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**AUTOMATION OF CUTTING OF LABEL PRODUCTS   
ON ONE-KNIFE PAPER-CUTTING MACHINES BASED   
ON PROGRAMMABLE LOGIC CONTROLLERS**

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***Research methodology.*** *Experimental by development and research of a physical model of counting-impulse system of numerical programme control (NPC), the usage of simulation method of its work on the computer in the FBD editor (Functional Block Diagram), using LOGO!Soft Сomfort program and mathematical modeling.*

***Results.*** *The laboratory sample of counting-impulse system NPC of one-knife paper-cutting machines (OKPCM) for label products cutting has been developed based on programmable logical controllers, which are produced multiple and correspond to the achieved level of the scientific and technical developments.*

***Novelty.*** *The general questions of development of counting-impulse system NPC have been explained based on programmable logical controllers, that are used for cutting a certain range of printing products on national OKPCM and some recommendations for choosing the software and hardware platform and their parameters have been suggested.*

***Practical significance.*** *Using a counting-impulse system NPC for OKPCM increases its productivity by reducing support time, improves accuracy when multiple feeding of stacks, reduces a cutter errors effect on the quality of work and it reduces his fatigue, improves production standards. The results have been introduced into the educational process in the frames of development of scientific and technical support for the regional cluster «Publishing and Printing».*