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# SET UP WHILE RUN RDC
Workable formats and overall performances
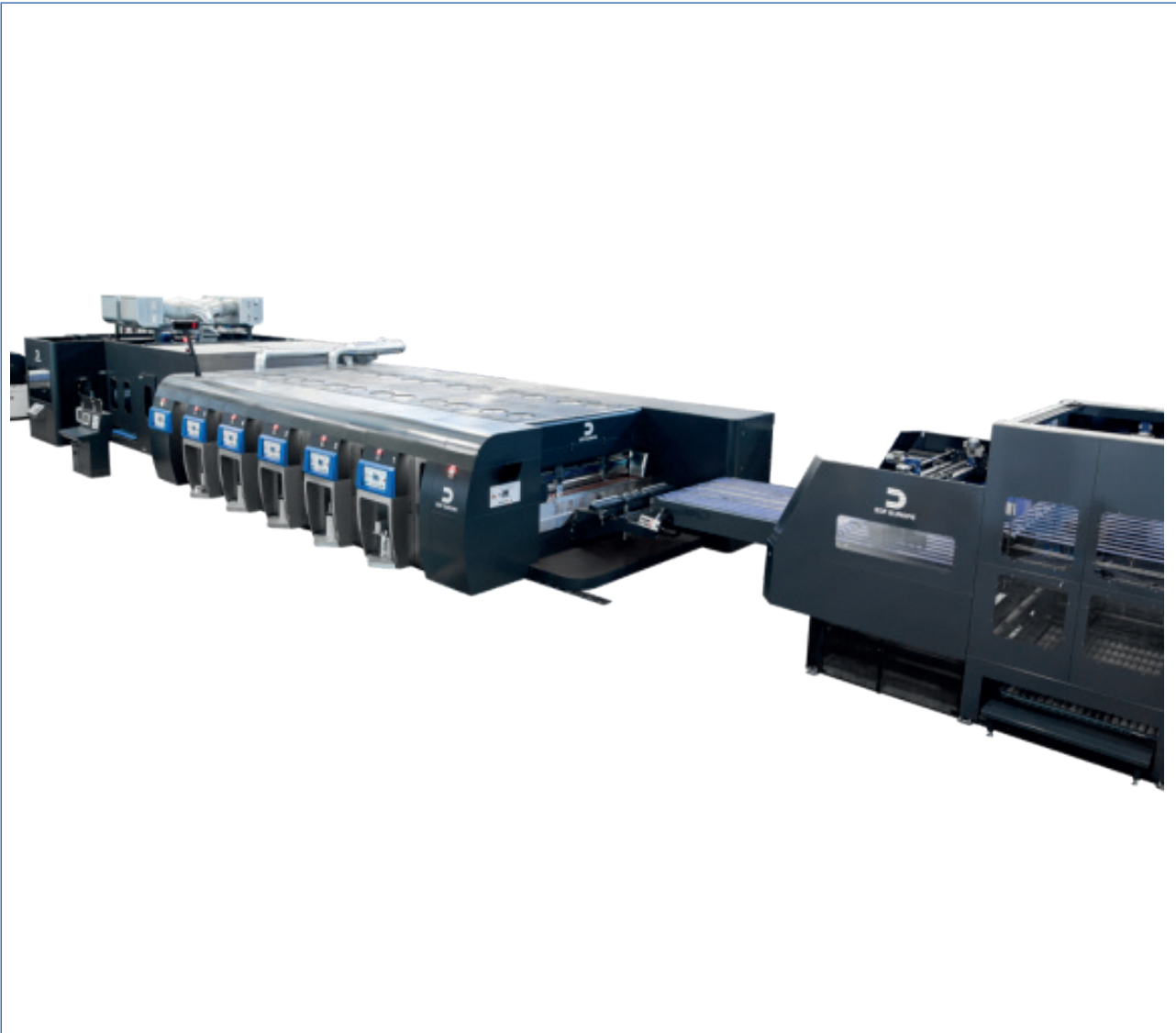
HGL-HBL 1628

Revision	Description	Date	Reviewed by
1.3	Updated version	28/04/2023	Guido Gubitta

Converting Bottom print flexo machine with Rotary Die Cutter functions , inking units with downwards disengagement (in pit) that being spaced between them allow easy operator access to perform the change of printing plates while machine running.

Cardboard and box sizes
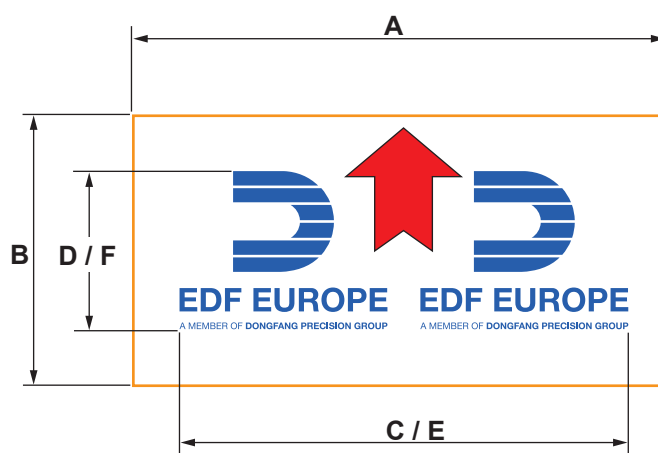
SIDES	DEFINITION	Min	Max
A	Sheet width (mm)	500	2.850
B	Sheet height (mm)	450	1.600
C	Printable width (mm)	/	2.800
D	Printable length (mm)	/	1.560
E	Die-cut width (mm)	/	2.800
F	Die-cut length (mm)	/	1.560

General characteristics

Theoretical roll circumference:	**1.676 mm**
Machine speed:	**min 1.000 - max 12.000 boxes/h**
Inserted minimum sheet width:	**500 mm**
Inserted maximum sheet width:	**2.850 mm**
Inserted minimum sheet height:	**450 mm**
Inserted maximum sheet height:	**1.600 mm**
Max print area:	**2.800 x 1.560 mm**
Board thickness:	**1 - 10 mm**
Processable corrugation types:	**A, B, C, E, A+B, B+C, B+E**

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Indicative overall performances*:

Full speed	**12.000 sheets/h**
Introduction register between lead edge and the 1st printing unit	**+/- 1,0 mm**
Print register between the 1st and 4th printing unit	**+/- 0,3 mm**
Print register between the 1st and 6th printing unit	**+/- 0,4 mm**
RDC register between the last print and the die	**+/- 0,7 mm**

FTB (FishTail glue tab side) with single and double corrugation	**+/- 1,0 mm**
FTR (FishTail trim side) with single and double corrugation	**+/- 1,0 mm**
LG (Lead edge Gap) single corrugation	**+/- 1,8 mm**
LG (Lead edge Gap) double corrugation	**+/- 2,2 mm**
TG (Trail Gap) single corrugation	**+/- 1,8 mm**
TG (Trail Gap) double corrugation	**+/- 2,2 mm**
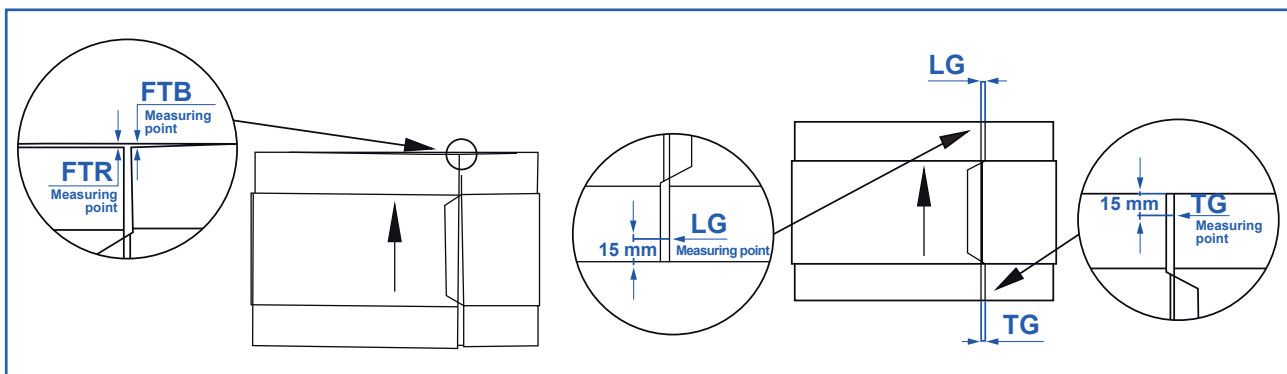
*   For commissioning, at least 5 different types of packaging will be agreed between EDF and buyer, for each package specific dimensional and performances guarantee and any limitations.