

## Daco DTD250

The Daco DTD 250 rotary die cutter is a cost effective, robust and easy to use machine for blank / plain label converting for the short to medium production runs. The DTD is available with either one or two rotary die cutting stations, rotary slitting and independent tension control for the unwind / rewind and has a production speed of 150m/minute. Many DTD250 rotary die cutters have been installed at clients who use them to produce plain labels for the growing thermal label transfer market.

The DTD's compact size and short web path keeps wastage to a minimum, the fully adjustable silicone covered nip drive roller helps to keep down time to a minimum as labels cannot attach themselves to the roller. The DTD250 has accurate tension control through the use of a pneumatic unwind brake which is infinitely variable and the rewind is controlled through a pneumatically operated variable rewind clutch.

### Standard Specification

- Web Width: 250mm (10")
- Maximum unwind diameter: 450mm (18")
  - Pneumatic unwind brake with independent regulator & gauge
  - 76mm (3") air mandrel
- Splicing table with web clamps
- 1 Rotary die station with matrix rewind



## Table Top Rotary Die Cutter

Cutter repeat lengths: 153-406mm (6" - 16") repeat

Gearing 1/8cp 20 degree pressure angle

- Precision ground 16mm (0.62") thick die plates.

- 76mm (3") mechanical mandrel for matrix rewind
- Maximum matrix rewind diameter: 400mm (15.75")
- Maximum rewind diameter 360mm (14")
  - Pneumatic rewind clutch with independent regulator & gauge
  - 76mm (3") air mandrel
- Labels in / labels out rewinding
- Maximum web speed: 150 Metres/min (492 feet/min) dependent on stock
- Count units: Labels / Metres with programmable slow down & stop
- Rotary scissor slitting unit
  - Removable interlocked cutter guard
  - Minimum slit width: 13mm (0.51")
  - Lateral knife adjustment: +/- 8mm (0.31")
- Fully adjustable silicone nip roller

### Optional Equipment:

- Lateral knife separation
- Removable anvil with support roller - enables back cutting and sprocket

punching

- Additional rotary die station for perforating (does not include stripping and matrix rewind)
- Die cut to register die station
- Electronic web guide with an ultrasonic sensor
- Full range of air mandrels from 25mm - 76mm (1" - 3")
- Razor slitting: minimum slit width 10mm (0.39") and lateral adjustment
- Dual product rewinds
- DBS250 back scorer (enables edge trim to be wound with the matrix)
- RotoMetrics Hydra Jacks - die pressure gauges
- Die adaptors: KDO (K2), Mark Andy, Edale, Allied Gear & Focus, others available subject to specification



DBS250 Back scorer



Dual rotary die stations

## Daco D250

The Daco D250 was developed following the success of the Daco DTD250 and is aimed at clients that have medium to long runs. The machine has a 700mm (27.5") diameter unwind with taper tension control reducing the need for frequent roll changes and operator input. The machine is available with either one or two rotary die stations and single or twin product rewinds. The machines compact size and short web path keeps wastage to a minimum, the silicone covered nip drive roller helps to keep down time to a minimum as labels cannot attach themselves to the roller. The Daco D250 has independent control of both the unwind and rewind tensions. Rotary slitting with on the run lateral adjustment is fitted as standard and a splice table makes web splices both simple and quick.

### Standard Specification

- Web width: 250mm (10")
- Maximum unwind diameter: 700mm (27.5")
  - 76mm (3") air mandrel
  - Merobel electronic brake
  - Taper tension control
- Splicing table with pneumatic web clamps



## Rotary Die Cutter

- 1 Rotary die station with matrix rewind
- Cutter repeat lengths: 153-406mm (6" - 16") repeat
- 76mm (3") mechanical mandrel for matrix rewind
- Maximum matrix rewind diameter: 400mm (15.75")
- Gearing 1/8cp 20 degree pressure angle
- Precision ground 16mm (0.62") thick die plates.
- Maximum product rewind diameter: 360mm (14")
- 76mm (3") air mandrel

Merobel electronic clutch

- Labels in / labels out rewinding
- Maximum web speed: 175 metres / minute (575 feet / minute) dependent on stock
- Count units: Labels / Metres with programmable slow down and stop
- Rotary scissor slitting unit
  - Removable interlocked cutter guard
  - Minimum slit width: 13mm (0.51")
  - Lateral knife adjustment: +/- 8mm (0.31")
- Adjustable spring loaded silicon nip

### Optional Equipment

- E-package - 457mm (18") rewind with taper tension control, feet counting, batch count, total count, touch screen control.
- Removable anvil with support roller - enables back cutting and sprocket punching
- Additional rotary die station for perforating (does not include stripping and matrix rewind)
- Sheeting station
- Matrix stripping bar (for use with difficult to strip matrix)
- Electronic web guide with an ultrasonic sensor and integrated splice table with pneumatic web clamps (removes standard splicing table)
- DBS250 Back scorer - 2 knife holders (edge trimming and winding with waste)
- RotoMetrics Hydra Jack - die pressure gauges
- Dual product rewinds
- Lateral knife separation for rotary slitting
- Razor slitting: minimum slit width 10mm (0.39") and lateral adjustment
- Web separator roller with 5 web separators
- Full range of air mandrels from 25mm (1") to 76mm (3")
- Die adaptors: KDO (K2), Mark Andy, Edale, Allied Gear & Focus others available subject to specification

## Daco D330

The Daco D330 blank / plain label converter is aimed at the medium to long run production runs and utilises either a single or dual rotary die cutting station. The large 700mm (27.5") unwind with taper tension control and electronic brake keeps roll changes to a minimum.

The Daco D330 compact size and short web path keeps wastage to a minimum, the fully adjustable silicone covered nip drive roller helps to keep down time to a minimum as labels cannot attach themselves to the roller. The D330 has accurate tension control through the use of an electronic unwind brake with taper tension control and the rewind is controlled through an electronic clutch. Quick set rotary slitting with on the run lateral adjustment is fitted as standard, the slitting knives can be set with the web in position unlike some cartridge systems. A splice table makes web splices both simple and quick. Quick change air mandrels for the product rewind ensures that cores a gripped firmly and a production speed of 175m/minute (575 feet/minute).

### Standard Features

Web widths 330mm (13")

- Unwind
  - Maximum unwind diameter: 700mm (27.5")
  - 76mm (3") air mandrel
  - Merobel electromagnetic particle brake
  - Taper tension control - No roll-followers or external sensors to be adjusted or maintained
- Splice Table - Makes web splicing easier and quicker
  - Pneumatic web clamps
- Die Station



## Rotary Die Cutter

254-380mm (10"-16") die repeats

RotoMetrics through hardened anvil - 105T - (13.125") repeat

Gearing - 1/8 cp, 20 degree pressure angle

A driven capstan roller with adjustable tension control ensures reliable matrix stripping, enabling high speed running even if the matrix

rewind becomes unstable

Matrix / Waste Rewind - 400mm (15.75") diameter with fully adjustable tension control.

76mm (3") mechanical mandrel for waste rewind

### • Draw Head

Silicone nip roller against a driven draw roller

The silicone nip roller does not allow labels to attach themselves to it reducing down time

Fully adjustable to allow for different label stocks

The draw roller is driven by a 1.5Kw (2 hp) motor

### • Slitting

3 quick set rotary scissor slitting knives (shear knife)

Minimum slit width: 13mm (0.51")

Lateral knife adjustment: +/- 8mm (0.31")

Removable interlocked cutter guard for easy access to the slitting knives and anvils

### • Rewind

1 Product rewind

Maximum rewind diameter: 360mm (14")

76mm (3") quick change air mandrel

Label in / labels out rewinding

Merobel electromagnetic particle clutch

### • Count Facility

Labels

Linear - metres

Programmable auto slow down and stop when the count is reached

Auto reset counter

### • Speed

175 metres/minute - 575 feet/minute - dependent on material

### Optional Equipment

- E-package
  - 457mm (18") rewind, automatic taper tension control, feet counting, batch count, total count and colour touch screen control
- Additional rotary die cutting station - for perforating/sprocket punching (does not include matrix rewind)
- Electronic web guide with an ultrasonic sensor and integrated splice table with pneumatic web clamps (removes standard splicing table)
- Removable anvil with support roller - enables back cutting and sprocket punching
- Matrix stripping bar
- Dual product rewinds
- Range of air mandrels - 25 to 76mm (1 to 3").
- RotoMetrics RD scorer - enables edge trim to be wound with the waste matrix.
- RotoMetrics Hydra Jacks - die pressure gauges
- Razor slitting - with on the run lateral adjustment and a 10mm (0.39") minimum slit width

## Daco DSI 330/410

The Daco DSI rotary die cutter is a high speed plain label converter offering both flexibility and ease of use. Its design includes a quick make ready rotary scissor slitting box and touch screen HMI operator interface for quick and easy job setups.

Both the rewind and unwind tensions are fully and independently adjustable and has taper tension control as standard. The unwind also has a programmable end of roll function, which allows the operator to select an end of roll diameter.

The Daco DSI is equipped with a single rotary die cutting station with removable anvil and an optional second rotary die cutting station can be fitted to allow perforating.

An electronic web guide ensures that the finished rolls are perfectly wound, and an adjustable splicing table with pneumatic web clamps is also fitted as standard, enabling splices to be made both neatly and easily.

Airshafts for both the unwind and rewind means that changing the rolls could not be simpler, and a programmable web advance system makes it easy to attach the web to the core when starting a new roll.

### Standard Specification

- Web widths 330mm (13") or 410mm (16")
- Maximum unwind diameter: 762mm (30")
  - 76mm (3") diameter airshaft
- Merobel electronic brake
- Taper tension control
- Programmable end of roll function

The user is able to program the roll end diameter slowdown and/or stop - The system does not use any roll followers or external sensors that can be damaged at roll changes. The diameter is programmed from the touch screen operator interface.



- 700mm (27.5") Inspection table with adjustable splicing facility & pneumatic interlocked web clamps
- Electronic web guide
  - Ultrasonic sensor enables guiding of opaque and clear materials
  - Adjustable web guide sensor
- Single rotary die station
  - Removable anvil
  - 10-24" die repeats
  - Gearing: 1/8cp 20 degree pressure angle
  - Lateral die adjustment
  - Matrix stripping tower
  - 76mm (3") mechanical mandrel for matrix removal
- Rotary scissor slitting
  - Knife separation
    - Allows for easy setting of the knife and anvil with the web in place. Does not require costly off machine setting tools.
  - Minimum slit width: 13mm (0.51")
  - Lateral knife adjustment: +/- 5mm (0.196")
- 1 Product rewind
  - Max rewind diameter: 457mm (18")
  - 76mm (3") diameter
  - Taper tension control

## Plain Label Converter

Merobel electronic clutch  
Labels in / labels out rewinding  
Programmable web advance system  
The web advance delay time is programmable from the touch screen

The mandrels are quick change.

The mandrel size is selected on the touch screen and is electronically compensated for, so there are no gears to change.

- Maximum speed: 250 metres per minute (820 ft/min) dependent on material specification and condition
- Count units labels / feet / metres with programmable slowdown and stop
- Colour touch screen HMI operator interface
  - Shows machine status and system messages (interlocks not met etc)
  - Counting options
  - Tension settings
    - Allows for easy and quick jobs set ups
- Air operated silicone nip roller with independent regulator and gauge

### Optional Equipment

- Modular unwind 762mm (30")
- Additional rotary die stations (no matrix rewind)
- Twin product rewinds with independent tension control
- Matrix stripping bar (for use with difficult to strip matrix)
- RotoMetrics RD Scorer (enables edge trim to be wound with the matrix)
- RotoMetrics Hydra Jacks - die pressure gauges
- Full range of air mandrels from 25 - 76mm (1" - 3")
- 1460mm Inspection table with adjustable splicing facility & pneumatic web clamps
- Die adaptors to utilise existing rotary dies - Edale Beta, Nilpeter, Gallus & Mark Andy (others available upon request)
- Additional rotary slitting knives

## Daco TD 330/410



The Daco TD turret rewinder is the ideal machine for producing plain labels automatically with little operator input. The machine is equipped with a high capacity 1m (40") unwind to keep master roll changes to a minimum. The 3 spindle turret offers quick change over times, which coupled with a touch screen HMI operator interface makes the machine both interactive and user friendly. The machine can be configured with either one or two rotary die stations.

There is a host of optional equipment which enables you to specify a very adaptable converting line.

### Standard Specification

- Web widths 330mm (13") or 410mm (16")
- Maximum unwind diameter: 1000mm (40")
  - 76mm (3") diameter air shaft
- Safety chuck
- Automatic roll lift
- Merobel electronic brake
- Taper tension control

### Programmable end of roll function

The user is able to program the roll end diameter slowdown and/or stop - The system does not use any roll followers or external sensors that can be damaged at roll changes. The diameter is programmed from the touch screen operator interface.

- Electronic web guide
  - Ultrasonic sensor enables guiding of opaque and clear materials
  - Adjustable web guide sensor
- Converting module
  - Single rotary die station
    - Removable anvil
    - 10-24" die repeats
    - Gearing: 1/8cp 20 degree pressure angle
    - Lateral die adjustment
    - Matrix stripping tower
    - 76mm (3") mechanical mandrel for matrix removal
  - Rotary scissor slitting
    - Knife separation
      - Allows for easy setting of the knife and anvil with the web in place. Does not require costly off machine setting tools.
    - Minimum slit width: 13mm (0.62")
    - Lateral knife adjustment: +/- 5mm (0.51")

## Plain Label Turret Rewinder/Die Cutter

### In-line turret module

- Maximum rewind diameter: 350mm (13.75")
- Taper tension control for the rewind
- Hot melt core gluing system: 5 glue transfer wheels
  - The glue bath does not need to be removed from the machine to add or remove glue transfer wheels.
- Hot melt tail gluing device
- Air Mandrels: 3 off at 76mm - (3")
- Automatic roll eject system
- Adjustable core positioning stop
- Colour touch screen HMI operator interface
  - Shows machine status and system messages (interlocks not met etc)
  - Counting options
  - Tension settings
    - Allows for easy and quick jobs set ups
- Maximum web speed: 150 metres/minute (492 ft/min) (die cutting speed is dependent on label size & the ability to strip the label)
- Speed 25-38mm (1" - 1.5") mandrels 100 m/minute (328 ft/min)
- Cycle time: 20 seconds / 3 cycles per minute
- Count Units: Labels / Metres / Feet

### Optional Equipment

- Closed loop tension control for the unwind

### In-line turret module

- Inter-label cutting
- Full range of air mandrels from 25 - 76mm (1" - 3")
- Additional glue transfer wheels

### Converting module

- RotoMetrics RD scorer - 2 knife holders (for edge trimming & winding with matrix)
- RotoMetrics Hydra Jack die pressure gauges
- Matrix stripping bar (for use with a difficult to strip matrix)
- 2 die base (only fitted with a single die station)
- Additional rotary die station (no matrix rewind)
- Air assisted turn bar with additional web guide

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