

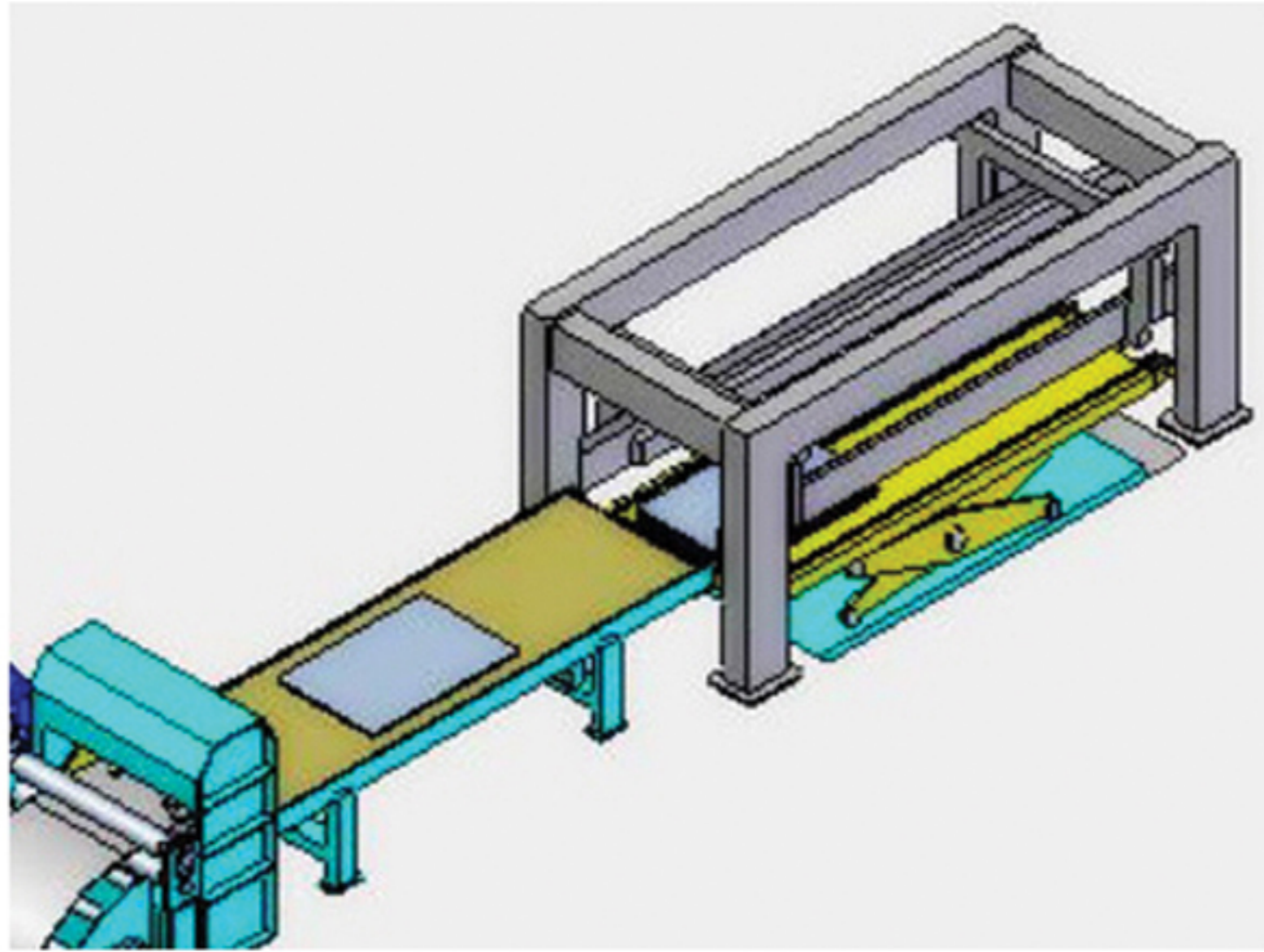
STACKING SYSTEMS

- **Bomb Door Type**
- **Magnetic Belt Stacker**



Stacking Systems

Packaging & Stacking Systems



Stackers:

- › Automatic stacker type Bomb - Door.
- › Fully automatic Magnetic stacker.
- › Automatic Vacuum stacker.
- › Stacking accuracy length / width of +/- 0,5 mm.
- › Stacks packaging without production interruption.

Standard stacking systems:

1.- Automatic stacker type BOMB - DOOR

2.- Double Station MAGNETIC Stacker

›› METAL COIL SLITTING and CUT to LENGTH LINES
›› LÍNEAS de CORTE LONGITUDINAL y TRANSVERSAL
›› LIGNES de REFENDAGE et COUPE à LONGUEUR



Stacking Systems Bomb Door Type

Automatic stacker type Bomb-Door:

Is a **Line designed for stacking the sheet formats** in a regular stacks according production requirements.

The stacker is composed by a **main frame fixed to foundation with anchor bolts and nuts.**

The frame is **supporting:**

- › **Motor operated lateral guides** with up and down **motion and at symmetric position** in reference to the stacking line axis.
- › Supporting arms for up and down tilting rolls to get formats in position.
- › A symmetric row of driven tilting rolls acting as formats support.



- › The rolls are **manufactured in carbon steel** and covered with polyurethane of hardness of 90° Shore.
- › Tilting motion of the rolls row is operated by a.c. motor and gear.
- › Pneumatic formats stack centering system located in one of the lateral guides.
- › Swinging and displaceable stopper at end side, operated by elec. motor and gear.
- › Stopper swinging motion, allowing **stacks exit from the Line.**

- › Hydraulic operated pushing device located in the front of formats.
- › Hydraulic operated scissor type table supporting the chain conveyor.
- › **Stacks chain conveyor**

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Stacking Systems Bomb Door Type

Automatic stacker type Bomb-Door:



Characteristics for a representative case:

Formats length min / max	mm	500/6000
Formats width min / max	mm	800/2000
Max. stack height	mm	500
Max. stack weight	Kg	5000
Production speed	mts/min	10
Drive motor power	Kw	4

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Magnetic Stacker with Double Station



Is a stacking line for carbon steel formats and it is located outlet of cutting shear.

- » The **magnetic stacker line function** is:
- » Formats **conveyor from the shear to the stacker.**
- » Formats **stacking on exit cars.**
- » Automatic **displacement of exit car for stacks transportation.**
- » **Automatic cars entry at stacking position.**

The conveyor is **composed for two belts with a length to be fixed case by case** according line requirements.

The first belt next to shear is **an expanding type design**, enabling shear knife replacement.

The second conveyor is a **fix length belt**. The speed of this conveyor is **higher than the conveyor next to shear to get the required gap between formats for correct stacking.**

The stacker has two separate and independent stations and each one is equipped with 03 magnet stands with an automatic positioning system on width direction.



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Magnetic Stacker with Double Station



Each station is **designed for formats stacking according production length requirements.**

Each station is equipped with an automatic positioning system of 04 driven tailbacks according formats dimensions for stacking.

Each tailback position is controlled by means of encoders.

The programme has a feed back positioning data memory for all formats sizes according production requirements.

The stacks exit by means of exit cars.

General characteristics for a representative case:

Type of Stacker	start/stop
Nº of stations	2
Formats shape	rectangular
Surface type / quality	flat
Magnetic metal	yes
Oiled	yes
Max. format length	3000 mm.
Min. format length	400 mm.
Max. format width	1500 mm.
Min. format width	300 mm.
Thickness of formats	4 mm.

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