

Installation  
**MAG-IN® - SYSTEM**

for printing or coating unit in offset-printing machine

**INSTRUCTION MANUAL**



## SAFETY INSTRUCTION

First of all:

Read the instruction manual carefully before installing the MAG-In® System from WSD®.

Keep this instruction manual in a safe place for future reference. Improper installation of the MAG-In® System may lead to serious damage to the system itself, and/or to the printing machine.

Always wear safety gloves, while handling the sharp MAG-cut® tools to avoid injuries.

Safety-instructions of your printing machine manufacturer should be referred thoroughly.

The MAG-In® System is only allowed to be used in printing machines approved by WSD® GmbH.

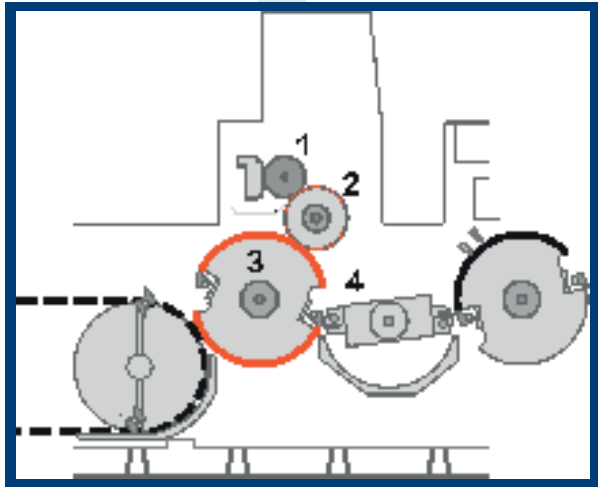
The manufacturer is not liable for any damages occurred by ignoring the safety instruction.

## CARE OF THE MAG-IN® SYSTEMS

1. Before the installation, remove impurities and foreign particles from the MAG-base® and from the MAG-cut®
2. After use, remove colour remains and paper dust from the MAG-base® and from the MAG-cut®.
3. For storage the MAG-cut®, rub it with acid free oil and pack it into the oiled paper.
4. The MAG-base® and all accessories have to be kept in the MAG-In® System box.

## CROSS SECTION OF A COATING UNIT

- 1| Grid roller
- 2| Coating cylinder
- 3| Impression cylinder
- 4| Paper direction



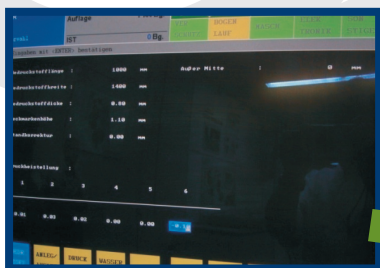
## INSTALLATION INSTRUCTION

1. The thickness of the stock (paper, board etc.) has to be fed in the control panel.
2. The Impression cylinder has to be cleaned.
3. The printing plate should be unclamped and taken out of the printing unit. The NIP-width should be maximized. If the MAG-In® System is to be installed into coating unit, the grid-roller and the washing unit has to be taken out.
4. Stick on the self-adhesive protective sheet MAG-care®, MAG-supercare® or MAG-powercare bubble free around the impression cylinder and let it run reverse (under pressure) together with the blanket.
5. The blanket/coating including underlays should be remove and cylinder has to be cleaned and free of foriegn particles.

## INSTALLATION INSTRUCTION

6. The MAG-In® System and underlay (when needed) should be calculated to the required height and clamped on the blanket/coating cylinder.  
(See page 5)
7. Clamp the MAG-base® instead of the rubber-/coating blanket. Torque should not be higher than 30 Nm.
8. The MAG-base® has to sit flat and bubble free before you position the MAG-cut® tools, using the millimeter calibration.
9. Enable „PRINT“ in the corresponding unit. Disable „COLOUR“, „WATER“ etc. in that unit. If you use the coating unit, remove grid roll and washing set-up.
10. Now the NIP-width should be reduced by 1/100 mm step by step. The contours should be controlled after every pull. If needed tight the MAG-base®.

If the punch position doesn't fit, the MAG-cut® tool has to be repositioned. If the position is correct, the MAG-cut® tool has to be fixed by using the provided tape. Fixing the tools allows higher printing speed.



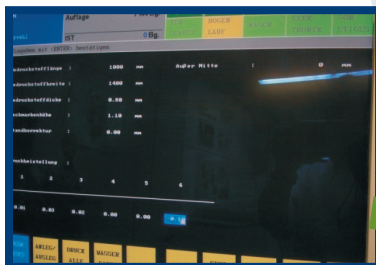
1



3

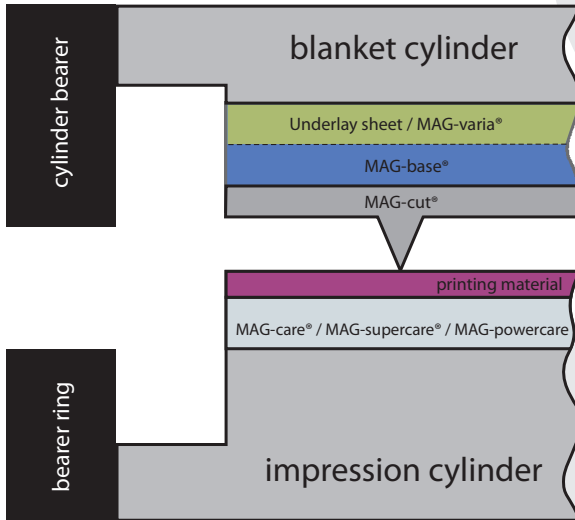


4



9

## CROSS SECTIONAL PUNCHING AREA



## UNDERLAY CALCULATING CHART

Nip width	MAG-care®	Tool height 0,80 mm	Tool height 0,45 mm
Undercut	MAG-supercare®	Underlay	Underlay
2,0 mm	0,25 mm	not possible	0,00 mm
2,3 mm	0,25 mm	0,00 mm	0,35 mm
2,6 mm	0,25 mm	0,30 mm	0,65 mm
3,2 mm	0,25 mm	0,90 mm	1,25 mm

Please use calibrated underlay paper or MAG-varia®. The MAG-varia® has to be used for emboss.

## TIPS & TRICKS

The NIP-width should be reduced by 1/100 mm step by step, in order to cut the paper/ material - not the protective sheet on impression protection.

*Excessive impression pressure reduces the lifetime of the MAG-cut® tool.*

For repeating jobs, the MAG-cut® tool has to be in a good condition.  
***Do not use damaged tools.***

For storage, MAG-cut® tools has to be cleaned and applied with acid free oil. Store it into anti corrosive paper.

For your own safety, always wear protective gloves while installing of MAG-base® / MAG-cut®-tools and applying protective sheets on the impression cylinder.

Specialists use printing plates instead of underlay paper.

For mounting the protective sheet, let it run reverse (under pressure) together with the blanket.

## STANDARD TOOL HIGHT

0,45 mm for printing material in range of 0,06 mm - 15 mm

0,80 mm for printing material in range of 0,16 mm - 30 mm

1,00 mm for printing material in range of 0,35 mm - 40 mm

Other tool heights on request.

*Use only products from WSD® GmbH. This is very important, because the tools, impression cylinder protections and the underlay foils are optimized in hardness for optimum durability.*



*Distributed worldwide...*

**WSD**<sup>®</sup> GmbH   
Innovative Stanzlösungen  
*innovative cutting solutions*

Otto-Hahn-Str. 63, 48529 Nordhorn

phone: +49 (0) 59 21 / 81 987 - 0

fax: +49 (0) 59 21 / 81 987 - 29

mail: [info@wsd-stanzen.de](mailto:info@wsd-stanzen.de)

web: [www.wsd-stanzen.de](http://www.wsd-stanzen.de)



**GREEN**line production.

Protect the environment – emission reducing strategies

