

WINKLER+ DÜNNEBIER

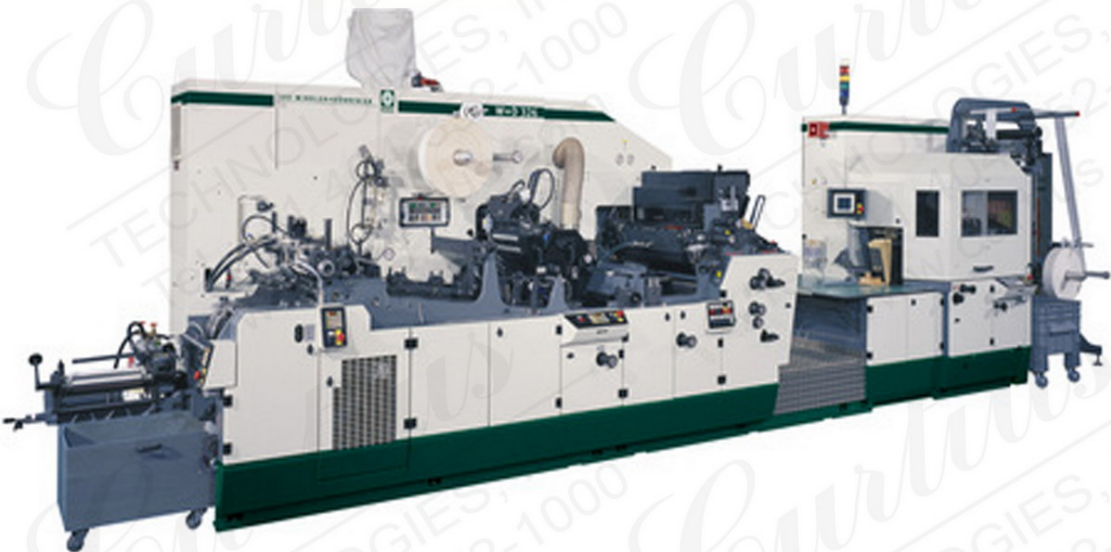
WD

326 BC



Universal Machine for Envelopes and Pockets





Products

- * Wallets and pockets from small formats up to C4
- * Envelopes in diamond and wallet styles
- * Pockets with center or side seam gumming
- * Single or multiple windows
- * Seal flaps with remoistenable gumming, self-seal or pressure-sensitive gumming (cold glue or hot-melt)
- * Optionally also for oversize formats (booklets) up to B4
- * Gusset envelopes

Flexibility and performance

- * Up to 500 envelopes/minute
- * Up to 250 pockets/minute
- * 2 flexo outside and 1 flexo inside print units
- * Flexible and easy-to-operate window section for cut off lengths up to 254 mm
- * 360° cutting section for window and complete cut
- * EasyCut magnetic cylinder technology with flexible dies
- * Non-wearing and size-independant aligner section

Product quality and operation

- * Operator monitor for input, controls and information
- * Manual format set-up and fine adjustment
- * Cull gate for waste product removal
- * Compact and ergonomic design with integrated control cabinet
- * Modem for remote diagnostics
- * Easy access to all sections





Standard Components



Blank feed

Field proven blank feeder with reciprocating blowing nozzles for an optimized processing of different paper grades and blanks



Printing

Flexo blank printing units for inside and outside printing



Window section

Window cutting and window material patching section for cut off lengths up to 254 mm (10")



EasyCut magnetic cylinder technology

Rotary cutting technology with flexible dies for window and complete cut



Gumming section

Gumming section for wallet side flaps as well as pocket bottom flap



Collating and seal flap gumming section

Collating and seal flap gumming section for remoistenable and latex seal flap gumming





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Aligner section

Aligner section with low maintenance aligner drum and separating cylinder



Control panel

Screen for machine operation and control function

Optional Components



Extrusion gumming

Extrusion gumming for booklet side flaps



Outside side seams

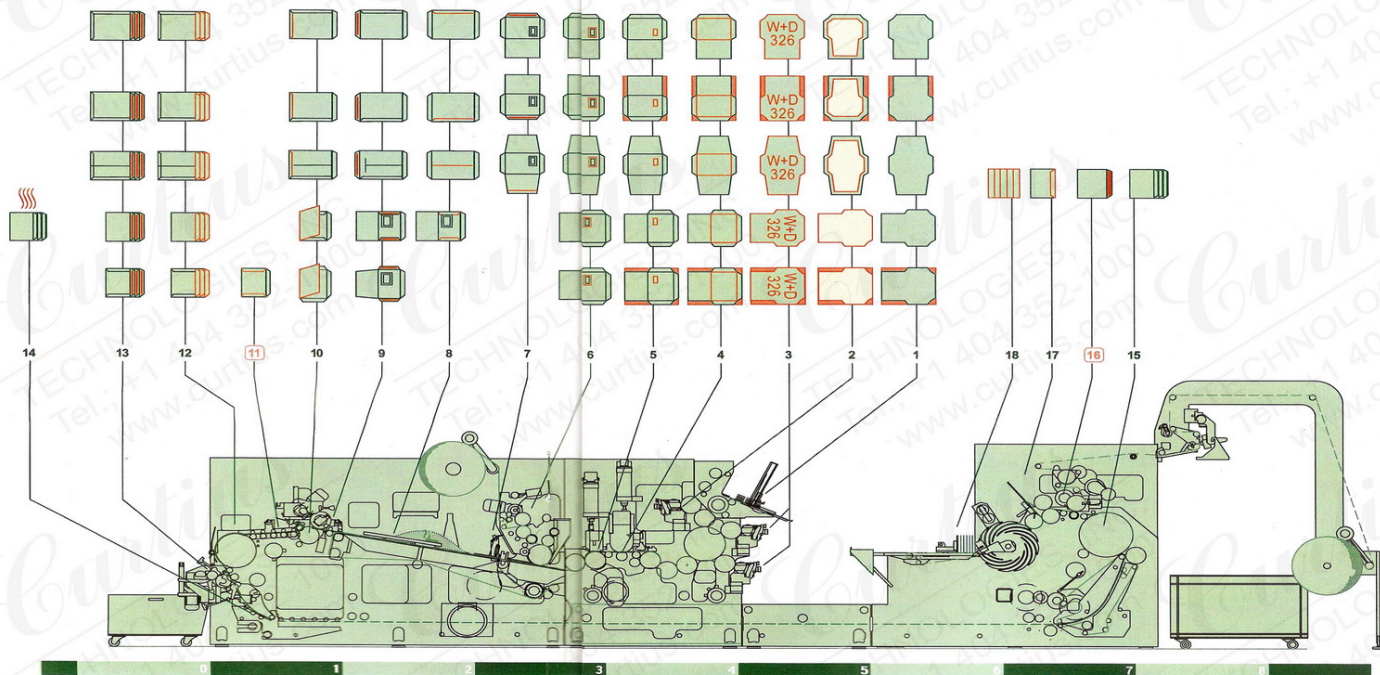
Parts for the manufacture of envelopes with outside side seams



Hot-melt section

Section for applying peel and seal gumming (hot-melt)





- 01 Feed
- 02 Flexo blank inside printing unit
- 03 Flexo blank outside printing units
- 04 Scoring section
(longitudinal and cross score)
- 05 Cutting section for window cut and complete cut

- 06 Window patching section
- 07 Side flap gumming section for pockets
- 08 Side flap folding section
(inner side flaps)
- 09 Side/bottom flap gumming section
- 10 Bottom flap folding section
- 11 Folding tools for outside side seams

- 12 Collating section
- 13 Seal flap gumming section
- 14 Drying run
- 15 Aligner section
- 16 Pressure-sensitive gumming section
(cold glue, hot-melt)
- 17 Seal flap folding section
- 18 Delivery

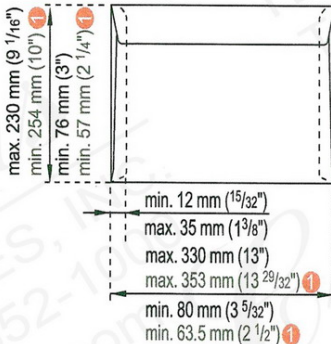
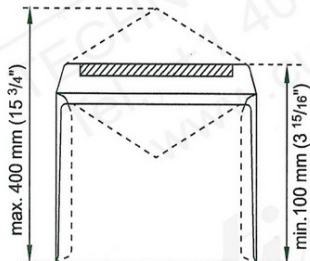




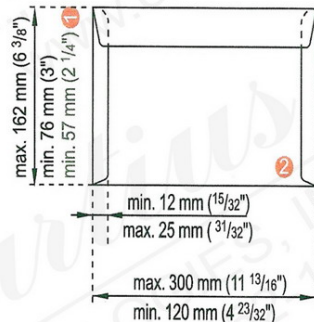
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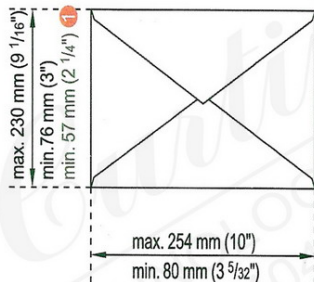
Size ranges for envelopes



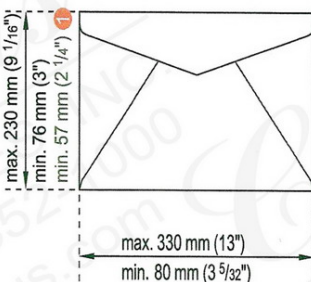
Booklet



Booklet with outside side flaps



Diamond-shape



Commercial-style

- ① Only available with the option "increased format size"
- ② Special folding tools necessary
- ③ Please contact us for more information on oversize formats

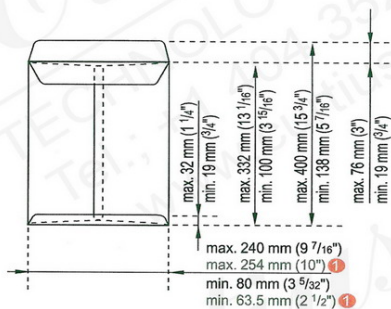




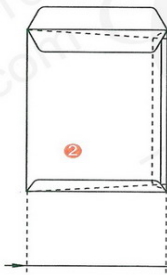
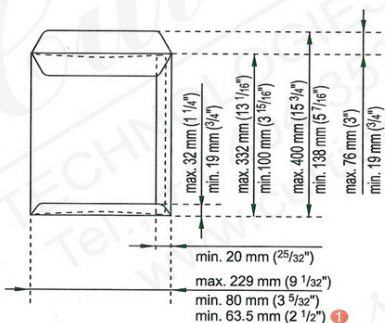
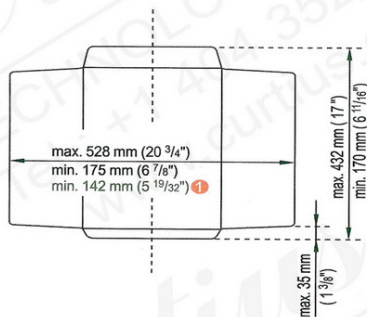
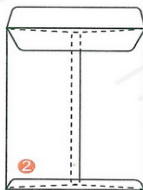
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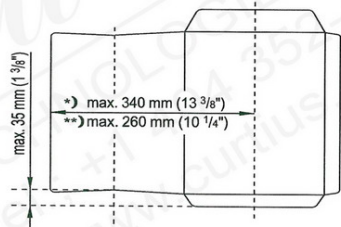
Size ranges for pockets



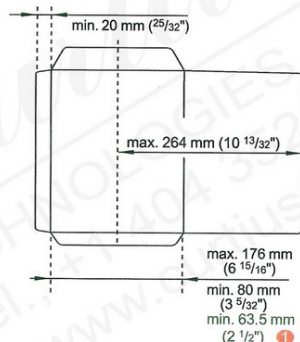
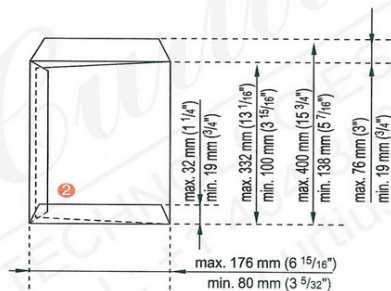
Center seam



max. 176 mm (6 15/16")
min. 80 mm (3 1/8")



Side seam with right hand side gumming

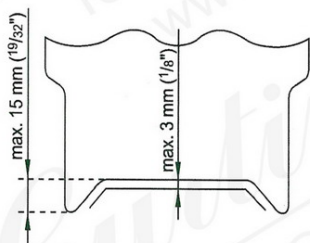


Side seam with left hand side gumming

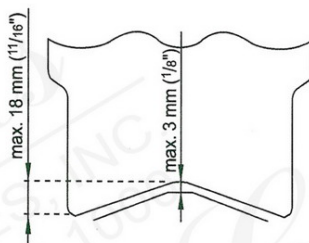


Dimensions and formats

Cut-out depth



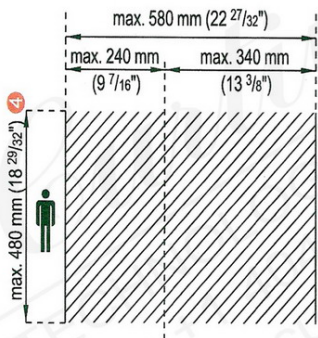
With trapezoidal cuts



With V cuts

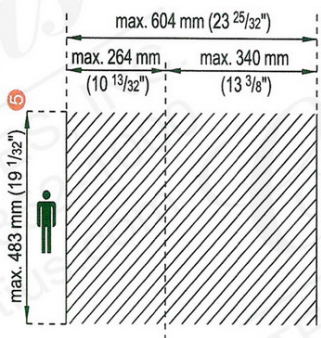
- ① Only available with the option "increased format size"
- ② Special folding tools necessary
- ③ Please contact us for more information on oversize formats
- ④ For plate cylinders with a clamping device the printing length will be reduced to 460 mm (18 1/8")
- ⑤ In case of a complete cut from a rectangular sheet with circumferential contour the cut-out height will be reduced to 465 mm (18 5/16")

Printing range

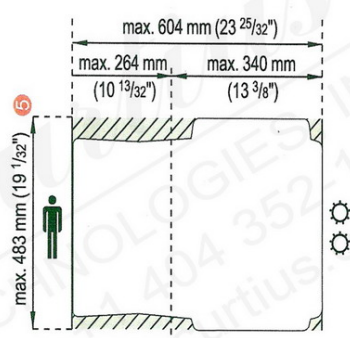


Blank printing units for inside
and outside printing

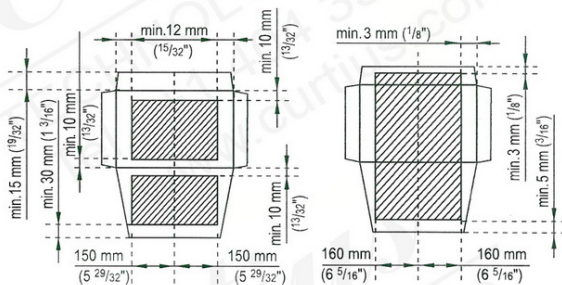
Cutting area



Cutting section for window-
and complete cut



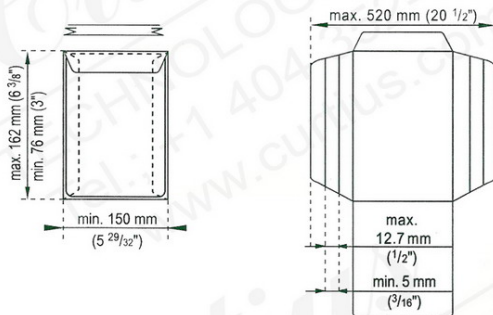
Window range



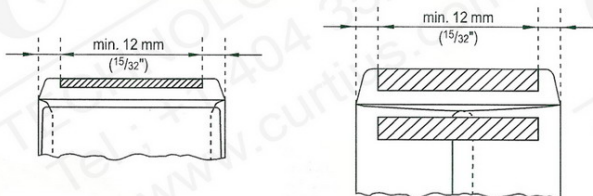
Cutting area

Patching area

Gusset sizes



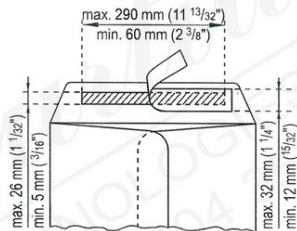
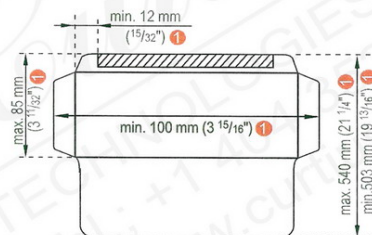
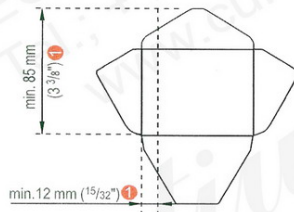
Seal flap gumming



Remoistenable gumming

Self seam gumming

Special design for oversize formats



Pressure-sensitive with protective strip





WTechnical Data

Maximum output per minute

- * Envelopes
60–150 g/m² (16–40 substance)
500 pieces
- * Pockets
80–150 g/m² (21–40 substance)
250 pieces
- * Gusset envelopes
80–150 g/m² (21–40 substance)
150 pieces
- * Oversize booklets
100–150 g/m² (27–40 substance)
150 pieces

Blank dimensions

- * Total length
max. 483 mm (19")
min. 170 mm (6 11/16")
- * Total length (1*)
max. 540 mm (21 1/4")
min. 127 mm (5")
- * Total width
max. 528 mm (20 3/4")
min. 115 mm (4 17/32")
- * Total width (1*)
max. 528 mm (20 3/4")
min. 100mm (3 15/16")
- * Stagger width
max. 188.5 mm (7 13/32")
min. 10 mm (13/32")

Paper weights

- * Envelopes
60–150 g/m² (16–40 substance)
- * Pockets
80–150 g/m² (21–40 substance)

Flexo-printing section

- * Printing length with seamless plate cylinder
max. 480mm (18 29/32")
- * Printing length with pin system
max. 460mm (18 1/8")
- * Printing width
max. 580 mm (22 13/16")

Window material

- * Window material reel diameter
max. 500 mm (20")
- * Winding core - inner diameter
70–80 mm (2 3/4–3 5/32")
- * Basis weight
30–50 g/m² (8–13.3 substance)
- * Material thickness
30–50 µm
- * Cut-off length
max. 254 mm (10")
min. 45 mm (1 25/32")
- * Cut-off width
max. 320 mm (12 1/2")
min. 45 mm (1 25/32")





Pressure-sensitive gumming

- * Silicone paper reel diameter
max. 500 mm (20") Cold-glue
max. 800 mm (31 1/2") Hot-melt
- * Silicone paper reel width
max. 300 mm (11 13/16")
min. 70 mm (2 3/4")
min. 66 mm (2 19/32") Hot-melt
- * Winding core - inner diameter
70–80 mm (2 3/4–3 5/32")
- * Protective strip cut-off length
max. 32 mm (1 1/4")
min. 12 mm (15/32")
- * Recommended application weight
20-25 g/m2 Cold-glue
max. 15g/m2 Hot-melt

Dimensions and weight

- * Length
6,800 mm
- * Width
2,200 mm
- * Height
2,200 mm
- * Net weight with switch cabinet
approx. 9,600 kg

(1*) Only available with the option „increased format size”

(2*) Optionally with additional equipment

(3*) Only after consultation with
WINKLER+DÜNNEBIER and only for small standard
formats

Connected load (Standard version)

- * Drying section
12 kW
- * Material suction
6 kVA
- * Vacuum pumps
50 kVA
- * Total excl. drying section
86.5 kVA
- * Compressed air consumption 6 bar
approx. 27 m3/h
- * Vacuum requirement 0.6 bar
approx. 675 m3/h
- * Blowing air requirement
approx. 140 m3/h

