

Product	-	Automatic Die Cutting Machine with Stripping, Blanking, Heating Chase and 600Tons Cutting Pressure
Model	-	BHT-1060 ASCER
Warranty	-	2 Years



Please note that the picture is for **ILLUSTRATION ONLY** and may vary from the equipment offered.

Expertise Jobs can do with 600 Tons Cutting Pressure:

Cake Base Cutting, Kappa Board Cutting, Deep Embossing, 3D Embossing, Plastic Jobs.

Processed Materials:



Corrugated Board



Features:

1. CE Approved.
2. Centre Line System.
3. Human Machine Interface and PLC from Siemens.
4. Belt Driven Main Drive.
5. High Speed and Precision Feeder Equipped.
6. Photoelectrical Device for Safe Operation.
7. **Ultrasonic Double Sheet Detector without touching the paper hence Scratch Free, Reliable, and Quick Set Up.**
8. **Sheet Slow Down Device.**
9. **600 Tons Cutting Pressure**
10. **Equipped with Heating Chase**
11. **Overload Protection Torque Limit Controller**
12. **Micro-Adjustment for Quick Set Up and Easy Make-Ready.**
13. **Variable Speed Worm Gear Drive Device allows Large Motion Angle Hence Minimum Number and Size of Nicks at reasonable Max Production Speed.**
14. **Four Side Stripping System.**



15. Advanced Quick Tooling Set Up System ensures Fast Job Change

Over and hence High Productivity while running Stripping.

16. Automatic Central Lubrication with Oil Cooling Device.

17. Non-Stop Sampling.

18. Wide Stock Range for Corrugated Board and Card Board.

19. ISO 9001 and CE Approved Manufacturing Process.

20. European, Taiwan and Japanese Standard Spare Parts.

Machine Configuration:

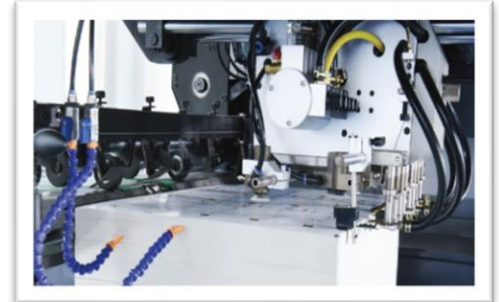
S. No.	Features	Include	Qty.
1	Machine Platform	Y	1 No's
2	Gripper Bar Assembly	Y	1 No's
3	Paper Trolley	Y	2 No's
4	Die Chase (Installed in Machine)	Y	1 No's
5	5mm Cutting Plate (Made in Germany)	Y	1 No's
6	4mm Counter Plate (Made in Germany)	Y	1 No's
7	1mm Cutting Plate	Y	1 No's
8	Optional Non-Stop Sampling System	Y	1 No's
9	Stripping Waste Basket	Y	1 No's
10	Optional Extra Die Chase	N	1 No's
11	Optional 5mm Hardened Die Cutting Plate (Made in Germany)	N	1 No's
12	Optional 4mm Hardened Counter Plate (Made in Germany)	N	1 No's
13	Optional Extra 1mm Hardened Die Cutting Plate (Made in Germany)	N	1 No's
14	Optional Extra 1mm Hardened Die Cutting Plate (Made in China)	N	1 No's
15	Optional Gripper Bar Assembly	N	1 No's
16	Optional Stripping Waste Basket	N	1 No's
17	Optional Speed Display	N	1 No's
18	Optional Tape Inserter (Including 8 Tapes)	N	1 No's
19	Optional PLC Remote Controller (For Software Upgrade and Maintenance)	N	1 No's
20	Optional Die Chase Loader (Without Die Chase) - For Pre-Make Ready of Next Job	N	1 No's

Technical Specification:

Max. Sheet Size	1060 X 760 mm
Min. Sheet Size	400 X 350 mm
Max. Die Cutting Size	1050 X 745 mm
Inner Chase Size	1080 X 790 mm
Min. Gripper Margin	9-17 mm
Stock Range	90~1000g/m (Card Paper)
	≥ 4mm (Corrugated Paper)
Die Cutting Accuracy	± 0.1 mm
Max. Cutting Pressure	300 Tons
Machine Speed	8000 s/h
Feeder Pile Height	1600 mm (Including Wooden Pallet)
Delivery Pile Height	1400 mm (Including Wooden Pallet)
Main Motor Power	15 kw
Total Power Required	26 kw
Machine Dimensions (Length: Including Pre-Feeding Track) (Width: Including the Pedal)	10300 X 5857 X 2657 mm
Total Weight of Machine	22 Tons
Air Pump Displacement	0.6~0.7Mpa, ≥0.37m ³ /min

FEEDER:

1. Three lifting up and four forwarding sucker heads with angle adjustment to handle different kinds of materials.
2. Preloading device with rail cart and scaled gate.
3. Manually side adjustment of pallet table (+/- 40 mm).
4. Side adjustment of pallet table.
5. Non-stop feeder with automatic pile lift.
6. Side blowers adjustable according to sheet size for smooth feeding, especially for smooth thin paper transport.



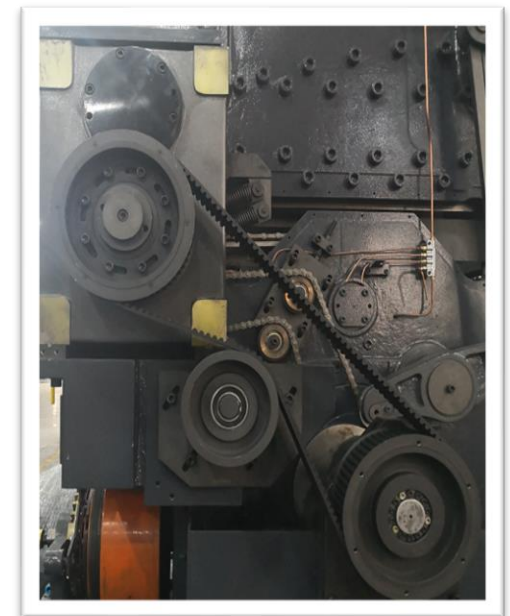
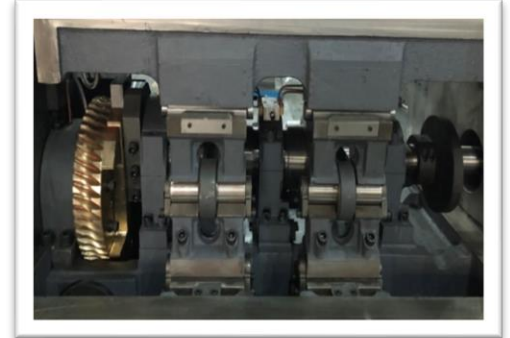
FEEDING TABLE:

1. Left and right-side push lays to ensure accurate alignment and power registration.
2. Sheet slow down device of feeder belts to assure accurate position of the sheet to the front lays (electro-pneumatically adjustable).
3. Synchronizing device to adjust the sheet positioning to the front lay by hand during production.
4. Feed table inlet equipped with lateral ramps.
5. Four individually adjustable front lays at the operation side of the machine.
6. Ultra-Sonic double sheet detector (without contact).
7. Sheet hold-down device (guiding the sheets to the front lays).
8. Upper frame with manual lifting device.
9. Pull and push convertible side lays (OS and OOS) with photo sensor sheet arrival control.



DIE-CUTTING SECTION:

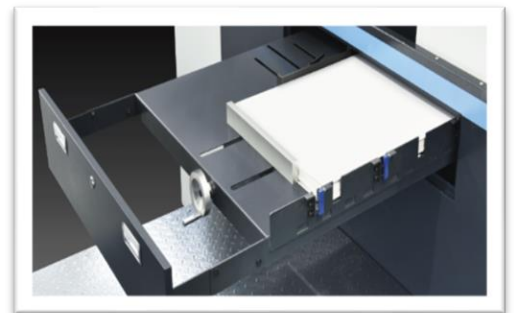
1. Precision worm gear crank toggle driving system to ensure smooth and dynamic lower platen movement.
2. Short stroke movable platen, driven by eccentric worm gear and toggle mechanism allows large motion angle hence minimum number and size of nicks at reasonable max. production speed.
3. Precision stationery upper platen.
4. State-of-art 3 cam index gripper bar drive system to ensure smooth and precise gripper bar intermittent movement.
5. Pneumatic clutch/brake for main drive system.
6. Motorized cutting force setting by push button.
7. Digital strain gauge die cutting pressure tonnage display at HMI with adjustable pressure limit protection.
8. Eight high precision alloy gripper bars.
9. High quality pre-stretched gripper bar drive chain.
10. Torque limit safety clutch to protect the index drive system in case of gripper bar crash.
11. Double cam driven gripper opener and front lay swing frame without position restore spring for smooth and accurate sheet register and take off.
12. Pneumatic push button die chase locking mechanism to ensure safe and operator friendly changing of the die.



- 13.5mm hardened cutting plate or 4+1mm sandwich plate (optional) on top of 15mm precision synthetic supporting plate with +/-0.9mm micro adjustment for quick set up and make ready.
14. Automatic main chain lubrication system.

STRIPPING & BLANKING SECTION:

1. Complete set of stripping tools with upper and lower stripping pins
2. Centre line system for quick stripping die set up
3. Integrated Quick Locking System
4. Automatic quick locking device for the upper tool integrated in the machine
5. Funnel for waste guidance
6. Efficient and smooth cam running curve drives the stripping and blanking tooling with large motion angle to ensure clean and tiny stripping and blanking at speed
7. Automatic binder sheet inserter with electrical sheet presence control
8. Automatic selection of suction cups according to the sheet size
9. Constant compression level system (NCT)
10. Continuous pile lowering whist maintaining a constant height of the pile
11. Automatic pallet changing device
12. Automatic non-stop device
13. Waste or skeleton removal apron
14. Upper blanking tool mounting frame can be pulled out for quick job set up and make ready
15. Full sheet delivery can be achieved with die cutting and stripping only, while blanking is not necessary.



SAMPLING SECTION:

The sampling function can be used to remove a sample sheet on the fly by one button only, easy for operating.



ELECTRICAL CONTROL SECTION:

1. Adopts electrical components of world-famous brands for better performance and in time and local after-sale-service and maintenance.
2. Siemens latest PLC technology to ensure safe and trouble-free running.



MAIN MACHINE PARTS:

S. NO.	MAIN PARTS	BRAND	COUNTRY(REGION)
1	Main Motor	SIEMENS	Germany
2	Man-Machine Interface	SIEMENS	Germany
3	PLC	SIEMENS	Germany
4	Servo Motor	YASKAWA	Japan
5	Servo Drive	YASKAWA	Japan
6	Timing Belt	GATES	American
7	Cutting Plate	4 + 1 mm HIGH ALLOY PLATE	Germany
8	Vacuum Pump	BECKER	Germany

9	Intermittent Segmentation	HANDEX	Taiwan
10	Rotary Joint	OMPI	Italy
11	Electromagnetic Clutch	OMPI	Italy
12	Electromagnetic Gear Clutch	OMPI	Italy
13	Crankshaft Material	Ni-Cr-Mo METAL STEEL	Germany
14	Main Drive Chain	IWIS	England
15	Secondary Chain	TSUBAKIMOTO	Japan
16	Grip Bar, Gripper	KUI	Japan
17	Indicator Light	MOELLER/EATON	Germany
18	Circuit Breaker	MOELLER/EATON	Germany
19	Safety Relay	MOELLER/EATON	Germany
20	Security Module	MOELLER/EATON	Germany
21	Button	MOELLER/EATON	Germany
22	Motor Protector	MOELLER/EATON	Germany
23	Magnetic Switch	MOELLER/EATON	Germany
24	AC Contactor	MOELLER/EATON	Germany
25	Button	MOELLER/EATON	Germany
26	Relay	MOELLER/EATON	Germany
27	Photoelectric Switch	OMRON	Japan
28	Relay Seat	OMRON	Japan
29	Proximity Switch	OMRON	Japan
30	Encoder	OMRON	Japan
31	Sensor	OMRON	Japan
32	Bearing	NSK	Japan
33	Cable	TKD	Germany
34	Air Cylinder	FESTO	Germany
35	Air Volume Regulator	FESTO	Germany
36	Main Solenoid Valve	FESTO	Germany
37	Linear Guide	ABBA	Taiwan
38	Worm and Gear	WANCENG	Taiwan
39	Wallboard and Machine Body Structure	QT 600-7 Nodular Cast Iron	China
40	Feeder	YONGCHUAN	Taiwan
41	Main Paper Feeding Motor	CHENGBANG	Taiwan
42	Lift Motor of Paper Collecting Platform	CHENGBANG	Taiwan

Current Product Range Covers

BHT Model (Most Advance Series)

1. Automatic Die Cutting Machine with Four Side Stripping, Heating System and 600 Tons Cutting Pressure
BHT-1060/1060A/1060AR/1060CE/1060ACE/1060ACER/1060SCE
/1060ASCER

MHK Model (Efficient Series)

1. Automatic Die Cutting Machine with Four Side Stripping
MHK-820/820CE/1050/MHK-1050CE
2. Automatic Die Cutting & Hot Stamping Machine
MHK-820T/1050AT
3. Automatic Die Cutting & Hot Stamping Machine with Four Side Stripping
MHK-/820TC/1050ATC
4. Automatic Lead Edge Feeding Die Cutting Machine with Four Side Stripping
MHK-1300FC/1500FC/1650FC/1900FC
5. Automatic Bottom Feeding Die Cutting Machine with Four Side Stripping
MHK-1300EFC/1500EFC/1650EFC/1900EFC
6. Automatic-Manual Die Cutting Machine with Four Side Stripping (Top Feeding)
MHK-1300EC/1500EC/1650EC/1900EC
7. Duo Press Automatic Die Cutting Machine with Double Station
MHK-2S1050RMC/2S1050TMC/2S1050TRC/2S1050TTC
8. Trio Press Automatic Die Cutting Machine with Triple Station
MHK-3S1050TRMC/3S1050TTMC/3S1050TTRC

MHC Model (Economical Series)

1. Automatic Die Cutting Machine (Top Feeder)
MHC-820/1060
2. Automatic Die Cutting Machine with Three Side Stripping (Top Feeder)
MHC-820CE/1060CE
3. Automatic Die Cutting & Hot Stamping Machine (Top Feeder)
MHC-820T/1060AT
4. Automatic Die Cutting & Hot Stamping Machine with Three Side Stripping
(Top Feeder)
MHC-820TC/1060ATC
5. Automatic Lead Edge Feeding Die Cutting Machine
MHC-1300F/1500F/1650F/1900F
6. Automatic Lead Edge Feeding Die Cutting Machine with Three Side
Stripping
MHC-1300FC/1500FC/1650FC/1900FC
7. Automatic Bottom Feeder Die Cutting Machine
MHC-1300EF/1500EF/1650EF/1900EF
8. Automatic Bottom Feeder Die Cutting Machine with Three Side Stripping
MHC-1300EFC/1500EFC/1650EFC/1900EFC
9. Automatic Die Cutting Machine (Tiptronic Feeder)
MHC-1100E/1300E/1500E/1650E/1900E
10. Automatic Die Cutting Machine with Three Side Stripping (Tiptronic
Feeder)
MHC-1100EC/1300EC/1500EC/1650EC/1900EC
11. Semi-Automatic Die Cutting Machine
MHC-1100B/1300B/1500B/1650B/1900B



12. Semi-Automatic Die Cutting Machine with Three Side Stripping
MHC-1100BC/1300BC/1500BC/1650BC/1900BC
13. Semi-Automatic Die Cutting Machine with Feeding Table
MHC-1100BL/1300BL/1500BL/1650BL/1900BL
14. Semi-Automatic Die Cutting Machine with Feeding Table & Three Side Stripping
MHC-1100BLC/1300BLC/1500BLC/1650BLC/1900BLC

Company Introduction:

Zhejiang Dayuan Machinery Co., Ltd. (Origin Ruian Ruiyang Printing Machinery Co., Ltd.) is headquartered in No.105, Haize Road, Binhai New Area, Pingyang county, Wenzhou city, covering an area of over 40000 square meters and construction area of over 80000 square meters.

Founded in 1999, Dayuan now owns modern production facilities and over 400 employees with annual production capacity of 600 sets.

At Dayuan, we are proud that every machine has been under manufacturing in strict accordance with ISO 9001 Quality Management System and CE Standards. There are over 3000 machines running in 30 countries, such as UK, Spain, Egypt, Saudi Arabia, Poland, Czech, Russia, South Africa, Brazil, Argentina and etc. Since started the partnership with world leading packaging companies of European, Asian, Middle East, North & South America companies, Dayuan will continually satisfy our customers by offering high quality machines and first-class service.

Factory:



Workshop:

