SHANGHAI EX.EXPORT INTERNATIONAL INDUSTRY CO., LTD

EX-1224 Vacuum Transfer Full Automatic Lead Feed Flexo Printing Slotting Die Cutting Machine

Main Technical Parameters

1224 FULLY AUTOMATIC LEAD FEEDER FLEXO THREE COLOR PRINTING SLOTTING DIE CUTTINGMACHINE	
Max Machine Speed (pcs/min)	250
Economic Working Speed (pcs/min)	200-220
Max Feeding Size (mm)	1200×2600
Max Printing Size (mm)	1200×2400
Skip-feeding Size (mm)	1400×2600
Min Feeding Height (mm)	350（low speed, full printing）
Max Slotting Depth (mm)	380
Standard Plate Thickness (mm)	7.2
Suitable Cardboard Thickness (mm)	2 - 11
Main Motor Power (kw)	30
Total Power (kw)	100
Overall Dimensions (mm) L*W*H	15000×4500×1800

CONFIGURATION

General Features:

►The whole machine is designed and made according to high requirements with reliable and safety function; allows quick order changing and user-friendly operation;

►Select the excellent materials and parts, all orders are made of the fine steel, with chrome plating and harden treatment;

►Driving gears are imported products, its grinding hardness is above 60 degrees;

►Adopted joint ring-free technology, to reduce abrasion and achieve precise printing result;

►With automatic zero setting and reset function;

►Adopted gear lubricant auto self-balance device, to keep the lubricant levels in each unit uniform at all times;

►Independent computer control is able to store different orders, enable quick order changing;

►Each working unit is motorized for open and close actions, with warning alarm system to ensure safety;

►The distance adjustment of the feeding roll, press roll, and netted roll are achieved by electric control;

►Central collection system for the dust and waste flakes

A. Feeder Unit

►Continuous or skip feeding is available with counter;
►Copy sun automation lead edge feeder with strong vacuum transfer for precise and stable feeding;(made from Guangdong province)
►Variable frequency drive control for vacuum blower fan for increased or decreased vacuum suction to match different size cardboard.
►Feeding roll is made of two-layer rubber, inner layer is soft and outer layer is hard, this makes inner layer more flexible and surface more wear-resistant, and reduce the flute damage of the cardboard;
►Dust remove system with brush and segmented vacuum sheets cleaner; Self-locked system adopts for adjusting feeding rolls gap, motorized and PLC control of feeder side guides;
►Motorized backstop forward /backward and up/down position for easy and quick adjustment;
►Main motor is protected from starting up when units are not fully closed and locked.

B. Printer Unit

►with four-unit ceramic roller and doctor blade.
►Mounting roller with left and right both of side locking device, let the mounting position more accurately.
►Pneumatic clutch is adopted on the anilox roll to:
(1) Make the roll run at the same speed as the main motor when the unit is printing;
(2) Make the roll stop when the unit is not printing;
(3) Reduce the possibility of damage to the rubber roll and the anilox roll for in proper operation;
(4) Allow units which are not in use to be washed up while running.
►Printing register is digitally controlled by motor and PLC
►Transverse register is also digital controlled by motor and PLC ±10mm
►Quick set and self-locking pull collars.
►A fixed device of printing register and brake of electromagnetic clutch is used when the unit is opened. upon closing the unit, the positions are precisely restored so the unit is ready for production without adjustment.
►Cleaning function can be automatically switched to ensure the ink recycling thoroughly
►Automatic resetting after cleaning the printer
►with six units ceramic roller and four units doctor blade.
►ceramic roller LPI according to customer requirement.

C. Slotting Unit

►Single shaft five blades slotting, an internal gear adjusts the height of the carton box and prevents the lubricating oil from spilling or leaking onto the cardboard
►The first pre-creasing, the cardboard not be damaged after prepressing.
►Upper creasing roll covered by anvil ring, so cardboard is not damaged easily.
►Slotting bosses move along liner lead rails and are driven by lead screws for flexible and precise movement.
►Upper boss and lower boss are coupled to keep the two knives aligned while moving, which is helpful to prolong service life.
►Slotting register and height of carton box are digital controlled by motor and PLC.
►Transversal movement of the pre-creasing rolls, and slotting bosses' are digital controlled by motor and PLC
►Motorized controls of the slotting bosses caliber.
►A protective device prevents the slotting knife from crashing when the height of the carton box is adjusted.
►Flexible angle cutting knife can cut 3 or 5 or 7 ply cardboard with no adjustment, easy to operate.

D. Die Cutting Unit

►with separate servo motor.
►Side to side oscillation of anvil drum(45mm)
►The die drum's transverse movement can prolong the service life of anvil cover.
►Die-cutting register is digitally controlled by motor and PLC
►The die-cut cylinder lateral register is digitally controlled by motor and PLC, rang about±10mm
►Motorized caliper adjustment between anvil roll and die drum.
►Auto speed compensation system controlled by the independent motor can achieve the superb die accuracy.
►Anvil rubber roller speed compensation adopted independent motor for driving to control the rubber roller speed, the compensation scope is ±3mm.
►Anvil trimmer to keep surface of the anvil covers flat and smooth.
►Anvil cover is depride made from Germany

E. Main Bought-in Parts (from Good Famous Manufacturers)

1． Main motor

1) Main motor adopts frequency conversion motor，Siemens Bedford brand
2) Fans adopt frequency motor(Shanghai)。

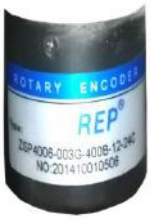
2.Bearings

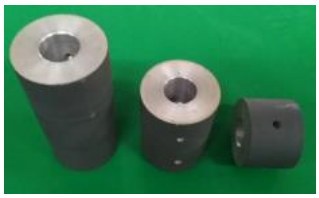
1) imported (Japan) nsk

3.Electrical Parts

1)Units adopt independent control unit, safe and reliable
2)Relay, lights, buttons, contactor, air switch adopt (France) Schneider etc. good famous brand, to ensure reliable
3)Adjust frequency converter adopt Delta (main motor frequency conversion adjustment, suction feeding frequency adjustment)
4)PLC controller adopt Taiwan Delta
5)Rotary encoder adopt the Japan Omron
6)Cylinders, pneumatic components using (Taiwan) Airtac.
7)solenoid valve adopt (Japan)SMC
8)Touch screen adopt (Taiwan) delta.
9)Rubber roller, (Guangdong) Jingyang made
10)Phase motor frequency control, inverter (Taiwan) Delta
11)Inking motor with (Taiwan) Chengbang motor
12)ceramic anolox roller adopts (Guangdong province) Guangtai.

Name	Origin	remarks
1. main motor 	KunShan	The main motor adopts frequency conversion motor SIEMENS better
2.Fan 	ShangHai	Fan with variable frequency motor (Shanghai) Zhicheng
3.Bearing 	Japan	nsk Bearing
4.electrical components 	France	Units with independent control unit, the safety and reliability of the relay, lights, buttons, contactor, air switch with Schneider and other famous products, to ensure the reliable
5.delta inverter 	Taiwan	Adjust the frequency converter adopts Delta (the main motor frequency conversion adjustment, suction feeding frequency adjustment

6..PLC controller 	Taiwan	PLC The controller adopts Delta
7.rotary encoder 	Japan	The rotary encoder using OMRON (Japan)
8.Cylinder 	Taiwan	Cylinder, pneumatic components adopts (Taiwan) Yadeke
9.solenoid valve 	Taiwan	The electromagnetic valve adopts AIRTAC (Taiwan)
10.touch screen 	Taiwan	The touch screen display adopts Delta
11.rubber roll 	Hebei	Rubber roller, Jing Hui of Guangzhou city
12.Phase motor 	Taiwan	Taiwan Sheng bang phase motor
13.ink motor 	Taiwan	Ink motor used (Taiwan Sheng bang motor)
14.knife tool	Qingdao	15.Qingdao JINDA knife

		tool
16.Ceramic anilox roll 	Jiangsu	Haili roller
17.Two piece 	Zhejiang	DEKE
18.Diaphragm pump 	Wuhan	Jin Changjiang
19.Rubber pad 	Taiwan	Chaonai
19、Expanding sleeve 	Shanxi	Xianyang
20.  Ceramic feeding wheel	Guangzhou	Guangtai

21.printing unit suction motor 	Foshan	Siemens

Explanation

1)While customer signing contract, must mark positive or negative knifes

2)Customer need choose anilox lines No.