HOACO Rotary Die Cutting Machine
13-Stations Model

The Machine (For illustration only, actual machine may differ)

Technical Specifications

Parameters	Specifications
Rated Power	42KW
Maximum Current	84A
Input Voltage	380V ± 10%, 3 Phase 5 Wires, 50/60Hz
Compressed Air	0.45 – 0.60 MPa
Dimension	L5900 x W3020 x H2470mm
Weight	6 Tons
Typical precision	±0.1mm
Max operating speed	60 meters/min

Web width	250mm or 350mm
Max Web Roll Diameter	500mm
Max Rotary Die Diameter	250mm
Air Shaft Tension (min – max)	1N-150N
Machine Base Frame	Welded Steel
Machine Body Frame	Industrial-Grade T-Slot Aluminium
RDC Station Plates	Stainless Steel
Air Shaft Motor/Controller	Delta Electronics (Taiwan)
RDC Station Motor/Controller	Omron (Japan)
PLC Controller	Omron (Japan)
HMI Screen	Weiview (Taiwan)
Web Guiding System	TechMach (China)
Bottom Roller	Teeth: 81, Module: 1.010634
Anvil Roller	Teeth: 70, Module: 1.010634
Groove Roller	Teeth: 70, Module: 1.010634
Guiding Roller	Teeth: 81, Module: 1.010634
Low Voltage Electrical Components	Schneider (France)
Electrical Cables	China
Magnetic Valve	Taiwan/Japan
Operating environment	Indoor with altitude < 1000m
Temperature	0~+40 ℃
Humidity	0-70%RH
Vibration	< 5.9m/S2

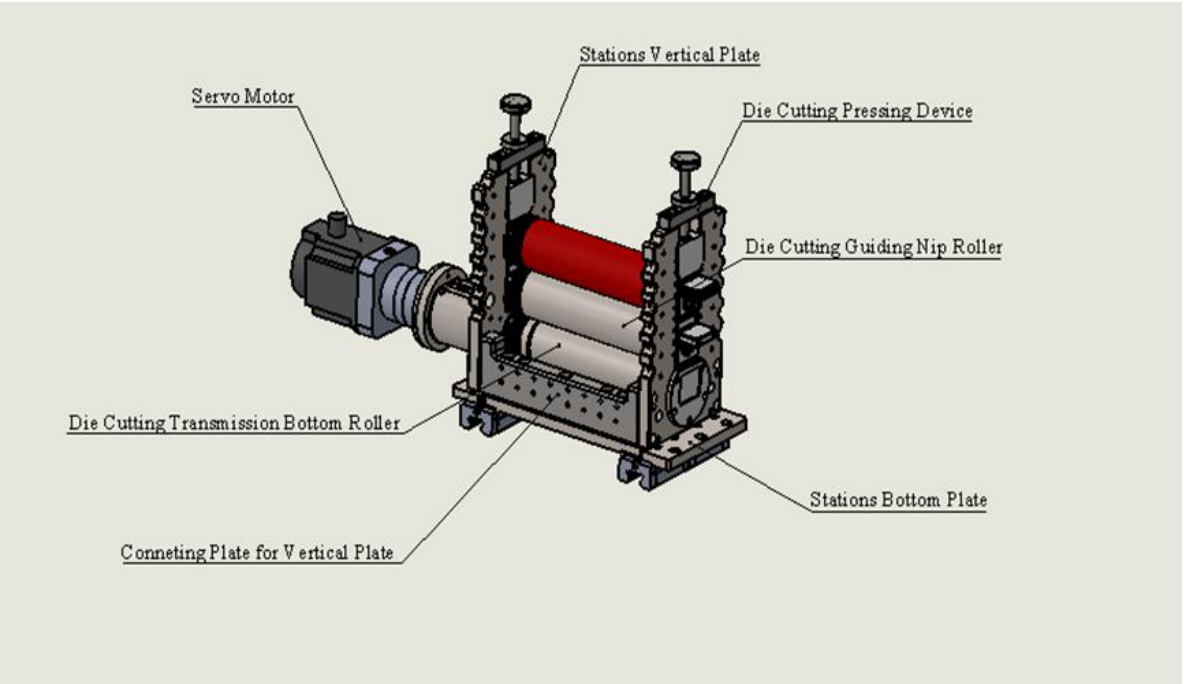
Packing List (Standard 13-Stations RDC Machine)

No.	Part Name	Specifications	QTY	Unit	Remark
1	Station	250	13	group	installed on machine
2	Bottom roller	81 teeth	13	pcs	installed on machine
3	Lamination rubber (hard)	81 teeth	4	pcs	installed on machine
4	Lamination rubber (soft)	81 teeth	5	pcs	installed on machine (3 pcs no gear)
5	Guiding groove roller	70 teeth	5	pcs	installed on machine
6	Guiding nip roller	70 teeth	1	pcs	installed on machine
7	Pressing hand wheel	M14X1.5	26	pcs	installed on machine
8	Pressing block		26	pcs	installed on machine
9	Air expanded shaft	3"-250	26	set	installed on machine
10	Web guiding device	250	1	set	installed on machine (including web guiding bracket)
11	Removable operation platform		1	set	in packaging box
12	Mould adjuster	M16X1.25	9	set	in packaging box
13	Cutter pressing device		9	set	in packaging box
14	Material guiding bent roller	Φ24-40	5	pcs	installed on machine
15		Φ35-40	12	pcs	installed on machine
16		Φ35-55	5	pcs	installed on machine
17		Φ35-55	5	pcs	installed on machine
18		Φ35-75	5	pcs	installed on machine
19	Material guiding straight roller	Φ35	8	pcs	installed on machine
20	Biaxial compression bending shaft		1	set	installed on machine
21	Uniaxial compression bending shaft	Φ35-40	3	pcs	installed on machine
22	Reset spring		6	pcs	in packaging box
23	Removable air expanded shaft		3	pcs	installed on machine

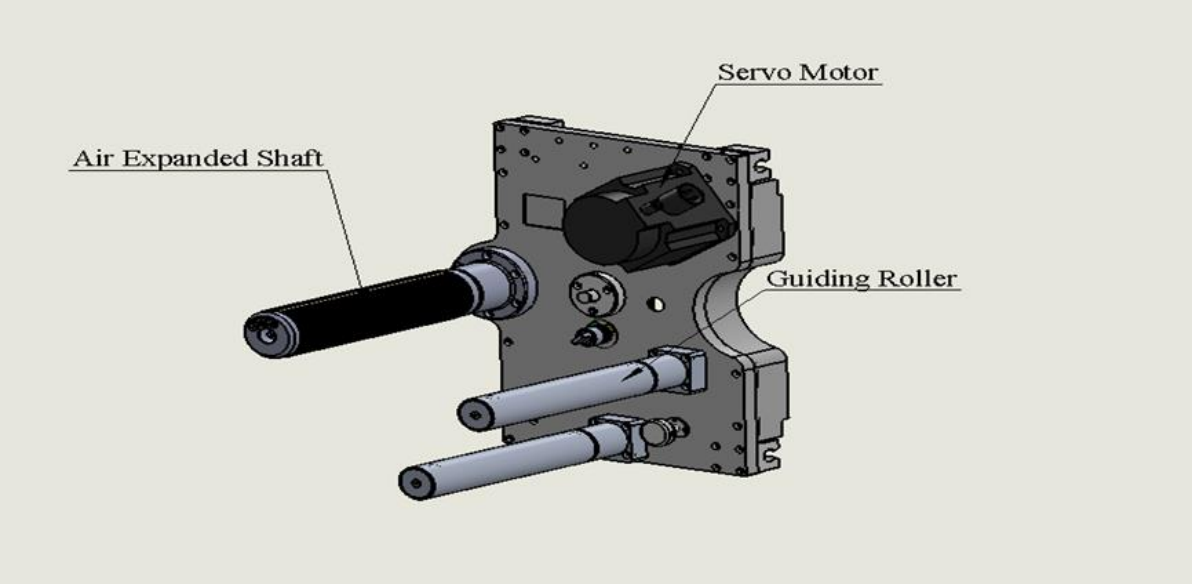
24	Removable material guiding roller		9	pcs	installed on machine
25	Material shield plate	Φ200	16	pcs	in packaging box
26		Φ330	34	pcs	in packaging box
27	Check ring	Φ35	20	pcs	in packaging box
28		Φ50	20	pcs	in packaging box
29	Scissor		1	pcs	in packaging box
30	Utility knife		1	pcs	in packaging box
31	Expanded ring		50	pcs	in packaging box
32	Expended core	3 to 6	4	pcs	in packaging box
33	Separating cutter（3 big 2 small）	250	5	pcs	installed on machine
34	T-type guiding rail	40x40x400	1	pcs	installed on machine
35	T-type guiding rail	40x40x500	1	pcs	installed on machine
36	Pedal		1	set	in packaging box
37	Air gun	Φ8	2	set	in packaging box
38	Damping cushion		18	set	in packaging box
39	Short handle rotary knob		1	pcs	in packaging box
40	Station extended block		2	pcs	in packaging box
41	Shaft button		2	pcs	in packaging box
42	Pause button		4	pcs	in packaging box
43	Front panel hose lamp		3	pcs	in packaging box
44	Air tube joint	HPGΦ10-Φ8	1	pcs	in packaging box
45	Oilcan		1	pcs	in packaging box
46	Tool kit		1	pcs	in packaging box
47	T-type nut		30	pcs	in packaging box
48	Internal hexagonal wrench		1	set	in packaging box
49	Utility knife fixture		1	set	in packaging box
50	Screwdriver		4	pcs	(two flat-head and two phillips) in packaging box

51	Accessories rack		1	set	in packaging box
52	Standby screw		some	pcs	M6X25、M8X30、M10X25

Die Cutting Station



Unwind/Rewind Station



HOACO Machine Features and Benefits

Mechanical

• Available in 3 to 20 movable stations, the machine enables ultimate flexibility in process design and material placement. Each station is fully capable of handling multiple layers of kiss-cut, through cut or lamination

• Materials and cut parts are facilitated in roll form

• Standard web material width: 250mm (10") and 350mm (13")

• Pendant arm HMI touchscreen for greater ergonomics

• Active web guiding control maintains even feeding of materials

Electro-Servo

• All servo-motors are synchronized by our ingenious software

• Dedicated servo-motor for each cutting/laminating and unwind/rewind station ensures synchronized positioning accuracy and precision up to ±0.05mm

• CCD camera registration/inspection with feedback for correction/adjustment to improve precision and minimize material waste

Process and Control

• **Dual Systems:** A single RDC machine's available stations can be separately configured to manufacture two different products, operated by two operators at the same time without interference. Modular independent stations and replaceable cutters deliver unparalleled simplicity and flexibility in enabling the manufacturing of two products on a single machine, saving customer investment and factory footprint.

• **Graphite Sheet Cutting:** Overcoming challenges of partial edge banding and backside adhesiveness when cutting thermal graphite sheet, HOACO RDC machine successfully automated multilayered cutting/lamination of thermal graphite sheet with 95% yield.Fueled by the superior performance and yield, HOACO commands a majority market share in the domestic thermal graphite cutting market.

• **Fixed-Length Crosscutting function** can be achieved by setting cutting length in advance according to product requirement. Once set, the machine can automatically crosscut parts based on input material length, eliminating the need for a separate cutting machine.

• **Screen Frame Adhesive Sticker Tape** production through asynchronous cutting and splicing of edge strips greatly reduced material waste while maintaining precision and speed.

• **Single/Double Asynchronous function** enables different modes of cutting operation—automatic async, manual async, coupled asycn and passive async moded can reduce material waste by up to 30%.