

Stripping and Blanking System

Stripping Section

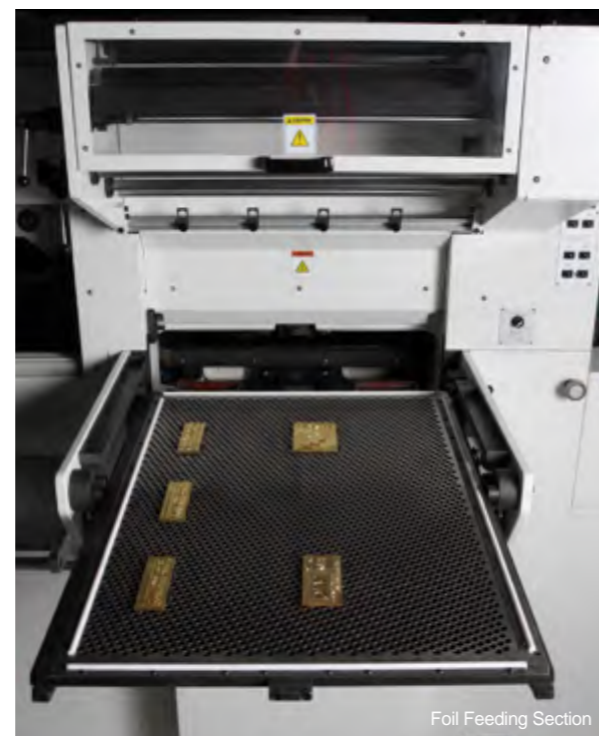
The high quality transmission mechanism and cam movement curve provide stripping stability and accuracy. The central registration system used for the stripping boards provides accurate positioning and easy adjustment. The pneumatic raising device for upper stripping board creates more internal working space. The stripping system is equipped with a quick lock system for user friendly operation and quicker stripping board positioning.

Blank Separation Section

The fully finished product stack is made without any further process, even for full sheet paper collection. The central registration is used for upper board of finished product, for easy adjustment. The pneumatic raising device for upper stripping board is for convenient operation. The non-stop blanking unit can insert separation sheets at predetermined quantities.

Chase Changing System

- 1)Center line position system
- 2)Labour saving device for offline revision or set up



Foil Feeding Section

Feeder

- 1)Strong suction head, 4 lifting and 5 forwarding suction cups. The suction head can be adjusted to the angle of the sheets if the stock quality varies.
- 2)When the sheets arrive at the front lays, the speed control system guarantees the precise location of the sheet.
- 3)Vernier calibration is adjusted manually for accuracy and ease of operation.
- 4)The side lays have a pull or push facility which can be adjusted easily by one screw.
- 5)The motor uses synchronised belt to transfer energy, making it more smooth, and maintenance free.
- 6)Single-position engagement clutch

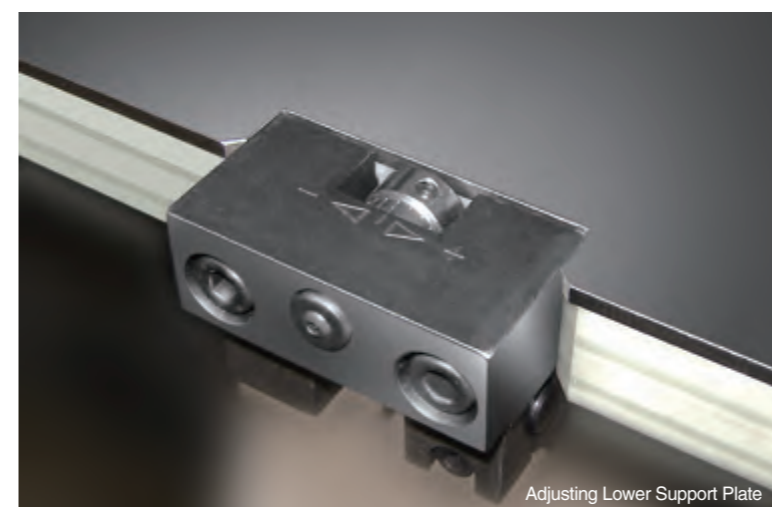
Foil Feeding System

- 1)The foil controlling system on press 1 uses three servo driven axis for foil feeding. The largest diameter of foil is $\phi 250\text{mm}$, which saves a considerable amount of time when changing foil and reduces machine down time.
- 2)Press 1 also has two servo driven axis on the cross pull foil feeding unit. The largest diameter of foil is $\phi 200\text{mm}$.
- 3)Brush rollers for waste foil.
- 4)20 independent heated zones, ensure precise and balanced heating control of the platen area.
- 5)The MK development of the foil stamping control system has meant that many kinds of intelligent jump-step algorithms can be programmed into the system. This results in massive foil savings, and holographic positioning system control accuracy $>\pm 0.2\text{mm}$.



Gripper Bars and Chains

- 1)The gripper bar uses special ultra-aluminum extrusions, surface-treated aluminum alloy after anodizing. Patented design of the adjusting mechanism to ensure that the two units have high register accuracy
- 2)Main drive chains are imported and are a specially strengthened chain design, the stress intensity is increased to 46%, which improves the stability and accuracy of the machine as well as extending the service life of the machine.



Lower Support Plate

- 1)Combined plate system (3mm+1mm, can reduce production cost dramatically.
- 2)Unified centerline system; die cutting, stripping and product tools fast lock system; all stripping, product tools are incorporated with a vernier regulation system, this increases the efficiency of changing jobs.

Waste Conveying System

- 1)A separate power-driven waste conveyor belt, is capable of removing waste at high speed. The machine is also equipped with waste collection bins.
- 2)Paper damping deceleration using pressure paper brush devices, ensuring the smooth collection of the waste.
- 3)Non stoping sampling function.

Platen Press Section

- Platen press 1 has auto pressure adjustment by servo motor. Platen press 2 has auto pressure adjustment by motor.
- 1)Lower support plate can be micro adjustmnt by two direction.
 - 2)20 heating zones individually controlled the precision heating temperature with a range of $\pm 5^\circ\text{C}$, The heating system is imported with qualified lifetime.
 - 3)The chase and lower support plate are locking by pneumatic device from both direction.
 - 4)Optimized pressure adjustment gives a better result on foil stamping with a good press timer to improve the foiling and embossing result.



MK21060SER

DUOPRESS Foil Stamping Die Cutting Machine with Stripping and Blanking

- Platen
- Sheet-Fed
- Duo-Press
- Die Cutting
- Foil Stamping
- Stripping
- Blanking Function

In the past: Printed sheet → Foil stamping → Embossing → Die cutting
→ Stripping → Counting → Finished product stacking → Product

Integrated designs, processing in one pass, from printed sheet to foil stamping and embossing products

Now: Sheet → MK21060SER → Product

Technical Data	MK21060SER
Max sheet size	1060mmX760mm
Min sheet size	400mm x 350mm
Max die cutting size	1060mmX745mm
Max stamping size	1060mmX740mm
Inner chase size	1120mmX770mm
Stock range	90~2000g/m ² (paper) / 0.1~2mm (paper) / ≤4mm (corrugated)
Max die cutting force	2.5MN
Max die cutting speed	5000s/h (die cutting) ; 5000s/h (foil stamping)
Max feeder pile height	1400mm (wooden pallet included)
Max delivery pile height	1130mm (wooden pallet included)
Widest dimension of in longitudinal	φ250mm
Widest dimension of in transversal	φ200mm
Main motor wattage	18.5KW
Number of heating zones	20 heating zones, 40~180°C Adjustable
Dimension of the foil	20~1060mm
Press 1 foil advance shafts	3 longitudinal & 2 transversal
Reserved foil-stamping function for press 2	Foil-stamping function as option
Net weight approx	33000kg
Air requirement	0.6~0.7Mpa, flow rate:>1 m ³ /min
Accuracy of overprint	≤±0.10mm

To configure ● Standard configuration ○ Optional configuration

The high-speed feeder is adjusted with 4 lifting suction cups and 5 carrier suction cups	●
Non-stop sheet feed system with high speed	●
Non-stop sheet delivery	●
Single-position engagement clutch with high-performance	●
Conveyor belt wide in width	●
Vacuum feeding table	○
Pneumatic side lay	—
Imported torque restrainer	●
Imported worm wheel and worm set products	●
Pneumatic locking device	●
Bi-directional pneumatic locking device	●
3+1mm adjustable lower supporting plate	●
Films fasten device	●
Adjustable honeycomb chase	●
Adjustable die-cutting chase	●
chase quick locking device	○
Imported pneumatic clutch	●
High precision transversal servo foil feeding system	●
High precision longitudinal servo foil feeding system	●
Foil unwind device	●
Foil break detector	●
Air blast foil separation system	●
20 heating zones	●
Central registration system	—
High speed indexing device	—
Patent design gripper bar	●
Automatic lubricating system	—
CE certification	●
Overload protector	●
Mitsubishi PLC Q series	●
Mitsubishi PLC FX series	—
Chase preparation stand	—
Pre-stacking device	○
Pre-loading device	○
Pre-stocking device	●
Used foil rewind device	○
Hologram foil stamping	○
Automatic discharging device	●
Automatic discharging device with rotation type	○
Pneumatic lifting and locking device of upper stripping frame at stripping unit	●
Stripping quick lock device	●
Stripping board micro adjustment device	●
Waste collection box	●

Brochure content is only for reference, the machines please refer to the actual products.



Masterwork Machinery Co.,Ltd was established in 1995. It is specifically established as a high technology manufacturer of print finishing equipment. On March 29th, 2012, Masterwork Machinery Co.,Ltd has successfully listed on the stock exchange in Shenzhen, which lays a solid foundation for the company's further development.

At present, Masterwork Machinery Co.,Ltd can be found in over 20 countries. The company has continuously given full play to the advantages in resource, technology and talents. It devotes itself to promoting the core business—manufacture of the printing & packaging equipment. The products have gained acceptance all over the world. Masterwork Machinery Co.,Ltd has become one of the preferred suppliers for the solutions of the global print finishing equipment.

For one company and successful team, every step made is covered with sweat and smile. Hard forward and rain or shine is the promise made by MK, and its belief for the future. The past excellent performance has laid a solid foundation for MK's sustainable growth. MK hopes to achieve the bright future by the close co-operation with the business partner.

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有恒·长荣
Together & Better



Technology Supporting Hope,
Today Carrying Yesterday,The Future Revealed,
Together We Have No Limits!!!

MK21060SER
DUOPRESS Foil stamping,Embossing,
Die cutting machine with stripping and blanking

天津长荣印刷设备股份有限公司
MASTERWORK MACHINERY CO., LTD.



Foil stamping,Embossing, Die cutting, Strip-
ping and blank separation, product collec-
tion, six processes in one pass

DUO+ MK21060SER foil stamping and die cutting machine with stripping and blank separation has been designed to satisfy the added value sector of print and packaging industry. The unique DUO+ MK21060SER produces foil stamped, die cut, stripped, blank separated sheets in one pass. DUO+ MK21060SER will reduce the down time and increase production efficiency.

- A world first creation without equal, produces foil stamping, embossing, cutting, stripping and blanking separation process in one pass.
- Combining all these processes in line dramatically improves productivity.
- Unified centerline system; die cutting, stripping and product tools fast lock system; all stripping, product tools are incorporated with a vernier regulation system, this increases the efficiency of changing jobs.
- Improved foil control systems have been designed to ensure accurate foil feeding and create greater foil saving benefits.
- Multi-function blank separation section provides convenient changeover between blank separation and sheet delivery, which satisfies the different requirements of the jobs.
- The machine is equipped with automatic finished product pile delivery, which reduces the requirement of labor.