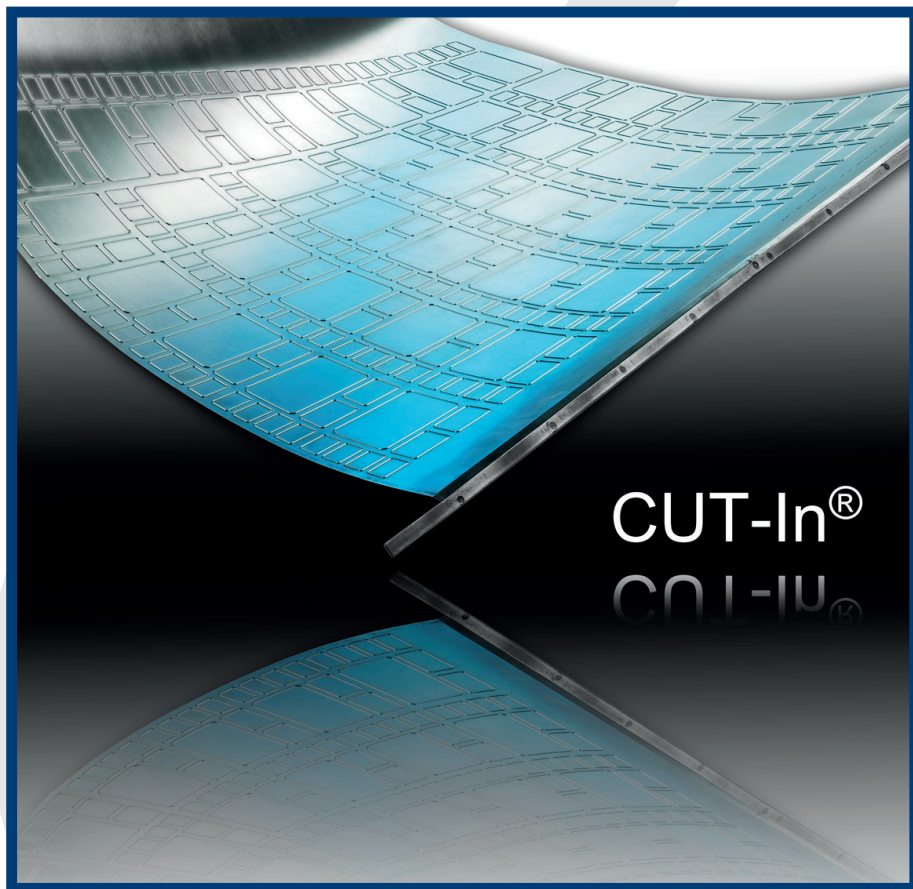


Installation
CUT-IN® - SYSTEM

for printing or coating unit in offset-printing machine

INSTRUCTION MANUAL



SAFETY INSTRUCTION

First of all:

Read the instruction manual carefully before installing the CUT-In® tool from WSD®.

Keep this instruction manual in a safe place for future reference. Improper installation of the CUT-In® tool may lead to serious damage to the system itself, and/or to the printing machine.

Always wear safety gloves, while handling the sharp CUT-In® tools to avoid injuries.

Safety-instructions of your printing machine manufacturer should be referred thoroughly.

The CUT-In® tool is only allowed to be used in printing machines approved by WSD® GmbH.

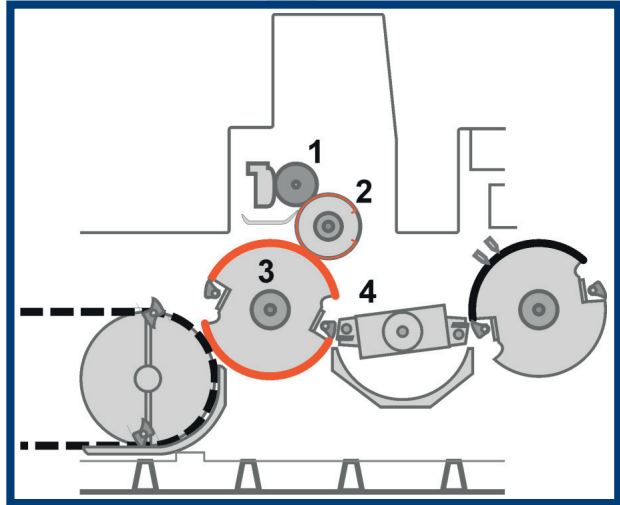
The manufacturer is not liable for any damages occurred by ignoring the safety instruction.

CARE OF THE CUT-IN® SYSTEM

- Before the installation, remove impurities and foreign particles from the CUT-In®.
- After use, remove colour remains and paper dust from the CUT-In®.
- For storage the CUT-In® tool, rub it with acid free oil and pack it into the oiled paper.

CROSS SECTION OF A COATING UNIT

- 1| Grid roller
- 2| Coating cylinder
- 3| Impression cylinder
- 4| Paper direction

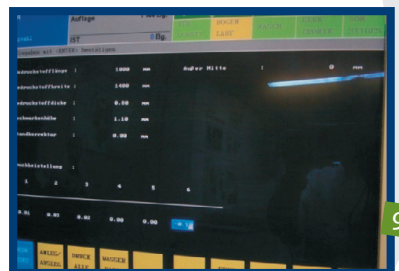
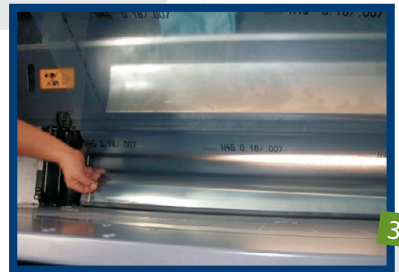
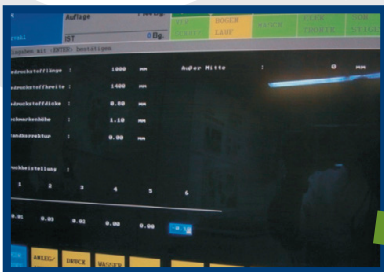


INSTALLATION INSTRUCTION

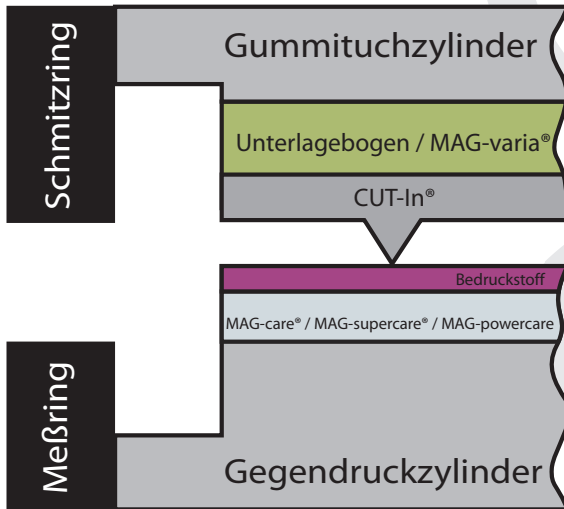
1. The thickness of the stock (paper, board etc.) has to be fed in the control panel.
2. The Impression cylinder has to be cleaned.
3. The printing plate should be unclamped and taken out of the printing unit. The NIP-Width should be maximized. If the CUT-In® tool is to be installed into coating unit, the grid-roller and the washing unit has to be taken out.
4. Stick on the self-adhesive protective sheet MAG-care®, MAG-supercare® or MAG-powercare bubble free around the impression cylinder and let it run reverse (under pressure) together with the blanket.
5. The blanket/coating including underlays should be removed and the cylinder has to be cleaned and free of any foreign particles.

INSTALLATION INSTRUCTION

6. The CUT-In® tool and underlay (when needed) should be calculated to the required height and clamped on the blanket/coating cylinder.
(See page 5)
7. Clamp the CUT-In® tool instead of the rubber-/coating blanket. Torque should not be higher than 30 Nm. The CUT-In® tool has to sit flat and bubble free before you start.
8. Enable „PRINT“ in the corresponding unit. Disable „COLOUR“, „WATER“ etc. in that unit. If you use the coating unit, remove grid roll and washing setup.
9. Now the NIP-width should be reduced by 1/100 mm step by step. The contours should be controlled after every pull.
10. If the contours (cutting result) is desired, you can start the production. If needed tight the tool. Please control the print job continuously. If needed adjust the NIP-Width.



QUERSCHNITT STANZBEREICH



BERECHNUNGSTABELLE UNTERLAGE

Unterschnitt	MAG-care®	Wkz Höhe 0,80 mm	Wkz Höhe 0,45 mm
Einstichtiefe	MAG-supercare®	Unterlage	Unterlage
2,0 mm	0,25 mm	0,95 mm	1,30 mm
2,3 mm	0,25 mm	1,25 mm	1,60 mm
2,6 mm	0,25 mm	1,55 mm	1,90 mm
3,2 mm	0,25 mm	2,15 mm	2,50 mm

Verwenden Sie zum unterlegen kalibriertes Kartonpapier oder MAG-varia®. Zum Rillen/Nuten muss MAG-varia® verwendet werden.

TIPS & TRICKS

The NIP-Width should be reduced by 1/100 mm step by step, in order to cut the paper/ material - not the protective sheet on impression protection.

Excessive impression pressure reduces the lifetime of the CUT-In® tool.

For repeating jobs, the CUT-In® tool has to be in a good condition.
Do not use damaged tools.

For storage, CUT-In® tools has to be cleaned and applied with acid free oil. Store it into anti corrosive paper.

For your own safety, always wear protective gloves while installing of CUT-In® tools and applying protective sheets on the impression cylinder.

Specialists use printing plates instead of underlay paper.

For mounting the protective sheet, let it run reverse (under pressure) together with the blanket.

STANDARD TOOL HIGHT

0,45 mm for printing material in range of 0,06 mm - 15 mm

0,80 mm for printing material in range of 0,16 mm - 30 mm

1,00 mm for printing material in range of 0,35 mm - 40 mm

Other tool hights on request.

Use only products from WSD® GmbH. This is very important, because the tools, impression cylinder protections and the underlay foils are optimized in hardness for optimum durability.



Distributed worldwide...

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Innovative Stanzlösungen
innovative cutting solutions

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