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2-Axis Servo Stacker LS 650 / Turbo

Lehr stacker



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The lehr stacker is designed to transfer glass ware in rows from the cross conveyor across the transfer plates onto the lehr mesh belt.

This reliable lehr stacker was designed for the operation with high capacity IS machine lines at speeds up to 600 BPM, and a max. cross conveyor speed of 50m/minute.

The two individual servo drives allows creating flexible stacking speeds and motions in order to meet the high production demands. Smoothness and accuracy are the requirements of modern container glass lines.

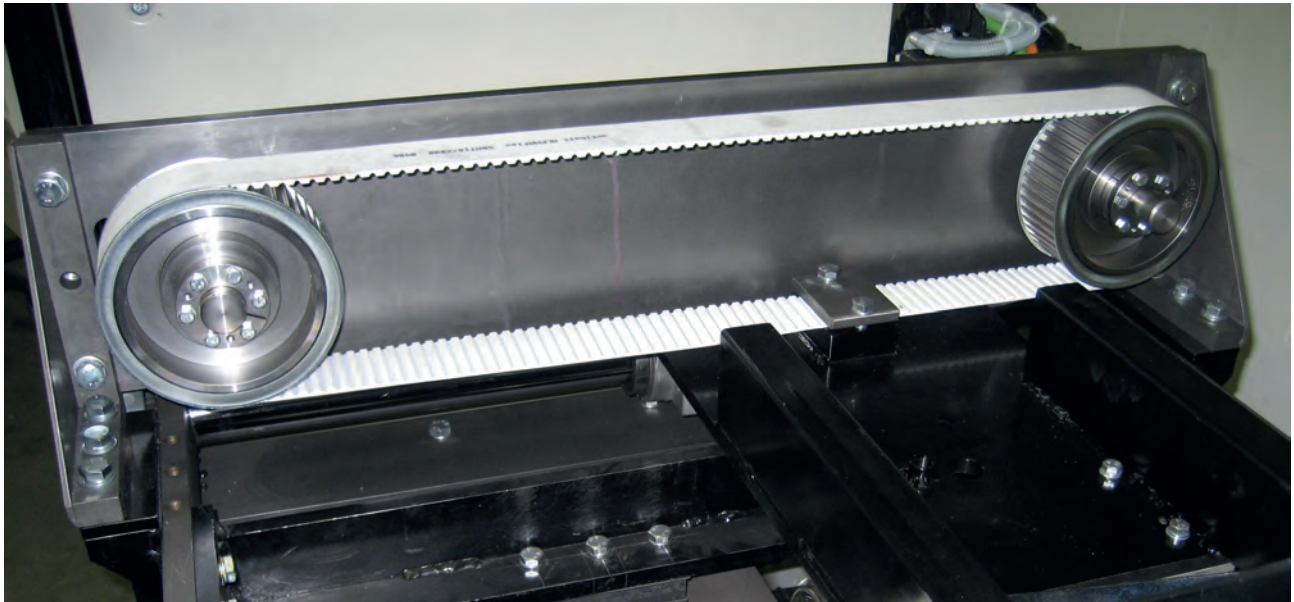
The stacker is placed on a trolley and rail assembly on the factory floor and may be withdrawn from the heat for maintenance and job change reasons.

An internal cooling blower protects the enclosed stacker housing from overheating and/or being overheated by the hot air from the lehr. The enclosure (shielding) all around the stacker is made from stainless steel for cleanliness.

Due to the use of the two frequency controlled servo drives, the stacking motion becomes smooth and careful. The actual stacking motion (contact to the glass) is executed by the forward motion that is combined with a sideways movement. Both movements are executed by separate servo drives. The standard side stroke length is at 450mm.

The lifting stroke is executed by use of a cam, whereas two different lifting cams are available (lifting height of 250 & 400mm). When manufacturing pharmaceutical ware (small heights) the selection of the small cam allows increased timing for the actual forward stroke.

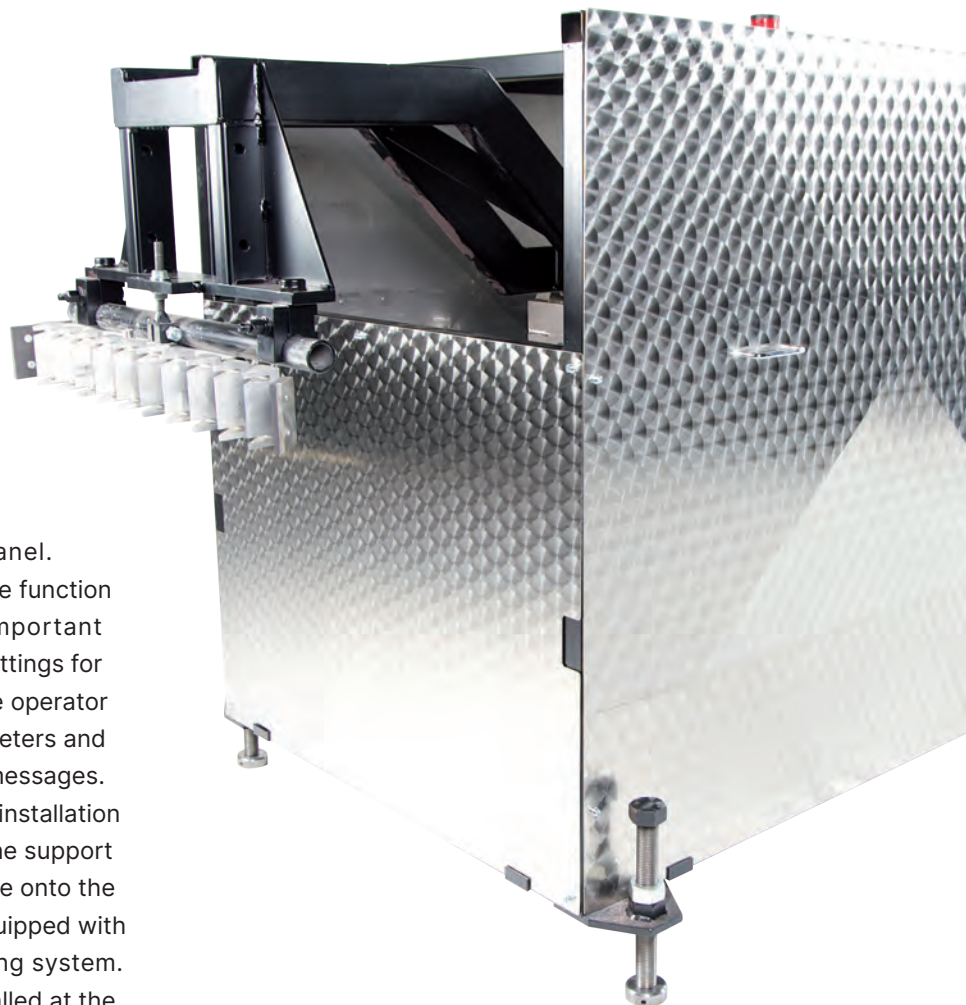
The entire stacker is operated and monitored by the PLC and the graphic touch panel which is mounted directly on the stacker units itself. The connecting cables between control and machine are therefore not required. The graphic operator touch panel visualises the operational motions and settings. All special software such as „Stop in front“, „Offset stacking“, „Slow motion when transferring to the lehr belt“ and others are to be set at the



Individually driven second axis drive



Pressure fan for machine cooling



operator screen on the main control panel.

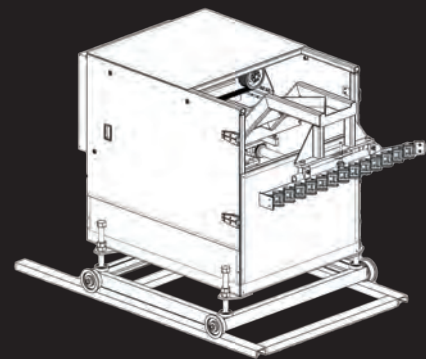
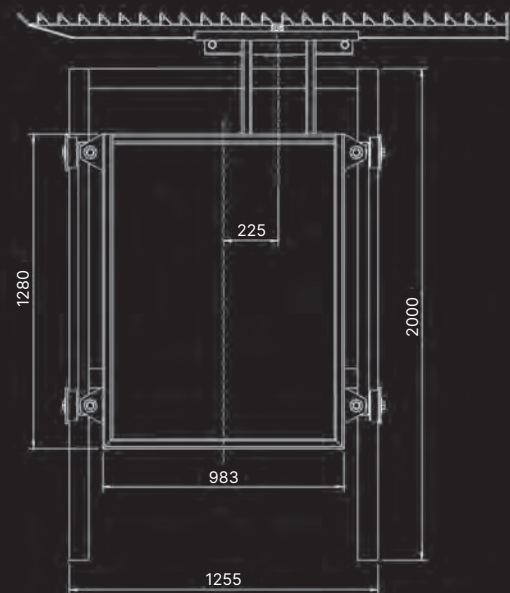
In addition the stacker is equipped with the function "Pre-calculation". This function is an important assistance in order to pre-calculate the settings for a "new" production. The easy menu on the operator panel guides through the setting of parameters and provides information on status and error messages. In addition the stacker is prepared for the installation of a ware steady bar system that allows the support at the bottle finish during its forward stroke onto the lehr belt. However, even this stacker is equipped with the unique Pennekamp stacker bar cooling system. Therefore it has a pressure controller installed at the back end in order to fine tune the stacker bar straightness on the run (online). The start impulse may be connected as a potential free contact, generated from the ware transfer or be coming from the forming machine. The start impulse may be shifted by use of an electrical differential gear (advance and retard).

Features

- Solid, electrical servo drive systems by inverter (two individual motions)
- Cam system for lifting motion
- Adjustable stroke length forward motion
- Adjustable stroke length side motion by touch panel
- Most modern PLC control system with graphic touch panel
- Adjustable stacking speeds and characteristics selectable by touch panel
- Electrical timing differential to advance/retard start signal
- Rail/trolley system for stacker withdrawal
- Stacker bar air cooling system
- Operational mode „stop in front“
- Offset stacking

Options:

- Steady bar system
- Air cooled pocket stacker bar
- Air cooled flat stacker bar
- Automatic lubrication system



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Length/Depth	1.280mm
Width	985mm
Height	1.350mm
Working height	850 - 1.070mm
Voltage	400V 50HZ*
Prefusing	10A
Compressed Air Pressure	2 - 6 bar 28 - 84 PSI
*others on request	

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