**Cutting Machine Type Code**

Circular knife cutting system = KRS
Blade cutting system = KLS
Gross material width in millimetres = xxxx
Number of cutting positions = x
Single-knife version = E
Double-knife version = D
Manual clamping screw: = MK
Manual, hand crank = MH
Electric; semi-automatic = EH
Electric; fully automatic = EV
In sync = S
Not in sync = A
Operating side on left = L
Operating side on right = R
Operating side both sides = B
Maintenance access input side = E
Maintenance access output side = A

**Other specification details:**

Throughput speed: 1 - 500 m/min
Material to be cut: PET, PP, PS, fabric, paper, HDPE, ...
Material strength: Dependent on material
Minimum cutting width (single cut): 100mm
Minimum cutting width (double cut): min. 6mm up to max. 12mm
Electrical connection: 3 x 400V, 50Hz, 3KW, with MP
TRIP SWITCH: Trip switch dead-lock and dry contact for collective fault indication; conductance 0-10V
Control box: c. W 800 x H 800 x D 320mm; mounted on the cutting machine; fully fitted
Material feed, in and out: Over smoothed aluminium guide rollers (80mm
Machine connections: Tapped holes (see layout)
Gauge display (only on synchronised version): Tape measure; optional: measuring system
Protective cover: Polycarbonate sliding doors; steel panel painted in RAL 7032 (optional: stainless steel panel)
Machine signage: German
Documentation 1 x German, A4
The Cutting Machine Type Code Explained

- **Type of system:**
  - **KRS** (circular knife cutting system)
    - Patented cutting head system on the scissors-style principle
    - Combined immersing and pressing movement
    - Powered lower knives
    - Electronically adjustable throughput speed of up to 100m/min.
    - Upper knives can be changed in less than one minute (by means of pre-fitted cassettes)
    - Lower knives can be changed quickly and easily with no need to disassemble any other components
    - All of the following can be precision-adjusted:
      - Angle of clearance
      - Cutting pressure
      - Immersion depth
  - **KLS** (blade cutting system)
    - Eight-blade rotor in the form of pre-fitted cassettes
    - No drive unit or lower knives

- **Gross material width**
  - Individually constructed for each application. The width of the machine is determined by the gross width of the film to be cut.

- **Cutting positions**
  - A choice of one to seven cutting positions. More on request.

- **Knife versions**
  - **Single knife**
    - The cutting head is fitted with a circular knife for simple cuts
  - **Double knife**
    - The cutting head is fitted with two circular knives for cutting out strips. The machine’s special construction allows cut out sections to be drawn away and coiled without any need for clamping. For double cutting, there is a minimum cutting width that must be observed.
Adjusting sheet width

- KRS
  - Manual clamping screw:
    - Unlike for all other versions, upper and lower knives are separately (asynchronously) released, pushed back and clamped by hand. 
    - More info The lower knife shaft must be completely disassembled to replace the lower knives!
  - Manual, hand crank:
    - Sheet width adjustment for the upper and lower knives is achieved in synchronisation using a hand crank or hand-wheel. To adjust the machine to individual cutting positions, the hand crank is set on the relevant adjusting spindle.
  - Electric; semi-automatic
    - The position of individual cut-outs is changed in sync by an electronic drive unit. The machine is button-operated. During the cutting process, it is essential that cutting positions are monitored in order to avoid collisions.
  - Electric; fully automatic
    - In this, the most convenient of all the variants, sheet width is set from a terminal (by means of an on-screen dialogue). The operating process is electronically monitored and when the due position is reached, the drive unit is automatically switched off. It is also possible for all cutting positions to operate at the same time. User-friendly editing of all of the machine’s other functions is similarly possible via the operating controls.

- KLS
  - Manual clamping screw:
    - Unlike for all other versions, the cutting positions are released, pushed back and clamped by hand.
  - Manual, hand crank
    - Sheet width settings are adjusted by using a hand crank or hand-wheel. To adjust the machine to individual cutting positions, the hand crank is set on the relevant adjusting spindle.
  - Electric; semi-automatic
    - The position of individual cut-outs is changed by an electronic drive unit. The machine is button-operated. During the cutting process, it is essential that cutting positions are monitored in order to avoid collisions.
  - Electric; fully automatic
    - In this, the most convenient of all the variants, sheet width is set from a terminal (by means of an on-screen dialogue). The operating process is electronically monitored and when the due position is reached, the drive unit is automatically switched off. It is also possible for all cutting positions to operate at the same time. User-friendly editing of all of the machine’s other functions is similarly possible via the operating controls.
- **Synchronisation**
  - *KRS*
    - On the KRS model, excluding the MK variant, upper and lower cutting positions are set in sync. That means: there is no need for any readjustment once the sheet width has been set.
    - On the MK variant, synchronisation is not possible. Each time the sheet width is set, upper and lower knives must be readjusted and realigned.
  - *KLS*
    - As the KLS model has no lower knives, the issue of synchronisation is of no relevance, and the standard choice for this model is not in sync.

- **Operating side**
  - The operating side (left / right / both sides) should always be given in relation to the material extrusion direction. In connection to this, it is also important to give the operating height.

- **Maintenance access**
  - So that knives can be changed without any difficulty, the machine must be accessible from one side or the other. This should be given in terms of either the input or output side.