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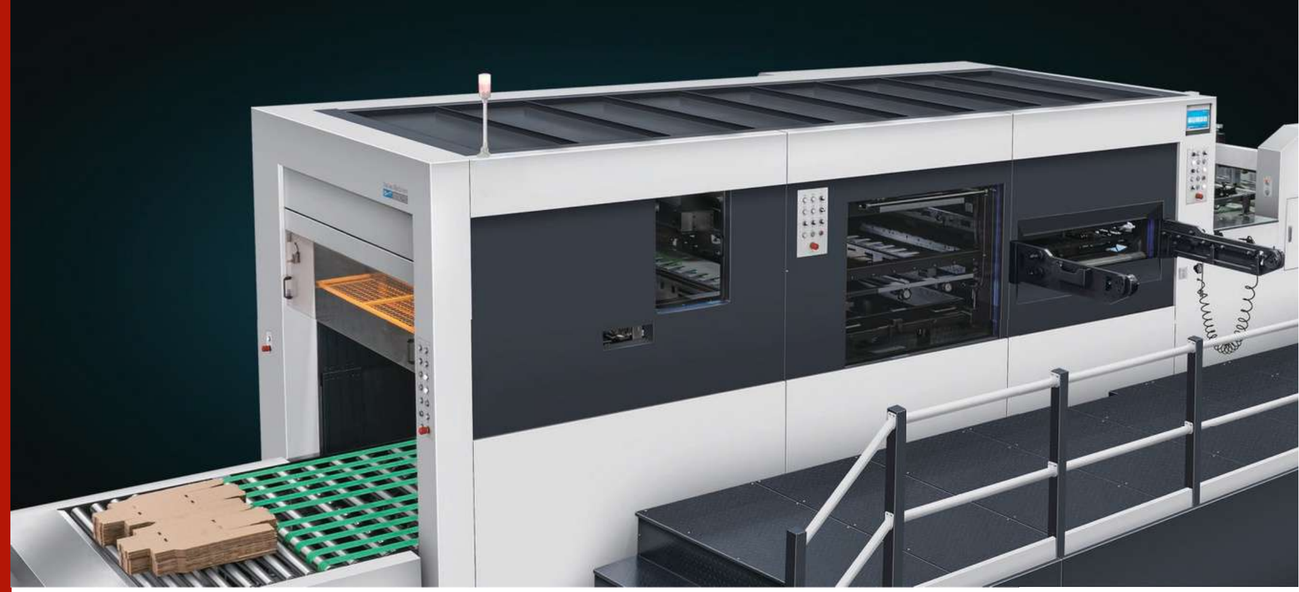
Royo Machinery USA, LLC
PO Box 565931
Miami, FL 33256
Tel: +1 (786) 713-0996

Equipment Sales:
sales@royomachinery.com
Parts Sales:
parts@royomachinery.com

+1 (786) 402-8152 WhatsApp

RRD1970 WeChat

www.royomachinery.com



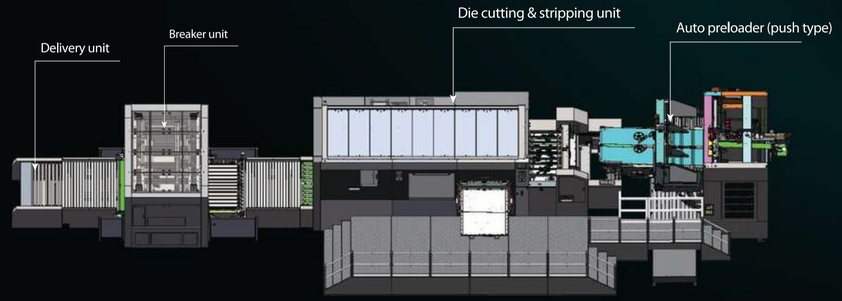
BHT MHK MHC Series Die Cutting Machine BHT MHK MHC

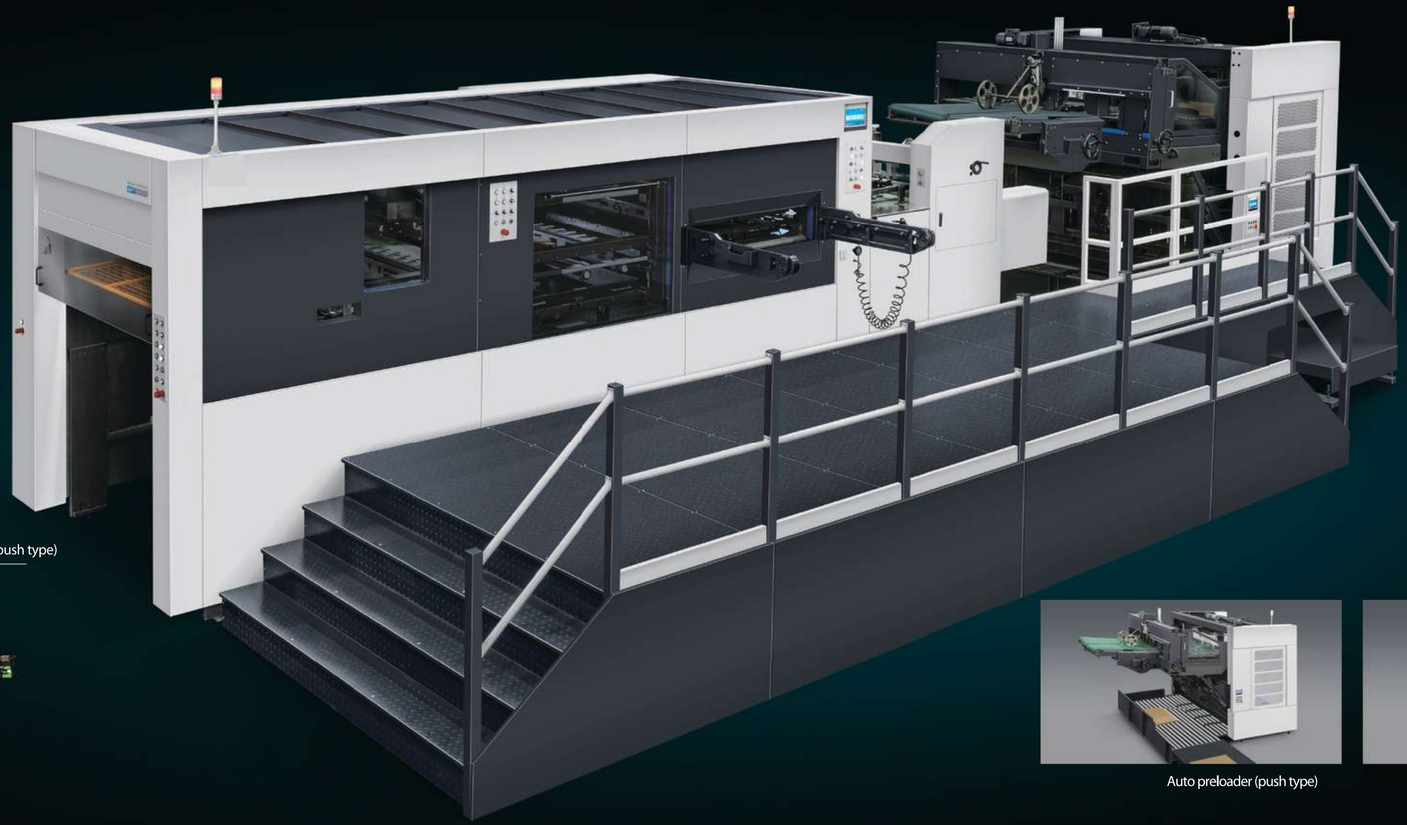
ROYO MACHINERY

BHT 1650FC | 1650EFC | 1900FC | 1900EFC | 2100FC | 2100EFC

Automatic Die Cutting Machine
Linkage Production Line

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.





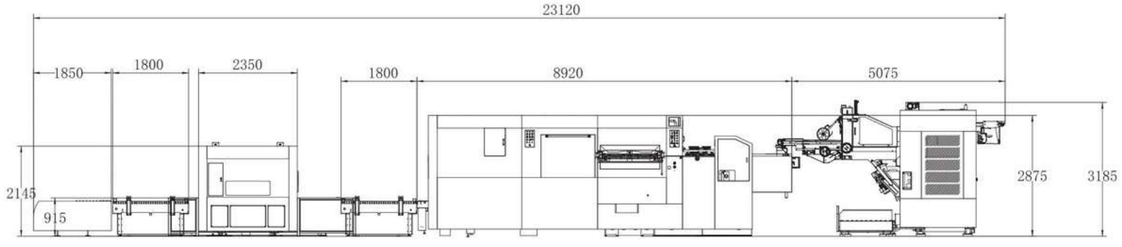
Details

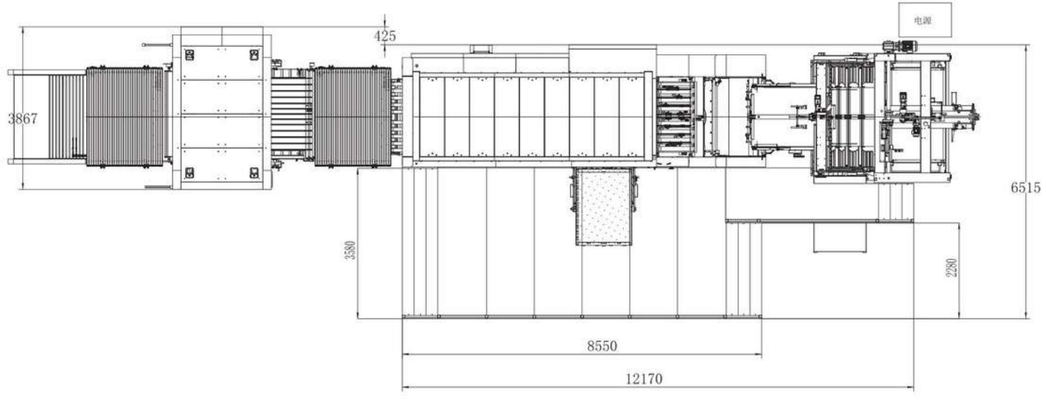
Auto preloader (push type)

Paper breaker

ROYO MACHINERY

DRAWING





SPECIFICATIONS

Model	BHT-1650FC/1650EFC	BHT-1900FC/1900EFC	BHT-2100FC/2100EFC
Sheel size	Max. 1650 × 1200mm Min. 650 × 450mm	Max. 1900 × 1400mm Min. 650 × 450mm	Max. 2100 × 1600mm Min. 650 × 450mm
Corrugated board. Up to	1-9mm	1-9mm	1-9mm
Batch height	Max. 1800mm	Max. 1800mm	Max. 1800mm
Pile weight	1000kg	1200kg	1400kg
Machine weight	4000kg	4500kg	5000kg

MAIN TECHNICAL PARAMETERS

Model	BHT-1650FC/1650EFC	BHT-1900FC/1900EFC	BHT-2100FC/2100EFC
Max. sheet size	1650 × 1200mm	1900 × 1400mm	2100 × 1600mm
Min. sheet size	650 × 500mm	650 × 500mm	750 × 650mm
Max. die cutting size	1630 × 1180mm	1880 × 1380mm	2080 × 1580mm
Inner chase size	1670 × 1230mm	1920 × 1430mm	2120 × 1630mm
Stock range	≤9mm瓦楞纸，F、E、B、C、A和AB瓦楞纸		
Min. gripper waste	10-18mm	10-18mm	10-18mm
Min. gripper margin	6-12mm	6-12mm	6-12mm
Cutting rule height	23.8mm	23.8mm	23.8mm
Max. die cutting speed	6000s/h	5000s/h	4000s/h
Max. die cutting pressure	400ton	450ton	450ton
Total power required	38kw	40kw	47kw
Electrical power	380V, 50HZ, 3PH	380V, 50HZ, 3PH	380V, 50HZ, 3PH
Mobile lower platen adjusting range	± 1.5mm	± 1.5mm	± 1.5mm
Machine dimension	11638 × 5254 × 2776mm	13377 × 6360 × 2902mm (FC)	14370 × 6360 × 2970mm (FC)
		13252 × 6360 × 2902mm (EFC)	14250 × 6360 × 2970mm (EFC)
Machine weight	40T/41T	46T/47T	51T/52T

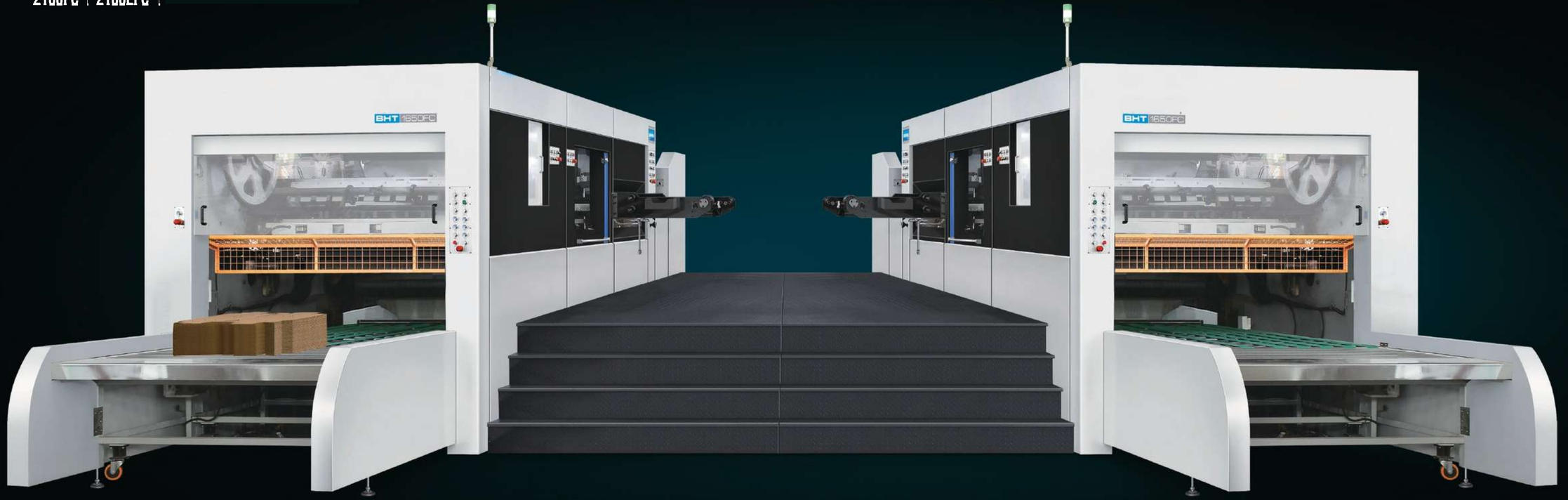
BREAKERS

Model	BHT-1650FC/1650EFC	BHT-1900FC/1900EFC	BHT-2100FC/2100EFC
Sheel size	Max. 1650mm, Min. 650mm	Max. 1900mm, Min. 650mm	Max. 2100mm, Min. 650mm
Min. Batch dimension in machine direction	200mm	200mm	200mm
Max. Batch thickness	300mm	300mm	300mm
Min. Batch thickness	20mm	20mm	20mm
Batch passage height from the floor	900mm (adjustable)	900mm (adjustable)	900mm (adjustable)
Machine weight	4000kg	4500kg	5000kg

BHT 1650FC | 1650EFC
1900FC | 1900EFC
2100FC | 2100EFC

Mirror Machines Dual Diecutter
Working Station

ROYO MACHINERY



THE ADVANTAGE OF MIRROR MACHINES DUAL DIECUT TER WORKING STATION

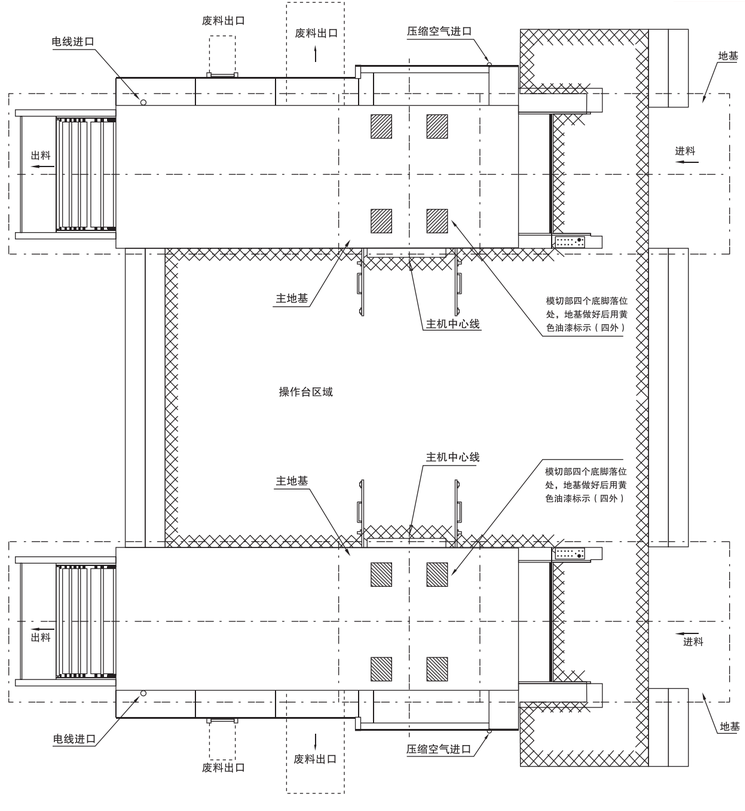
- Two flat die cutting machine operation relatively, and make sure the feeding and collecting is homodromous. Two die-cutting machine Shared the same foot pedals, knife version, stripping, waste clearance version, and all the plate and frame, and even the same plate andframe the function of the switchboard.
- 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 discoversthat 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	197.3m^2	148.5m^2	48.8m^2
Without Chase Loade	172.2m^2	142.8m^2	27.4m^2

ROYO MACHINERY

Drawing



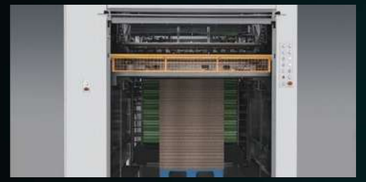
BHT 1650FC | 1650EFC
1900FC | 1900EFC
2100FC | 2100EFC

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

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

PAPER COUNTING & COLLECTING SECTION (OPTIONAL)

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.



AUTO NON-STOP COLLECTING DEVICE (OPTIONAL)

Main collecting device and Auto non-stop collecting device switch automatically without any operation, which make the machine more efficient.

ROYO MACHINERY

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.

DOWN FEEDER

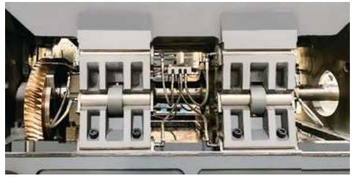
Non-stop down suck feeder.
Pneumatic board for sheet trimming.
Down suck feeding to protect the printing.

THREE LAYER 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.

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.



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.

AUTO NON-STOP COLLECTING DEVICE (OPTIONAL)

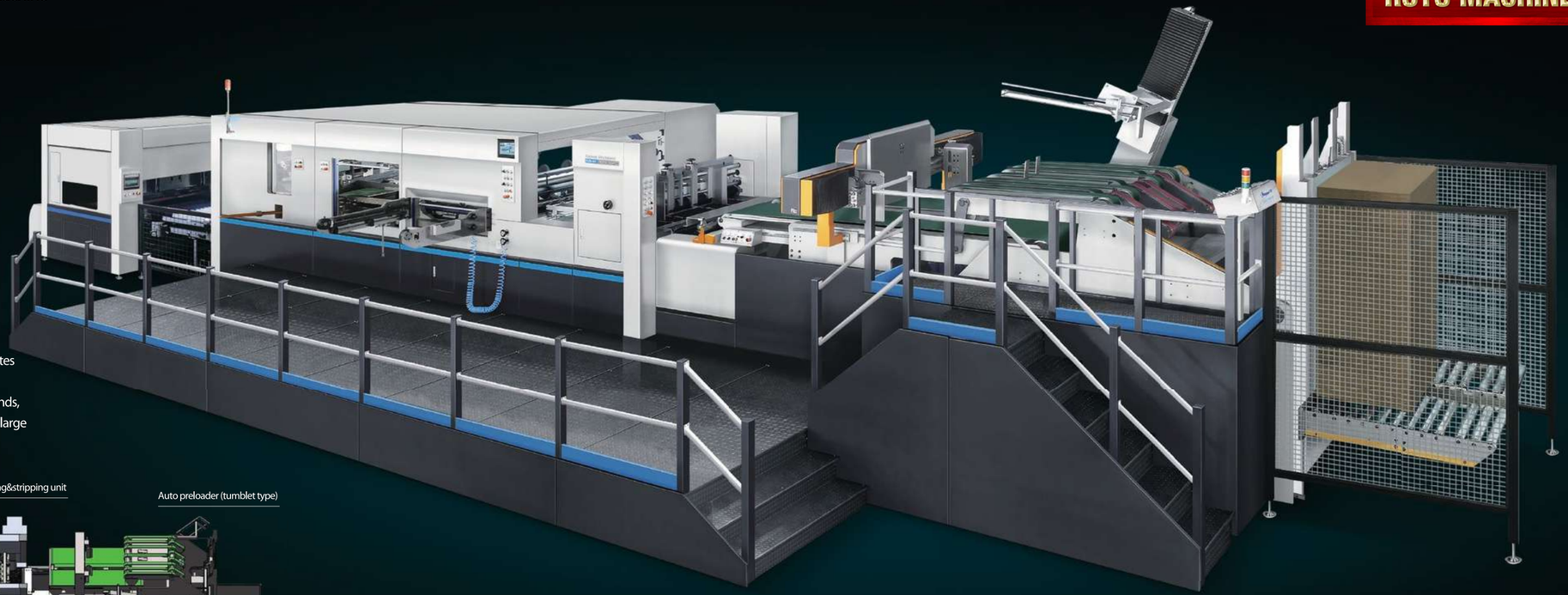
Main collecting device and Auto non-stop collecting device switch automatically without any operation, which make the machine more efficient.

Model	BHT-1650FC/1650EFC	BHT-1900FC/1900EFC	BHT-2100FC/2100EFC
Max. Sheet Size	1650 × 1200mm	1900 × 1400mm	2100 × 1600mm
Min. Sheet Size	650 × 500mm	650 × 500mm	750 × 650mm
Max. Die Cutting Size	1630 × 1180mm	1880 × 1380mm	2080 × 1580mm
Minimum Width of Double Cuts	10-18mm	10-18mm	10-18mm
Gripper Margin	6-12mm	6-12mm	6-12mm
Cutting Rule Height	23.8mm	23.8mm	23.8mm
Inner Chase Size	1670 × 1230mm	1920 × 1430mm	2120 × 1630mm
Stock Range	≤9mm F、E、B、C、		
Max. Die Cutting Speed	6000s/h	5000s/h	4000s/h
Max. Die Cutting Force	400T	450T	450T
Mobile Lower Platen Adjusting Range	±1.5mm	±1.5mm	±1.5mm
Max. Delivery Pile Height	1500mm	1500mm	1500mm
Overall Dimension (L×W×H)	10187 × 5254 × 2776mm	11488 × 6360 × 2902mm (FC)	12480 × 6360 × 2970mm (FC)
	W:platform included)	11363 × 6360 × 2902mm (EFC)	12360 × 6360 × 2970mm (EFC)
		W:platform included)	W:platform included)
Mirror Machine Overall Dimension (L×W×H)	10286 × 11440 × 2776mm	11286 × 12440 × 2970mm	12286 × 13440 × 2970mm
	W:platform included)	W:platform included)	W:platform included)
Max. Delivery Pile Height			
Overall Dimension (L×W×H)	11638 × 5254 × 2776mm	13377 × 6360 × 2902mm (FC)	14370 × 6360 × 2970mm (FC)
	W:platform included)	13252 × 6360 × 2902mm (EFC)	14250 × 6360 × 2970mm (EFC)
		W:platform included)	W:platform included)
Mirror Machine Overall Dimension (L×W×H)	11737 × 11440 × 2776mm	12737 × 12440 × 2970mm	13737 × 13440 × 2970mm
	W:platform included)	W:platform included)	W:platform included)
Net Weight Approx	40/41T	46/47T	51/52T
Main Motor Wattage	18.5kw	18.5kw	22kw
Full Load Wattage	38kw	40kw	47kw
Air Requirement	压力 Air pressure: 0.6~0.7Mpa， Flow rate: ≥1m³/min		

MHK **1650SFC** | **1650SEFC**
1500FC | **1500EFC**
1300FC | **1300EFC**

Automatic Die Cutting Machine
Linkage Production Line

ROYO MACHINERY



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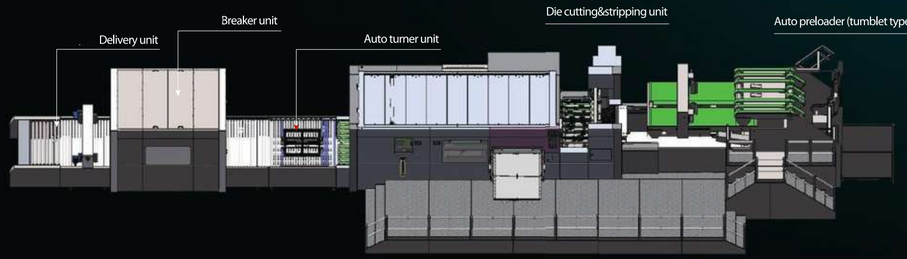
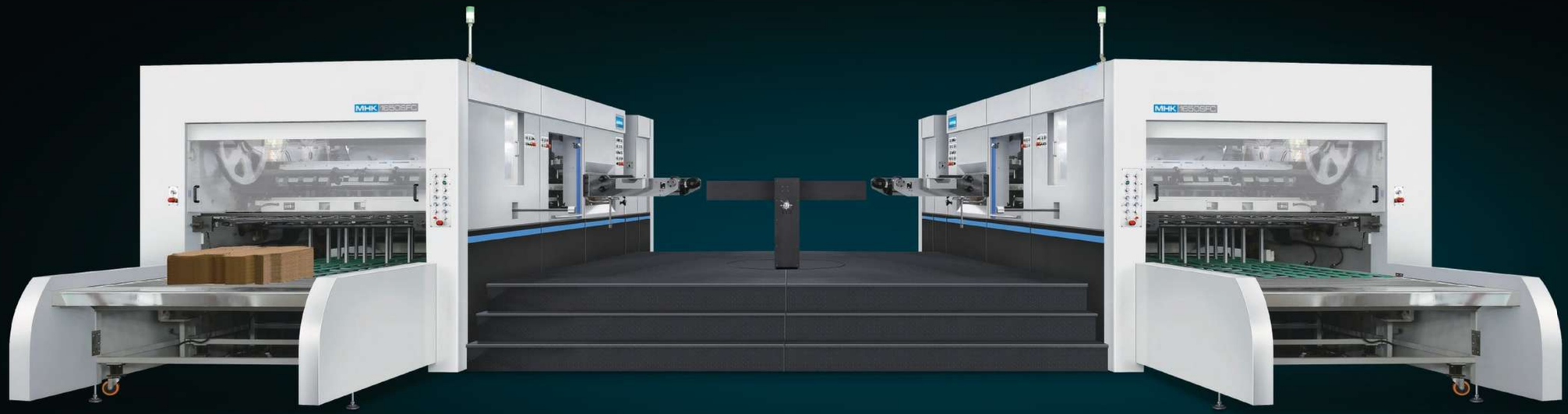


MHK 1650SFC | 1650SEFC
1500FC | 1500EFC
1300FC | 1300EFC

Mirror Machines Dual Diecutter
Working Station

ROYO MACHINERY



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MHK **1650SFC** | **1650SEFC**
1500FC | **1500EFC**
1300FC | **1300EFC**

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

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

FC series lead edge feeder

EFC series down feeder

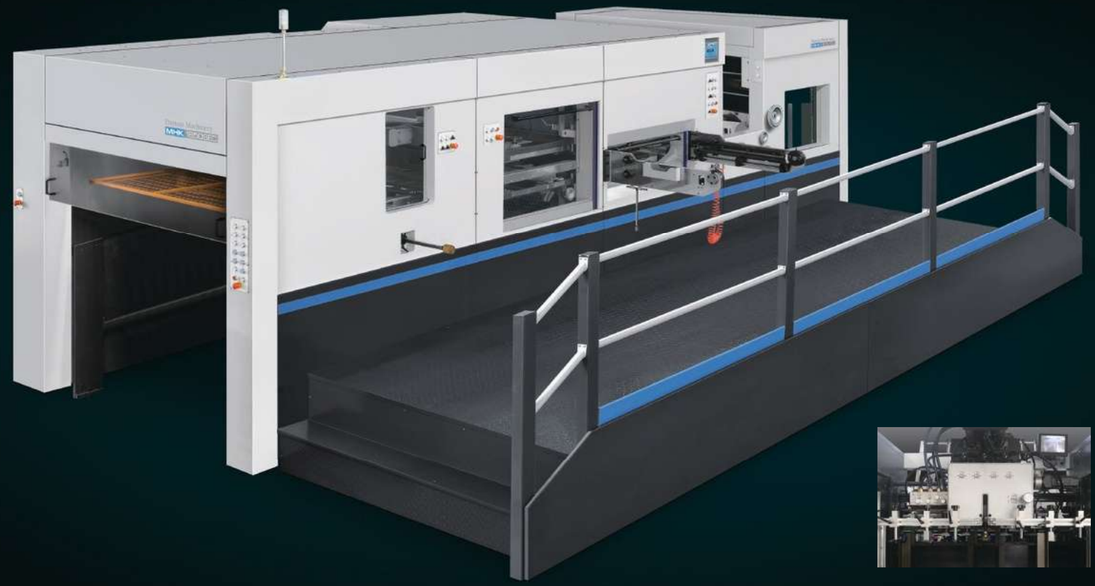
Paper counting & collecting section (optional)

Auto non-stop collecting device (optional)

ROYO MACHINERY

MHK 1650SEC 1500EC 1300EC

Automatic Die Cutting Machine with Stripping (Lead Edge Feeder)



EC series feeder

ROYO MACHINERY

SPECIFICATIONS

Model	MHK–1650SFC/1650SEFC	MHK–1500FC/1500EFC	MHK–1300FC/1300EFC
Sheel size	Max. 1650 × 1200mm Min. 650 × 500mm	Max. 1500 × 1100mm Min. 480 × 480mm	Max. 1290 × 940mm Min. 480 × 480mm
Corrugated board. Up to	1–9mm	1–9mm	1–9mm
Batch height	Max. 1800mm	Max. 1800mm	Max. 1800mm
Pile weight	1000kg	900kg	800kg
Machine weight	4000kg	3500kg	3200kg

MAIN TECHNICAL PARAMETERS

Model	MHK–1650SFC/1650SEFC/1650SEC	MHK–1500FC/1500EFC/1500EC	MHK–1300FC/1300EFC/1300EC
Max. Sheet Size	1650 × 1200mm	1500 × 1100mm	1290 × 940mm
Min. Sheet Size	650 × 500mm(SFC/SEFC)	480 × 480mm	480 × 480mm
	550 × 500mm(SEC)		
Max. Die Cutting Size	1620 × 1180mm	1480 × 1080mm	1280 × 920mm
Min. Gripper Waste	10–18mm	10–18mm	10–18mm
Gripper Margin	6–12mm	6–12mm	6–12mm
Cutting Rule Height	23.8mm	23.8mm	23.8mm
Inner Chase Size	1657 × 1212mm	1510 × 1120mm	1310 × 950mm
Stock Range	≤8.5mm瓦楞纸，E、B、C、A 和 AB 瓦楞纸		
Max. Die Cutting Speed	4500s/h	6000s/h	6000s/h
Max. Die Cutting Force	400T	400T	400T
Mobile Lower Platen Adjusting Range	±1.5mm	±1.5mm	±1.5mm
Max. Delivery Pile Height	1600mm (含木托板)	1600mm (含木托板)	1600mm (含木托板)
Overall Dimension (L×W×H)	9930 × 5720 × 3089mm(SFC)	10490 × 5020 × 2800mm(FC)	9880 × 4820 × 2800mm(FC)
	9930 × 5720 × 2900mm(SEFC)	10490 × 5020 × 2800mm(EFC)	9680 × 4820 × 2800mm(EFC)
	11703 × 5240 × 2800mm(SEC)	11666 × 5020 × 2800mm(EC)	10910 × 4820 × 2800mm(EC)
	(宽含脚踏板 W:platform included)		
Max. Delivery Pile Height	计叠式收纸(选配)	计叠式收纸(选配)	计叠式收纸(选配)
Overall Dimension (L×W×H)	11665 × 5720 × 2477mm(SFC)	11782 × 5020 × 2400mm(FC)	10630 × 4820 × 2400mm(FC)
	11306 × 5720 × 2500mm(SEFC)	11473 × 5020 × 2400mm(EFC)	10630 × 4820 × 2400mm(EFC)
	12221 × 5240 × 2397mm(SEC)	13400 × 5020 × 2400mm(EC)	12140 × 4820 × 2400mm(EC)
	(宽含脚踏板 W:platform included)		
Net Weight Approx	28T/29T/26T	25T/26T/23T	22T/23T/20T
Main Motor Wattage	15kw	15kw	11kw
Full Load Wattage	35kw/35kw/33kw	32kw/30kw/30kw	27kw/25kw/25kw
Air Requirement	压力 Air pressure: 0.6~0.7Mpa，流量 Flow rate: ≥1m³/min(SFC/SEFC)	压力 Air pressure: 0.6~0.7Mpa，流量 Flow rate: ≥0.37m³/min	
	流量 Flow rate: ≥0.37m³/min(SEC)		

BREAKERS

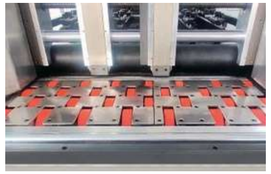
Model	MHK–1650SFC/1650SEFC	MHK–1500FC/1500EFC	MHK–1300FC/1300EFC
Sheel size	Max. 1650mm, Min. 650mm	Max. 1500mm, Min. 550mm	Max. 1300mm, Min. 550mm
Min. Batch dimension in machine direction	200mm	200mm	200mm
Max. Batch thickness	300mm	300mm	300mm
Min. Batch thickness	20mm	20mm	20mm
Batch passage height from the floor	900mm (adjustable)	900mm (adjustable)	900mm (adjustable)
Machine weight	4000kg	3500kg	3000kg

MHC **1100FC** **1300EFC** Automatic Die Cutting & Creasing Machine with Stripping (Lead Edge Feeder)
1300FC **1500EFC**
1500FC **1650EFC** Automatic Die Cutting & Creasing Machine with Stripping (Down Feeder)
1650FC

ROYO MACHINERY

MHC 1100F | 1300EF — Automatic Die Cutting & Creasing Machine (Lead Edge Feeder)
1300F | 1500EF
1500F | 1650EF — Automatic Die Cutting Machine (Down Feeder)
1650F | 1900EF
1900F
2100F

ROYO MACHINERY



F/FC SERIES LEAD EDGE FEEDER

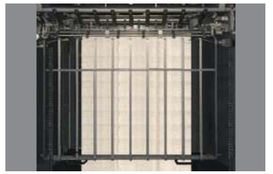
Top gear and precise Lead Edge Feeder design, allowed consistent feeding with various quality corrugated board.
New technology polyurethane wheel surface with grid lifter and air cushion ensure smooth feeding and accurate alignment even warped board.
Fine vacuum suction adjustment through inverter adapts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

EF/EFC SERIES DOWN FEEDER

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

AUTO NON-STOP COLLECTING DEVICE

Main collecting device and Auto non-stop collecting device switch automatically without any operation, which make the machine more efficient.



PAPER COLLECTING UNIT (1100FC STANDARD CONFIGURATION)

Main collecting device and Auto non-stop collecting device switch manually, which make the machine more efficient.

MAIN TECHNICAL PARAMETER

Model	MHC-1100F/1100FC	MHC-1300F/1300FC	MHC-1500F/1500FC	MHC-1650F/1650FC	MHC-1900F	MHC-2100F
		MHC-1300EF/1300EFC	MHC-1500EF/1500EFC	MHC-1650EF/1650EFC	MHC-1900EF	
Max. sheet size	1100×790mm	1290×940mm	1500×1100mm	1650×1200mm	1900×1400mm	2100×1600mm
Min. sheet size	470×450mm	470×470mm	470×470mm	650×500mm	650×550mm	750×650mm
Max. die cutting size	1070×770mm	1280×920mm	1480×1080mm	1620×1180mm	1870×1380mm	2070×1580mm
Max. working speed	7000s/h	5000s/h	5000s/h	4000s/h	3500s/h	3000s/h
Min. gripper waste	12mm	12mm	12mm	12mm	12mm	12mm
Min. gripper margin	6-12mm	6-12mm	6-12mm	6-12mm	6-12mm	6-12mm
Cutting rule height	23.8mm	23.8mm	23.8mm	23.8mm	23.8mm	23.8mm
Electrical power	380V, 50HZ, 3PH	380V, 50HZ, 3PH	380V, 50HZ, 3PH	380V, 50HZ, 3PH	380V, 50HZ, 3PH	380V, 50HZ, 3PH
Air pump displacement	空气压缩机排气量1.05m^3/min，12kg/cm^2--用户自备 1.05m^3/min，12kg/cm^2-- (prepared by user)					
Min. motor power	11kw	11kw	15kw	15kw	18.5kw	22kw
Max. working pressure	300T	300T	300T	300T	300T	300T
Machine weight	16T(F)/17T(FC)	18T(F/EF)/19T(FC/EFC)	20T(F/EF)/21T(FC/EFC)	22T(F/EF)/23T(FC/EFC)	30T(F/EF)	37T
Machine dimension	7000×4250×2350mm(F)	7400×4510×2300mm(F/EF)	8100×4710×2300mm(F/EF)	8230×5140×2500mm(F/EF)	8700×5880×2530mm(F/EF)	9800×6300×2530mm
	8000×4250×2350mm(FC)	8760×4510×2300mm(FC/EFC)	9140×4710×2300mm(FC/EFC)	9580×5140×2500mm(FC/EFC)		
Stock range	≤7mm瓦楞纸，E、B、C、A 和 AB 瓦楞纸	≤8.5mm瓦楞纸，E、B、C、A 和 AB 瓦楞纸				

MHC 1100EC / 1300EC / 1500EC / 1650EC

Automatic Die Cutting Machine with Stripping (Tiptronic)

全自动清废平压平模切机（手自一体）

MHC 1100E / 1300E / 1500E

Automatic Die Cutting Machine (Tiptronic)

全自动平压平模切机（手自一体）

ROYO MACHINERY

FEEDER UNIT

- 飞达采用伺服电机控制系统
- 液压式升降飞达装置（手自一体两用功能）
- Feeder adopt servo motor control system
- Hydraulic feeder lifting device (tiptronic function)

CONVEYING UNIT

采用伺服电机控制系统

- 单张送纸功能（适用于4–8mm瓦楞纸板）
- 双叠式送纸功能（适用于2–4mmE瓦楞纸板）
- 多叠式送纸功能（适用于250g–2mm纸张）

Adopt servo motor control system.

- Single sheet feeding (for 4-8mm corrugated board)
- Double sheets overlapped feeding (for 2-4mm E flute corrugated board)
- Multiple sheets overlapped feeding (for 250gsm-2mm cardpaper)

AUTO NON-STOP COLLECTING DEVICE (OPTIONAL)

无需任何操作，主、副收纸装置自动切换，大大提升工作效率

Main collecting device and Auto non-stop collecting device switch automatically without any operation, which make the machine more efficient

MAIN TECHNICAL PARAMETER

Model	MHC–1100E/1100EC	MHC–1300E/1300EC	MHC–1500E/1500EC	MHC–1650E/1650EC	MHC–1900E
Max. paper size	1100 × 790mm	1290 × 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
Main motor wattage	11kw	11kw	15kw	15kw	18.5kw
Max. working pressure	300T	300T	300T	300T	300T
Machine weight	16T/17T	18T/19T	20T/21T	22T/23T	28T
Overall dimension(E)	6550 × 4250 × 2350mm	8900 × 4400 × 2300mm	9250 × 4600 × 2300mm	9650 × 5000 × 2500mm	10740 × 5880 × 2530mm
(EC)	7700 × 4250 × 2350mm	10125 × 4400 × 2300mm	10650 × 4600 × 2300mm	11160 × 5000 × 2500mm	
	(长含预上纸轨道 L: paper prepared track included 宽含脚踏板 W: platform included)				
Scope of application	白板纸≥250g，瓦楞纸≤7mm	白板纸≥250g	白板纸≥350g		
	white board corrugated paper	Cardboard≥250g	Cardboard≥350g		
	≤7mm瓦楞纸，E、B、C、A 和 AB 瓦楞纸	≤8.5mm瓦楞纸，E、B、C、A 和 AB 瓦楞纸			

MHC 1100BLC / 1300BLC / 1500BLC / 1650BLC — Semi-automatic Die Cutting Machine with Stripping & Feeding Table

MHC 1100BL / 1300BL / 1500BL / 1650BL — Semi-automatic Die Cutting Machine with Feeding Table

MHC 1100BC / 1300BC / 1500BC / 1650BC — Semi-automatic Die Cutting Machine with Stripping

ROYO MACHINERY

MHC 1100B / 1300B / 1500B / 1650B / 1900B / 210□ — Semi-automatic Die Cutting & Creasing Machine