

## Busch High Die Cutters - Since 1949

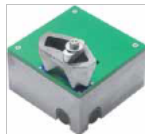
Busch has been manufacturing Post-Press equipment, in Hamburg, Germany, for over 40-years. In addition to High Die Cutting equipment Busch produces Pile Turners, Banders and Waste Conveyors.

Our Busch High Die Cutters (Ram Punches) come in three series - A, B & C - with size format capabilities ranging from less than 1" x 1" up to 14" x 16". With three levels of automation for each size format, our High Die Cutters can finish up to three-quarters of a million labels per hour.

The design of a Busch High Die Cutter (Ram Punch) is different from that of our competitors. The machine's engineering allows for simplified setup, tighter tolerance cutting, increased productivity, and the ability to tackle more jobs without a Counter-Pressure device.

## Convenient Makeready

Engineered with (5) arms, the High Die Cutter's clamps are infinitely adjustable around the circumference of the machine and



positioned to allow the untrimmed labels to pass through the die. With the die positioning block inside the machine, the top and operator side arms can be extended out towards the die. These are adjusted via black wheels at the top of each arm. Traditionally - if always

using the same 1/8" or 1/4" trim waste - the bottom arm(s) and non-operator side arm do not need to be adjusted. L-shaped brackets, at the end of each arm, form a right angle around the edge of the die.



Thus far, all measurements are approximate. After testing a few sheets, the operator micro-adjusts the position of the die, in relation to the untrimmed labels, via a hand dial. The operator does not have to adjust each arm one-by-one! The micro-adjustment

rotates the X and Y axis of the die around the circumference of the machine's clamp design.



After small adjustments to the feeding tray (delivery) section, trained operators should anticipate no more than 15 - 20 minute makereadies.

## Frequently Asked Questions

**Q Do I adjust the punching arm between jobs?**

A No, you do not. The ram actuates via a self-detecting hydraulic valve. On our A series machines the punching pressure is 5,500lbs; our B series is 12,500lbs; and our C series exceeds 25,000lbs.

**Q What is the typical waste margin on Busch models?**

A While we require a minimum trim of 3/32", most clients maintain 1/8" or 1/4" of scrap on all sides.

**Q Do you supply waste slitters with the unit?**

A Waste slitters help separate the trim into appropriate sized pieces. They are affixed to the die you procure from your local tool & die manufacturer. Nonetheless, Busch provide additional slitters should you want to add more to a job. The operator attaches them at the base of any of the (5) clamp arms.

**Q Where do I source dies?**

A If you have a local die supplier most of them either produce high dies, or would steer you to a fellow knife shop. For the most precise dies on the market, clients prefer Stamfag Dies, a Swiss entity. Stamfag are represented in North America by [Valley Grinding & Manufacturing](#). For more affordable dies, [Best Cutting Die](#), in the Chicagoland area, is tried and true.

**Q When is a Counter Pressure unit needed?**

A As a general answer, optional Counter Pressure modules are used to minimize tolerance errors. More specifically, Counter Pressures are commonly used during the production of In-mold Labels (IML), or when cutting oversized labels that would otherwise have a tendency to sag.

**Q Is your Counter Pressure a fixed system?**

A It is not. Firstly, a Counter Pressure unit can be purchased at any point in time after you already own a Busch machine (should your business grow and you gain new accounts). The system is removable, which is important, as not all jobs require counter pressure, which - when utilized - reduces any High Die Cutter's cycle speed by half. Swapping out the Counter Pressure takes, on the average, thirty minutes.

## Video Resources

- [Die Change on Busch BL High Die Cutter](#)
- [Busch BL High Die Cutter in Action](#)
- [Busch AL High Die Cutter in Action](#)