

KOENIG & BAUER

Sheet Handling Systems



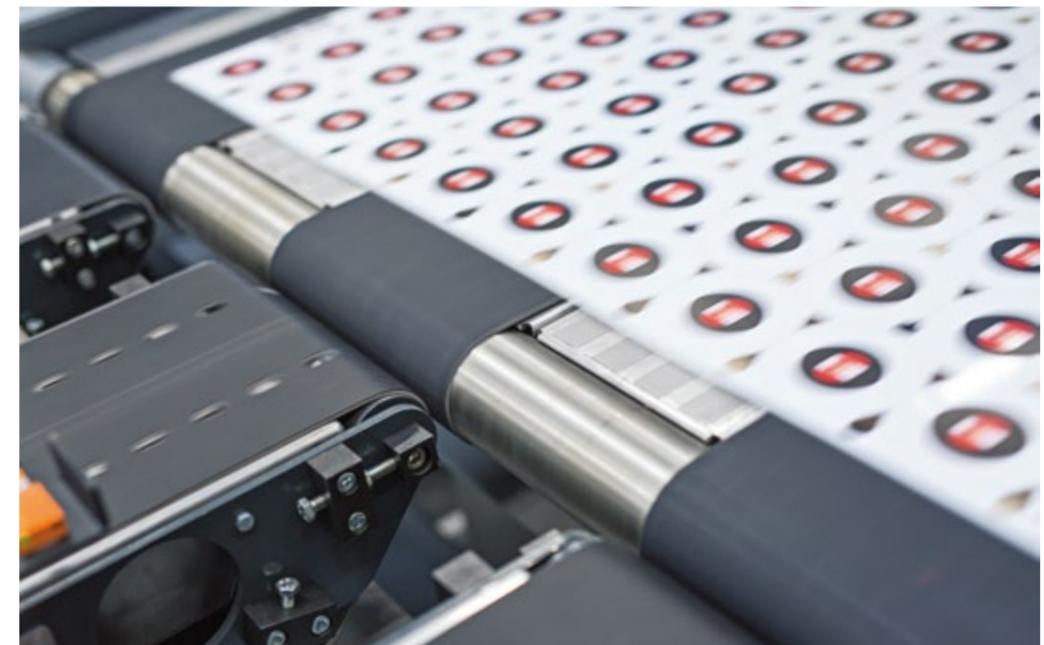
we're on it.



Koenig & Bauer MetalPrint GmbH

As a system supplier to the metal packaging industry, we at Koenig & Bauer MetalPrint offer innovative systems for the metal decoration market. Koenig & Bauer MetalPrint supplies complete production lines for the printing, coating and drying of tinplate and aluminium sheets. The product range comprises multicolour printing presses and coating machines in combination with thermal drying ovens or UV curing systems. Further areas of specialisation are material handling systems and state-of-the-art, energy-efficient installations for exhaust air purification.

The name Koenig & Bauer MetalPrint stands for quality, innovation and continuous further development. We offer complete solutions which are tailored specifically to the customer's individual requirements.



Solutions in **Sheet Handling** – Optimise Processes & Increase Efficiency

Whether before, in, or directly behind the production line – metal decoration is a logistical challenge in many ways. In addition to high line speeds, optimised transport processes are decisive for efficient production.



As the leading system supplier, we at Koenig & Bauer MetalPrint offer all the components necessary to ensure smooth, highly automated production, and offer individually tailored sheet handling solutions for the integration of quality assurance systems, process optimisation and automation, including adaptation to any relevant local requirements.

The product portfolio

- Pallet changers
- Feeders for printing and coating lines incl. suitable logistics
- Sheet management systems
- Wide-belt conveyors and conveyors for special purposes
- Venturi transport for ultra-stable sheet transport
- Modular stacking incl. suitable logistics
- Pile turners

Contents

Pallet changers

- 8/9** Pallet changer type 775
Pallet changer type 637

Feeders and suitable logistics

- 10/11** Feeder type 780
- 12/13** Feeder logistics

Sheet inspection

- 14/15** Sheet Management System
SMS type 881

Transport solutions

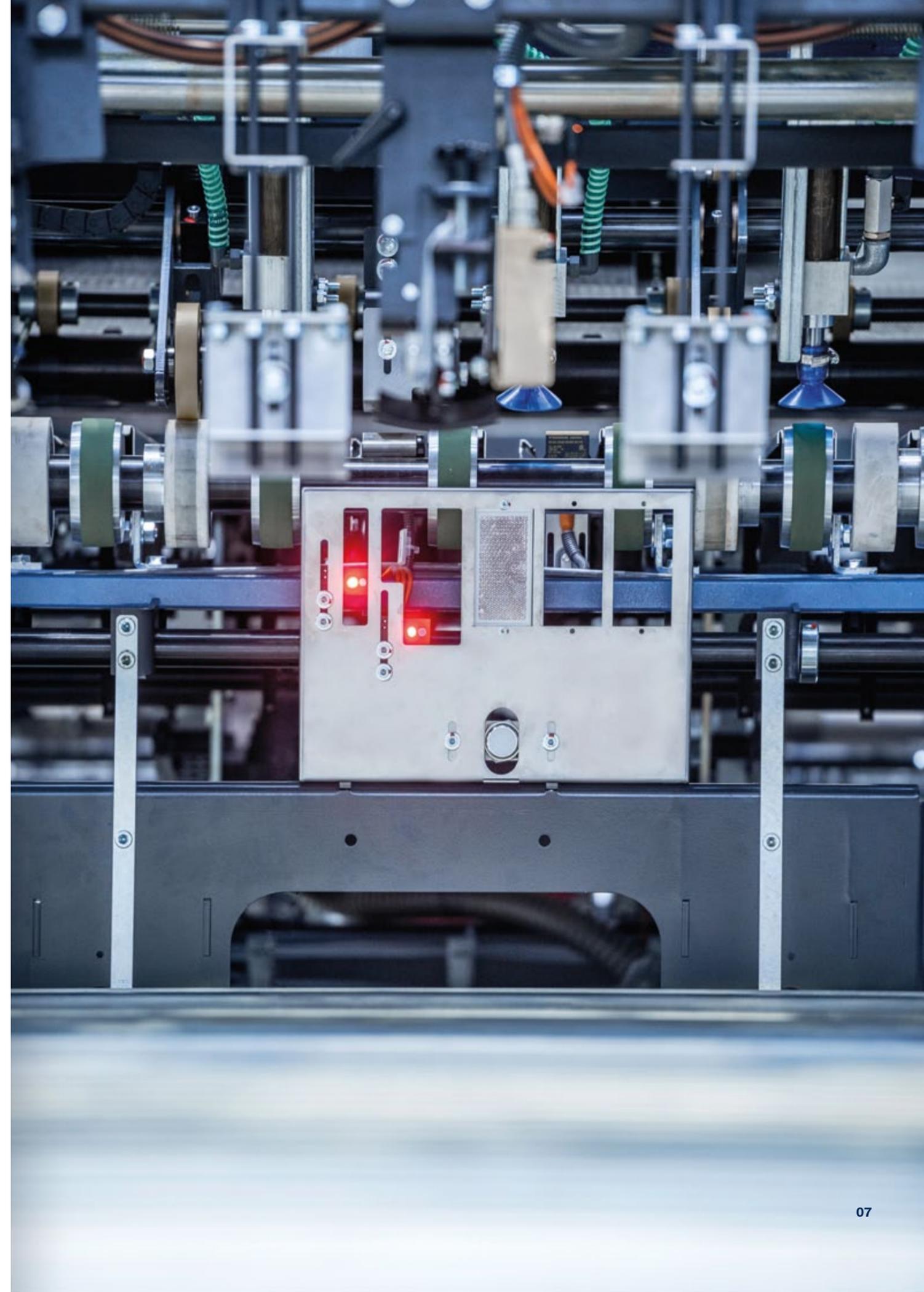
- 16/17** Bridge conveyor type 837
- 18/19** Wide belt conveyor type 831
Wide belt conveyor type 832
- 20/21** Inspection conveyor type 839
- 22/23** Round belt conveyor and
Venturi transport

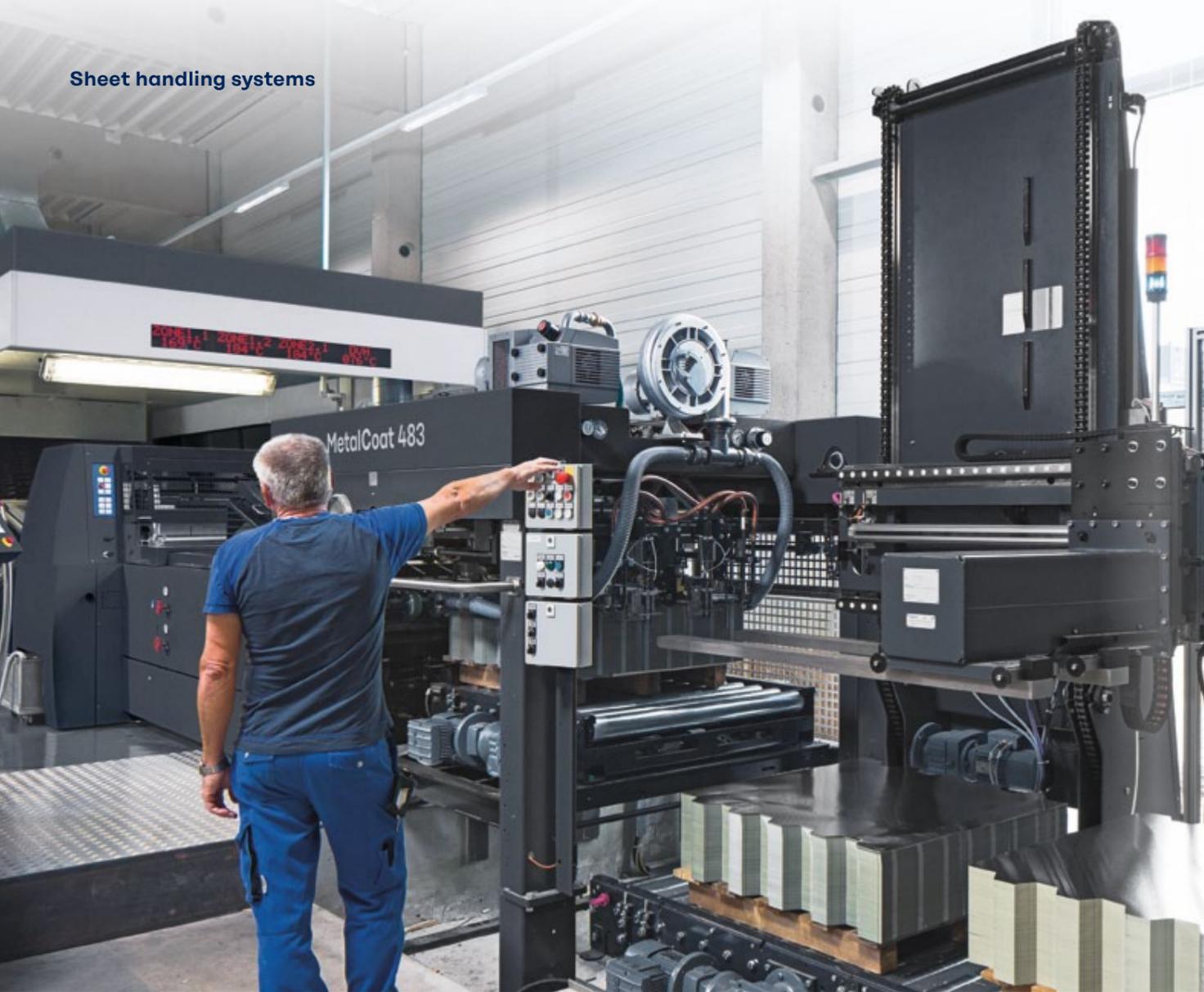
Stacking and suitable logistics

- 24/25** Stacker type 806
Dynamic sheet control
- 26/27** Stacker type 806
MagStack / VacStack
- 28/29** Stacker logistics

Pile turners

- 30/31** Pile turner type 822
- 32/33** Pile turner type 821





Pallet Changer Systems Type 775 / Type 637

The pallet changer reduces pallet changeover times to 20–30 seconds¹. That alone is a basis for a significant increase in productivity and a considerable reduction in energy requirements as well – especially in conventional lines with thermal ovens.

Semi-automatic pallet changer, type 775 for feeder 780 on coating lines



Functional principle

1. The forks remain in a waiting position until the remaining pile is reduced to a defined height.
2. As soon as this height is reached, the operator receives a signal that the forks must be inserted under the pallet in the feeder.
3. The forks now continue lifting of the pile and the main pile frame can be lowered.
4. A new pile can now be placed on the frame and raised to a waiting position under the forks, where it is aligned using Stop&Turn².
5. When the pile in the feeder is empty, the forks automatically remove the empty wooden pallet.
6. The new pile is then raised by the operator, and production resumes as soon as the pallet reaches its top position in the feeder.

Good to know: standard wooden pallets can also be used – minimum runner height 65 mm.



Fully-automatic pallet changer, type 637 for MetalStar 4

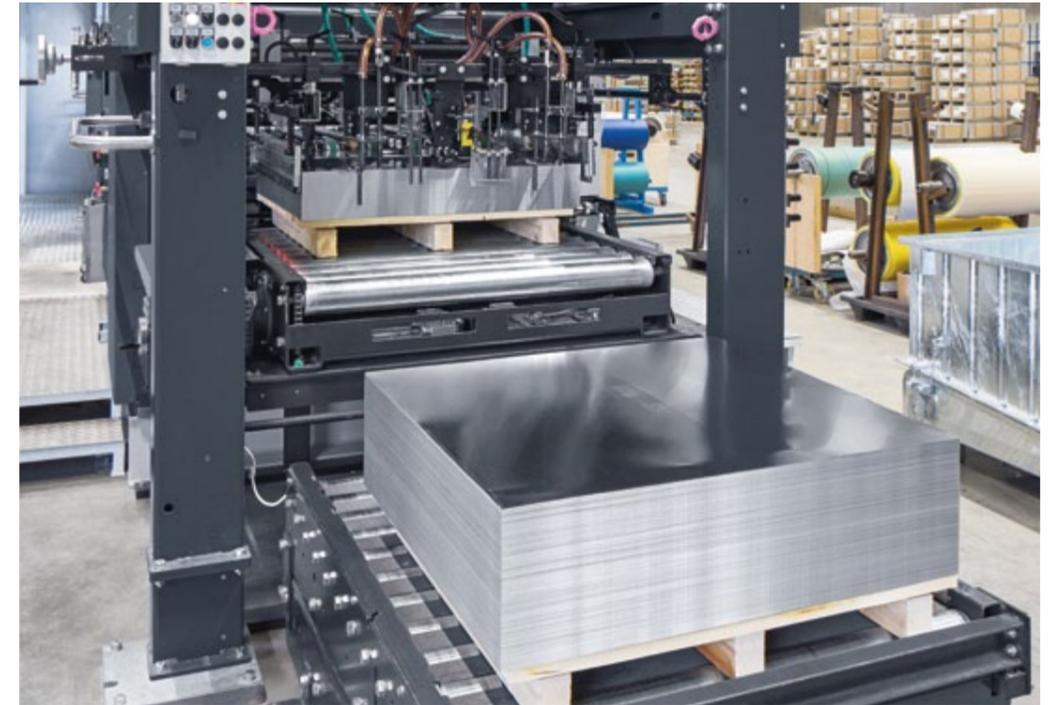
Specifications	Pallet changer, type 775		Pallet changer, type 637	
	approx. 300 kg	approx. 661.39 lbs	approx. 380 kg	approx. 837.76 lbs
Maximum weight of pile for fork	500 mm	19.69 in	750 mm	29.53 in
Maximum pile height with pallet (corresponds to max. clearance height)	720 mm ³	28.35 in ³		
Minimum pallet skid height	65 mm	2.56 in	65 mm	2.56 in
Length without roller conveyor	2280 mm	89.76 in	not available	not available
Length including standard roller conveyor	2410 mm	94.88 in	7155 mm approx. 5800 mm ⁴	281.69 in approx. 228.35 in ⁴
Width	2180 mm	85.83 in	3290 mm	129.53 in
Height	3345 mm	131.69 in	2200 mm	86.61 in

¹ Subjective factors can limit information; Stop&Turn is a prerequisite.

² Stop&Turn is a prerequisite for an optimal changing process.

³ When plinth-mounted.

⁴ With Stop&Turn at the feeder; outside feeder.



Option: Stop&Turn with laser-assisted pile centring

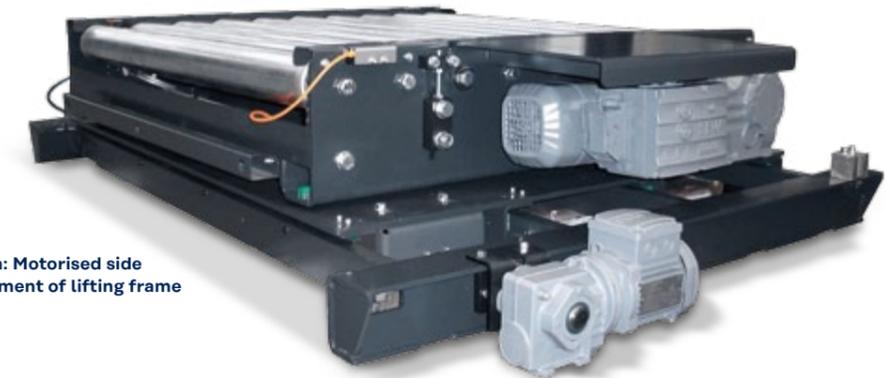
High-Performance Single Sheet Feeding Feeder Type 780

Productivity doesn't start just anywhere – it starts right at the beginning. The reliable single sheet feeder type 780 lets you meet the challenges of modern daily production and ensure a consistent and stable production process – whether on the Mailänder or a coating line.

Key facts

- Designed for high speed and large sheet formats
- **New standard:** Continuous pile lifting during production
- Suitable for tinplates, TFS as well as aluminium sheets (optional)
- Remote feed start from main control panel
- Clearly arranged operating console
- Fast lifting and lowering of pile frame
- Ongoing control of pile height during sheet feeding
- Lifting frame stops automatically after last sheet has been removed, which prevents feed of any non-metal material
- Double sheet ejection system
- Permanent magnets and blowing nozzles to separate sheets
- Reduced noise level due to specially developed blowing nozzles
- Freely adjustable magnets at side guides for sheet separation
- Format setting and pile centring by handwheel
- Adjustable sheet arrival while machine is operating for optimised sheet conveyance to the infeed table
- Oil-free compressor and vacuum pump for low maintenance requirements

Option: Motorised side adjustment of lifting frame



Further available options

- Automated pallet changer for reducing the pile change time to 20–30 seconds
- Motorised roller conveyor sections
- Pallet side feeding and unloading system
- Customised conveyor solutions for flexible pallet logistics
- Stop&Turn device with turntable for faster pile alignment and less damages
- Laser-assisted pile centring
- Motorised side adjustment of lifting frame instead of manual adjustment
- Special sheet guiding systems for scroll sheets
- Overhead magnet bars with rollers for scroll sheets
- Air blowing nozzles at side guides to separate aluminium sheets
- Anti-flecking system for flame treatment of the sheets
- Sheet straightening device

Customised Feeder Logistics

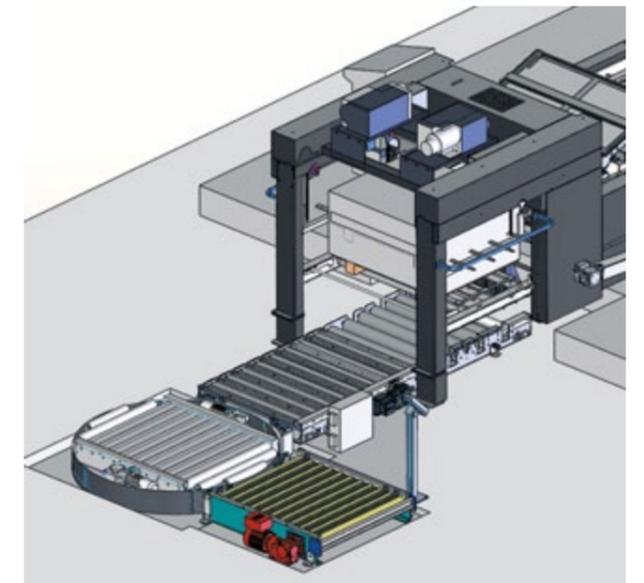
We offer a diversity of solutions tailored to your individual needs and the space available – the perfect basis for a smooth production process.



Side chain conveyor for feeder 780

Solutions for every use case

- Stop&Turn functionality for fast, convenient and automatic front alignment of the pallet for feeder type 780 and type 631/632 (MetalStar)
- Roller conveyor extensions with or without Stop&Turn
- Facilities for pallet loading from one or two sides within the feeder frame
- Single-side chain conveyor outside the feeder frame in combination with a roller conveyor
- Side chain conveyors in various lengths and for different transport weights
- Turntables 90° – 180°



Roller conveyor with turntable for feeder type 780

Your benefits

- Fast pile changes
- Better access to the production line with forklifts
- Easier and faster loading and unloading

Sheet Management System SMS Type 881

Reliable and damage-free ejection and re-insertion of inspected sheets at maximum production speed. Also available with safe and convenient waste sheet ejection for the re-use of sheets in make-ready processes.



Ejection only

1. In the basic version, a single sheet can be ejected smoothly for inspection during ongoing production

Ejection + Re-insertion

1. This variant combines ejection with a function for re-insertion at full production speed
2. After inspection, the sheet is re-inserted precisely into the gap produced when the next inspection sheet is ejected

Ejection + Ejection via waste box

1. For this variant, a waste box is added to the SMS
2. A pre-selected number of waste sheets (up to a maximum height of 200 mm, including pallet) can be ejected automatically. These waste sheets can then be removed at the side with the aid of a trolley
3. The waste box is equipped with motorised format setting as standard

Ejection + Re-insertion + Ejection via waste box

1. This is the full configuration level of the SMS – it ultimately combines the versions 2 & 3



SMS

The Sheet Management System features a modular design that allows it to be integrated into the line as one of four different versions. All four variants use sheet transport based on wide belts as standard, which makes format-specific adjustment superfluous – less make-ready time and reduced risk of operating errors in your production processes!

Your benefits

- Maximum operating convenience
- Safe and reliable handling
- High level of operator safety
- Efficient use of resources and assured production quality

Optional features

- A further option for the waste box is a freely mobile roller trolley
- An interface to an image inspection system can be supplied upon request
- Waste box is fitted with a magnetic overhead sheet brake for stacking that is even more accurate

Specifications

	SMS Sheet Management System, type 881	
Maximum sheet size	1000 x 1200 mm	39.37 x 47.24 in
Minimum sheet size	510 x 710 mm	20.08 x 27.95 in
Sheet thickness standard	0.12 – 0.50 mm (0.100 mm upon request) ²	0.0047 – 0.0197 in (0.00394" upon request) ²
Maximum sheet weight	2.6 kg	5.73 lbs
Maximum speed ¹	up to 8500 sheets/h	up to 141 spm
Maximum weight of pile in waste sheet stacker	approx. 300 kg	approx. 661.39 lbs
Maximum pile height with pallet in waste sheet stacker	200 mm	7.87 in

¹ The specified speed is the maximum mechanical running speed. The maximum speed actually attainable in production is dependent on the substrate, the quality of the materials used and other internal production conditions.

² Transport and handling of sheets with thickness 0.1 mm must be checked at the SMS; additional components may be required; other line components must be taken into account.

Bridge Conveyor – Maximum Flexibility in One Production Line

A bridge conveyor enables sheets to be passed from a printing line to a subsequent coating line. It separates and links both lines – depending on what the order situation requires – giving you maximum flexibility.

Applications

- Telescopically extendable bridge conveyor between two production lines in combination with an intermediate feeder serving the downstream line
- In combination with stacking at the end of the upstream line, the bridge conveyor incorporates front stops for realignment of the sheets
- Or in combination with stacker type 806 with dynamic sheet control for an upstream conventional line
- Or with stacker type 806 MagStack / VacStack for an upstream UV or UV-LED printing line



Bridge conveyor with additional front edge alignment in combination with an intermediate feeder (viewed from the drive side with second bridge conveyor following)



Two bridge conveyors for connecting two production lines by bridging stacker (upstream line) and feeder (downstream line)

Your benefits

- Splitting of one line into two independent single lines
- Combination of two lines into production line

Bridge conveyor in combination with stacker type 806 (viewed from the operating side)

Wide Belt Conveyors – Customer-Oriented Solutions for Printing and Coating Lines

Wide belt conveyors are available in different lengths and versions

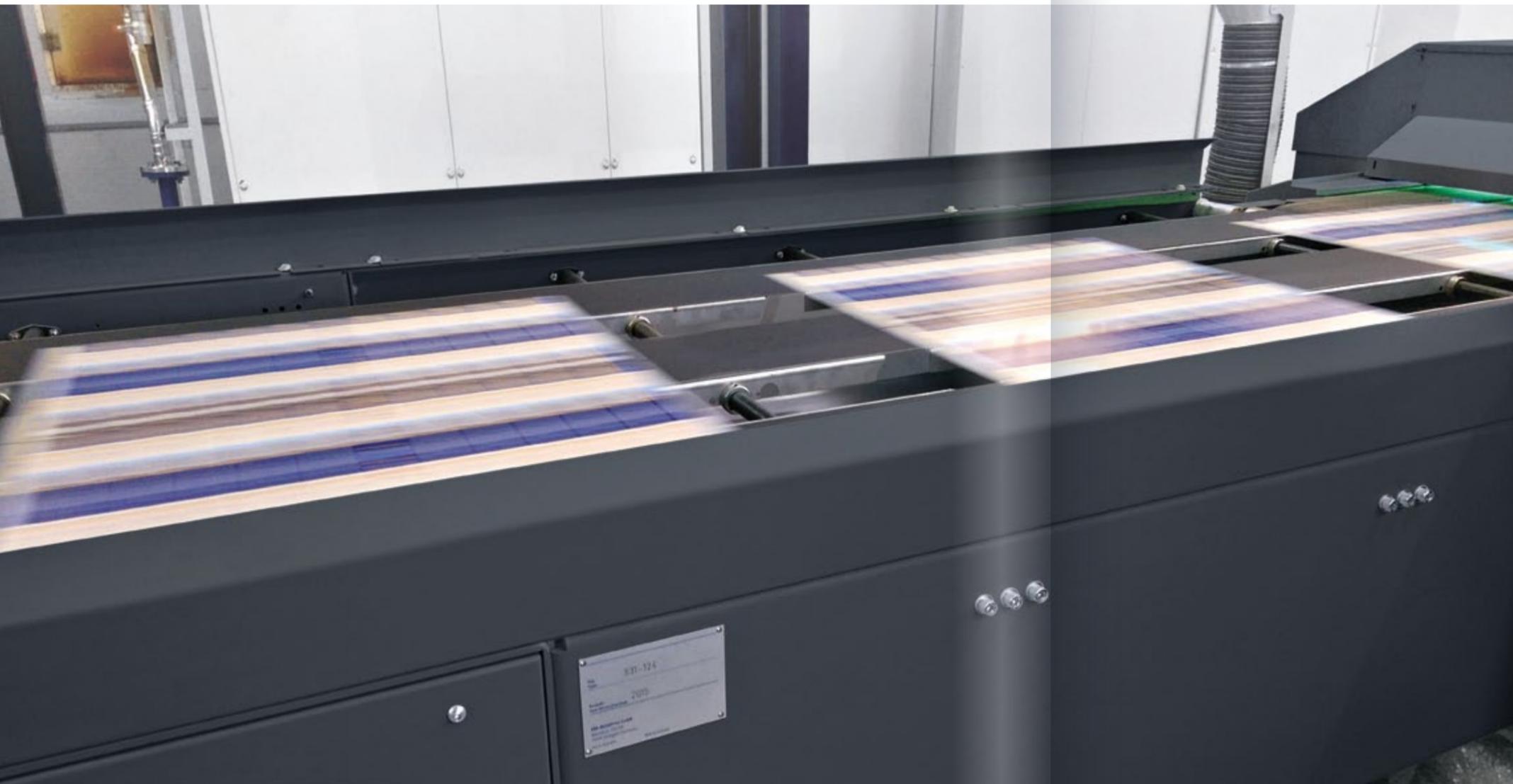
- For image inspection systems
- As an extension/flow-out zone after a MetalCoat 470/480/483 coating machine or as an integrated coater on a MetalStar 4 prior to UV or UV-LED final drying
- For height compensation between two line components
- As a conveyor for UV or UV-LED final drying
- After a UV or UV-LED backside dryer
- FDA-compliant belts available for all wide belt conveyor systems



Wide belt conveyor for image inspection systems



Sheet transport after a UV backside dryer



Flow-out zone / wide belt conveyor with sheets



Wide belt conveyor as height compensation



UV final dryer



Quality Assurance at the Highest Level – The Conveyor for Double-Sided Sheet Inspection

To meet the increasing demands for higher quality, the inspection conveyor establishes unbeatable evidence in the area of quality assurance. This safeguards today's process, minimises customer complaints, and at the same time lays the foundation for future efficiency in day-to-day production.

The transport system with partial overhead transport enables 100 percent quality control – integrated into the existing printing and coating process.

This is achieved by a sheet transport system that offers unprecedented stability and precision when it comes to the inspection of sheets. Never before has it been so easy to realise a complete inspection of the running production inline. Thanks to

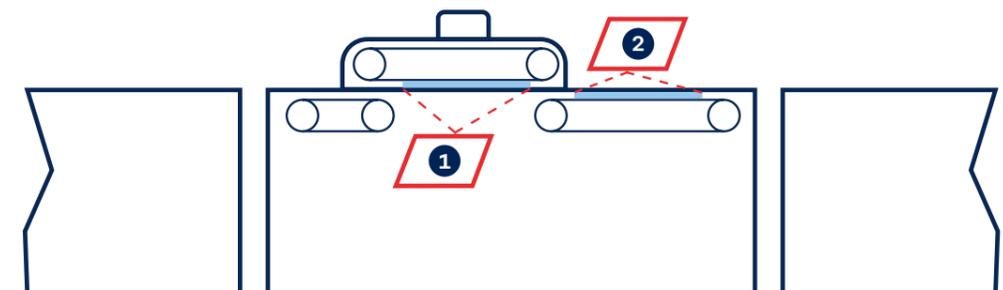
the modular design – with an installation length identical to the familiar standard wide belt conveyor – there are virtually no limits to integration into printing and coating lines. Whether as a retrofit to replace a wide belt conveyor after the UV or UV-LED final dryer, or as part of your new coating line – the inspection conveyor will allow you to meet the increasingly stringent quality requirements in the metal packaging market.

Applications

UV printing line (Inspection conveyor: Position and style of integration in line)	Inspection & reporting	+ Ejection of faulty sheets
Behind the final dryer	■	
Behind the final dryer and with a 3.18 m wide belt conveyor downstream	■	■ (via makubox at the stacker)
Behind the final dryer and with SMS ejection and re-insertion downstream	■	■ (via makubox at the stacker)
Behind the final dryer and with a 3.18 m wide belt conveyor and SMS (with waste stacking) downstream	■	■ (via makubox at the SMS or with makubox at the stacker)
Conventional coating line (Inspection conveyor: Position and style of integration in line)	Inspection & reporting	+ Ejection of faulty sheets
Behind the oven	■	
Behind the oven and with a 3.18 m wide belt conveyor downstream	■	■ (via makubox at the stacker)
Behind the oven and with SMS ejection and re-insertion downstream	■	■ (via makubox at the stacker)
Behind the final dryer and with a 3.18 m wide belt conveyor and SMS (with makubox) downstream	■	■ (via makubox at the SMS or with makubox at the stacker)
Offline inspection line (Inspection conveyor: Position and style of integration in line)	Inspection & reporting	+ Ejection of faulty sheets
Behind the feeder	■	
Behind the feeder and with a 3.18 m wide belt conveyor downstream	■	■ (via makubox at the stacker)
Behind the feeder and with SMS ejection and re-insertion downstream	■	■ (via makubox at the stacker)
Behind the feeder and with a 3.18 m wide belt conveyor and SMS (with makubox) downstream	■	■ (via makubox at the SMS or with makubox at the stacker)

Optional features

1. ISRA CoatStar for inspection of the backside*
2. ISRA DecoStar for inspection of the frontside**



Process principle

* CoatStar for inspection of the frontside upon request
**DecoStar for inspection of the backside upon request



Round belt transportation bridge and dynamic sheet control for loading machines.

Delivery Table, Transportation Bridge and Loading plus Unloading

Round belt conveyors have become established after the coating process. The new and innovative Venturi technology offers even more advantages.

Conveyors for coating lines – the right solution for each requirement

	Delivery	Transport	Loading	Unloading
Standard	Round belt delivery	Round belt transportation bridge available in different lengths	Loading machine type 801	Unloading machine type 802 with dynamic sheet accelerator
Variant/Option	Venturi delivery	Venturi transport	Dynamic vacuum sheet control – with narrow belts – with round belts – with Venturi transportation	Unloading machine type 802 with Venturi transportation and dynamic sheet accelerator

Loading and unloading

The dynamic sheet control system for the loading machine and the dynamic sheet accelerator for the unloading machine ensure slippage free and precise positioning of the sheets. Even at the highest speeds, the sheet is held in the correct place.

Delivery and transport table

The delivery conveys the tin or aluminium sheet from the coating machine to the following line components, e.g. the round belt transportation bridge.

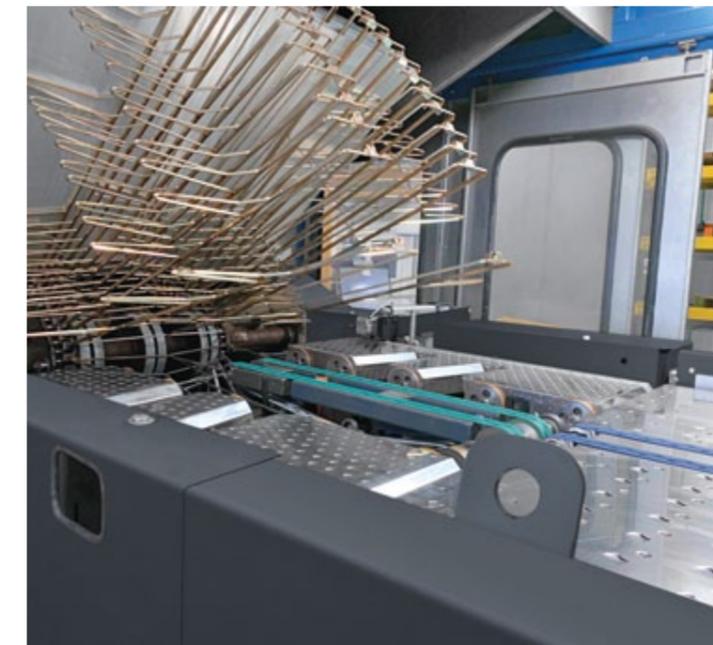
- Safe conveyance of the metal sheets by round belts
- Small contact surfaces between the round belts and the sheet
- Fast format adjustments
- Low cleaning effort

New: The innovative Venturi technology for highest productivity

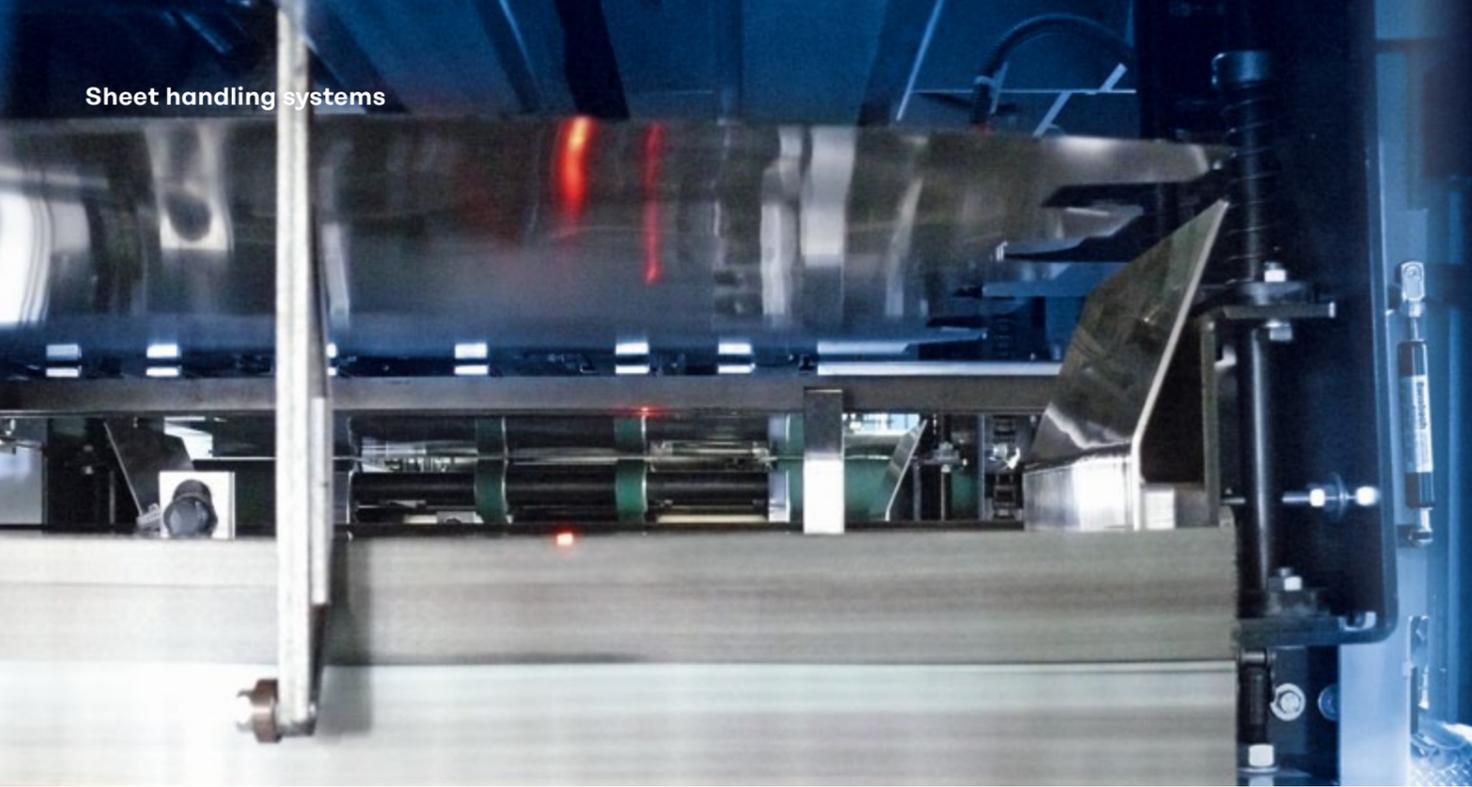
The innovative Venturi sheet transportation system is available for the delivery, transport, loading and unloading machine. Air nozzles generate a uniform air cushion on which the sheet can move. Only two narrow vacuum belts, positioned in the middle of the table, are required to ensure precise sheet transport. The result: stable production even at high production speed. This is especially advantageous for thin materials and scroll sheets. Finally, the set-up times can be shortened, as there is no longer any need for format adjustments.

Additional advantages of using Venturi technology for all types of transportation

- Extremely reliable and precise sheet transport using vacuum belts
- Fewer contact points between the sheet and transportation table due to air cushion transportation
- Fewer crashes due to contact-reduced sheet transfer
- No adaptations to sheet size necessary
- Easy to clean
- Fewer wear parts



Venturi transport and loading machine with dynamic sheet control



Specifications

	Stacker, type 806 dynamic sheet control	
Maximum sheet size	1000 x 1200 mm	39.37 x 47.24 in
Minimum sheet size	510 x 710 mm	20.08 x 27.95 in
Sheet thickness standard	0.12 – 0.50 mm (0.100 mm upon request) ²	0.0047 – 0.0197 in (0.00394" upon request) ²
Maximum sheet weight	2.6 kg	5.73 lbs
Maximum speed ¹	up to 7000 sheets/h	up to 116 spm
Maximum weight of pile with pallet	approx. 3500 kg	approx. 7716.18 lbs

¹ The specified speed is the maximum mechanical running speed. The maximum speed actually attainable in production is dependent on the substrate, the quality of the materials used and other internal production conditions.

² Transport and handling of sheets with thickness 0.1 mm must be checked at the Stacker; additional components may be required; other line components must be taken into account.

Stacker – Type 806

Reliable and established technology.

The stacker type 806 is fitted with a dynamic sheet brake as standard. The sheets are decelerated dynamically by way of a vacuum acting on the underside, and then deposited gently into the stacker box with the aid of an adjustable air cushion. To achieve this, the sheets are aligned using spring front stops and side guides. This stacker is only available as a single-box unit.

As an option, the stacker can be equipped with motorised adjustment for all format-dependent components via a touchscreen display.



Single-box stacker type 806 with dynamic sheet control

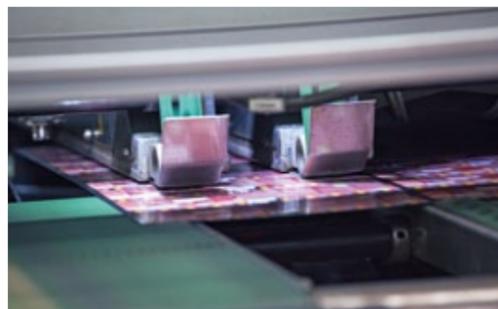
Stacker – Type 806 MagStack / VacStack

Technology at its finest! Absolutely reliable and scratch-free stacking at maximum production speed.



Double-box stacking unit in a MetalStar 3 printing line

The high-tech stacker type 806 MagStack / VacStack features a dynamic overhead brake and is designed for absolutely damage-free stacking at the highest speeds. The design enables configuration in single, double and triple box versions.



- The suspended sheets are held from above using either magnets (MagStack) or vacuum (VacStack); under electronic control, this allows them to be slowed down from production speed to zero at precisely the right time to be dropped vertically
- The benefits are precise and scratch-free stacking at the maximum possible speed
- Suitable for tinplate, ECCS (TFS) and aluminium sheets (VacStack only)
- This form of stacking is ideal for scroll sheets and – as the MagStack version – is also extremely quiet
- To enable non-stop operation, the modular stacker can be configured as a double-box unit

Overhead sheet brake



Stacker

Triple-box stacking

- At the double stacker, one of the boxes can optionally be defined as a waste stacking unit. Alternatively, extending the double box into a triple box can provide an additional box specifically for stacking waste sheets
- As an option, the stacker can be equipped with motorised adjustment of all format-dependent components via a touchscreen display
- Interface to an image inspection system for controlled and automatic ejection of faulty sheets upon request

Your benefits

- Quiet and damage-free stacking
- Maximum production output even with sensitive materials
- Operator-friendly
- Non-stop production
- High level of automation reduces make-ready times
- High productivity



Specifications

	Stacker, type 806 MagStack / VacStack	
Maximum sheet size	1000 x 1200 mm	39.37 x 47.24 in
Minimum sheet size	510 x 710 mm	20.08 x 27.95 in
Sheet thickness standard	0.12 – 0.50 mm (0.100 mm upon request) ²	0.0047 – 0.0197 in (0.00394" upon request) ²
Maximum sheet weight	2.6 kg	5.73 lbs
Maximum speed ¹	up to 8500 sheets/h	up to 141 spm
Maximum weight of pile with pallet	3500 kg	7716.18 lbs

¹ The specified speed is the maximum mechanical running speed. The maximum speed actually attainable in production is dependent on the substrate, the quality of the materials used and other internal production conditions.

² Transport and handling of sheets with thickness 0.1 mm must be checked at the stacker; additional components may be required; other line components must be taken into account.

Customised Stacker Logistics

We offer a diversity of solutions customised to your individual needs and the space available – the perfect basis for a smooth production process.



Triple-box stacking including waste sheet stacking and side chain conveyor

Solutions for every use case

- Roller conveyor extensions as stack buffer zone
- Roller conveyors with geared drive for jerk-free transport (recommended for slippery sheets)
- Stack removal by either roller conveyor or side chain conveyor
- Turntables 90° – 180°
- Inline pile turner type 821

Your benefits

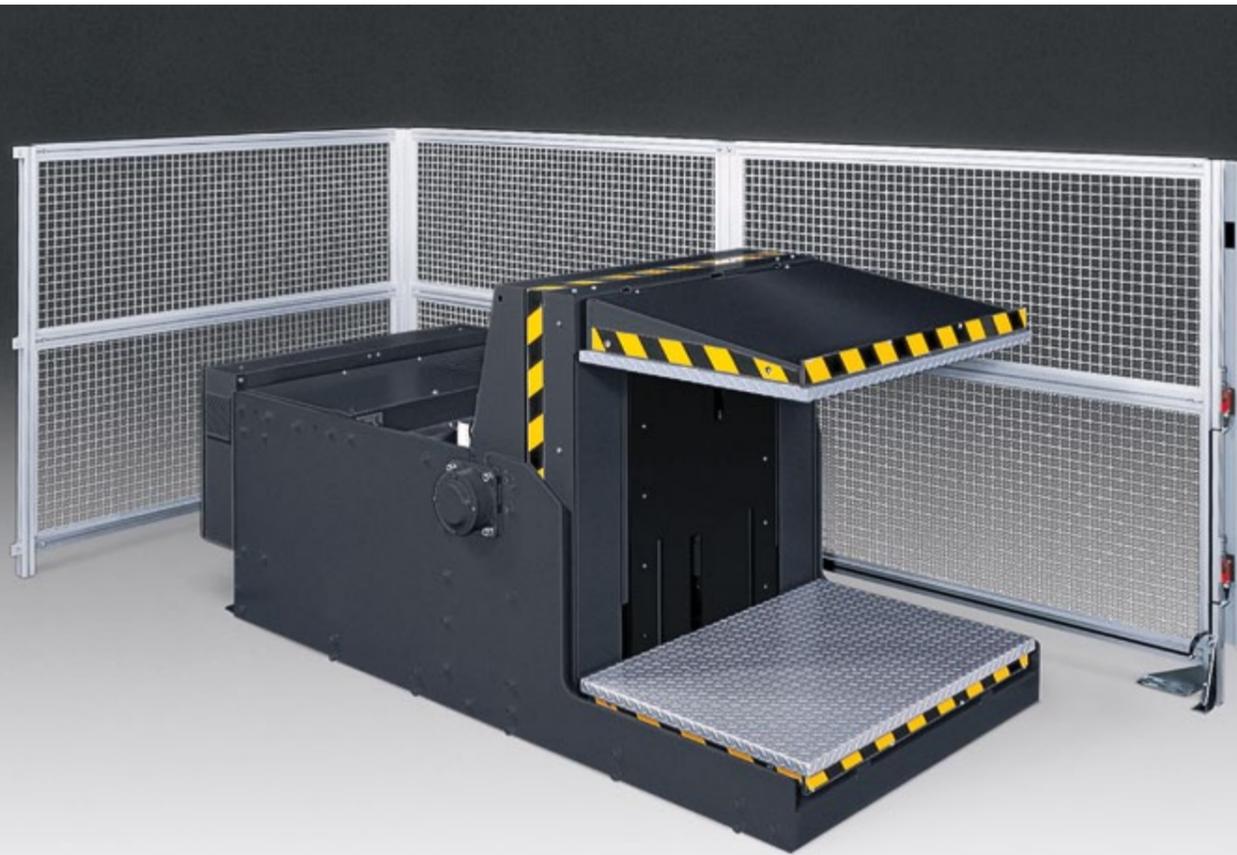
- Better access to the production line with forklifts
- Smooth pile changes
- Easier and faster unloading incl. possibility of inline preparation for next process step



Optional stack removal via a side chain conveyor

Pile Turner – Type 822

The hydraulic pile turner 822 is designed for a standalone configuration (offline).



Your benefits

- Minimal space requirements resulting from single-sided operation
- Rapid operation of the unit allows the pile turner type 822 to serve up to 8 lines
- Easy access for forklift or manual lift trucks
- Damage-free turning of large and small piles
- Low pile grip pressure prevents problems due to sheets sticking

- Automatic operation
- Solid construction

Good to know: optionally available with H1 hydraulic aggregate especially for food packaging environments.

Operation

- The pile is placed in the turner by a forklift truck. A second pallet must be placed on the top (figure 1)
- A push button starts operation of the turner which proceeds through the following automatic operations:
 - The support plates close (figure 1)
 - The pile is lifted (figure 2)
 - Rotation takes place (figure 3)
 - The pile is then lowered to the original position
 - The support plates open, allowing the pile to be removed
- The pallet is removed from the top of the pile, which can then be removed by a forklift truck



Figure 1: Closing of the support plates

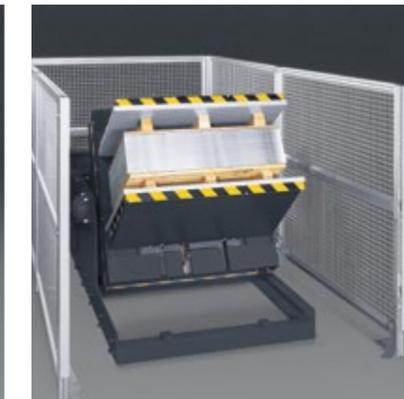


Figure 2: Lifting



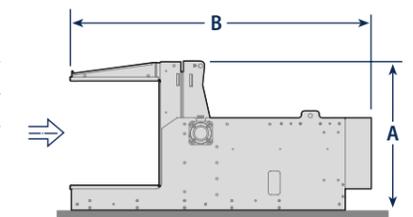
Figure 3: Turning

Specifications

	Pile turner, type 822	
Maximum pile weight	3 500 kg	7 716.18 lbs
Maximum sheet size ¹	1 000 x 1 200 mm	39.37 x 47.24 in
Size of support plates (L x W)	750 x 1 120 mm	29.52 x 44.09 in
Max. space between support plates	860 mm	33.86 in
Min. space between support plates	280 mm	11.02 in
Floor space (L x W)	2 546 x 1 422 mm	100.24 x 55.98 in
Turning time ²	approx. 50 sec.	approx. 50 sec.
Installed electrical power	9 kW	9 kW
Weight without roller conveyor ³	2 450 kg	5 401.33 lbs

Dimensions

	Pile turner, type 822	
Height of machine (A)	1 258 mm	49.53 in
Width of machine	1 422 mm	55.98 in
Length of machine (B)	2 546 mm	100.24 in



¹ Upon request, special design for larger sheet sizes available.

² Without insertion of the empty pallet.

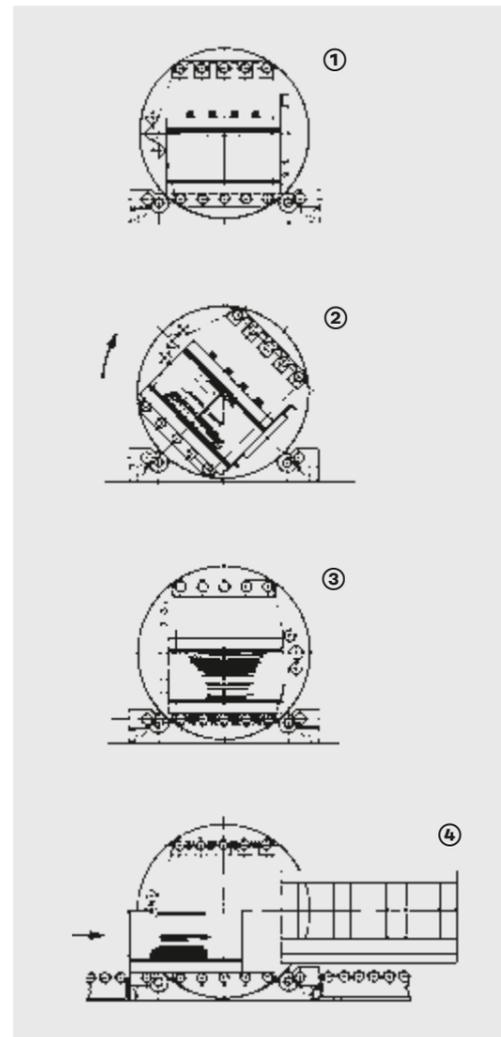
³ 2 800 kg (6 172.94 lbs) including seaworthy packing.

Pile Turner – Type 821

The 821 model pile turner can be placed behind the stacking machine as an inline unit, or be used as a free-standing machine capable of handling the output from three metal decorating lines.

Your benefits

- No pressure is applied to the pile during turning, thereby preventing sticking sheets
- Solid construction



Operating sequence – free-standing

- The pile is placed in the unit with a forklift truck. A second pallet must be placed on top of the pile.
- The upper support plate is lowered until it touches the top pallet without exerting pressure ①. Subsequently, the rotation starts automatically ②.
- After rotation, the pile is lowered and the top pallet can be removed ③.
- By pressing a control button, the turner is reversed to the starting position.

Operating sequence – inline

- The pile is lowered in the stacker.
- The electrically driven roller conveyor moves the pile into the turner. A second pallet must be placed on top of the pile.
- The upper support plate is lowered until it touches the top pallet without exerting pressure ①. Subsequently, the rotation starts automatically ②.
- After rotation, the pile is lowered and the top pallet can be removed. By pressing a control button, the pile is discharged onto a roller conveyor ③.
- The pile turner returns to the start position when a second button is pressed.

If the pile does not need to be turned, the rear wall of the pile turner can be pivoted out of the way to allow the pile to be conveyed straight through the unit ④.



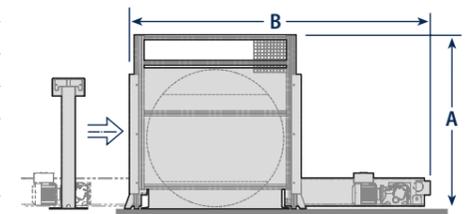
Pile turner

Specifications

	Pile turner, type 821	
Maximum pile weight	3500 kg	7716.18 lbs
Maximum sheet size ¹	1000 x 1200 mm	39.37 x 47.24 in
Size of support plates (L x W)	910 x 1350 mm	35.83 x 53.15 in
Max. space between support plates	800 mm	31.50 in
Min. space between support plates	300 mm	11.81 in
Floor space (L x W)	1360 x 2750 mm	53.54 x 108.27 in
Turning time ²	approx. 50 sec.	approx. 50 sec.
Installed electrical power	6 kW	6 kW
Weight without roller conveyor ³	2150 kg	4739.94 lbs

Dimensions

	Pile turner, type 821	
Height of machine (A)	1600 mm	62.99 in
Width of machine	2814 mm	110.79 in
Length of machine (B)	2800 mm	110.24 in
Length including standard roller conveyor when being used as 'inline pile turner'	2657 mm	104.61 in
The roller conveyor can be extended by segments of	1244 mm	48.98 in



¹ Upon request, special design for larger sheet sizes available.

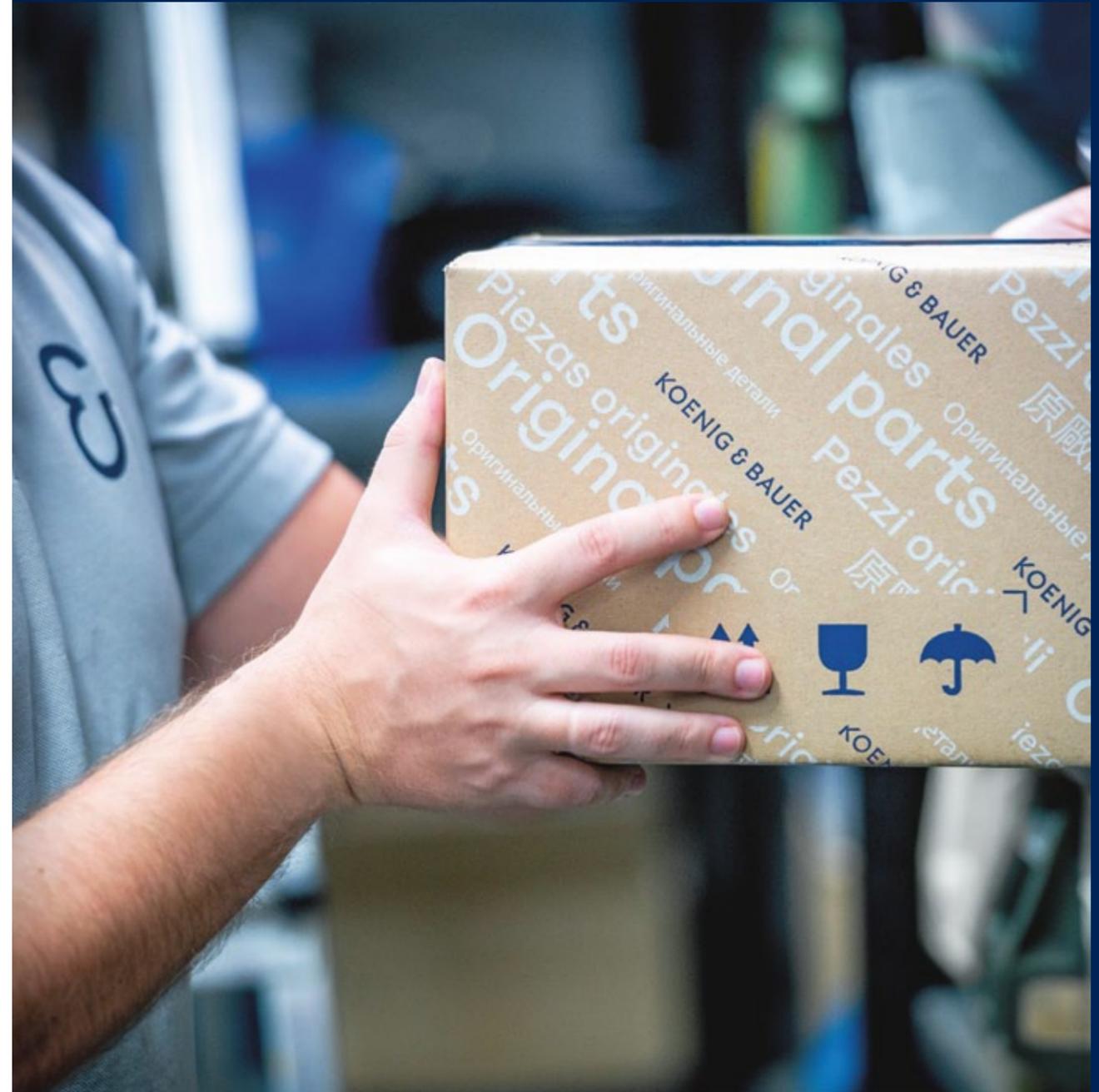
² Without loading/unloading using the roller conveyor and insertion of the empty pallet.

³ 2500 kg (5511.56 lbs) including seaworthy packing.

Professional Services for Your Koenig & Bauer MetalPrint Products

We are at your service! Our experts provide assistance and support to your production lines. All over the world and over the full service life.

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Koenig & Bauer MetalPrint GmbH

Wernerstr. 119-129
70435 Stuttgart, Germany

T +49 711 699 71-0
F +49 711 699 71-670
info-metalprint@koenig-bauer.com

metalprint.koenig-bauer.com

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