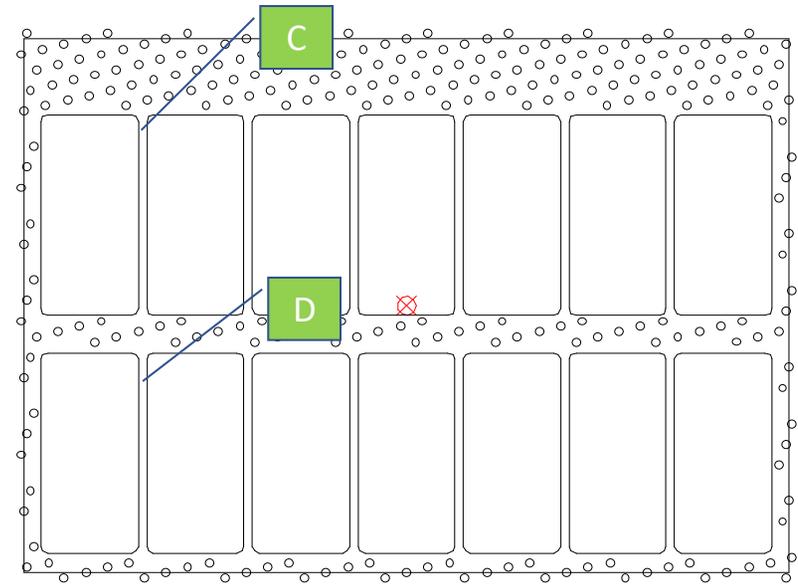


If the cut lines are not straight, certain numbers of upper pins need to be placed in the lines.  
\*Number of pins can be decreased depends on the condition (shapes and nicks).

## Layout3



If the distance between point A to B is more than 200mm, upper pins need to be places between products (vertically).  
\*right side figure is an example of after modification.

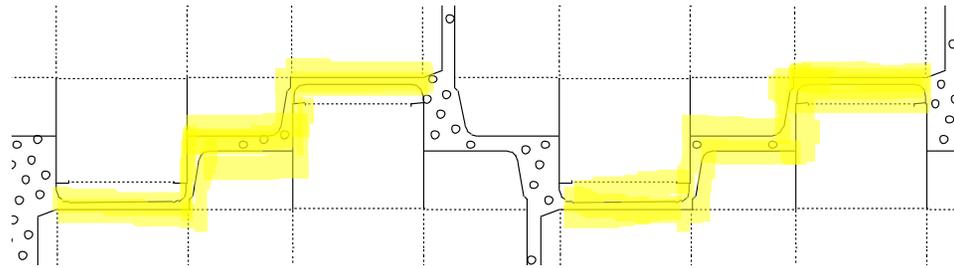


If the distance between point C to D is less than 200mm, there is no need to place upper pins. The waste areas can be remove with other area where upper pins push down the waste.

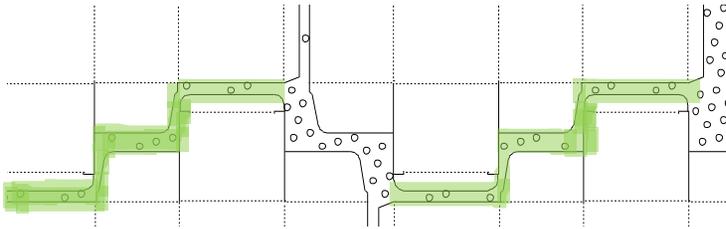
## Layout4

- Double cut -

If the upper pins can't be fit between 2 products

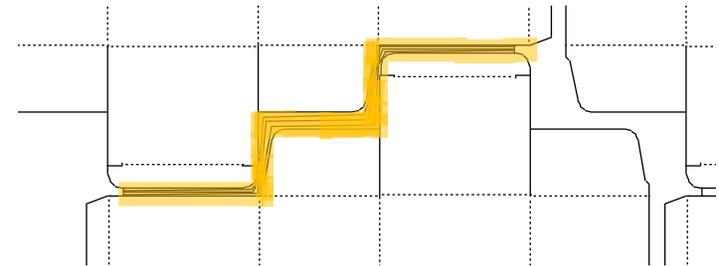


Solution1



Increase the distance between products  
to place upper pins.

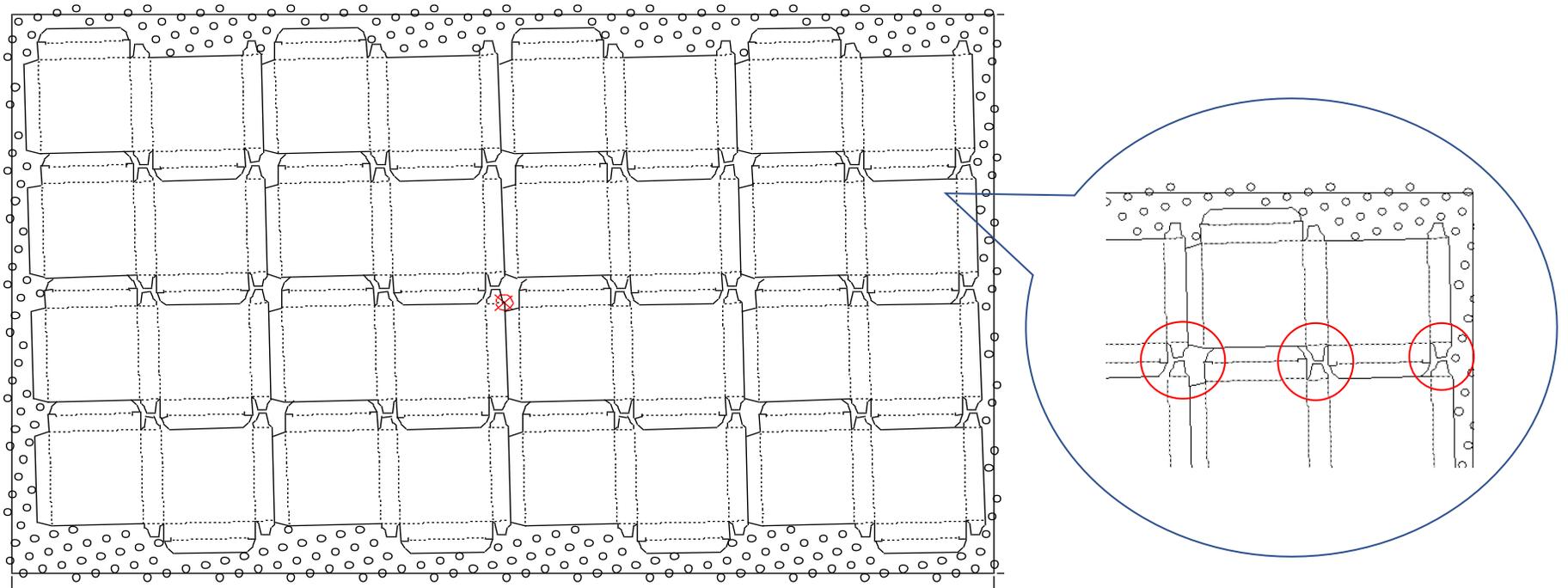
Solution2



Strip the waste areas above

## Layout5

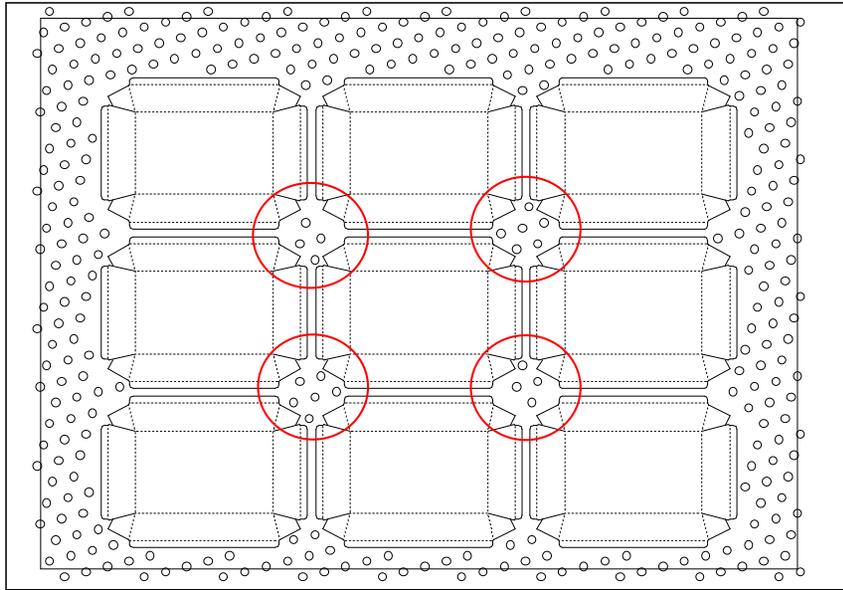
- Single cut -



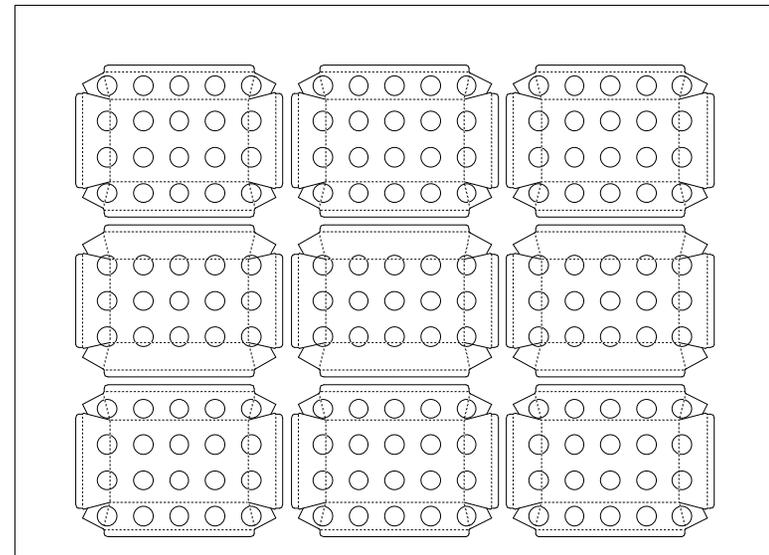
Single cut makes keeping the sheet size minimum.  
Stripping for internal waste areas are needed before blanking.

## Layout6

- Small spaces of waste area (window) -



Upper pin layout

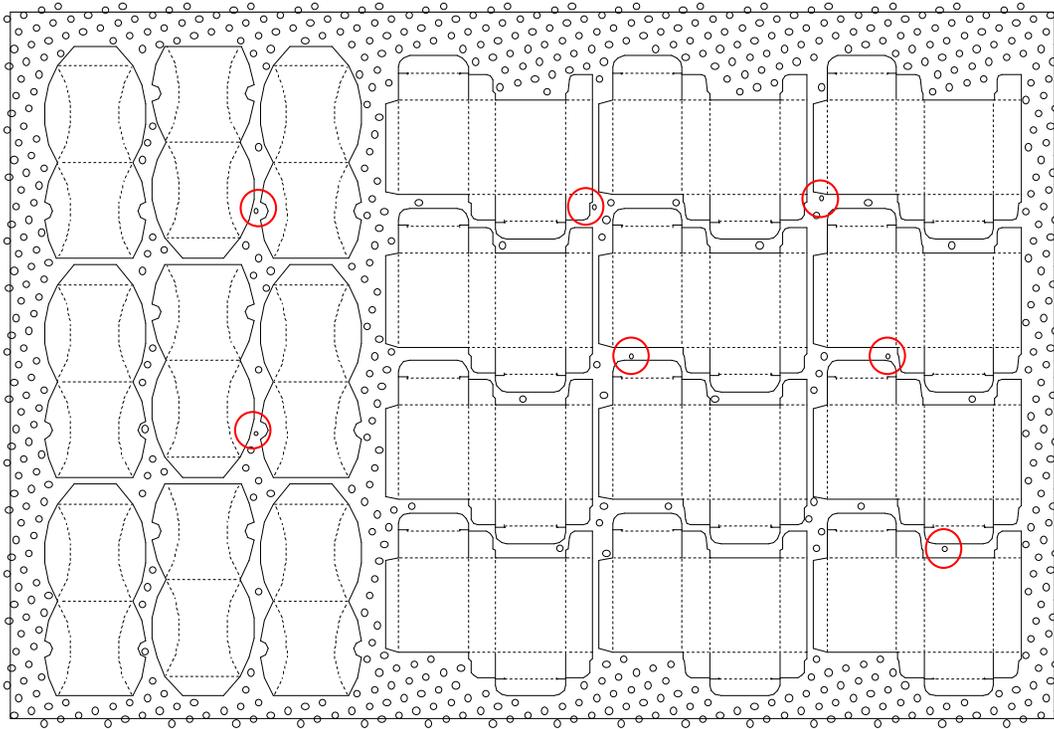


Lower pin layout

Upper pins need to be inside the small spaces of waste are or window at least 3 pins to push the waste down. If it is not possible, stripping needs to be done before blanking.

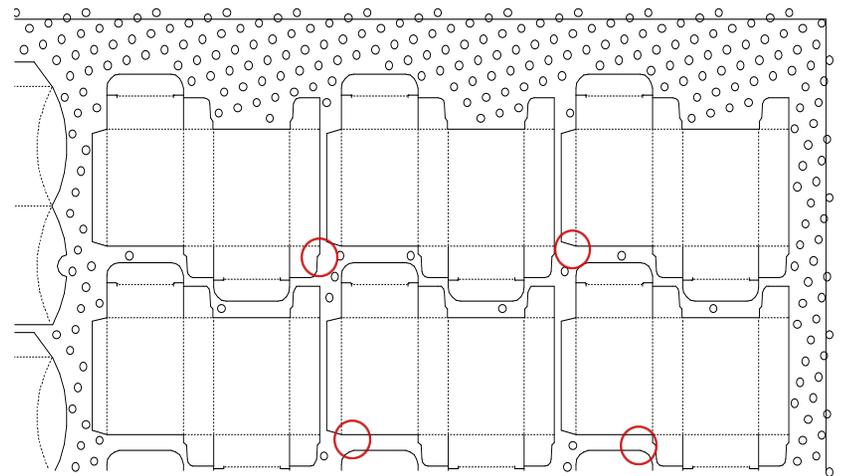
## Layout7

- 4 $\Phi$  pin (option) -



Using 4 $\Phi$  pins

If the 6 $\Phi$  pins can't be fit between products and the layout/paper size can't change, there is another solution. Using 4 $\Phi$  pins instead of 6 $\Phi$  pins.



Using 6 $\Phi$  pins

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