



The Rietstack IRS stand-alone converting machine



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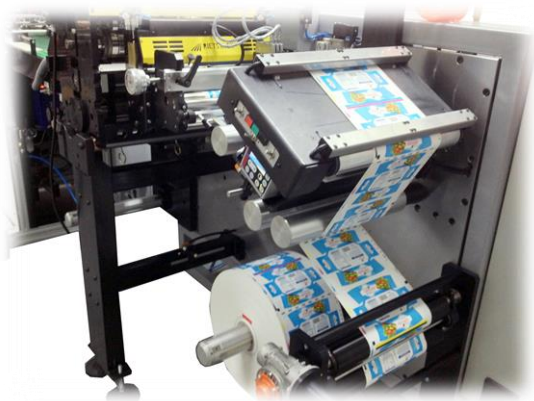
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Technical description IRS 330, IRS380 IRS 440 and IRS550 stand-alone converting machine

The IRS stand-alone converting machine is designed as automatic rotary cutting machine for the production of label stacks in various materials like IML, paper (PS paper), carton, film (BOPP film 50µm)etc. from a pre-printed reel. Next to that the IRS is designed to produce small reels from a pre-printed mother reel by means of longitudinal cutting of self-adhesives, foil- and paper materials.

Thanks to the servo driven die-cutting station and a special control system the machine is able to provide an in register die cut production.

Basic machine with die-cutting unit	IRS 330	380	440	550
Technical data				
Maximum web width in mm	330	380	440	550
Maximum mechanical speed	200m/min			
Maximum Unwind diameter Standard	750mm			
Unwind Unit (Stand-alone) maximum Unwind diameter	1000mm or 1200mm (Option)			



Standard Unwind Unit on IRS With De Curl-Bar-Unit



Unwind Stand-alone (option)

Unwind unit equipped with:

- Pneumatic unwind spindle
- Unwind spindle, cantilever type
- Splice table with 2 pneumatic clamps
- Micro-processor control system
- Electronic counter (labels/meters)
- Web guide BST
- Precise adjustment of rewind and unwind web tension
- Electronic correction of web tension on unwind unit
- De-Curl-bar-unit
- Flag detector
- Automatic stop at roll end
- Additional socket

76mm



Flag detector

Single-Rewind unit equipped with

- 1 pneumatic rewind spindle diameter
- Electro-magnetic clutches (powder type)
- Maximum rewind diameter
- Simple change of winding direction
- Simple change of spindle diameter

76mm

440mm

Slitting station with 3 knives, shear cut type

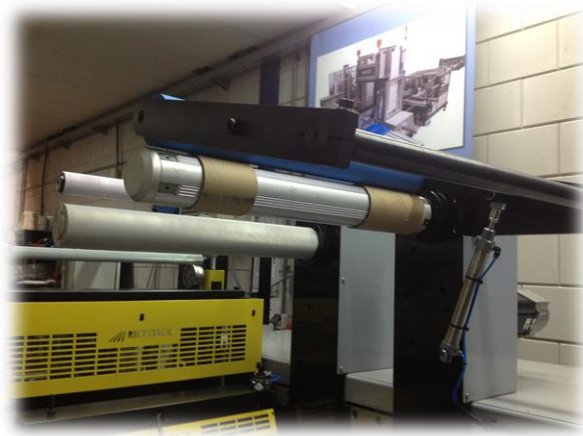
Pneumatic nip roller device

Crush cut unit (option)



Crush cut unit/razor blade unit (option)

Die cutting station (including matrix rewinder)	IRS 330	380	440	550
<ul style="list-style-type: none"> • Maximum working width of magnetic cylinder • Magnetic cylinder • Material support plate • Maximum rewind diameter-matrix • Rewind spindle-Diameter • Rewind spindle is driven by friction clutch • Die-cutting cylinder driven by servo drive • The matrix pneumatic rewind spindle driven by servo drive • Dancer roller for tension matrix • Hydraulic pressure read out 2 clocks • Modified Pressure Bridge allowing to lift the magnetic die-cylinder without hoist to mount the magnetic die plate. • Control system for off-line in register die cutting • Maximum machine speed during in-register die-cutting process 120m/min for stable materials. 	330	380	440	550
	96-200T			
	500 mm			
	76 mm			



Matrix nip roller unit (option)

Control panels on movable arm

Delivery conveyor with basic stacker

Delivery conveyor table, including vacuum-belt and vacuum-pump (max. 4 streams across)

Antistatic bar: 3pc

Basic stack unit to produce ready stacks with a max. height of 150mm. The ready stacks most taking out of stack-unit manually. The restriction is a min. label size of 7cm. For smaller labels, 3,5cm – 7cm, the stack has to be taken out by the 45° pins manually.

Max. Label size depending on working width of magnetic cylinder.

Stack Unit for 4 streams (max) model: extra delivery streams available upon request.

Delivery conveyor stacker non -stop

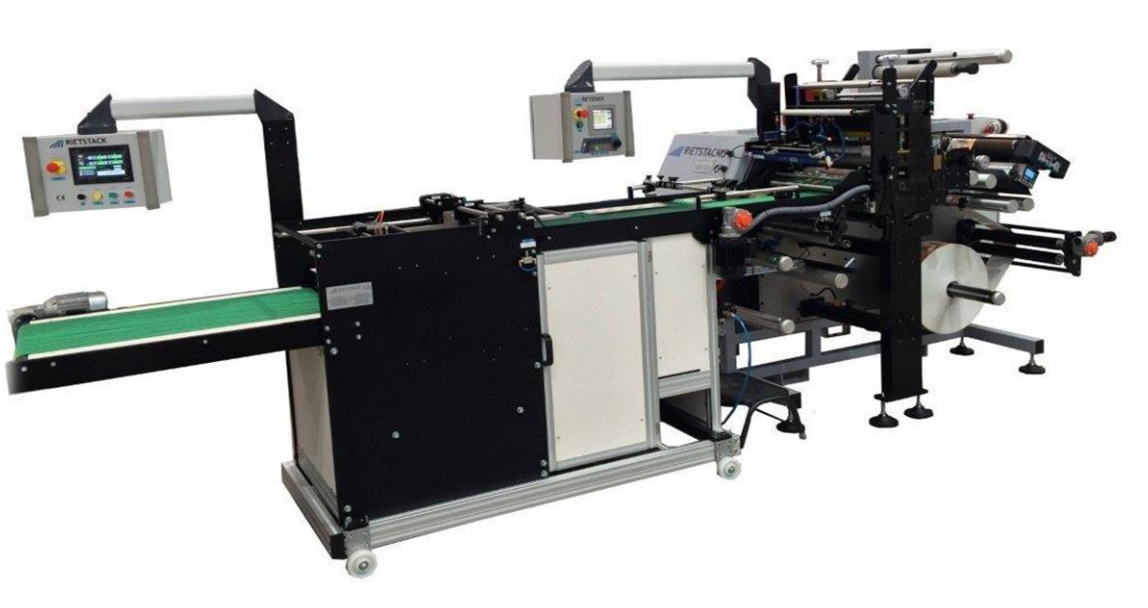
Delivery conveyor table, including vacuum-belt and vacuum-pump (max. 4 streams across)

Antistatic bar: 3pc

Non-stop Stacker unit to produce automatically ready stacks with a max. height of 150mm. The ready stacks are delivered by means of a pushing system. The restriction is a min. label size of 7cm. For smaller labels, 3,5cm – 7cm, the stack has to be taken out by the 45° pins manually.

Max. Label size depending on working width of magnetic cylinder.

Stack Unit for 4 streams (max) model: extra delivery streams available upon request.



IRS die-cutting non-stop

Options

- **Double Die cutting unit**
- **Crush cutting unit pneumatic**
- **Razor blade unit**
- **Nikka 100% inspection system**
- **Stand-alone unwinder 1000mm/1200**
- **Servo on the rewind unit**
- **Dual rewind unit**
- **Semiautomatic turret rewinder**
- **Rewind spindles in customized sizes**
- **Stroboscope**
- **Ventilator for slitting waste removal**
- **High pile stacker**

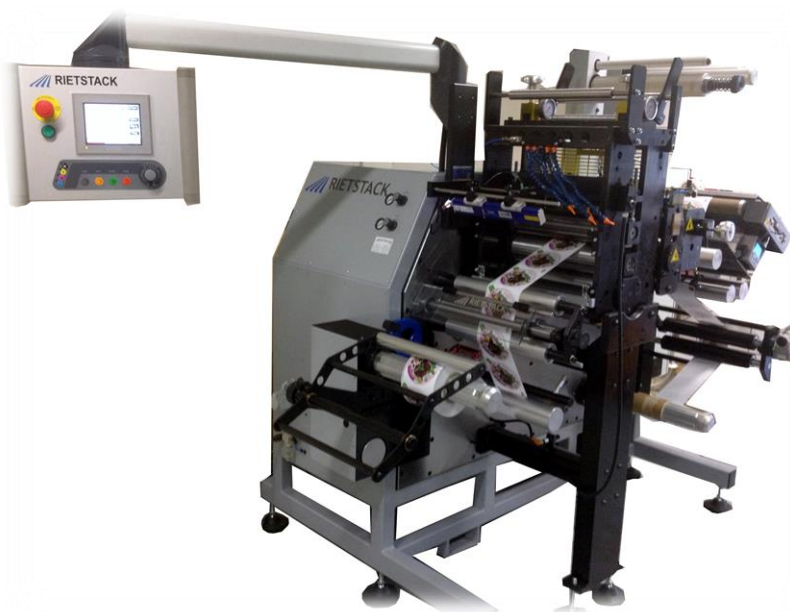
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IRS die-cutting slitter rewinder

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