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## BHT MHK MHC Series Hot Foil Stamping & Die Cutting Machine

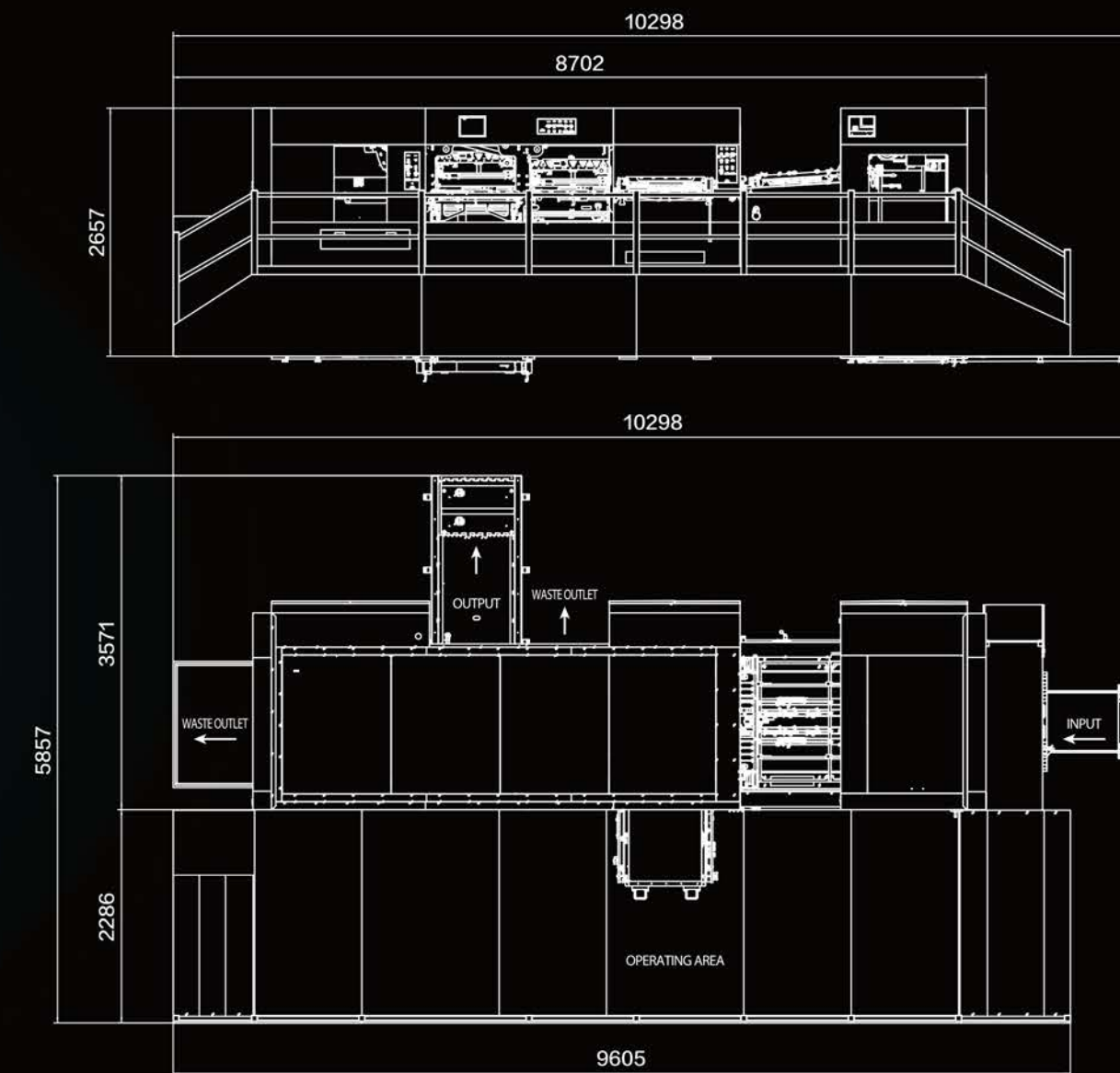




**RBHT 1060SCE**

Automatic Die Cutting and Creasing Machine  
With Stripping & Blanking

**ROYO MACHINERY**







FEEDER

Feeder based on advanced technical platform feeding precisely and consistently of wide range stock from 90g/m² thin paper to 1000g/m² cardboard as well as micro flute corrugated board.



DOUBLE SHEET DETECTOR

Ultrasonic double sheet detector without touching the paper, hence scratch free, reliable and quick set up.



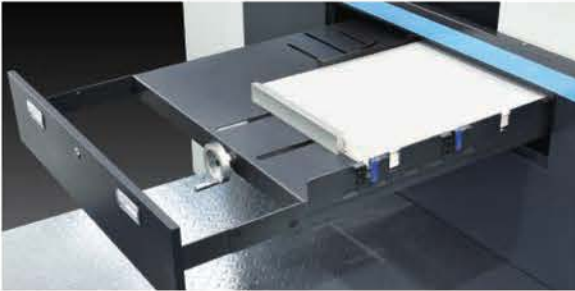
GRIPPER BAR

8 gripper bars made of cutting edge latest technology running extremely smoothly, thanks to the unique design of large motion angle eccentric worm gear drive system.



FULL SHEET DELIVERY

Full sheet delivery option to ensure easy production planning by selecting final delivery style.



AUTO SEPARATION SHEET INSERT

Automatic separating sheet inserter oupled with electronic position sensor at blanking station.



NON-STOP SAMPLING

The Sampling Function can be used to remove a sample sheet on the fly by one button only, easy for operating.



VARIABLE SPEED WORM GEAR DRIVE DEVICE

Worm gear and toggle mechanism allows large motion angle hence minimum number and size of nicks at reasonable max. production speed.



PLATE SETTING

5mm hardened cutting plate or 4+1mm sandwich plate on top 15mm precision synthetic supporting plate with +/-0.9mm micro adjustment for quick set up and easy make ready.



ADVANCED TOOLING LOCKUP

Advanced quick tooling set up system ensures fast job change over and hence high productivity at both stripping and blanking stations.



Main technical parameter	
Model	BHT-1060SCE
Stock Range	Paper: from 90 g/m² Board: up to 1000 g/m² Corrugated Board: up to 4 mm Carton acceptable warp: 2% across
Maximum sheet size	1060 × 760mm
Minimum sheet size	400 × 350 mm
Inner chase size	1080 × 770mm
Maximum cutting size	1060 × 745 mm
Minimum gripper margin	9~17 mm
Cutting rule height	23.8 mm
Minimum width of double cuts	5 mm
Maximum cutting pressure	300 Tons
Maximum mechanical speed	7000 sheet/hour
Designed maximum mechanical speed	8000 sheet/hour
Maximum pile height at feeder - normal mode	1800 mm
Maximum pile height at feeder - non - stop mode	1520 mm
Maximum pile height at delivery	1580 mm
Main motor power	15 KW
Total power required	26 KW
Machine dimensions	10298 × 5857 × 2657mm (L × W × H)
Net weight of machine	22000kg





**RMHK 3S1050TTRC**

TREPRESS Automatic High Speed Duoble Hot Stamping  
&Die Cutting Machine with Stripping&Heating System

**ROYO MACHINERY**

The job you can realize in one pass as below:

1. hot stamping+hot stamping+deep embossing
2. hot stamping+hot stamping+die cutting+stripping
3. hot stamping+deep embossing+die cutting+stripping

MHK-3S1050TTRC can meet the exacting requirements in the post press marketplace. This machine are able to do twice hot stamping&deep embossing or twice hot stamping&die cutting&stripping or hot stamping&deep embossing&die cutting& stripping in one pass which traditional machine and duopress machines are unlikely to delivery. It will bring you value-added enjoyment. Improved production and reduced labor cost, without any reduction in efficiency or quality, a unique machine foil stamping and die cutting in one seam-less operation.







**RMHK 3S1050TTMC**

TREPRESS Automatic High Speed Duoble Hot  
Stamping&Die Cutting Machine with Stripping

The job you can realize in one pass as below:

1. hot stamping+hot stamping+die cutting+stripping
2. hot stamping+deep embossing+die cutting+stripping



**RMHK 3S1050TRMC**

TREPRESS Automatic High Speed Hot Stripping&  
Die Cutting Machine with Stripping&Heating System

The job you can realize in one pass as below:

1. hot stamping+deep embossing+die cutting+stripping

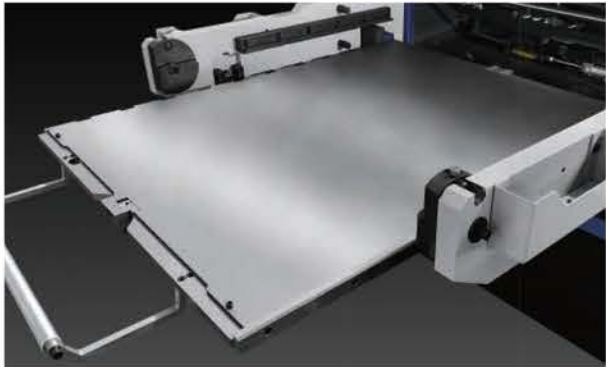


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Feeder



Micro adjustment for quick set up



Paper collecting unit

Core technical characteristics

The lower movable platform of each embossing unit has an independent driving device, and each driving device is respectively connected with a controllable variable-speed servo motor to realize the variable-speed movement of the lower movable platform. Each embossing unit realizes asynchronous operation.



Main Technical Parameter				
Model	MHK-3S1050TTRC	MHK-3S1050TTMC	MHK-3S1050TRMC	
Max.sheet size	1050 × 750mm	1050 × 750mm	1050 × 750mm	
Min.sheet size	400 × 360mm	400 × 360mm	400 × 360mm	
Max.die cutting size	1040 × 720mm	1040 × 720mm	1040 × 720mm	
Max.hot stamping size	1040 × 720mm	1040 × 720mm	1040 × 720mm	
Gripper margin	9~17mm	9~17mm	9~17mm	
Inner chase size	1080 × 745mm	1080 × 745mm	1080 × 745mm	
Stock range	80~600g/m <sup>2</sup> Cardboard	0.1~2mm Cardboard	≤4mm Corrugated	
Die cutting accuracy	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm	
Common stamping accuracy	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm	
Hologram positioning stamping accuracy	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm	
Max.die cutting force	600 ton+600 ton+600 ton	600 ton+600 ton+300 ton	600 ton+600 ton+300 ton	
Max.working speed	6200s/h	6200s/h	6200s/h	
Max.feeder pile height(wooden pallet included)	1600mm	1600mm	1600mm	
Max.delivery pile height(wooden pallet included)	1400mm	1400mm	1400mm	
Max.gold foil diameter	250mm Longitudinal,	200mm Transversal		
Electric-heated system	20 Heating zones, 40~180℃ Adjustable			
Foil width	20~1020mm	20~1020mm	20~1020mm	
Press 1 foil advance shafts	3 Longitudinal+2 Transversal	3 Longitudinal+2 Transversal	3 Longitudinal+2 Transversal	
Press 2 foil advance shafts	3 Longitudinal+2 Transversal	3 Longitudinal+2 Transversal	Electric-heated system	
Press 3 foil advance shafts	Electric-heated system		/	/
Servo motor power	15KW/15KW/15KW	15KW/15KW/15KW	15KW/15KW/15KW	
Full load wattage	141KW	129KW	99KW	
Air requirement	Air pressure: 0.6~0.7Mpa,	Flow rate: > 1m³/min		
Dimension	10800 × 4300 × 2390mm	10800 × 4300 × 2390mm	10800 × 4300 × 2390mm	
Weight	40T	39T	38T	





**RMHK 2S1050TTC**

DUOPRESS Automatic High Speed  
Foil Stamping And Die Cutting Machine

**ROYO MACHINERY**

The job you can realize in one pass as below:

1. hot stamping+hot stamping
2. hot stamping+die cutting+stripping
3. deep embossing+die cutting+stripping
4. hot stamping+deep embossing

The duo-press MHK-2S1050TTC can meet the exacting requirements in the post press marketplace. This machine has the ability to accurately register foiling and die cutting processes in one pass which traditional machine processes are unlikely to delivery. It will bring you value-added enjoyment. Improved production and reduced labor cost, without any reduction in efficiency or quality, a unique machine foil stamping and die cutting in one seam-less operation.







**RMHK 2S1050TRC**

DUOPRESS Automatic High Speed Foil  
Stamping And Die Cutting Machine with Heating System

The job you can realize in one pass as below:

1. hot stamping+deep embossing
2. hot stamping+die cutting+stripping
3. deep embossing+die cutting+stripping



**RMHK 2S1050TMC**

DUOPRESS Automatic High Speed Foil  
Stamping And Die Cutting Machine

The job you can realize in one pass as below:

1. hot stamping+die cutting+stripping
2. deep embossing+die cutting+stripping



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RMHK 2S1050RMC

DUOPRESS Automatic High Speed  
Die Cutting Machine with Heating System

ROYO MACHINERY

The job you can realize in one pass as below:

1. deep embossing+die cutting+stripping



Main Tactical Paramater				
Model	MHK-2S1050TTC	MHK-2S1050TRC	MHK-2S1050TMC	MHK-2S1050RMC
Max.sheet size	1050 × 750mm	1050 × 750mm	1050 × 750mm	1050 × 750mm
Min.sheet size	400 × 360mm	400 × 360mm	400 × 360mm	400 × 360mm
Max.die cutting size	1040 × 720mm	1040 × 720mm	1040 × 720mm	1040 × 720mm
Max.hot stamping size	1040 × 720mm	1040 × 720mm	1040 × 720mm	1040 × 720mm
Gripper margin	9~17mm	9~17mm	9~17mm	9~17mm
Inner chase size	1080 × 745mm	1080 × 745mm	1080 × 745mm	1080 × 745mm
Stock range	80~600g/m² Cardboard , 0.1~2mm Cardboard , ≤4mm Corrugated			
Die cutting accuracy	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm
Common stamping accuracy	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm
Hologram positioning stamping accuracy	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm
Max.die cutting force	600 ton + 600 ton	600 ton + 600 ton	600 ton + 300 ton	600 ton + 300 ton
Max.working speed	7200s/h	7200s/h	7200s/h	7200s/h
Max.feeder pile height (wooden pallet included)	1600mm	1600mm	1600mm	1600mm
Max.delivery pile height (wooden pallet included)	1400mm	1400mm	1400mm	1400mm
Max.gold foil diameter	250mm Longitudinal, 200mm Transversal			
Electric-heated system	20 Heating zones, 40~180℃ Adjustable			
Foil width	20 ~ 1020mm	20 ~ 1020mm	20 ~ 1020mm	/
Press1 foil advance shafts	3 Longitudinal+2 Transversal	3 Longitudinal+2 Transversal	3 Longitudinal+2 Transversal	Electric-heated system
Press2 foil advance shafts	3 Longitudinal+2 Transversal	Electric-heated system	/	/
Servo motor power	15KW/15KW	15KW/15KW	15KW/15KW	15KW/15KW
Full load wattage	114KW	84KW	72KW	48KW
Air requirement	Air pressure: 0.6~0.7Mpa, Flow rate: >1m³/min			
Dimension	9000 × 4300 × 2390mm	9000 × 4300 × 2390mm	9000 × 4300 × 2390mm	9000 × 4300 × 2390mm
Weight	33T	32T	30T	29T



RMHK

1050T

1050T S9000

Automatic Hot Foil Stamping & Die Cutting Machine

1050TC

1050TC S9000

Automatic Hot Foil Stamping & Die Cutting Machine with Stripping

1050AT

1050AT S9000

Automatic Hot Foil Stamping & Die Cutting Machine(Heavy duty)

1050ATC

1050ATC S9000

Automatic Hot Foil Stamping & Die Cutting Machine with Stripping(Heavy duty)



ROYO MACHINERY



Feeder



Conveying unit



Foil delivered unit



Hot foil stamping and die cutting unit



Paper collecting unit



TC/ATC series hot foil stamping or stripping section exchange device

MHK-1050T Automatic Hot Foil Stamping & Die Cutting Machine is used for carton box, label die-cutting, foil stamping and embossing especially on all kinds of exquisite printing materials such as the wine box, cigarette box, gift box, and the household appliance box, cosmetics box to achieve 3D and exquisite effect.

MHK-1050TC Automatic Hot Foil Stamping & Die Cutting Machine with stripping is equipped with stripping section based on MHK-1050T, thus ensures multi-operational function.





RMHK 1050

1050 S9000

Automatic Die Cutting Machine

1050A

1050A S9000

Automatic Die Cutting Machine(Heavy duty)



#### Main Technical Performance

- The whole machine adopts Schneider PLC system
- High quality feeder made in Taiwan with 4 suction cups for lifting paper and 4 suction cups for forwarding paper ensures stable and fast paper feeding
- Preload device, non-stop feeding, with max pile height up to 1600mm
- The preload device is equipped with guiding rails that enable the operators to move the prepared pile to feeder accurately and conveniently.
- Side and front lays are with precise photocells whose sensitivity is adjustable
- The anti-obstacle device is adopted to prevent the machine from damage
- Paper feeding will be slow down when the paper is about to reach front lays to achieve a more accurate paper orientation
- Japanese NITA convey belt with its speed being adjustable
- German made stainless steel is used for convey board in order to achieve smooth and quick paper conveyance
- Pneumatic lifting cutting plate for easy slide in and out
- Easy way to turn over and change die-cutting chase and plate to shorten setup time
- High quality gripper plate from Japan with long life time
- High quality German imported chain with pre-extended ensure stability and accuracy in long run
- Automatic lubrication and cooling system for main drive and automatic lubrication for main chain
- Overload protection device with torque limiter in index box for the highest safety of operator and equipment
- Crank shafts and worm rod is made of 40 Cr Harden Heating System. Worm gear is made of copper
- High quality imported air clutch
- SMC pneumatic components
- The upper, middle and lower stripping frames are controlled respectively by 3 GPRS of cam wheels
- Match with the centerline registration system in die-cutting section, the same system also apply to the stripping station to minimize changeover time. Accurate positioning can increase production efficiency

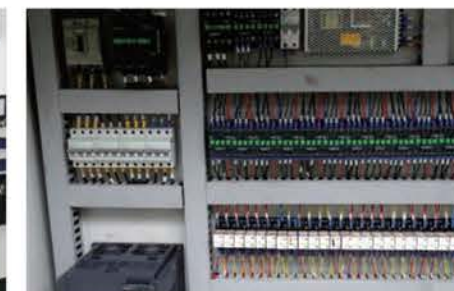


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#### Torque limiter, intermittent segmentation

- Taiwan high precision intermittent segmentation ensure high positional precision for long time usage
- Taiwan torque limiter can accurately protect the artificial operation accident to guarantee the people and machine safety by its sensitive limit protection performance



#### Electric control system

- Electric with Schneider and Omron brand imported parts in order to improve the operation quality control
- Adopt Schneider PLC programmable control system, simple circuit control procedures, the maintenance simple and easy



#### Main motor lubrication system

- Taiwan made automatic oil pump cooling circulation system to ensure main motor lubrication of high speed for a long time
- Equipped with oil pressure gauge and with oil pressure alarm device



#### Germany vacuum pump

- Germany Becker oil free blower and vacuum pump





**RMHK 1050CE**  
**1050ACE**

**1050CE S9000**  
**1050ACE S9000**

Automatic Die Cutting Machine With Stripping  
Automatic Die Cutting Machine With Stripping(Heavy duty)

MHK-1050CE Automatic Die Cutting Machine With Stripping is used for paper box, paper carton, and label die-cutting, and embossing especially on all kinds of exquisite printing materials such as the wine box, cigarette box, gift box, and the household appliance box, cosmetics box to achieve 3D and exquisite effect.



**RMHK 1050AR** | **1050AR S9000**

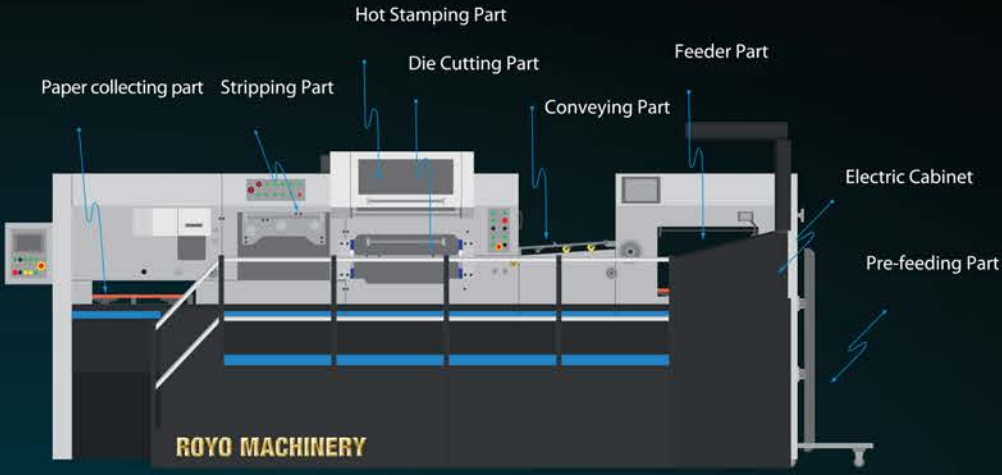
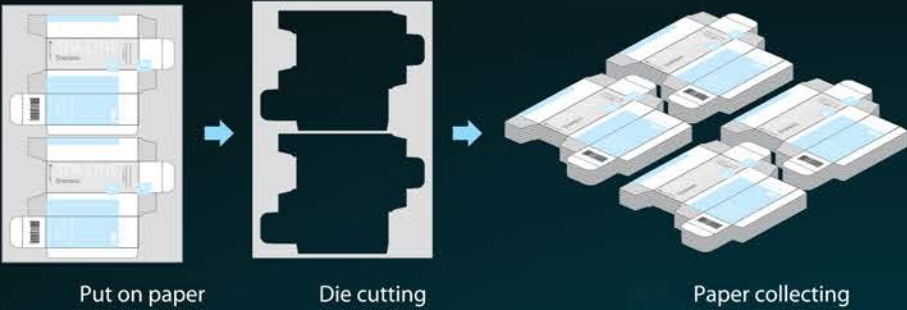
Automatic Die Cutting Machine  
with Heating System(Heavy Duty)

-  **≤±0.1mm**  
Die cutting accuracy
-  **7500s/h** Die cutting  
Max die cutting speed
-  **9000s/h** Die cutting  
Max die cutting speed
-  **1600mm**  
Max feeder pile height

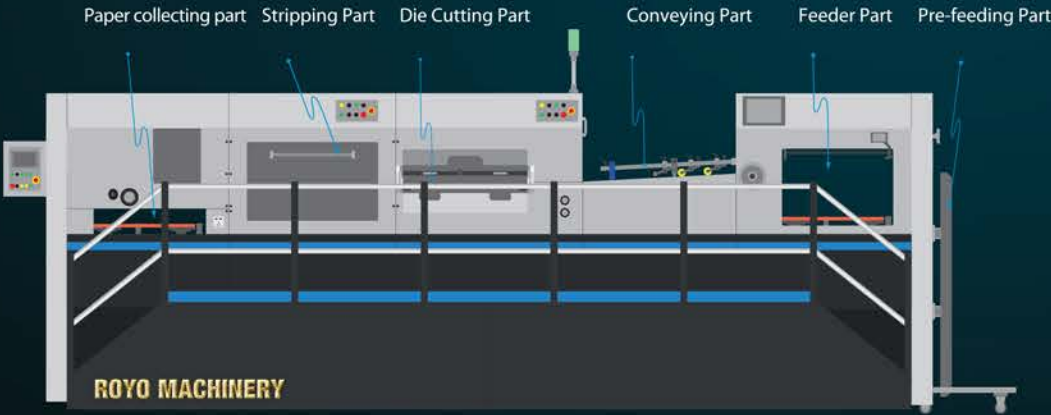




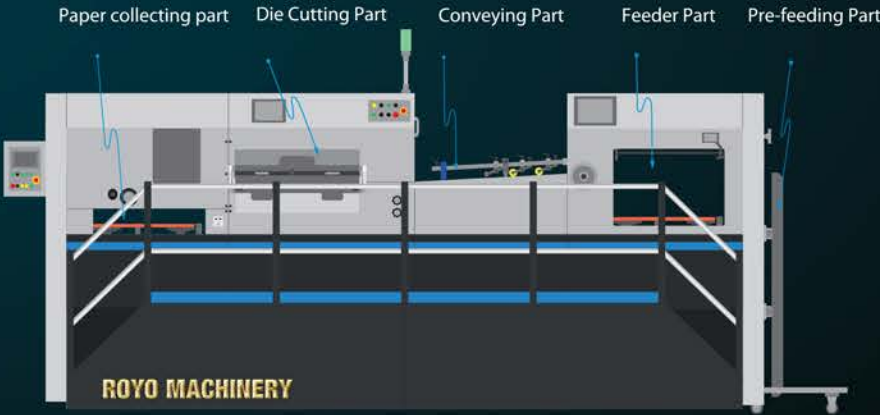
PROCESS FLOW



MHK-1050T/1050TC/1050AT/1050ATC  
MHK-1050T S9000/1050TC S9000/1050AT S9000/1050ATC S9000



MHK-1050CE/1050ACE  
MHK-1050CE S9000/1050ACE S9000



MHK-1050/1050A  
MHK-1050 S9000/1050A S9000



Main technical parameter				
Model	MHK-1050T/TC / MHK-1050AT/ATC	MHK-1050 / MHK-1050A	MHK-1050CE / MHK-1050ACE	MHK-1050AR
Max. sheet size	1050 × 750mm	1050 × 750mm	1050 × 750mm	1050 × 750mm
Min. sheet size	400 × 360mm	400 × 360mm	400 × 360mm	400 × 360mm
Max. die cutting size	1040 × 720mm	1040 × 720mm	1040 × 720mm	1040 × 720mm
Max. hot stamping size	1040 × 720mm	/	/	/
Gripper margin	9-17mm	9-17mm	9-17mm	9-17mm
Inner chase size	1080 × 745mm	1080mm × 745mm	1080 × 745mm	1080 × 745mm
Stock range	80-2000gsm( cardboard)	80-2000gsm( cardboard)	80-2000gsm( cardboard)	80-2000gsm( cardboard)
	≤4mm ( corrugated)	≤4mm ( corrugated)	≤4mm ( corrugated)	≤4mm ( corrugated)
Die cutting accuracy	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm
Max. die cutting force	300T(T/TC)/600T(AT/ATC)	300T/600T(A)	300T(CE)/600T(ACE)	600T
Max. die cutting speed	7500s/h Die cutting	7500s/h Die cutting	7500s/h Die cutting	7500s/h Die cutting
Max. feeder pile height	1600mm	1600mm	1600mm	1600mm
	( wooden pallet included)	( wooden pallet included)	( wooden pallet included)	( wooden pallet included)
Max. delivery pile height	1400mm	1400mm	1400mm	1400mm
	( wooden pallet included)	( wooden pallet included)	( wooden pallet included)	( wooden pallet included)
Max. gold foil diameter	250mm( vertical)	/	/	/
	200mm( horizontal)	/	/	/
Electric-heated system	20 , 40-180℃	/	/	20 , 40-180℃
	20 temperature ranges	/	/	20 temperature ranges
	40-180℃ is adjustable	/	/	40-180℃ is adjustable
Foil width	20-1020mm	/	/	/
Main motor wattage	11kw	11kw	11kw	11kw
Overall dimension	7100 × 4260 × 2350mm	6120 × 4260 × 2350mm	7100 × 4260 × 2350mm	6120 × 4260 × 2350mm
	( L:paper prepared track included	W:platform included)		
Net weight approx	18.5T(T/TC)/20.5T(AT/ATC)	16T/18.5T	17T/19T	18.5T
Full Load wattage	52kw	16kw	16.9kw	35kw

Remark: The max speed of MHK-1050 S9000 series is 9000s/h, other parameters are the same as that of MHK-1050 series.



RMHK 820CE

Automatic Die Cutting Machine  
With Stripping

MHK 820CE Automatic Die Cutting Machine With Stripping is used for paper box, paper carton, and label die-cutting, and embossing especially on all kinds of exquisite printing materials such as the wine box, cigarette box, gift box, and the household appliance box, cosmetics box to achieve 3D and exquisite effect.



RMHK 820

Automatic Die Cutting Machine

$\leq \pm 0.1\text{mm}$   
Die cutting accuracy

7500s/h  
Max die cutting speed

1500mm  
Max feeder pile height



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RMHK 820T

Automatic Hot Foil Stamping  
& Die Cutting Machine

ROYO MACHINERY



Feeder



Conveying unit



Paper collecting unit



Torque limiter, intermittent  
segmentation



Main motor lubrication system



Germany vacuum pump

Main technical parameter			
Model	MHK-820	MHK-820CE	MHK-820T
Max. sheet size	820 × 600mm	820 × 600mm	820 × 600mm
Min. sheet size	310 × 260mm	310 × 260mm	310 × 260mm
Max. die cutting size	800 × 580mm	800 × 580mm	800 × 580mm
Max. hot stamping size	/	/	800 × 600mm
Gripper margin	9-17mm	9-17mm	9-17mm
Inner chase size	910 × 610mm	910 × 610mm	910 × 610mm
Stock range	80-2000g/m²( Cardboard), ≤4mm (Corrugated paper)		
Die cutting accuracy	≤ ±0.1mm	≤ ±0.1mm	≤ ±0.1mm
Max. die cutting force	200T	200T	200T
Max. die cutting speed	7500s/h	7500s/h	7500s/h
Max. feeder pile height	1500mm(Including wooden pallet)	1500mm(Including wooden pallet)	1500mm(Including wooden pallet)
Max. delivery pile height	1300mm(Including wooden pallet)	1300mm(Including wooden pallet)	1300mm(Including wooden pallet)
Max. gold foil diameter	/	/	250mm(Longituinal) 200mm(lateral)
Electric-heated system	/	/	20 Temperature zone, 40-180℃ Adjustable
Foil width	/	/	20-780mm
Main motor wattage	11kw	11kw	11kw
Overall dimension	5950 × 3730 × 2140mm	7000 × 3730 × 2140mm	7000 × 3730 × 2140mm
Net weight approx	12ton	13ton	14.5ton
Full Load wattage	16kw	16.9kw	52kw





RMHK

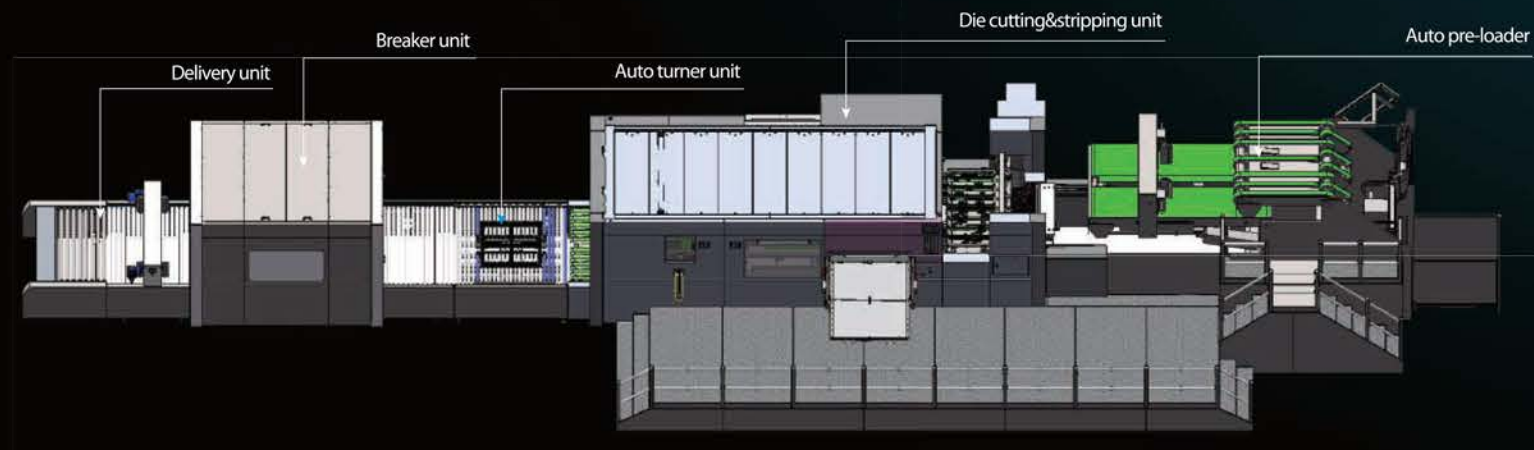
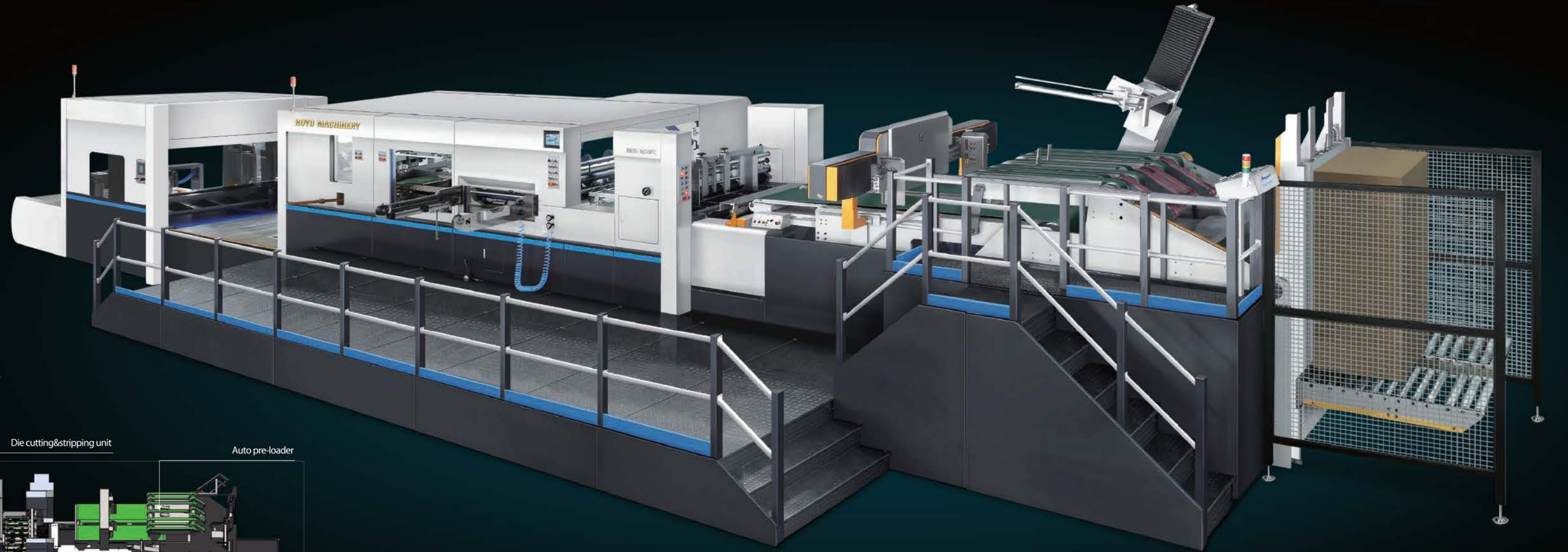
1900FC  
1650FC  
1500FC  
1300FC

1900EFC  
1650EFC  
1500EFC  
1300EFC

Automatic Die Cutting Machine  
Linkage Production Line

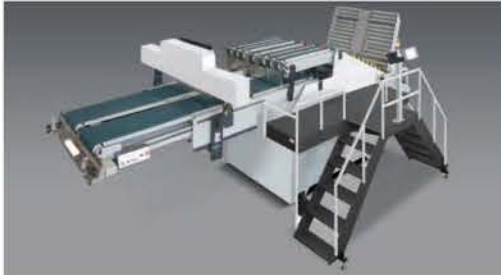
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Converting System Integration means devices combined in line to reduce the manual work, optimize and speed up the flow of products within a single process. Among different modes of production lines, it is the most popular and practical mode in the global market with higher stability. In this system, the automatic prefeeder is one important part linked with the feeder of automatic diecutter to raise feeding efficiency and relieve the workload of operator at maximum that manual work cannot totally reach. The automatic breaker in line with the delivery unit of diecutter automatically separates blanks from multiple ups and save considerable labor costs compared to manual work. Along with the advantages in efficiency and cost, the system is especially able to be customized at particular client demands, products techniques and processes. Nowadays this sytem has become the new tendency interested by a large number of brand owners in the corrugated board packaging industry.





Details



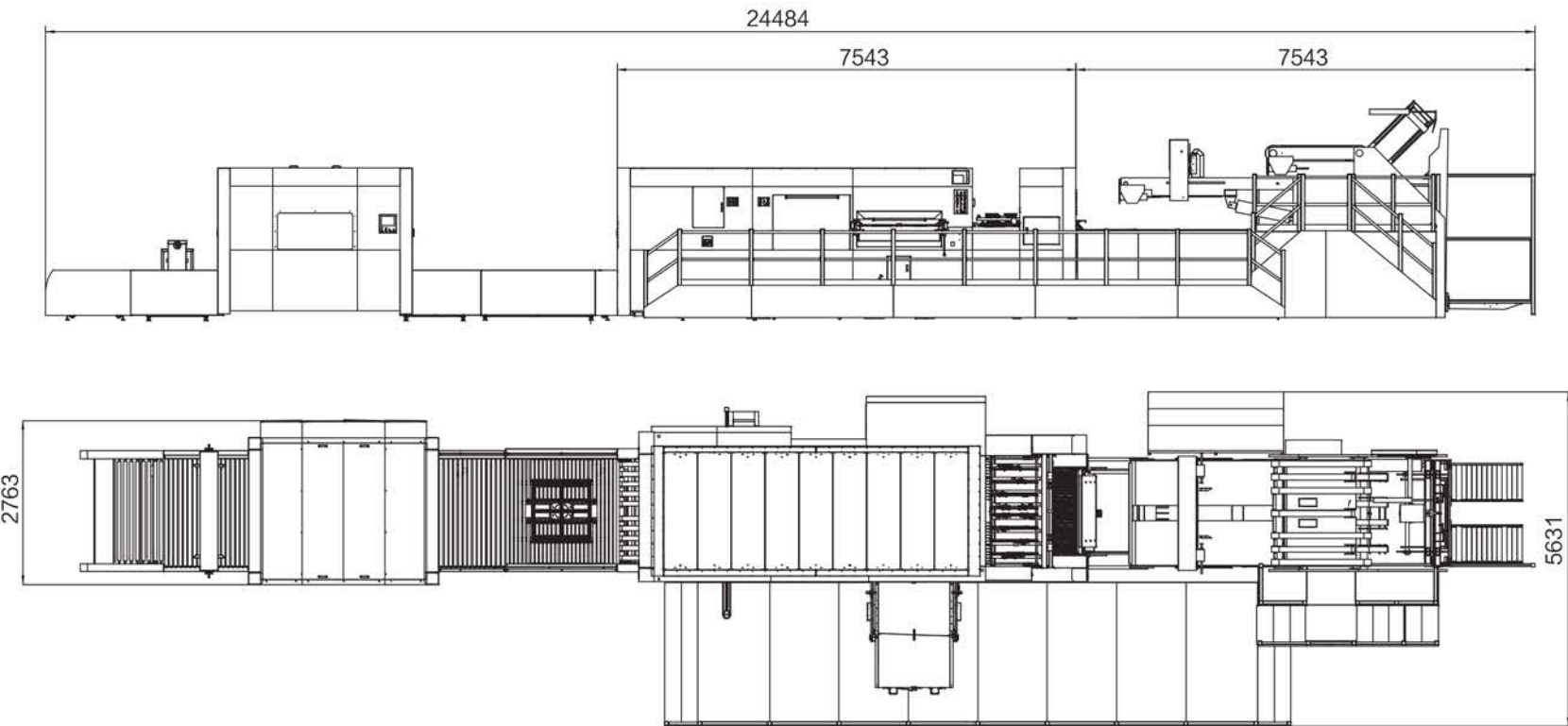
Auto pre-loader



Paper breaker



Drawing



Specifications				
Model	MHK-1900FC/1900EFC	MHK-1650FC/1650EFC	MHK-1500FC/1500EFC	MHK-1300FC/1300EFC
Sheel size	Max. 1900 × 1400mm Min. 650 × 450mm	Max. 1650 × 1200mm Min. 650 × 450mm	Max. 1500 × 1100mm Min. 550 × 450mm	Max. 1300 × 940mm Min. 550 × 450mm
Corrugated board. Up to	Max. 8.5mm, Min. 1mm	Max. 8.5mm, Min. 1mm	Max. 8.5mm, Min. 1mm	Max. 8.5mm, Min. 1mm
Batch height	Max. 1800mm	Max. 1800mm	Max. 1800mm	Max. 1800mm
Pile weight	1200kg	1200kg	1200kg	1200kg
Machine weight	4000kg	4000kg	3800kg	3600kg

Main technical parameter				
Model	MHK-1900FC/1900EFC	MHK-1650FC/1650EFC	MHK-1500FC/1500EFC	MHK-1300FC/1300EFC
Max. sheet size	1900 × 1400mm	1650 × 1200mm	1500 × 1100mm	1290 × 940mm
Min. sheet size	650 × 450mm	650 × 450mm	550 × 450mm	550 × 450mm
Max. die cutting size	1870 × 1380mm	1620 × 1180mm	1480 × 1080mm	1280 × 920mm
Inner chase size	1900 × 1430mm	1650 × 1230mm	1520 × 1130mm	1310 × 970mm
Stock range	E, B, C, A and AB flute corrugated paper (1-8.5mm thickness)			
Min. gripper waste	12mm	12mm	12mm	12mm
Min. gripper margin	6-12mm	6-12mm	6-12mm	6-12mm
Cutting rule height	23.8mm	23.8mm	23.8mm	23.8mm
Max. die cutting speed	5500s/h	6000s/h	6000s/h	6000s/h
Max. die cutting pressure	450ton	400ton	400ton	400ton
Total power required	38kw	38kw	30kw	25kw
Electrical power	380V, 50HZ, 3PH	380V, 50HZ, 3PH	380V, 50HZ, 3PH	380V, 50HZ, 3PH
Mobile lower platen adjusting range	± 1.5mm	± 1.5mm	± 1.5mm	± 1.5mm
Machine dimension	13000 × 6200 × 2780mm	11700 × 5470 × 2500mm	11800 × 5000 × 2400mm	10630 × 4820 × 2400mm
Machine weight	40T/43T	35T/38T	24T/26T	21T/23T

Breakers				
Model	MHK-1900FC/1900EFC	MHK-1650FC/1650EFC	MHK-1500FC/1500EFC	MHK-1300FC/1300EFC
Sheel size	Max. 1900mm, Min. 650mm	Max. 1650mm, Min. 650mm	Max. 1500mm, Min. 550mm	Max. 1300mm, Min. 550mm
Min. Batch dimension in machine direction	200mm	200mm	200mm	200mm
Max. Batch thickness	300mm	300mm	300mm	300mm
Min. Batch thickness	20mm	20mm	20mm	20mm
Batch passage height from the floor	900mm (adjustable)	900mm (adjustable)	900mm (adjustable)	900mm (adjustable)
Full PLC control				



RMHK

1900FC  
1650FC  
1500FC  
1300FC

1900EFC  
1650EFC  
1500EFC  
1300EFC

Mirror Machines Dual Diecutter  
Working Station

**ROYO MACHINERY**





OPTIONS



Auto pre-loader



Paper breaker



Frame switchboard

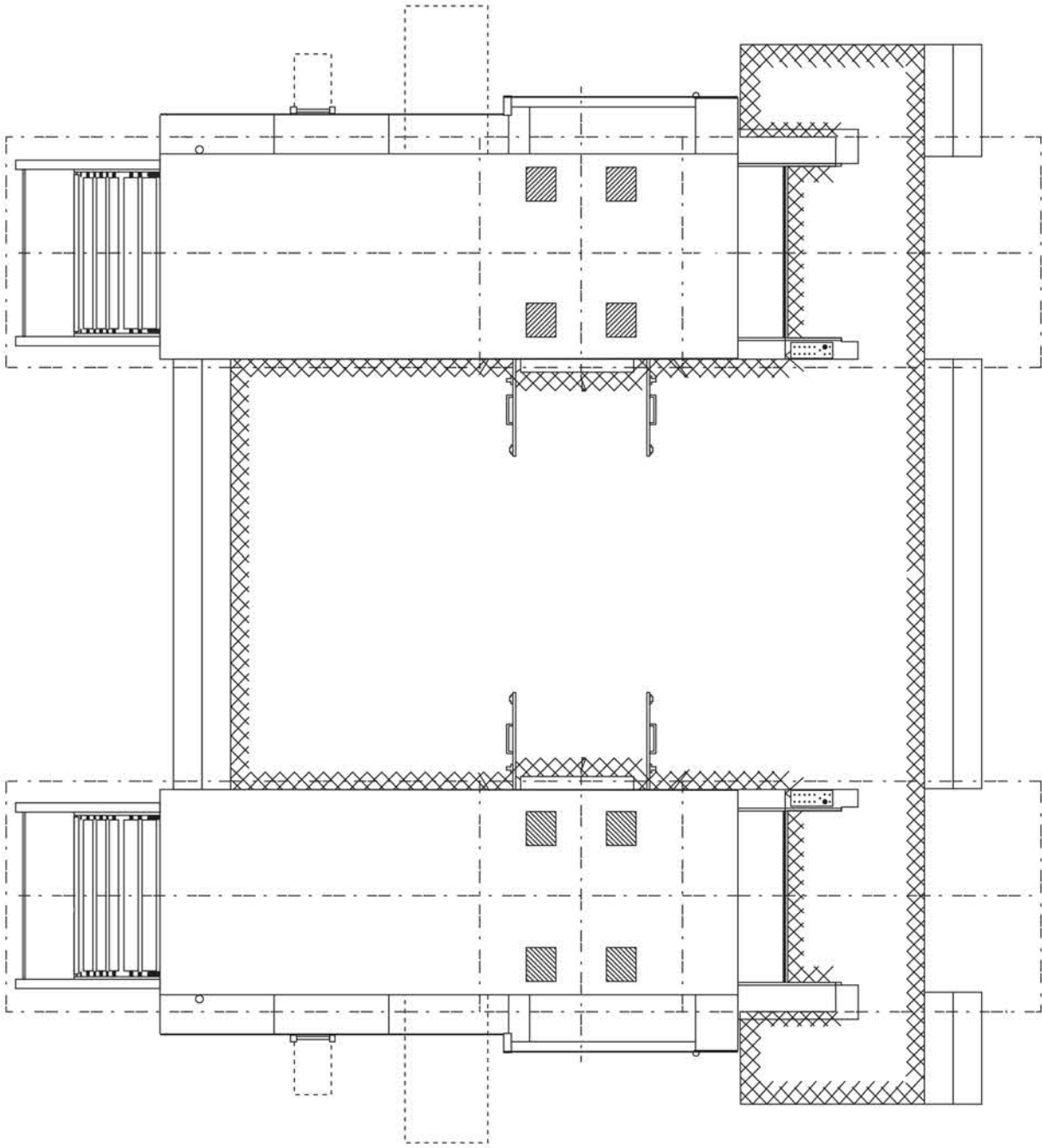
THE ADVANTAGE OF MIRROR MACHINES DUAL DIECUT TER WORKING STATION

- Two flat die cutting machine operation relatively, and make sure the feeding and collecting is homodromous. Two die-cutting machine Shared the same foot pedals, knife version, stripping, waste clearance version, and all the plate and frame, and even the same plate andframe the function of the switchboard.
- Two die cutting machine per shift just one captain, reduce the manpower cost. At the same time, the layout of the two die cutting machinewas face to face, to ensure the whole assignment in a pilot's visual monitoring range, convenient and when a pilot-in-command discoverthat the anomalies, troubleshooting, improve the yield.
- The same frame switchboard and the same plate frame can be used for the matching and installation of the double-unit combined die cutting machine, and the plate frame can be interchanged and installed freely.
- The central positioning system of the mobile phone is the same, all molds can be Shared.
- Positive and negative (left and right) hand double unit die cutting machine, which can save the machine floor space, is conducive to the enterprise space planning, and the investment efficiency is higher.



Area saving			
	2 Regular Machines Floor Space	Mirror Machines Floor Space	Total Space Saved
With Chase Loader	197.3m²	148.5m²	48.8m²
Without Chase Load	172.2m²	142.8m²	27.4m²

Drawing





**RMHK** 1900FC 1900EFC  
1650FC 1650EFC  
1500FC 1500EFC  
1300FC 1300EFC

Automatic Die Cutting & Creasing Machine  
with Stripping (Lead Edge Feeder)  
Automatic Die Cutting & Creasing Machine  
with Stripping (Down Feeder)

**ROYO MACHINERY**

#### 1 Lead edge feeder

- Top gear and precise Lead Edge Feeder design, allowed consistent feeding with various quality corrugated board.
- New technology polyurethane wheel surface with grid lifter and air cushion ensure smooth feeding and accurate alignment even warped board.
- Fine vacuum suction adjustment through inverter adapts to wide range stock from F flute to double wall corrugate.



Lead Edge Feeder



Down Feeder



Feeder



Auto Non-stop Collecting Device

1. Non-stop down suck feeder
2. Pneumatic board for sheet trimming
3. Down suck feeding to protect the printing





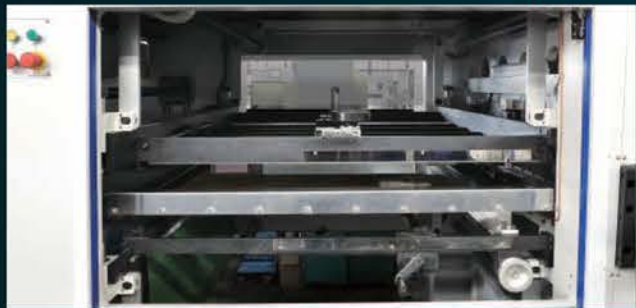
2 Sheet transmission and alignment section

- Selectable left and right side push lays to ensure accurate alignment.
- Advanced non-stop adjustment of feeding timing, reduce down time.
- Front gauge non-stop back and forth adjustable to accommodate variation in gripper margin.



3 Die Cutting Section

- Die cutting station safety door and pneumatic die chase safety locking system
- Air cushion underneath the cutting plate for easy sliding through
- Main drive adopts high quality precision worm gear and toggle system
- New technology of driving index with large motion angle to allow gripper bar gentle start and stop, less and smaller nicks required to achieve higher productivity. Equipped with overloading protection torque limit clutch.
- Cutting pressure fine adjustment wheel with position indicate gauge.



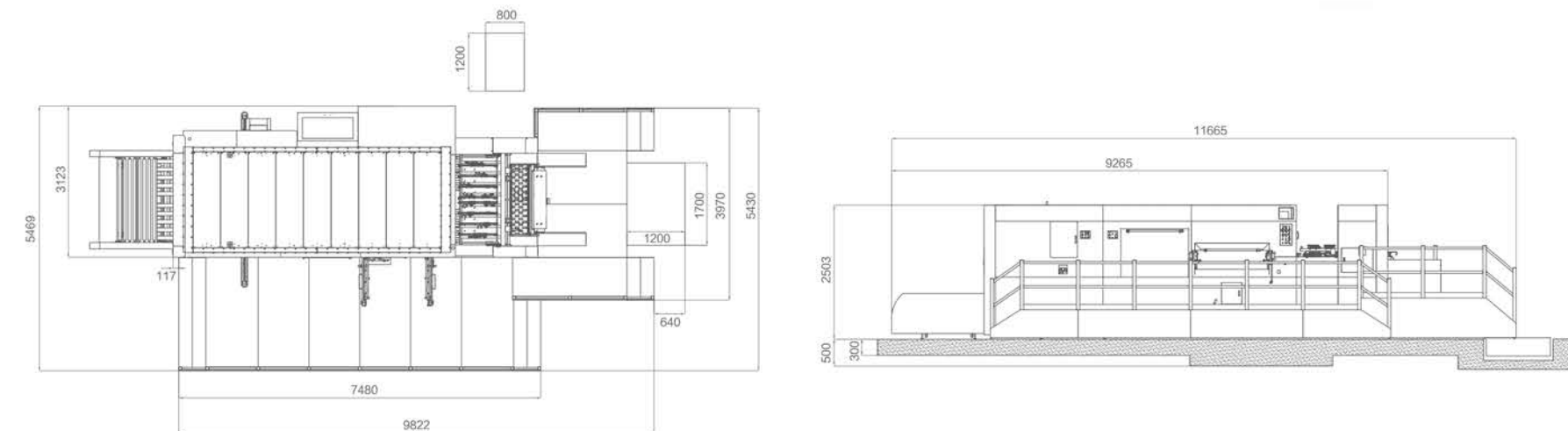
4 Stripping Section

- Stationary middle stripping board, coupled with zero jerk, smooth upper frame motion curve with extra punch at the moment of impact to obtain cleaner waste removal
- Gripper bar register block at outlets of Stripping Station ensures the accuracy of stripping
- Center line system for quick stripping tool set up and change over, compatible with centerline
- Front edge waste removal system removes and transfers waste edge outside the machine via conveyor belt



5 Paper counting & collection section

- Escalator delivery fork cooperate with non-stop air cylinder for neat and positive conveying to belt table. Bundle Delivery table is ready for further connection with Breaker for inline operation (to be required at order)
- Electrical batch counter as standard
- Spring loaded adjustable chain tensioner for maintaining constant tension thus reducing stress on chains and producing smooth gripper bar movement



Main technical parameter				
Model	MHK-1900FC/1900EFC/1900EC	MHK-1650FC/1650EFC/1650EC	MHK-1500FC/1500EFC/1500EC	MHK-1300FC/1300EFC/1300EC
Max. sheet size	1900 × 1400mm	1650 × 1200mm	1500 × 1100mm	1290 × 940mm
Min. sheet size	650 × 450mm	650 × 450mm	550 × 450mm	550 × 450mm
Max. die cutting size	1870 × 1380mm	1620 × 1180mm	1480 × 1080mm	1280 × 920mm
Inner chase size	1900 × 1430mm	1650 × 1230mm	1520 × 1130mm	1310 × 970mm
Stock range	E, B, C, A and AB flute corrugated paper(1-8.5mm thickness)			
Min. gripper waste	12mm	12mm	12mm	12mm
Min. gripper margin	6-12mm	6-12mm	6-12mm	6-12mm
Cutting rule height	23.8mm	23.8mm	23.8mm	23.8mm
Max. die cutting speed	5500s/h	6000s/h	6000s/h	6000s/h
Max. die cutting pressure	450T	400T	400T	400T
Total power required	38kw	38kw	30kw	25kw
Electrical power	380V, 50HZ, 3PH	380V, 50HZ, 3PH	380V, 50HZ, 3PH	380V, 50HZ, 3PH
Mobile lower platen adjusting range	± 1.5mm	± 1.5mm	± 1.5mm	± 1.5mm
Machine dimension	13000 × 6200 × 2780mm(FC/EFC)	11700 × 5470 × 2500mm(FC/EFC)	11800 × 5000 × 2400mm(FC/EFC)	10630 × 4820 × 2400mm(FC/EFC)
	15000 × 6200 × 2780mm(EC)	13250 × 5470 × 2500mm(EC)	12500 × 5000 × 2400mm(EC)	12000 × 4820 × 2400mm(EC)
Machine weight	40T/43T/39T	35T/38T/34T	24T/26T/23T	21T/23T/20T

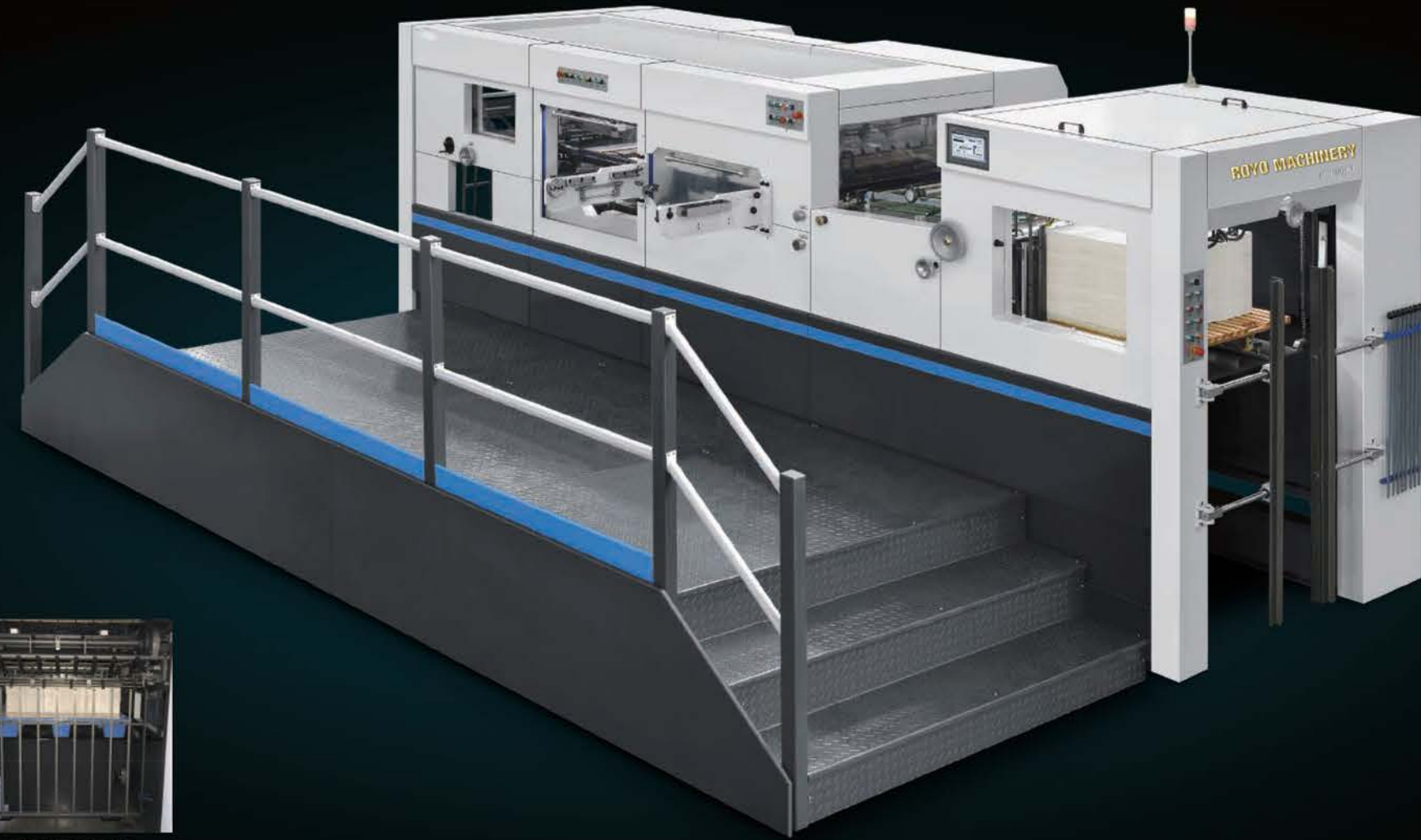






**RMHC** **1060CE**  
**1080CE**  
**1060ACE**  
**1080ACE**

Automatic Die Cutting&Creasing Machine with Stripping  
Automatic Die Cutting&Creasing Machine with Stripping(Heavy duty)



Paper Collecting Unit



**RMHC** **1060**  
**1080**  
**1060A**  
**1080A**

Automatic Die Cutting&Creasing Machine  
Automatic Die Cutting&Creasing Machine(Heavy duty)



**ROYO MACHINERY**





**RMHC** **1060AT**  
**1080AT**

Automatic Hot Foil &  
Die Cutting Machine(Heavy duty)

**ROYO MACHINERY**



Main technical parameter				
Model	MHC-1060/1080/1060A/1080A	MHC-1060AR/1080AR	MHC-1060CE/1080CE/1060ACE/1080ACE	MHC-1060AT/1080AT
Max. sheet size	1060 × 760mm/1080 × 780mm	1060 × 760mm/1080 × 780mm	1060 × 760mm/1080 × 780mm	1060 × 760mm/1080 × 780mm
Min. sheet size	400 × 350mm	400 × 350mm	400 × 350mm	400 × 350mm
Max. die cutting size	1050 × 750mm/1070 × 770mm	1050 × 750mm/1070 × 770mm	1050 × 750mm/1070 × 770mm	1050 × 750mm/1070 × 770mm
Max. hot stamping size	/	/	/	1050 × 750mm/1070 × 770mm
Gripper margin	9-17mm	9-17mm	9-17mm	9-17mm
Inner chase size	1120 × 786mm	1120 × 786mm	1120 × 786mm	1120 × 786mm
Stock range	90-2000g/m <sup>2</sup> paper	90-2000g/m <sup>2</sup> paper	90-2000g/m <sup>2</sup> paper	90-2000g/m <sup>2</sup> paper
	0.1-2mm paper	0.1-2mm paper	0.1-2mm paper	0.1-2mm paper
	≤4mm corrugated	≤4mm corrugated	≤4mm corrugated	≤4mm corrugated
Die cutting accuracy	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm	≤ ± 0.1mm
Max. die cutting force	300T/300T/600T/600T	600T	300T/300T/600T/600T	600T
Max. die cutting speed	7500s/h Die cutting	7500s/h Die cutting	7500s/h Die cutting	7500s/h Die cutting
Max. feeder pile height	1600mm	1600mm	1600mm	1600mm
	( wooden pallet included)	( wooden pallet included)	( wooden pallet included)	( wooden pallet included)
Max. delivery pile height	1400mm	1400mm	1400mm	1400mm
	( wooden pallet included)	( wooden pallet included)	( wooden pallet included)	( wooden pallet included)
Max. gold foil diameter	/	/	/	250mm( vertical)
	/	/	/	200mm( horizontal)
Electric-heated system	/	20 , 40-180℃	/	20 , 40-180℃
	/	20 temperature ranges	/	20 temperature ranges
	/	40-180℃ is adjustable	/	40-180℃ is adjustable
Foil width	/	/	/	20-1020mm
Main motor wattage	11kw	11kw	11kw	11kw
Overall dimension	6300 × 4200 × 2350mm	6300 × 4200 × 2350mm	7300 × 4200 × 2350mm	7300 × 4200 × 2350mm
	( L: paper prepared track included	W: platform included)		
Net weight approx	16T/17T/18.5T/19T	18.5T/19T	17T/18T/19.5T/20T	20T/20.5T
Full Load wattage	16.9kw	35kw	16.9kw	52kw
Air requirement	0.6 ~ 0.7Mpa, ≥0.37m <sup>3</sup> /min	0.6 ~ 0.7Mpa, ≥0.37m <sup>3</sup> /min	0.6 ~ 0.7Mpa, ≥0.37m <sup>3</sup> /min	0.6 ~ 0.7Mpa, ≥0.37m <sup>3</sup> /min

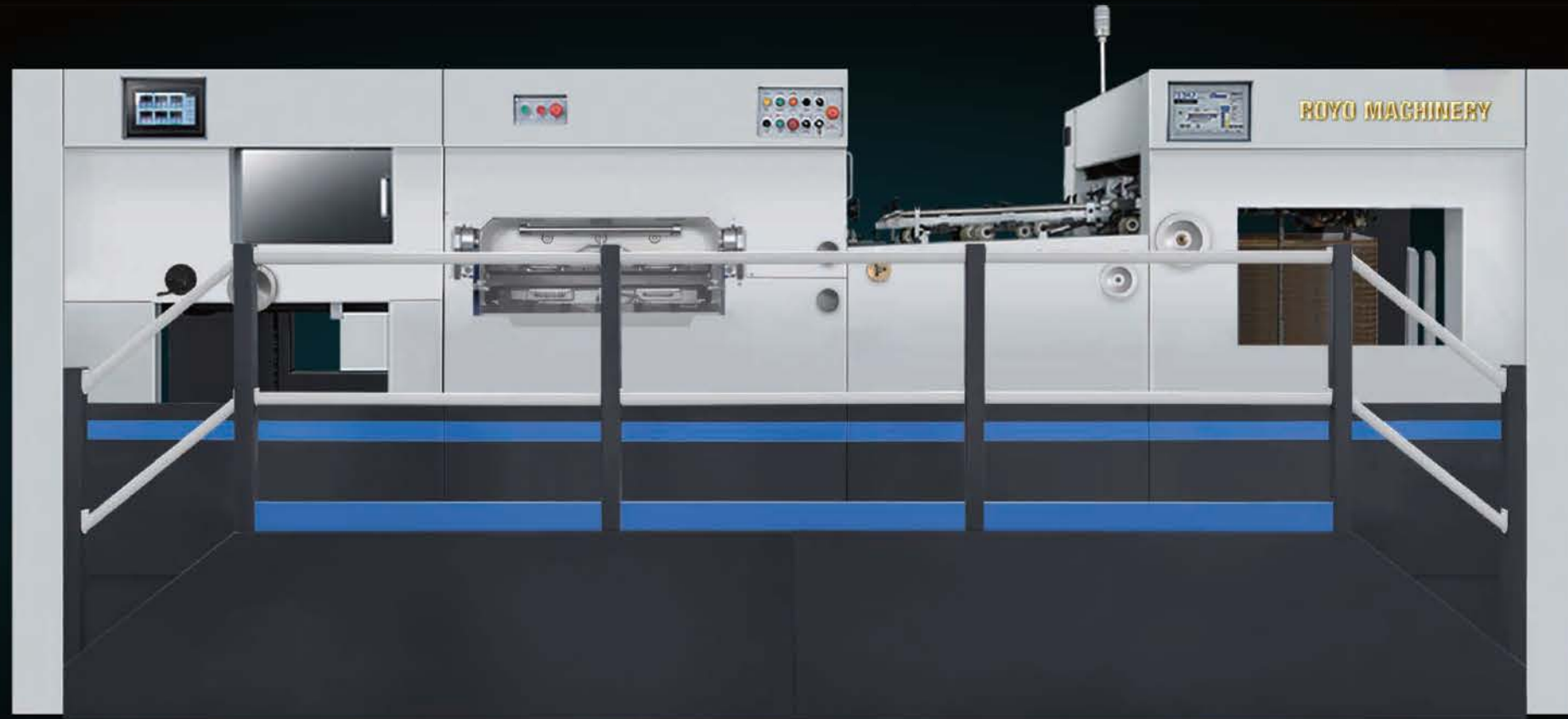


RMHC

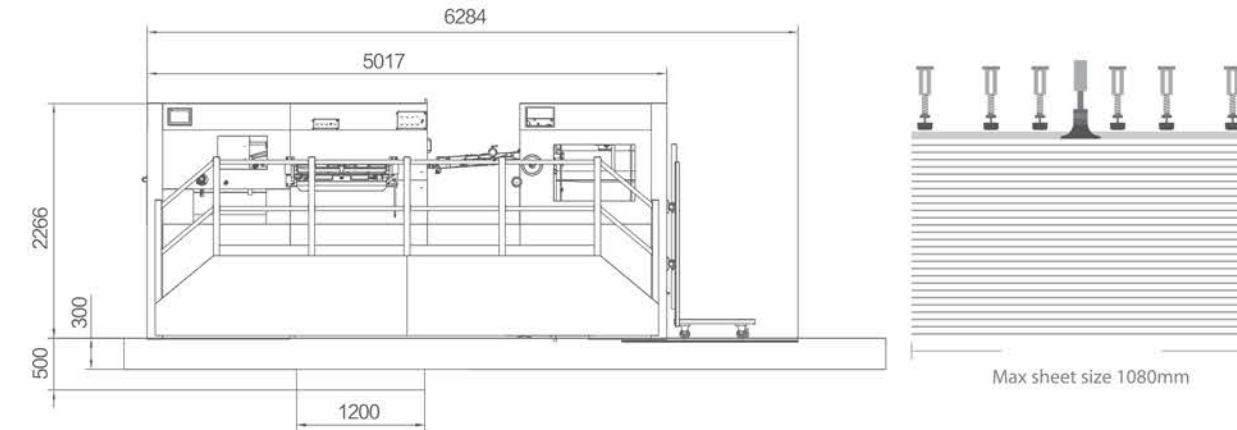
1060AR  
1080AR

Automatic Die Cutting Machine(Heavy duty, Heating system)

ROYO MACHINERY



The MHC-1060/1080AR Automatic Die Cutting Machine with Heating System is key equipment for printing finishing such as die cut, crease and embossing etc. Unique drive gears are adopted such as high-precision indexing mechanism, pneumatic closed up, pneumatic clutch, overload protection, automatic compression relief etc, to ensure stable and high speed running of the machine. This machine is equipped with practical and reliable mechanism such as pre-stack device, secondary delivery mechanisms, manual sampling, etc, which ensure the excellent performance of the machine. Electrical components and driving elements of internationally known brands to ensure die cutting precision and reliability of running. Also man-machine interface is able to monitor machine running status, troubleshooting and indicating relevant help information which fully actualized man-machine communication.







RMHC

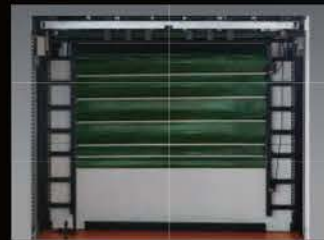
1100FC  
1300FC  
1500FC  
1650FC  
1900FC

1100EFC  
1300EFC  
1500EFC  
1650EFC  
1900EFC

Automatic Die Cutting & Creasing Machine  
with Stripping (Lead Edge Feeder)

Automatic Die Cutting & Creasing Machine  
with Stripping (Down Feeder)

ROYO MACHINERY



Auto Non-stop Collecting Device  
(Optional)





RMHC 1100E  
1300E  
1500E  
1650E  
1900E

## Automatic Die Cutting Machine (Tiptronic)

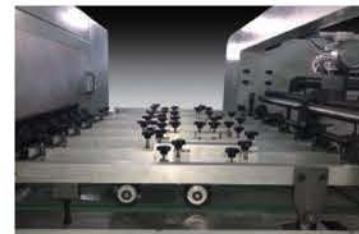


Main technical parameter					
Model	MHC-1100EC/1100E	MHC-1300EC/1300E	MHC-1500EC/1500E	MHC-1650EC/1650E	MHC-1900EC/1900E
Max. paper size	1100 × 790mm	1300 × 940mm	1500 × 1100mm	1650 × 1200mm	1900 × 1400mm
Min. paper size	400 × 350mm	470 × 420mm	470 × 420mm	550 × 500mm	650 × 550mm
Max. die-cutting size	1070 × 770mm	1280 × 920mm	1480 × 1080mm	1620 × 1180mm	1870 × 1380mm
Max. working speed	7000s/h	5000s/h	5000s/h	4000s/h	3500s/h
Rated power	11kw	13.5kw	13.5kw	19.7kw	22kw
Max. working pressure	300T	300T	300T	300T	300T
Machine weight	17T/16T	19T/18T	21T/20T	23T/22T	29T/28T
Overall dimension(EC)	7700 × 4250 × 2370mm	10125 × 4400 × 2300mm	10650 × 4600 × 2300mm	11160 × 5000 × 2500mm	12360 × 5880 × 2530mm
(E)	6550 × 4250 × 2370mm	8900 × 4400 × 2300mm	9250 × 4600 × 2300mm	9650 × 5000 × 2500mm	10740 × 5880 × 2530mm
	( L: paper prepared track included                      W: platform included)				
Scope of application	white board    corrugated paper	Cardboard ≥ 250g	Cardboard ≥ 350g		

ROYO MACHINERY



Feeder unit



Servo motor conveyor positioning device



Stripping unit



Germany vacuum pump



Electric appliance unit



The eighth generation of MHC Series Automatic Die Cutting Machine based on the seven generation of Automatic Die Cutting Machine, is equipped with servo motor control system, thus makes sure thick and thin paper feeding function effectively, paper feeding system can be divided into three types: 1. single piece of paper feeding function (for 4 - 8mm corrugated paper), 2. two pieces of overlapping paper feeding function (for 2 - 4mm corrugated paper), 3. multiple pieces of overlapping paper feeding function (for to 250g - 2mm paper). This machine including both manual paper feeding and automatic feeder paper feeding function. On condition of flat corrugated paper, automatic feeder paper feeding is accepted with raising efficiency and reducing workforce. Manual paper feeding comes in handy on condition of uneven corrugated paper. This machine maintains multi-operational function, and its development is combined with advantages of similar products in domestic and overseas, is special equipment for packing products such as cartons and paper boxes. Gripper bars with high intensity are applicable to all kinds of cardboard, paperboard and corrugated paper. Frontal, back and side registration mechanism ensures great precision of die cutting. Other parts are adopted such as intermittent mechanism with high precision, pneumatic clutch and pneumatic closed up mechanism, programmable controller and man-machine interface. The interface can display various digital information of machine such as working speed, amount of paper processed, total running time, etc. It is easy to eliminate troubles according to the display of trouble shooting. Transducer is adopted to control the main motor in achieving step-less speed variation.

This machine is equipped with sensors and safety device to ensure normal operation of machine and safety of workers.





RMHC

1100BLC  
1300BLC  
1500BLC  
1650BLC  
1900BLC

Semi-automatic Die Cutting Machine  
With Stripping&Feeding Table

ROYO MACHINERY







**RMHC** 1100BL  
1300BL  
1500BL  
1650BL  
1900BL

Semi-automatic Die Cutting Machine  
With Feeding Table



Two Times  
Position Function



MHC series Semi-automatic Die Cutting Machine is equipped with front conveyor delivery mechanism. The two groups of pressing wheels and two times positioning function will make the products more flat, and improve the accuracy and speed. The machine's development is combined with advantages of similar products in domestic and over seas, is special equipment for packing products such as cartons and paper boxes. Gripper bars with high intensity are applicable to all kinds of cardboard, paperboard and corrugated paper. Frontal, back and side registration mechanism ensures great precision of die-cutting. Other parts are adopted such as intermittent mechanism with high precision, air clutch, pneumatic locking mechanism, programmable controller and man-machine interface. The interface can display various digital information of machine such as working speed, amount of paper processed, total running time, etc. It is easy to eliminate troubles according to the display of trouble shooting. Transducer is adopted to control the main motor in achieving step-less speed variation.

**ROYO MACHINERY**



Transportation Unit



Stripping Unit



High Precision Chain



Electric Appliance Unit



Computer Control And Monitoring Section:  
Human Interface, Visualization Operations



Siemens Main Motor



Concentrate Lubrication



Worm Gear: Itadopts bronze alloy from taiwan It Has  
The feaure high precision, low noise and low abrasion.

Main technical parameter					
Model	MHC-1100BL/1100BLC	MHC-1300BL/1300BLC	MHC-1500BL/1500BLC	MHC-1650BL/1650BLC	MHC-1900BL/1900BLC
Max. paper size	1100 × 790mm	1300 × 940mm	1500 × 1100mm	1650 × 1200mm	1900 × 1400mm
Min. paper size	400 × 350mm	470 × 420mm	470 × 420mm	550 × 500mm	650 × 550mm
Max. die-cutting size	1070 × 770mm	1280 × 920mm	1480 × 1080mm	1620 × 1180mm	1870 × 1380mm
Max. working speed	7000s/h	5000s/h	5000s/h	4000s/h	3500s/h
Rated power	11kw	13.5kw	13.5kw	19.7kw	22kw
Max. working pressure	300T	300T	300T	300T	300T
Machine weight	14T/15T	16T/17T	18T/19T	21T/22T	27T/28T
Overall dimension(BL)	7600 × 4200 × 2350mm	8100 × 4400 × 2300mm	8420 × 4600 × 2300mm	8620 × 5000 × 2500mm	10400 × 5880 × 2530mm
(BLC)	8600 × 4200 × 2350mm	9300 × 4400 × 2300mm	9840 × 4600 × 2300mm	10100 × 5000 × 2500mm	12000 × 5880 × 2530mm
	( L: paper prepared track included		W: platform included)		
Scope of application	E, B, C, A and AB flute corrugated paper(1-8.5mm thickness)				





RMHC

1100B  
1300B  
1500B  
1650B  
1900B

Semi-Automatic Die Cutting & Creasing Machine



The second generation of MHC series Semi-automatic Die Cutting The Machine’ s development is combined with advantages of similar products in domestic and over seas, is special equipment for packing products such as cartons and paper boxes. Gripper bars with high intensity are applicable to all kinds of cardboard, paperboard and corrugated paper. Frontal, back and side registration mechanism ensures great precision of die-cutting. Other parts are adopted such as intermittent mechanism with high precision, air clutch, pneumatic locking mechanism, programmable controller and man-machine interface. The interface can display various digital information of machine such as working speed, amount of paper processed, total running time, etc. It is easy to eliminate troubles according to the display of trouble shooting. Transducer is adopted to control the main motor in achieving step-less speed variation.



Main technical parameter					
Model	MHC-1100B/1100BC	MHC-1300B/1300BC	MHC-1500B/1500BC	MHC-1650B/1650BC	MHC-1900B/1900BC
Max. paper size	1100 × 790mm	1300 × 940mm	1500 × 1100mm	1650 × 1200mm	1900 × 1400mm
Min. paper size	400 × 350mm	470 × 420mm	470 × 420mm	550 × 500mm	650 × 550mm
Max. die-cutting size	1070 × 770mm	1280 × 920mm	1480 × 1080mm	1620 × 1180mm	1870 × 1380mm
Max. working speed	7000s/h	5000s/h	5000s/h	4000s/h	3500s/h
Rated power	11kw	13.5kw	13.5kw	19.7kw	22kw
Max. working pressure	300T	300T	300T	300T	300T
Machine weight	13T/14T	15T/16T	17T/18T	20T/21T	26T/27T
Overall dimension(B)	6300 × 4200 × 2350mm	6600 × 4400 × 2300mm	6950 × 4600 × 2300mm	7150 × 5000 × 2500mm	8780 × 5880 × 2530mm
(BC)	7270 × 4200 × 2350mm	7800 × 4400 × 2300mm	8450 × 4600 × 2300mm	8700 × 5000 × 2500mm	10540 × 5880 × 2530mm
	( L: paper prepared track included		W: platform included)		
Scope of application	E, B, C, A and AB flute corrugated paper(1-8.5mm thickness)				