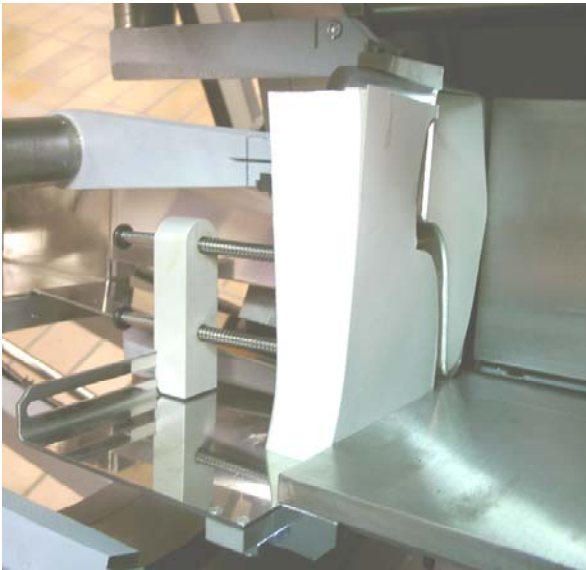


Holding device for the "Two-up system" (two punching steps) for automatic punching machine BL and BLS



Advantages:

- Guillotining time is reduced by about 50% - compared to guillotining time for blanks containing just one print
- Saving on material of about 20%
- The normal punching die can be used

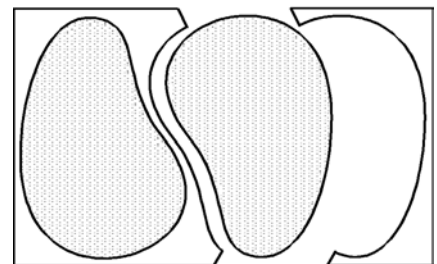
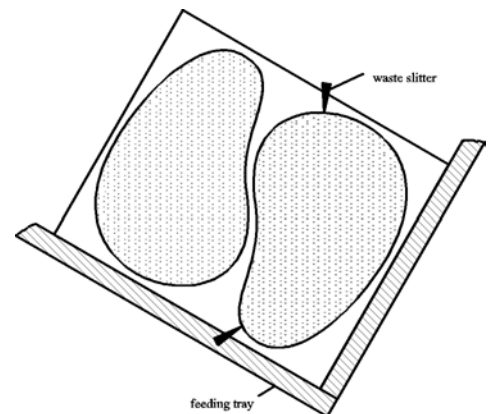
For saving on material the two-up blank contains two prints of labels (e.g. detergent labels or similar articles). The prints are composed interlocked, the second print is turned through 180°.

The distance between the labels must have only the usual waste margin (no double waste margin)!

The waste slitters must be positioned in such a way that the waste of the first punched label is cut off and falls down easily.

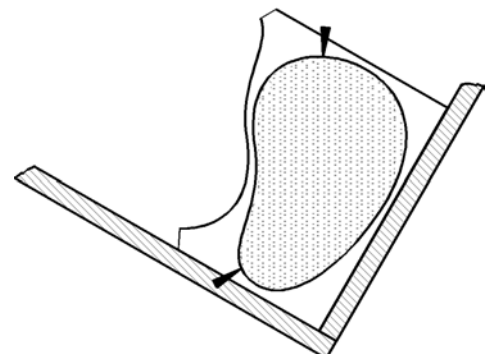
The punching process is done in two steps. The label stacks fed into the machine contain about 1000 sheets. The feeding height must be reduced to the height of the punching die if a clamping arm is located in the area of the passing stack (see photo), in order to prevent a collision between the passing stack and the clamping arm. The maximum feeding height for the holding device is 90 mm !

In the first step the lower positioned print is punched, whilst the upper print is separated from the stack and is moved aside the punching die onto the holding device which is mounted at the feeding tray.

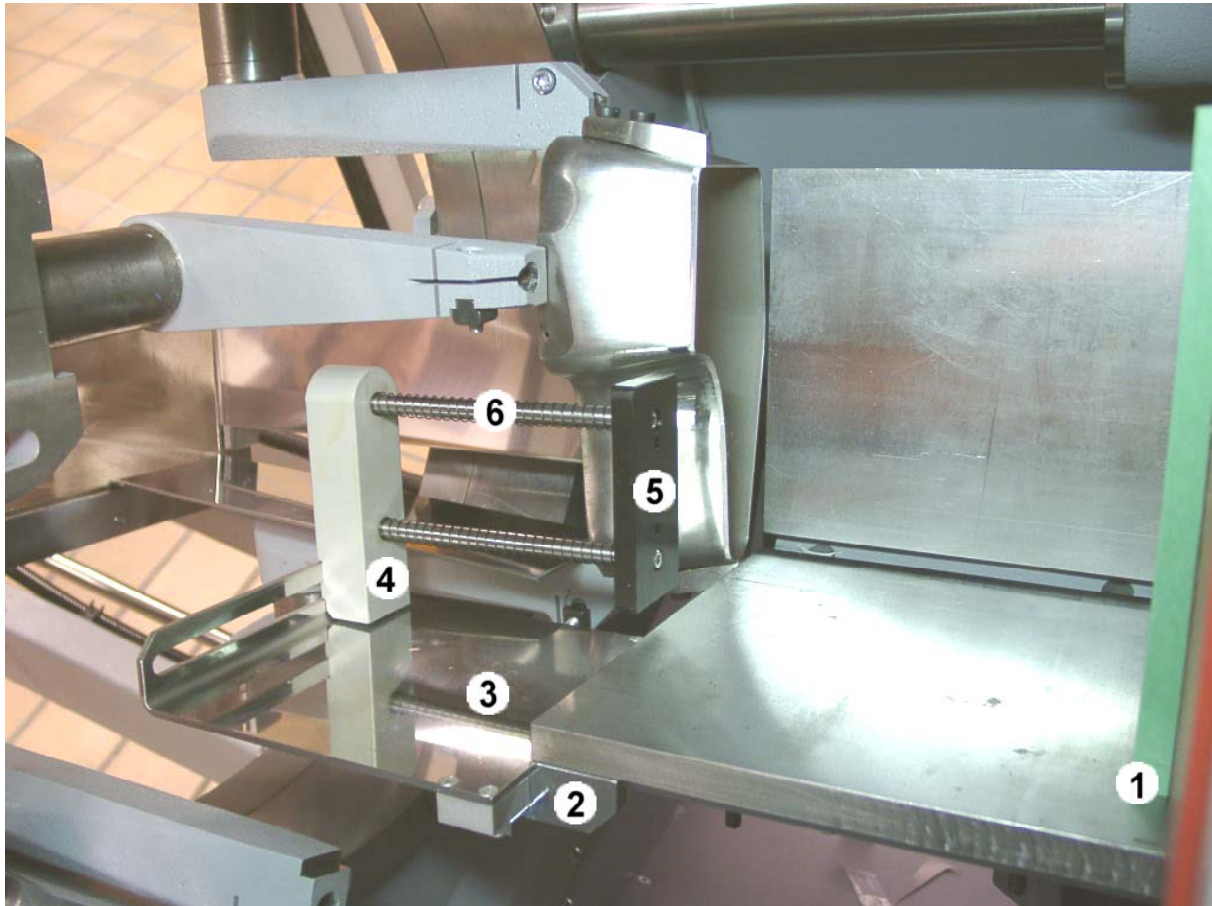


The upper print is collected manually from the holding device, turned through 180° and is fed to the machine for the second punching step. The punching die remains unchanged in its position for both punching steps.

This procedure is possible on BUSCH punching machines, as the machine design requires pre-guillotined sheets with just one rectangular part. This rectangular part is fed into the angle of the feeding tray. The other two sides of the sheets facing the operator can have any shape. The two-up system allows the use of normal punching dies with a height of 60-70 mm.



Installation of the holding device



Use a 4mm Allan key.

Important ! Danger of crash !

- If not installing the green plastic plate (1) the punching ram will crash against the holding device when punching the whole stack.
- Maximum feeding height = 90 mm !

1. Stick the green plastic plate (1) onto the red plate of the punching ram. Use four small pieces of double sided scotch tape. The position of the green plate must be changed from time to time for a steady abrasion of the plate.
2. Fix the holding device at the feeding angle (2) with 2 screws.
3. Adjust the position of the holding plate (3) with 2 screws at the bottom side.
 - Keep a distance of about 20-30mm to the die so that the waste of the second punched label falls down easily between the holding plate and the die.
4. Adjust the position of the stop (4) with 1 screw located at the rear side so that the second label passing the die is held safely by the stop plate (5).
5. Increase the spring tension in case of need by insertion of the second spring onto the top guiding shaft (6):
 - Loosen the screws at the stop (5) and slide the second spring onto the free shaft (use a 3 mm Allan key).
 - Mount the stop plate again.
6. The stop plate (5) contains two borings for attachment of further auxiliary metal sheets.

Note:

The waste slitters must be positioned in such a way that the waste of the first punched label is cut off and falls down easily (see drawings on the front page).