

W+D 326 BC

The universal
production system



W+D

The universal production system for envelope and pocket production

The **W+D 326 BC** offers the most variable range of format- and product-ranges – from envelopes to pockets. The complete cut technology ensures the most efficient path to productivity. Various multiple-windowing and seal-flap gumming options are possible. This machine enables you to adapt to your customers' diverse requirements and to provide individual, made-to-order products.



Features

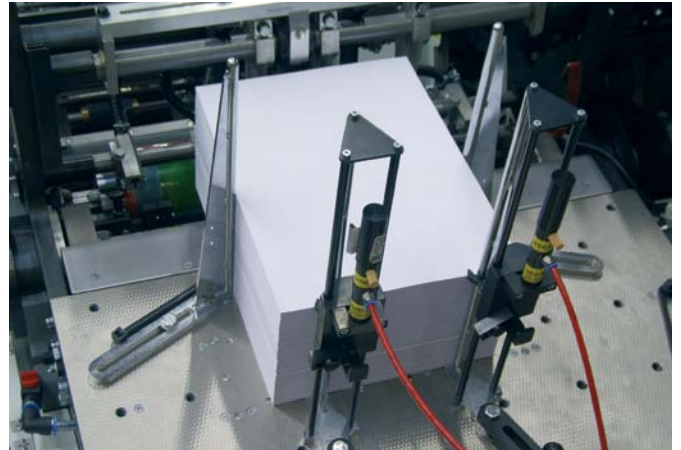
- / In-line cutting, foil patching, scoring and perforating capabilities
- / All types of envelopes and pockets for a wide size range
- / Speed up to 500 envelopes per minute
- / Quality prioritized production
- / EasyCut magnetic cylinder technology as a standard component
- / Inserting-style envelopes with inside / outside flap
- / All types of seal gumming: Seal flaps with remoistenable gumming, self-seal gumming and hot-melt pressure-sensitive gumming
- / Ideal for converting pre-printed material
- / Single or multiple windows

Advantages

- / Large size and product range
- / Space-efficient compact footprint with integrated switch cabinet
- / Easy to learn and operate
- / Superior envelope quality
- / EasyCut magnetic cylinder technologie
- / Low cost individual size tools
- / Hot-melt pressure-sensitive gumming available
- / Real-time remote diagnostic support
- / Odd size product shapes and special windows
- / Capability to work from rectangular sheets



Touch-screen for system control

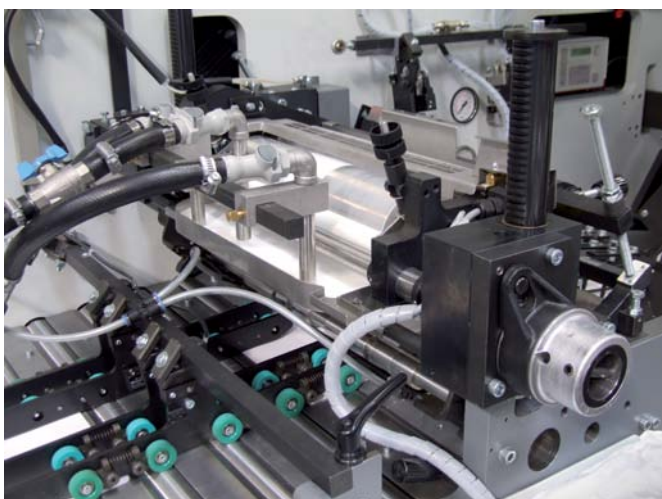


Blank feeder for blanks or rectangular sheets

Standard components

- / Blank feeder for blanks or rectangular sheets
- / EasyCut magnetic cylinder technologie
- / Display for entries, inspections, information and integrated pre-selection counter
- / Window material patching section

- / Seal flap gumming section for remoistenable and self-seal gumming
- / Gumming section for envelope side flaps and for pocket bottom flaps



Bottom flap and side flap gumming section



Seal flap gumming section



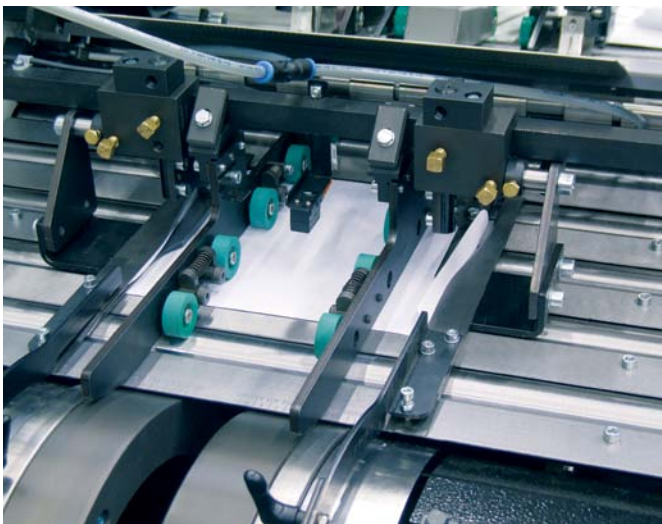
2nd window material patching section



Flexo printing unit for outside printing

Optional components

- / Flexo printing units for inside and outside printing
- / Hot-melt pressure-sensitive gumming section with silicone protective strip application
- / 2nd window material patching section
- / Tools for envelope production with outside side flaps
- / Integrated sound-proof hoods for reduced decibel levels
- / Nozzle gumming for side flaps when producing booklet format
- / Extended size range for formats up to B4 and/or K2
- / Tools for production of gusset-envelopes and bags



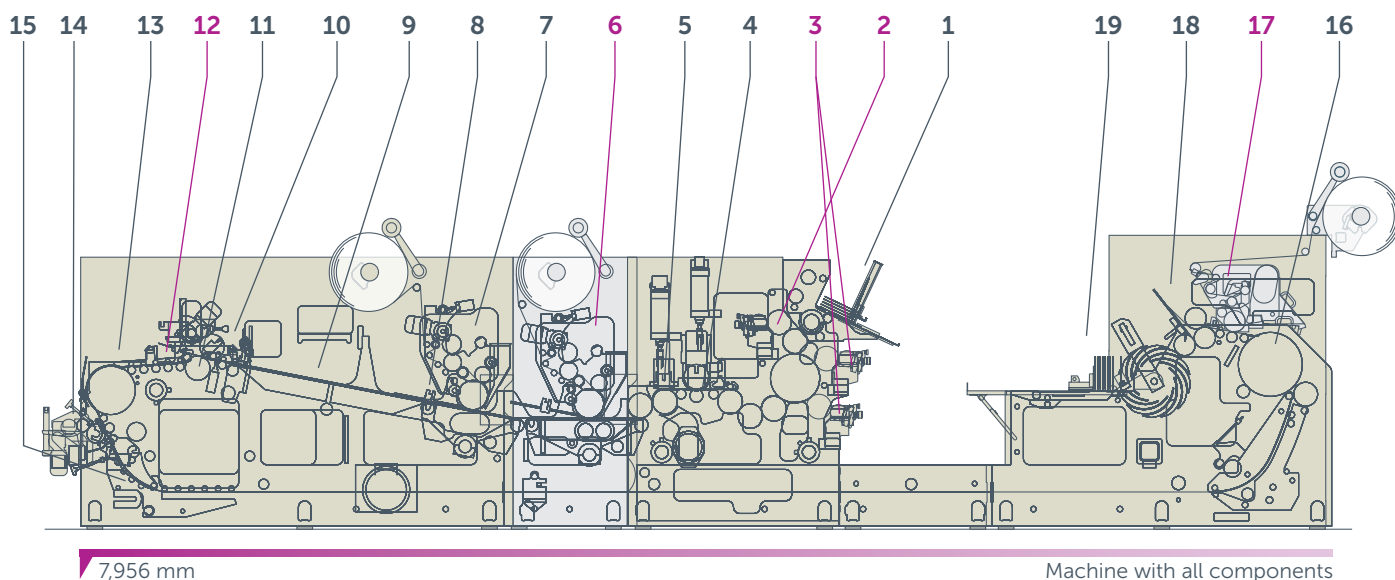
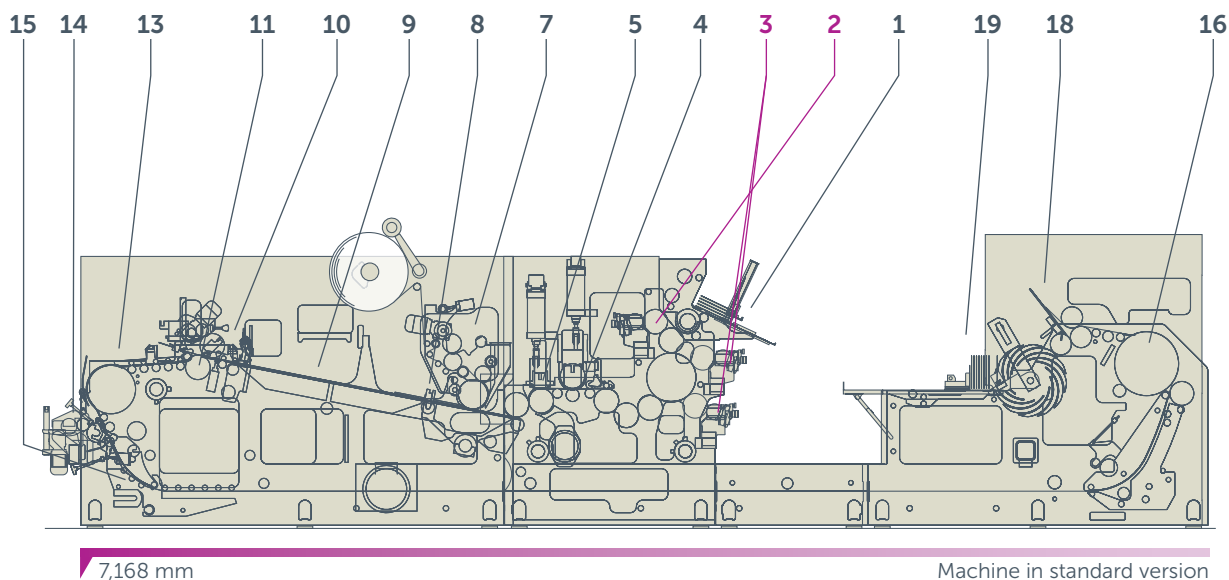
Folding tools for outside side flaps



Hot-melt pressure-sensitive gumming

Machine layout components

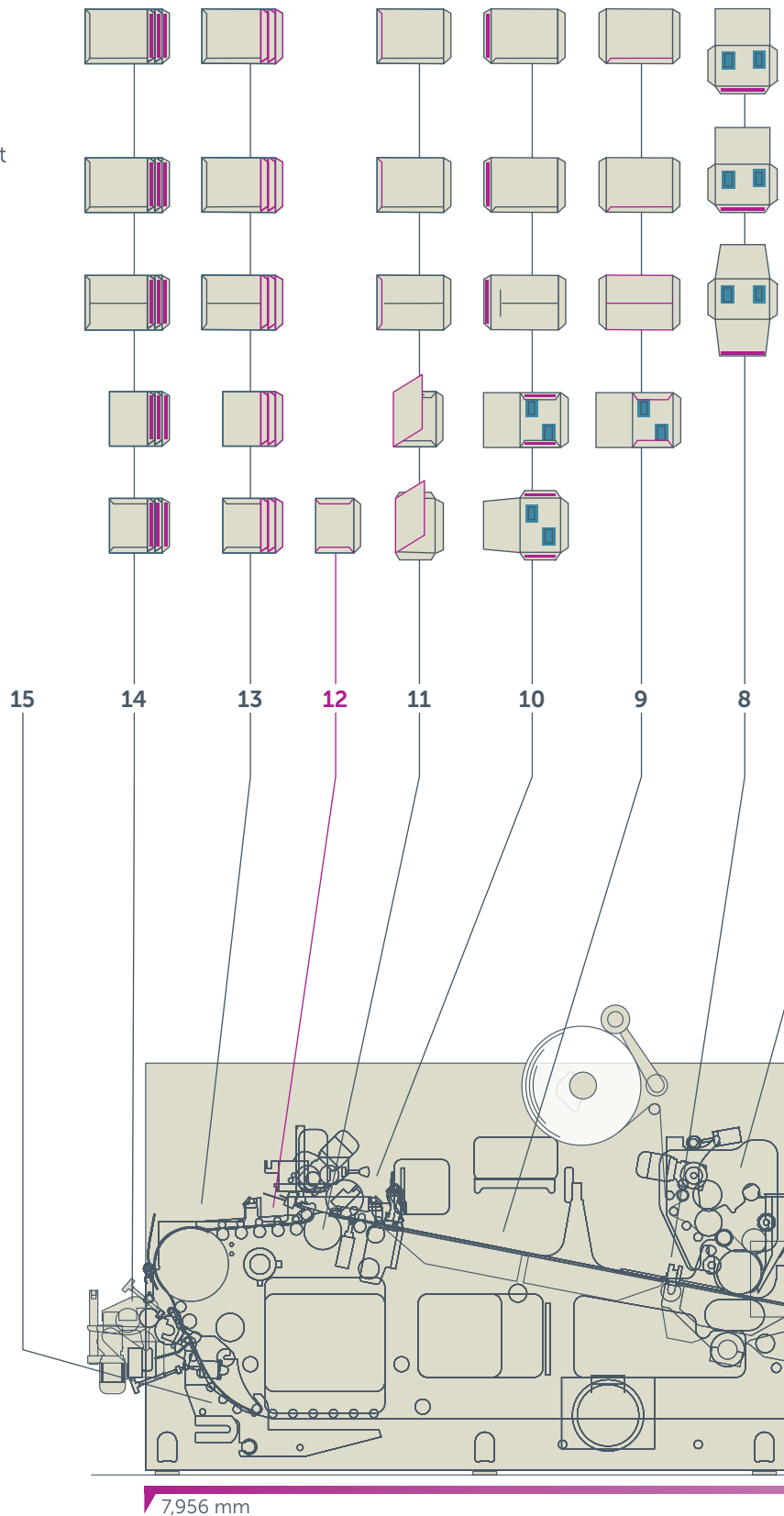
- | | |
|---|--|
| 1 Blank feeder | 12 Folding tools for outside side flaps |
| 2 Flexo printing unit for inside printing | 13 Staggering section |
| 3 Flexo printing units for outside printing | 14 Seal flap gumming section |
| 4 Longitudinal and cross scoring section | 15 Drying section |
| 5 Cutting section for window cut and complete cut | 16 Aligner section |
| 6 2nd window material patching section | 17 Hot-melt pressure-sensitive gumming section |
| 7 Window material patching section | 18 Seal flap folding section |
| 8 Side flap gumming section for pockets | 19 Delivery |
| 9 Side flap folding section (inside side flaps) | |
| 10 Bottom flap and side flap gumming section | |
| 11 Bottom flap folding section | |
- optional machine components

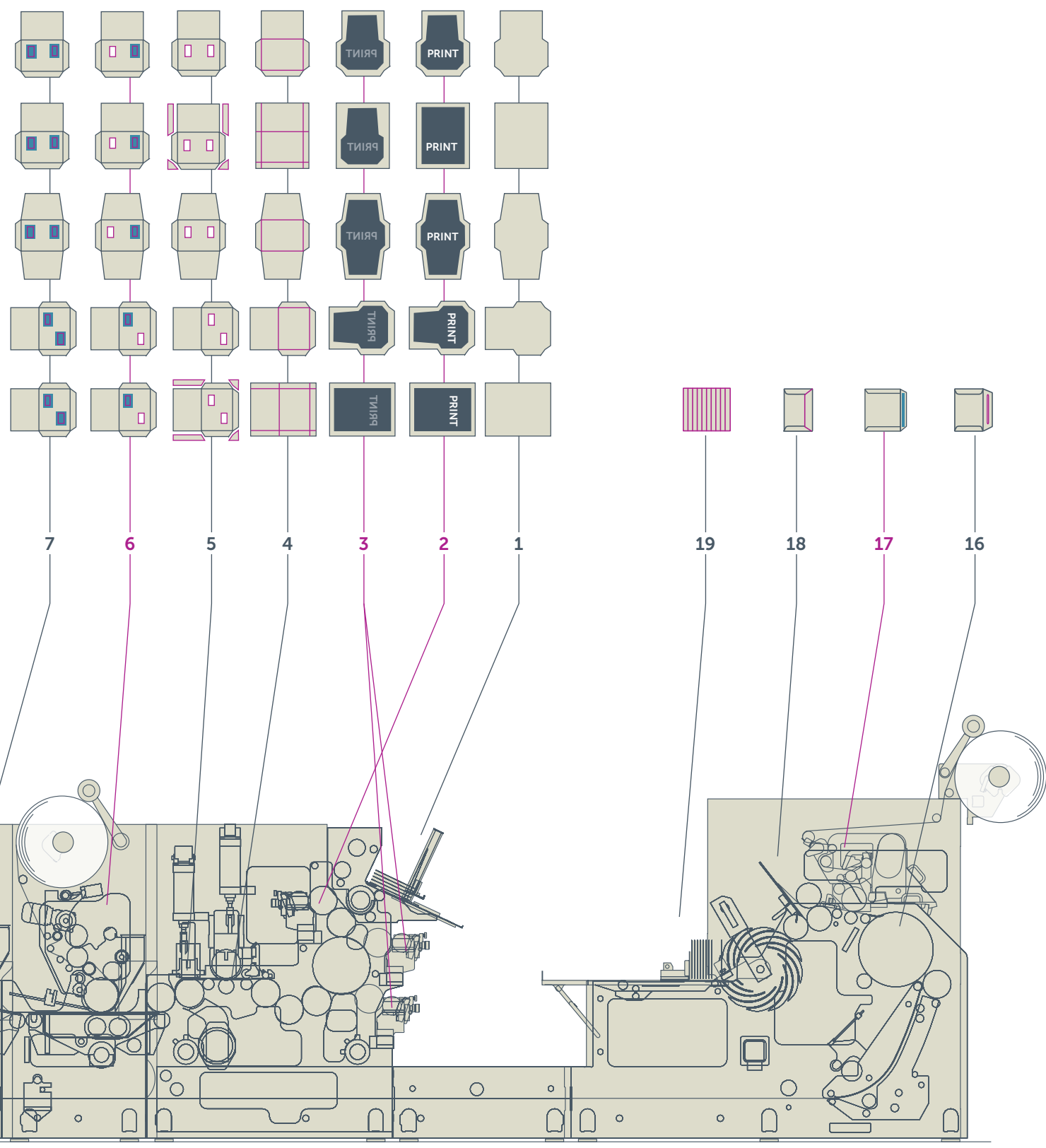


Machine layout

- 1 Blank feeder
- 2 Flexo printing unit for inside printing
- 2 Flexo printing units for outside printing
- 4 Longitudinal and cross scoring section
- 5 Cutting section for window cut and complete cut
- 6 2nd window material patching section
- 7 Window material patching section
- 8 Side flap gumming section for pockets
- 9 Side flap folding section (inside side flaps)
- 10 Bottom flap and side flap gumming section
- 11 Bottom flap folding section
- 12 Folding tools for outside side flaps
- 13 Staggering section
- 14 Seal flap gumming section
- 15 Drying section
- 16 Aligner section
- 17 Hot-melt pressure-sensitive gumming section
- 18 Seal flap folding section
- 19 Delivery

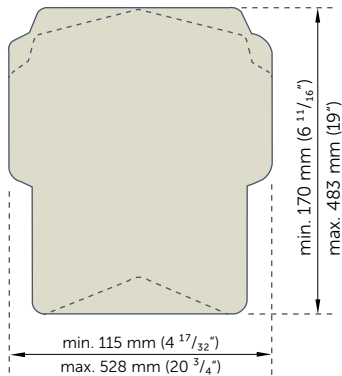
● optional machine components



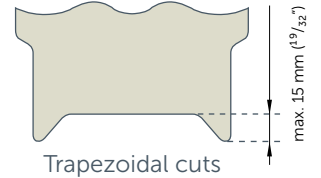
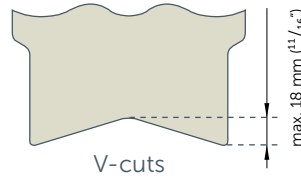


Dimensions and Formats

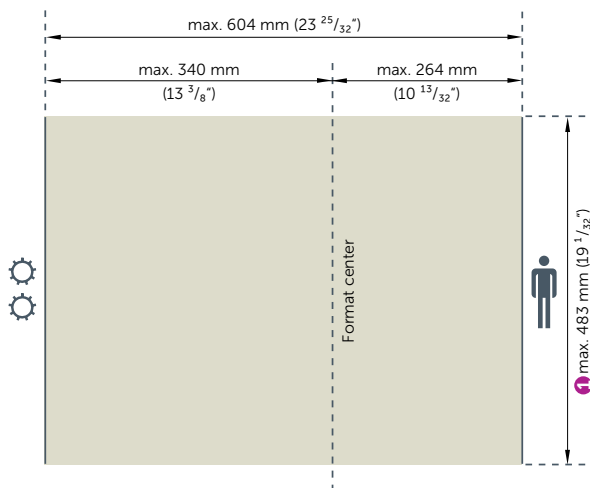
Blank format



Cut-out depth

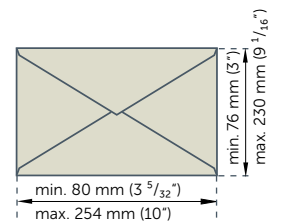
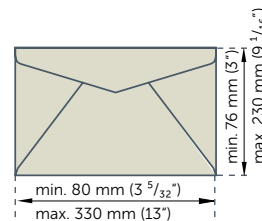
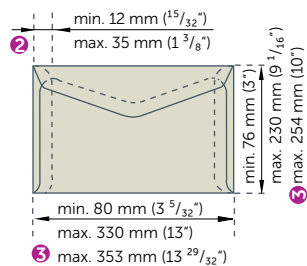
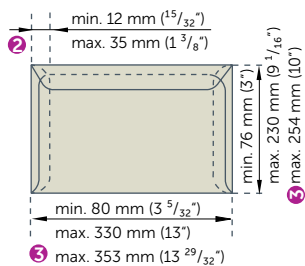


Complete cut



End format

Envelopes



Booklet

Inserting-style

Commercial-style

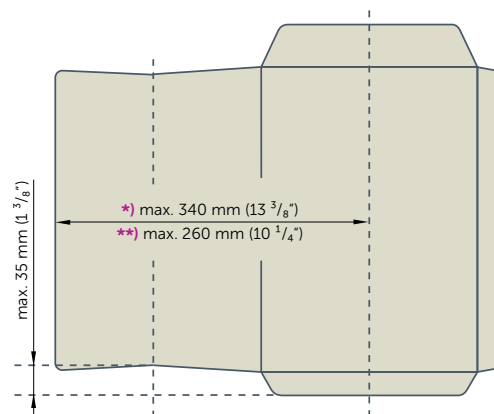
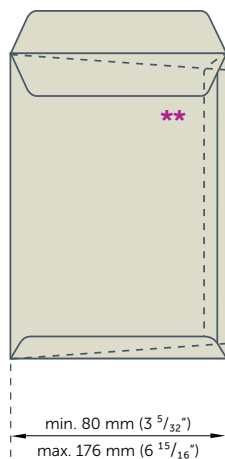
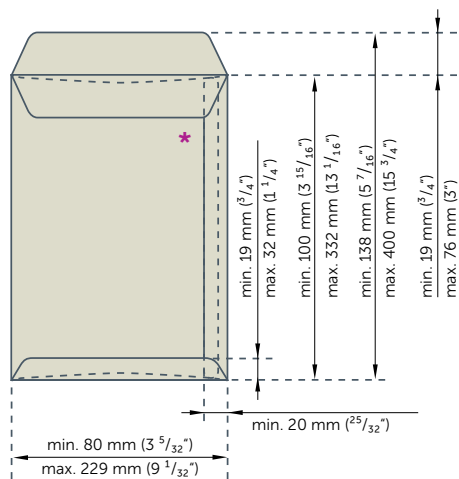
Diamond-style

- 1 In case of a complete cut from a rectangular sheet with circumferential contour the cut-out height will be reduced to 465 mm (18 $\frac{5}{16}$ ")
- 2 Outside side flaps are possible with 25 mm (1") – special folding tools
- 3 Only possible with extended size format range option

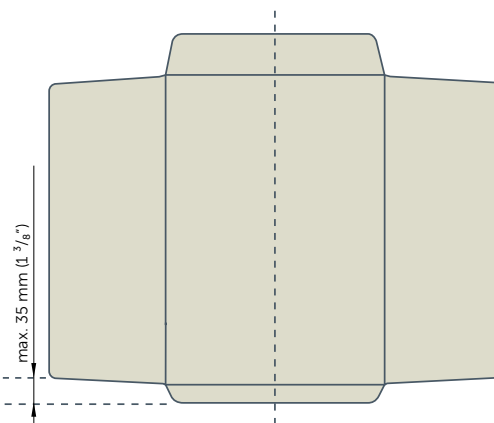
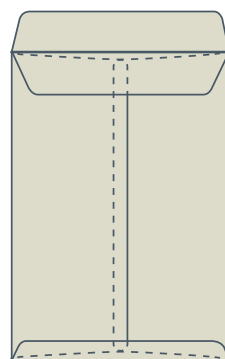
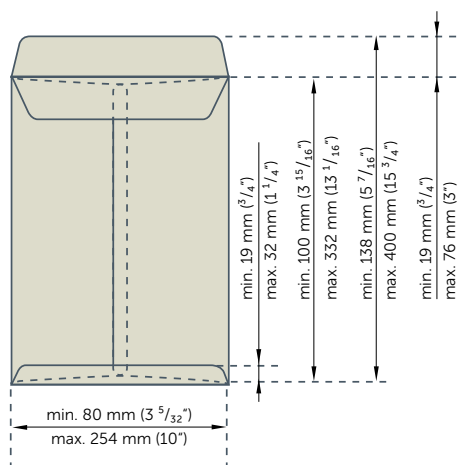
All binding data concerning the dimensions and formats for each machine type can be found in the performance data sheet.

End format

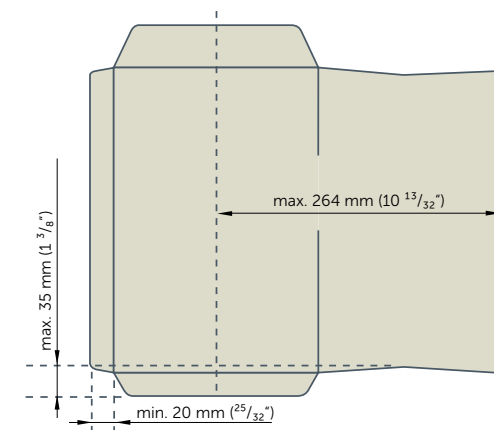
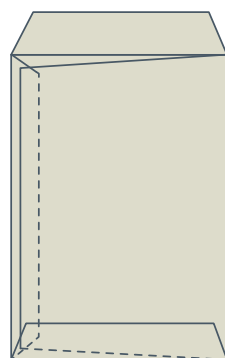
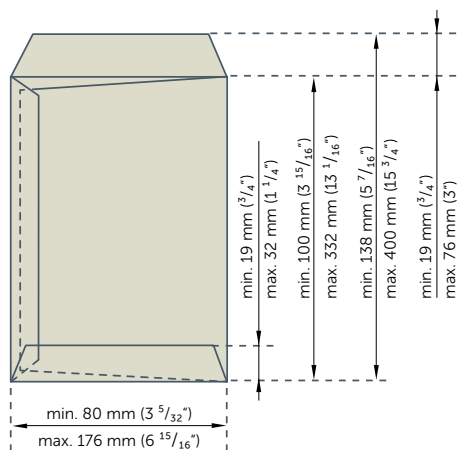
Pockets



Side seam right hand side



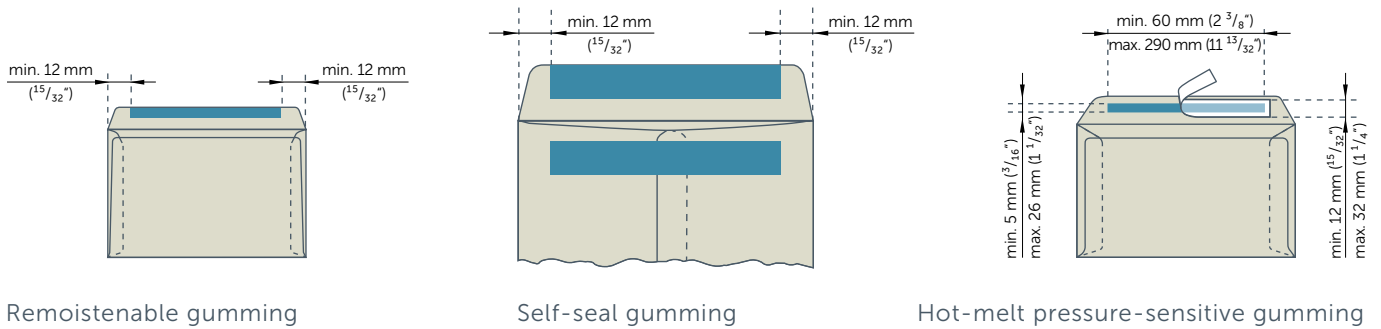
Center seam



Side seam left hand side

Dimensions and Formats

Seal flap gumming

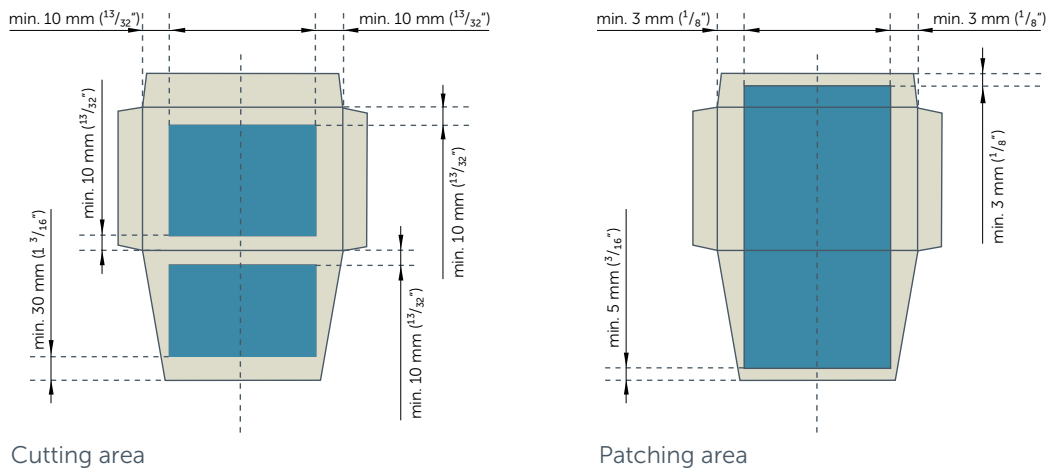


Remoistenable gumming

Self-seal gumming

Hot-melt pressure-sensitive gumming

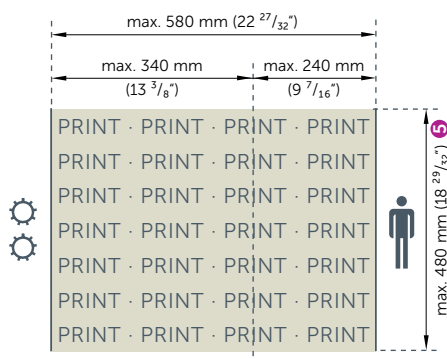
Window range



Cutting area

Patching area

Printing range



Flexo printing units for inside and outside printing

5 Seamless plate cylinders – when using plate cylinder with mounting system, the printing length is reduced to 460 mm ($18 1/2''$)

Technical specifications

Typ		BC	
Maximum output per min	Envelopes	500 pieces	
	Pockets	250 pieces	
	Oversized Booklets ^❶	100 – 120 g/m ² (27 – 32 lb) 150 pieces	
Paper weight	Envelopes	60 – 150 g/m ² (16 – 40 lb) ^❷	
	Pockets	80 – 150 g/m ² (21 – 40 lb)	
Size ranges envelopes	Booklet	min. 76 mm (3") x 80 mm (3 ⁵ / ₃₂ ") – max. 230 mm (9 ¹ / ₁₆ ") x 330 mm (13") max. 254 mm (10") x 353 mm (13 ²⁹ / ₃₂ ") ^❶	
	Commercial-style	min. 76 mm (3") x 80 mm (3 ⁵ / ₃₂ ") – max. 230 mm (9 ¹ / ₁₆ ") x 330 mm (13")	
	Diamond-style	min. 76 mm (3") x 80 mm (3 ⁵ / ₃₂ ") – max. 230 mm (9 ¹ / ₁₆ ") x 254 mm (10")	
Size height	Envelopes with open seal flap	min. 100 mm (3 ¹⁵ / ₁₆ ") – max. 400 mm (15 ³ / ₄ ")	
Size ranges booklet	Side seam right hand side	min. 100 mm (3 ¹⁵ / ₁₆ ") x 80 mm (3 ⁵ / ₃₂ ") – max. 332 mm (13 ¹ / ₁₆ ") x 229 mm (9 ¹ / ₃₂ ")	
	Center seam	min. 100 mm (3 ¹⁵ / ₁₆ ") x 80 mm (3 ⁵ / ₃₂ ") – max. 332 mm (13 ¹ / ₁₆ ") x 254 mm (10")	
	Side seam left hand side	min. 100 mm (3 ¹⁵ / ₁₆ ") x 80 mm (3 ⁵ / ₃₂ ") – max. 332 mm (13 ¹ / ₁₆ ") x 176 mm (6 ¹⁵ / ₁₆ ")	
Blank dimensions	Total length	min. 170 mm (6 ¹¹ / ₁₆ ") – max. 483 mm (19")	
	Total width	min. 115 mm (4 ¹⁷ / ₃₂ ") – max. 528 mm (20 ³ / ₄ ")	
Window material	Window material reel	Diameter	max. 500 mm (20")
		Width	min. 45 mm (1 ²⁵ / ₃₂ ") – max. 320 mm (12 ¹ / ₂ ")
	Winding core inner diameter		70 – 77 mm (2 ³ / ₄ " – 3 ¹ / ₃₂ ")
	Cut-off length		min. 45 mm (1 ²⁵ / ₃₂ ") – max. 254 mm (10")
Silicone paper	Silicone paper reel	Diameter	max. 500 mm (20")
		Width	min. 66 mm (2 ¹⁹ / ₃₂ ") – max. 300 mm (11 ¹³ / ₁₆ ")
	Winding core inner diameter		70 – 77 mm (2 ³ / ₄ " – 3 ¹ / ₃₂ ")
	Protective strip cut-off length		min. 12 mm (1 ⁵ / ₃₂ ") – max. 32 mm (1 ¹ / ₄ ")
Printing length / blank	With full seamless cylinder	max. 480 mm (18 ²⁹ / ₃₂ ")	
	With mounting system	max. 460 mm (18 ¹ / ₈ ")	
Printing width / blank	Inside and outside printing	max. 580 mm (22 ²⁷ / ₃₂ ")	
Dimensions and weight ^❸	Length		7,168 mm (23.5 ft)
	Width		2,200 mm (7.2 ft)
	Height		2,200 mm (7.2 ft)
	Net weight		9,750 kg (21,495 lb)
Compressed air	6 bar		max. 48 m ³ /h
Vacuum	0.6 bar		max. 1,140 m ³ /h
Blowing air	0.8 bar		max. 140 m ³ /h
Connected load (50 Hz)	Basic machine		max. 42.5 kVA
	Material suction		max. 7.5 kVA
	Vacuum pumps		max. 45.5 kVA
	Hot-melt pressure-sensitive gumming section		max. 8.5 kVA
Noise emission	According to specification EN 13023	without soundproofing	88 dB (A)
		with soundproofing	85 dB (A)

^❶ Only possible with extended size format range option, no complete cut, only from blank

^❷ Complete cut from 80 g/m² (21 lb) and material thickness of 0.085 mm (0.0033")

^❸ Machine as standard version, see page 5

All performance data published refers to the production of a defined reference product under certain circumstances reflecting a possible practice of use. The performances achieved in practice depend on a multitude of parameters which are beyond our control. This includes, amongst other factors, the condition of the raw materials to be processed, the shapes of the products, the air humidity and the ambient temperature. W+D reserves the right to make design changes and changes to the performance values.

Winkler+Dünnebier GmbH (W+D), part of global equipment manufacturer Barry-Wehmiller and its BW Converting Solutions platform of five industry leading brands, specializes in the design and manufacture of high-performance converting machinery for the tissue, nonwovens, hygiene, package-printing and bag-converting industries worldwide.

With more than 100 years of experience, W+D is the only engineering company to cover the entire envelope mail production value chain: from converting, printing and value ad enhancement systems for the manufacturing of envelopes to highly intelligent mail inserting technology. All with the aim to produce the most complex and personalized letter mail packages for postal system intake.

For more about W+D, visit w-d.de.

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BW Converting Solutions



ONE Global Team - Better Together



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