

# DACO

# Die Cutting

## Daco DTD250

### Bench Top Rotary Die Cutter



After consulting clients, we identified a need for a bench top rotary die cutter. Clients indicated that they were either producing on old label presses which did not have sufficient speed or they were producing on new multi colour presses. Neither situation is ideal, as the cost of the label is very high, due to machine speeds or the high cost of using a multi colour press.

We have built the Daco DTD, a high-speed bench top machine capable of 150 metres a minute, which is available with one

## Daco D250/330

### Rotary Die Cutter

The Daco D250 was developed following the success of the Daco DTD250 and is aimed at clients that have medium to long runs. The machine has a 700mm (27.5") diameter unwind with taper tension control reducing the need for frequent roll changes and operator input. The machine is available with either one or two rotary die stations and single or twin product rewinds.

The machines compact size and short web path keeps wastage to a minimum, the silicone covered nip drive roller helps to keep down time to a minimum as labels cannot attach themselves to the roller. The Daco D250 has independent



## Daco DSI

### Plain Label Converter



The Daco DSI rotary die cutter is a high speed plain label converter offering both flexibility and ease of use. Its design includes a quick make ready rotary scissor slitting box and touch screen HMI operator interface for quick and easy job setups.

Both the rewind and unwind tensions are fully and independently adjustable and has taper tension control as standard. The unwind also has a programmable end of roll function, which allows the operator to select an end of roll diameter.

The Daco DSI is equipped with a single rotary die cutting station with removable anvil and an optional second rotary die cutting station can be fitted to allow perforating.

An E & L electronic web guide ensures that the finished rolls are perfectly wound, and an adjustable splicing table with pneumatic web clamps is also fitted as standard, enabling splices to be made both neatly and easily.

or two die stations. We firmly believe that the machine is more efficient than producing blanks on an old label press and definitely more cost effective than using a higher speed multi colour press.

#### Standard Specification

- Web Width: 250mm (10")
- Maximum unwind diameter: 450mm (18")  
Pneumatic unwind brake with independent regulator & gauge  
76mm (3") mechanical mandrel
- Splicing table
- 1 Rotary die station with matrix rewind  
Cutter repeat lengths: 153-406mm (6" - 16") repeat  
76mm (3") mechanical mandrel for matrix rewind  
Maximum matrix rewind diameter: 400mm (15.75")  
Gearing 1/8cp 20 degree pressure angle
- Maximum rewind diameter 360mm (14")  
Pneumatic rewind clutch with independent regulator & gauge  
76mm (3") air mandrel  
Labels in / labels out rewinding
- Maximum web speed: 150 Metres/min (492 feet/min) dependent on stock
- Count units: Labels / Metres with programmable slow down & stop
- Rotary scissor slitting unit  
Removable interlocked cutter guard  
Minimum slit width: 13mm (0.51")  
Lateral knife adjustment: +/- 8mm (0.31")
- Fully adjustable silicone nip roller

control of both the unwind and rewind tensions. Rotary slitting with on the run lateral adjustment is fitted as standard and a splice table makes web splices both simple and quick.

The machine is the ideal solution to clients wishing to produce plain labels for the growing thermal transfer market.

#### Standard Specification

- Web width: 250mm (10") or 330mm (13")
- Maximum unwind diameter: 700mm (27.5")  
76mm (3") air mandrel  
Merobel electronic brake  
Taper tension control
- Splicing table with pneumatic web clamps
- 1 Rotary die station with matrix rewind  
Cutter repeat lengths: 153-406mm (6" - 16") repeat  
76mm (3") mechanical mandrel for matrix rewind  
Maximum matrix rewind diameter: 400mm (15.75")  
Gearing 1/8cp 20 degree pressure angle
- Maximum product rewind diameter: 360mm (14")  
76mm (3") air mandrel  
Merobel electronic clutch  
Labels in / labels out rewinding
- Maximum web speed: 150 metres / minute (492 feet / minute) dependent on stock

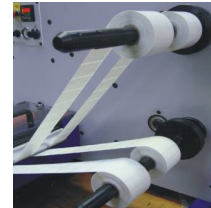
Airshafts for both the unwind and rewind means that changing the rolls could not be simpler, and a programmable web advance system makes it easy to attach the web to the core when starting a new roll.

#### Standard Specification

- Web widths 330mm (13") or 410mm (16")
- Maximum unwind diameter: 762mm (30")  
76mm (3") diameter airshaft  
Merobel electronic brake  
Taper tension control  
Programmable end of roll function  
The user is able to program the roll end diameter slowdown and/or stop - The system does not use any roll followers or external sensors that can be damaged at roll changes. The diameter is programmed from the touch screen operator interface.
- 700mm (27.5") Inspection table with adjustable splicing facility & pneumatic interlocked web clamps
- Electronic web guide  
Ultrasonic sensor enables guiding of opaque and clear materials  
Adjustable web guide sensor
- Single rotary die station  
Removable anvil  
10-24" die repeats  
Gearing: 1/8cp 20 degree pressure angle  
Lateral die adjustment  
Matrix stripping tower  
76mm (3") mechanical mandrel for matrix removal
- Rotary scissor slitting  
Knife separation  
Allows for easy setting of the knife and anvil with the web in place. Does not require costly off machine setting tools.  
Minimum slit width: 13mm (0.51")  
Lateral knife adjustment: +/- 5mm (0.196")
- 1 Product rewind

#### Optional Equipment:

- Lateral knife separation
- Additional rotary die station for perforating (does not include stripping and matrix rewind)
- Semi automatic turret rewinder
- Die cut to register die station
- Electronic web guide with an ultrasonic sensor
- Twin product rewinds
- Full range of air mandrels from 25mm - 76mm (1" - 3")
- Die adaptors: KDO, Mark Andy, Edale, Allied Gear & Focus, others available subject to specification
- Razor slitting: minimum slit width 10mm (0.39")
- Rotometrics RD Scorer (enables edge trim to be wound with the matrix)
- Sheeting station



Twin mechanical rewinds



Twin rotary die stations

- Count units: Labels / Metres with programmable slow down and stop
- Rotary scissor slitting unit  
Removable interlocked cutter guard  
Minimum slit width: 13mm (0.51")  
Lateral knife adjustment: +/- 8mm (0.31")
- Adjustable spring loaded silicon nip

#### Optional Equipment

- E-package - 457mm (18") rewind with taper tension control, feet counting, batch count, total count, touch screen control.
- Removable anvil
- Additional rotary die station for perforating (does not include stripping and matrix rewind)
- Sheeting station
- Matrix stripping bar (for use with difficult to strip matrix)
- BST electronic web guide with an ultrasonic sensor
- Rotometrics die pressure gauges
- Rotometrics RD scorer - 2 knife holders (for edge trimming and winding with waste)
- Twin product rewinds
- Lateral knife separation for rotary slitting
- Razor slitting with lateral knife adjustment
- Web separator roller with 5 web separators
- Full range of air mandrels from 25mm (1") to 76mm (3")
- Die adaptors: KDO, Mark Andy, Edale, Allied Gear & Focus others available subject to specification

Max rewind diameter: 457mm (18")

76mm (3") diameter

Taper tension control

Merobel electronic clutch

Labels in / labels out rewinding

Programmable web advance system

The web advance delay time is programmable from the touch screen

The mandrels are quick change.

The mandrel size is selected on the touch screen and is electronically compensated for, so there are no gears to change.

- Maximum speed: 250 metres per minute (820 ft/min) dependent on material specification and condition
- Count units labels / feet / metres with programmable slowdown and stop
- Colour touch screen HMI operator interface  
Shows machine status and system messages (interlocks not met etc)  
Counting options  
Tension settings  
Allows for easy and quick jobs set ups
- Air operated silicone nip roller with independent regulator and gauge

#### Optional Equipment

- Modular unwind 762mm (30")
- Missing label detection - pre die cut material or post die cutting - 6 lane or 12 lane
- Additional rotary die station (no matrix rewind)
- Twin product rewinds with independent tension control
- Matrix stripping bar (for use with difficult to strip matrix)
- Rotometrics RD Scorer (enables edge trim to be wound with the matrix)
- Full range of air mandrels from 25 - 76mm (1" - 3")
- 1460mm Inspection table with adjustable splicing facility & pneumatic web clamps
- Additional rotary slitting knives



## Daco DCR

### Die cut to register Rotary Die Cutter



The Daco DCR die cut to register machines allows pre-printed material to be die cut in register. The DCR offers both flexibility and high performance. Its design includes a quick make ready rotary scissor slitting box and touch screen HMI operator interface for quick and easy job setups.

Both the rewind and unwind tensions are fully and independently adjustable and have taper tension control as standard. The unwind also has a programmable end of roll function, which allows the operator to select an end of roll diameter.

The Daco DCR is equipped with a single rotary die station using the latest in servo drive technology enabling a cutting accuracy of 0.25mm at a constant running speed.

An electronic web guide ensures that the finished rolls are perfectly wound, and an inspection table with adjustable splicing table (with pneumatic web clamps) is also fitted as standard, enabling splices to be made both neatly and easily. Airshafts for both the unwind and rewind means that changing the rolls could not be simpler, and a programmable web advance system makes it easy to attach the web to the core when starting a new roll.

#### Standard Specification

- Web widths 330mm (13") or 410mm (16")
- Single rotary die station
  - Die cut to register servo drive system with a +/- 0.25mm (0.010") accuracy at a constant speed.
  - Removable anvil
  - 10-24" die repeats
  - Gearing: 1/8cp 20 degree pressure angle
  - Lateral die adjustment
  - Matrix stripping tower
  - 76mm (3") mechanical mandrel for matrix removal
- Maximum unwind diameter: 762mm (30")
  - 76mm (3") diameter airshaft
  - Merobel electronic brake
  - Taper tension control
  - Programmable end of roll function
    - The user is able to program the roll end diameter slowdown and/or stop - The system does not use any roll followers or external sensors that can be damaged at roll changes. The diameter is programmed from the touch screen operator interface.
- 700mm (27.5") Inspection / Splice table with adjustable splicing facility & pneumatic web clamps
- Air operated silicone nip against a driven draw roller
  - Fully adjustable with independent regulator and gauge
  - On / off feature to allow for easy threading of the web
  - Interlocked so that the machine can not be started with the nip roller off
- Electronic web guide
  - Ultrasonic sensor enables guiding of opaque and clear materials
  - Adjustable web guide sensor
- 1 Product rewind
  - Max rewind diameter: 457mm (18")
  - 76mm (3") diameter with quick change air shaft
  - Taper tension control
  - Merobel electronic clutch
  - Labels in / labels out rewinding
  - Programmable web advance system
    - The web advance delay time is programmable from the touch screen

The mandrels are quick change.

The mandrel size is selected on the touch screen and is electronically compensated for, so there are no gears to change.

- Maximum speed: 100 metres (328ft) per minute
- Counting units: labels / feet / metres with programmable slowdown & stop
- Rotary scissor slitting
  - Knife separation
    - Allows for easy setting of the knife and anvil with the web in place. Does not require costly off machine setting tools.
  - Minimum slit width: 13mm (0.51")
  - Lateral knife adjustment: +/- 5mm (0.196")
- Colour touch screen HMI operator interface
  - Shows machine status and system messages (interlocks not met etc)
  - Counting options
  - Tension settings
  - Allows for easy and quick jobs set ups

#### Optional Equipment

- Modular unwind 762mm (30")
- Additional rotary die station (not including waste rewind) for perforating
- Matrix stripping bar (for use with a difficult to strip matrix)
- Rotometrics RD Scorer (enables edge trim to be wound with the matrix)
- Missing label detection (post die cutting includes a second web guide & splicing area) - 6 lane or 12 lane
- Laminating station self wound laminate
- Laminating station - laminate with carrier - carrier rewind
- Full range of air mandrels from 25mm - 76mm (1" - 3")



Laminating

Minimum slit width: 13mm (0.62")

Lateral knife adjustment: +/- 5mm (0.51")

#### In-line turret module

- Maximum rewind diameter: 350mm (13.75")
- Taper tension control for the rewind
- Hot melt core gluing system: 5 glue transfer wheels
  - The glue bath does not need to be removed from the machine to add or remove glue transfer wheels.
- Hot melt tail gluing device
- Air Mandrels: 3 off at 76mm - (3")
- Automatic roll eject system
- Adjustable core positioning stop
- Colour touch screen HMI operator interface
  - Shows machine status and system messages (interlocks not met etc)
  - Counting options
  - Tension settings
  - Allows for easy and quick jobs set ups
- Maximum web speed: 150 metres/minute (492 ft/min) (die cutting speed is dependent on label size & the ability to strip the label)
- Speed 25-38mm (1" - 1.5") mandrels 100 m/minute (328 ft/min)
- Cycle time: 20 seconds / 3 cycles per minute
- Count Units: Labels / Metres / Feet

#### Optional Equipment

##### In-line turret module

- Air assisted turn bar
- Inter-label cutting
- Full range of air mandrels from 25 - 76mm (1" - 3")

##### Converting module

- Rotometrics RD Scorer (enables edge trim to be wound with the matrix)
- Matrix stripping bar (for use with a difficult to strip matrix)
- 2 die base (only fitted with a single die station)
- Additional rotary die station (no matrix rewind)

## Daco TD

### Plain Label Turret Rewinder / Die Cutter

The Daco TD turret rewinder is the ideal machine for producing plain labels automatically with little operator input.

The machine is equipped with a high capacity 1m (40") unwind to keep master roll changes to a minimum. The 3 spindle turret offers quick change over times, which coupled with a touch screen HMI operator interface makes the machine both interactive and user friendly. The machine can be configured with either one or two rotary die stations.

There is a host of optional equipment which enables you to specify a very adaptable converting line.

#### Standard Specification

- Web widths 330mm (13") or 410mm (16")

#### Unwind module

- Maximum unwind diameter: 1000mm (40")
  - 76mm (3") diameter air shaft
  - Safety chuck
  - Automatic roll lift
  - Merobel electronic brake
  - Taper tension control



#### Programmable end of roll function

The user is able to program the roll end diameter slowdown and/or stop - The system does not use any roll followers or external sensors that can be damaged at roll changes. The diameter is programmed from the touch screen operator interface.

- Electronic web guide
  - Ultrasonic sensor enables guiding of opaque and clear materials
  - Adjustable web guide sensor

#### Converting module

- Single rotary die station
  - Removable anvil
  - 10-24" die repeats
  - Gearing: 1/8cp 20 degree pressure angle
  - Lateral die adjustment
  - Matrix stripping tower
  - 76mm (3") mechanical mandrel for matrix removal
- Rotary scissor slitting
  - Knife separation
    - Allows for easy setting of the knife and anvil with the web in place. Does not require costly off machine setting tools.

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