SPeria 106-E Autoplasten® press
Automatic die cutter for paper and carton converting

Standard Equipment

MACHINE
- Centerline system for quick job changeover.
- Electronic device for sheet travel control.
- Adjustable centering at stripping station.
- Control cabinet cooling unit.
- Bobst-Electronic machine operating system C.U.B.E. (Control Unit Bobst Electronic).
This microprocessor based Bobst system allows the operator to easily control, visualize and check the various functions and elements of the machine.
- Main motor with frequency converter control.

FEEDER
- Pile tray with handle allowing manual lateral correction of the pile during production.
- Synchronization device timing the sheet arrival against the front lays when the machine is at a standstill.
- Pile lifting controlled by Pressfoot.
- Rear pile guides (OS and OOS).
- Side blowers adjustable with Centerline marks.
- Suction unit.
- Safety system for lowering the pile tray.

FEED TABLE
- Covered with an anti-static stainless steel plate.
- Feed table inlet equipped with lateral ramps.
- Front lays, adjustable in pairs with front register control.
- Pull guide (OS) adjustable according to Centerline marks, with side register control.
- Double sheet detector.
- Support plates at entry of platen station.
- Sheet hold-down device (guiding the sheets to the front lays).
- Upper frame with manual lifting device.
- Upper transport equipment for paper, paperboard and corrugated board.
- Transport belts.
With lateral guidance and automatic tension system.
PLATEN PRESS
- Gripper reopening device.
- Equipment centering and locking.
- Locking of the chase against the upper beam.
1 Cutting plate (E-4)
- Measurement of the cutting force with strain gauge.
1 Synthetic material supporting plate.  
  Thickness 23.5 mm (0.925 ")

WASTE STRIPPING STATION
- Quick locking device of the central stripping board.
- Motorized lifting of the upper frame.
1 Upper pull-out frame (F-2)
1 Upper stripping equipment (F-21)
  Equipment required to create a waste stripping tool, including crossbars, clamps, stripper holders and stripping pins of 3, 5 and 10 mm of diameter.
1 Fastening equipment for stripping die (F-22)
  Including crossbars and clamps.
1 Adaptation material for stripping board on the central frame (quick locking) (F-76)
1 Lower pull-out frame (F-8)
1 Lower stripping equipment (F-81)
  Equipment for waste stripping including crossbars, pins and supports.

DELIVERY
- Pile tray.
- Adjustable rear and side joggers with Centerline marks.
- Braking Brush.
- Front jogger.
- Manual non-stop rack.

CONFORMITY TO STANDARDS AND SECURITY
- This Autoplaten Press® is in conformity with the European Directives for the Safety and Health requirements related to its design and construction, as well as with the American standards UL 508 and NFPA related to industrial equipment.
- Emergency stops.
- Operator safety devices.
- Gripper Bar Chain Slip Clutch.
- Gripper bar chain locking device.
- Handling of the diecutting equipment.

INSTALLATION
- Machine delivered in one piece for installation on a flat floor with or without excavations.
Included Equipment

MACHINE

B-7 Platform (1)

FEEDER

C-4 Manual non-stop device (1)
_Pile height reduced by at least 200 mm (8"), when non-stop is used._

C-5 Synchronization device timing the sheet arrival against the front lays (1)
_Adjustable while in operation: to fine tune the feeder cycle to the platen. Facilitates the correction of the sheet advance to compensate for different variations of processed board._

FEED TABLE

D-1 Pull Guide (OOS) (1)
_With side register control. Pull guide adjustable according to the Centerline marks. For jobs with opposite operator side registering._

D-73 Feed belt slow-down device (1)
_Ensures smooth arrival of sheets against front lays._

PLATEN PRESS

E-3 Upper chase with quick locking: fixed bottom plate (2)
_Plate, thickness 2 mm and make-ready protection plate made of synthetic material, thickness 1mm._

E-5 Compensating plate (1)
_Thickness 4 mm. Ground steel plate required for thin cutting plates. Used for repeat jobs._
_Requires a set of thin cutting plates E-95 or E-98._
_Required: 1 additional compensating plate for off-machine preparation with Easypress._

E-95 Set of 10 thin plates, thickness 1mm (1)

E-55 Adjustable supporting plate centerings (1)
_Micrometric screws allow fine adjustment of counters mounted on the cutting plate with respect to the die. The total range for adjustment is +/- 0.9 mm lengthwise and crosswise. Brings a considerable gain in time when used for short set-ups of repeat jobs and to control creasing quality._
WASTE STRIPPING STATION

F-2  Upper pull-out frame
     1 unit is included in the standard equipment.

F-21 Upper stripping equipment
     Equipment required to create a waste stripping tool, including crossbars, clamps, stripper holders and stripping pins of 3, 5 and 10 mm of diameter.

F-31 Upper pull-out frame quick-locking device
     Reduces the time for stripping die set up. Stripping die quick-locking device allows changes to be made inside the machine.

F-8  Lower pull-out frame
     1 unit is delivered with the standard equipment.

Insurance/Shipping/Off-loading/Installation/Training
**Technical data**

**CONVERTIBLE STOCK**
- Paper (depending on quality), min. 80 g/m²
- Board (depending on quality), up to (*) 2000 g/m²
- Corrugated board, up to (*) 4 mm

(*) Carton acceptable warp: 4% of the widthwise sheet

**SIZES**
- Sheet size, max. 1060 x 740 mm
- Sheet size, min. 400 x 350 mm
- Cutting die standard IIIb size, max. 1060 x 744 mm

**DIECUTTING SIZE**
- With gripper margin, max. 1060 x 725 mm

**DIMENSION OF PALLETs**
- Feeder / delivery, max. 1200 x 800 mm

**DIECUTTING**
- Gripper margin 9 -17 mm
- Height of cutting rules 23.8 mm

**PRODUCTION**
- Adjustable platen pressure, max. 2,6 (260 t) MN
- Production rate, up to [sheets/h] 7700

**PILE HEIGHT**
- Feeder: normal mode, max. 1400 mm
- Feeder: Non-Stop mode, max. 1100 mm
- Delivery: max. 1100 mm

**INSTALLATION**
- Main motor power, max. 11 kW
- Total connected load, max. 30 kVA

**DIMENSIONS**
- See attached drawing.

**APPROXIMATE WEIGHT**
- Net 15000 kg
- Gross (in seaworthy packing) 17000 kg

**FOUNDATIONS**
Regardless of the location, i.e. on storeys or on floors with or without basement, users are to make sure that the floor with the machine mass has a natural frequency of more than 25 Hz. Only civil engineers are competent for checking the floor behavior on the basis of the values indicated on our foundation plans.

**PNEUMATIC SPECIFICATIONS**
The pneumatic system for the various parts of the Autoplaten requires at least a compressed air supply of 6 bars. If no central compressed air supply is available, a compressor with a capacity of 7.5 m³/h and a tank capacity of 110 liters is necessary.
Device for high-speed diecutting of paper (B-10) requires a compressed air supply of 6 bars. If no central compressed air supply is available, a compressor with a capacity of 35 m³/h and a tank of 250 liters is necessary. The compressor is not supplied by Bobst.

*Characteristics given subject to modification*