

BUSCH LABEL PRODUCTION LINE LABEL LINE 72

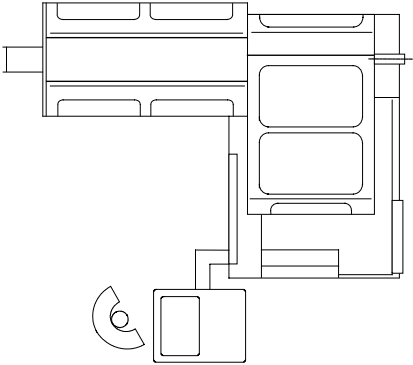
- Technical Data
- Operating Sequence
- Examples for Application



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1. Technical Data

	<p>Highly precise label production with integrated counter pressure. Saving on material by interlocking of labels.</p> <p>In-line finishing for large-scale production executing: pre-cut, final cut and banding of label packages with PE- foil tape incl. strip reading unit</p>
<p>Model</p>	<p>LABEL LINE 72</p>
<p>Installation consisting of:</p>	<p>STS - Strip puncher for the pre-cut VSB - Vertical puncher for the final cut with integrated counter pressure device and banding unit for banding with polyethylene tape in the widths 20, 30 and 40 mm</p>
<p>Strip size, max. mm</p>	<p>720 x 190</p>
<p>Size of pre-cut max. mm min. mm</p>	<p>140 x 190 20* x 60</p>
<p>Size of final cut max. mm min. mm</p>	<p>135 x 185 20 x 55</p>
<p>Feeding height mm</p>	<p>30 - 125</p>
<p>Output strokes / min</p>	<p>9 - 10</p>
<p>Working pressure of pneumatics bar Consumption of compressed air nl/min</p>	<p>7 420</p>
<p>Tank capacity for hydraulic oil liter</p>	<p>180</p>
<p>incl. 1 pre-cut die - straight - for the strip puncher incl. 1 set of heat sealing heads 20 mm for the banding unit without die for the final cut without hydraulic oil without compressor</p>	

* The last blank on the strip must have the size 30 x 60 !

2. Operating Sequence

Strip Puncher STS

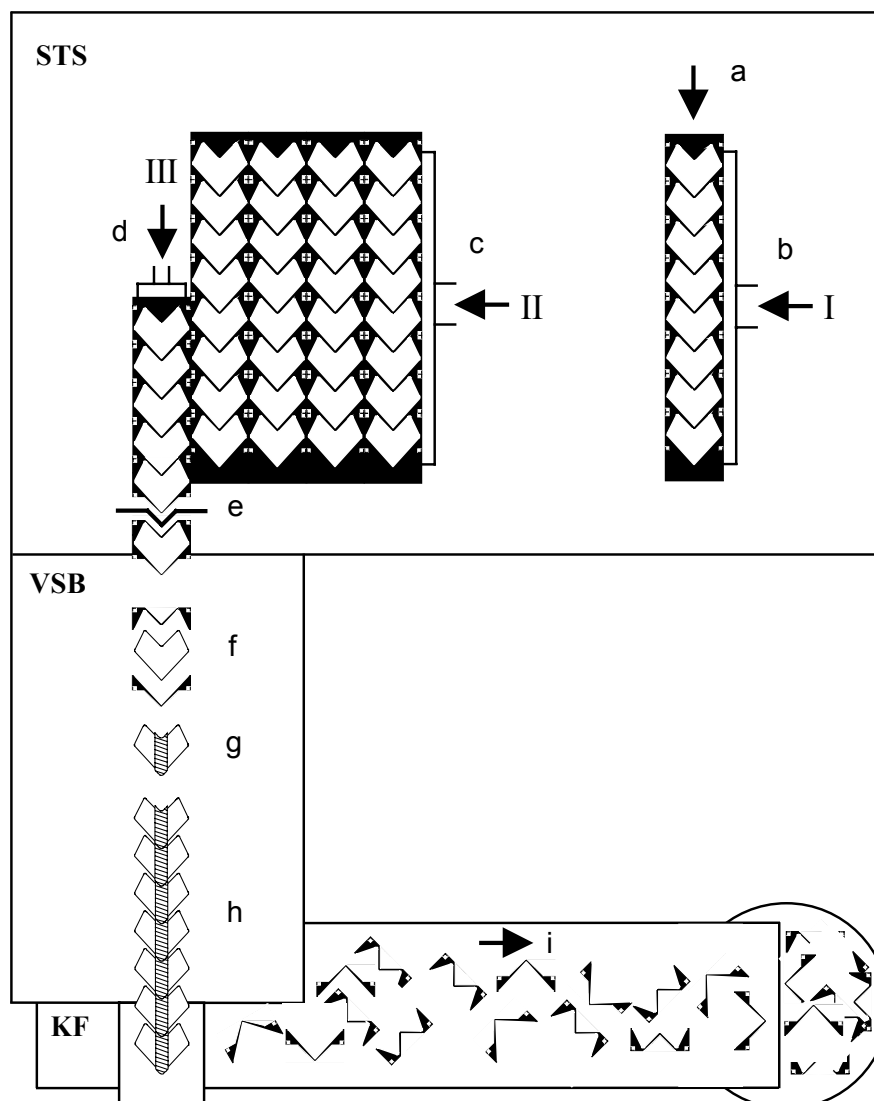
- a) Manual feed of the strip pile.
- b) Transport I moves the pile under transport II.
- c) By releasing the start button transport II effects a continuous restocking of the table in front of transport III.
- d) Transport III moves the first pile under the pre-cut die according to the entered cutting marks (resp. the marks determined by the strip reading unit).
- e) The pre-cut die (straight die or contour die) separates the strip in single piles. (The illustration below shows a contour die and interlocked labels)

Vertical Puncher with Banding Unit VSB

- f) Final cut with counter pressure and following
- g) banding of the single piles.
- h) The banded packages are moved onto the delivery tray.

Waste conveyor KF (option)

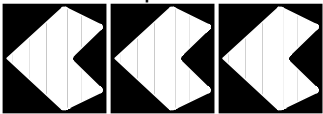
- i) Removal of punching waste out of the VSB.



3. Example for Application 1

Saving on costs with a BUSCH Label Production Line 'LABEL LINE'
by interlocking of labels

Order volume	100.000.000 labels 'König Pilsener' or 'Holsten Pilsener'
73 g metallized paper	4,60 Euro p. kg
PRINTING PRESS - Machine costs / 6-colour offset - Running speed net with metallized paper	360,- Euro p. hour 9.000 sheets p. hour
LABEL LINE - Output - Production net p. shift (7,5 hours efficiency 89%)	9 strokes p. min. 3.600.000 labels

Comparison of production data	Usual process	Process with interlocking
		
Label blank	71,5 mm high 74 mm wide	
Sheet width	13 rows à 74 mm + 18 mm margin = 980 mm	
Sheet length	9 labels à 71,5 mm + 16,5 mm margin = 660 mm	First label 71,5 mm + 12 labels à 50 mm + 18,5 mm margin = 690 mm
Sheet weight / 73 g	47,2 g / sheet	49,4 g / sheet
Number of labels p. sheet	117 labels	169 labels
Sheet requirement	854.700 sheets	591.716 sheets
Material requirement	40.342 kg	29.231 kg
Material costs	185.573 Euro	134.462 Euro
Machine run costs - printing press	34.200 Euro	23.760 Euro
Total costs	219.773 Euro	158.222 Euro

Saving by interlocking	
- Sheet requirement	262.984 sheets
- Material requirement	11.111 kg
- Material costs	51.111 Euro
- Machine run costs - printing press	10.440 Euro
- Saving on costs for cutting and waste disposal	no details
Total saving for this order	61.551 Euro
Saving per 1.000 labels	0,62 Euro