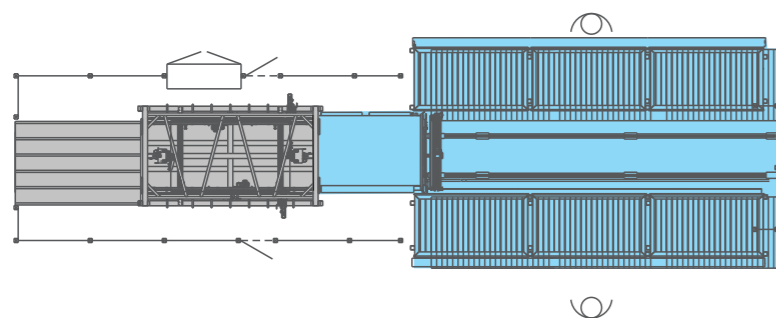


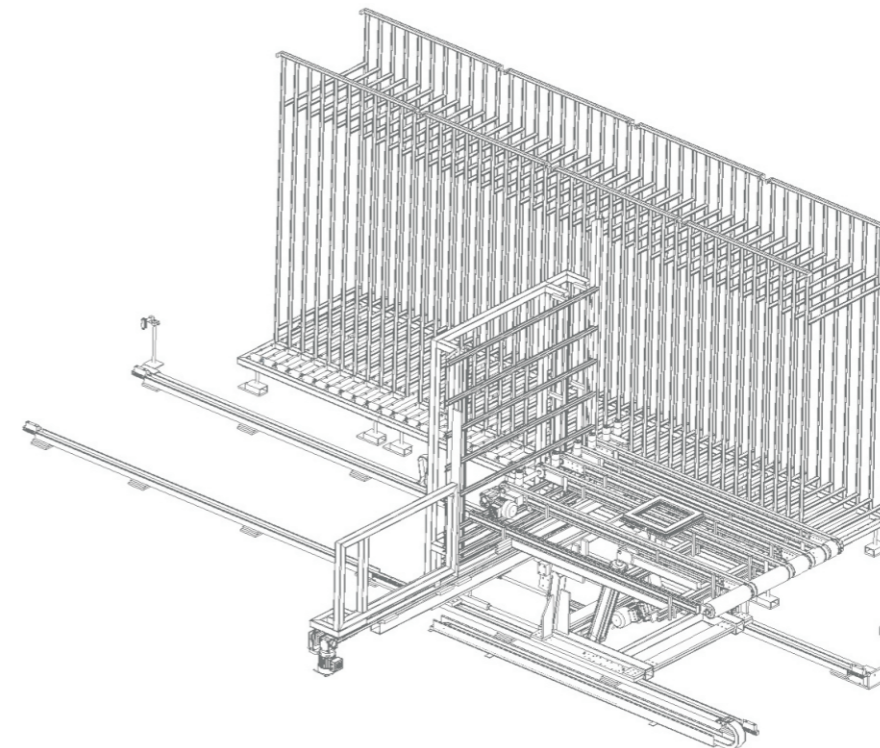
Technical Information

Size of sash max. outer theoretical welding size (B x H)	1500mm x 2500mm
Size of frame max. outer theoretical welding size (B x H)	3500mm x 2500mm
Supply voltage	230/400 V 50 Hz
Control voltage	24 VDC
Total connected load	4,5 kW
Electrical connection type	CCE
Operating pressure	6 bar
Air consumption	150 l/min
Pneumatic connection type	Quick connection coupling 1/2"



Automatic stacking unit for window elements

The picture shows a stacking unit for sashes, positioned downstream of an 4-side bolting machine.



For elements made of:

✓ PVC

✓ Wood

✓ Aluminum

The all-round service from LEMUTH - guarantees security for your investment.

You will receive the following services from a single source and harmonised down to the last detail:

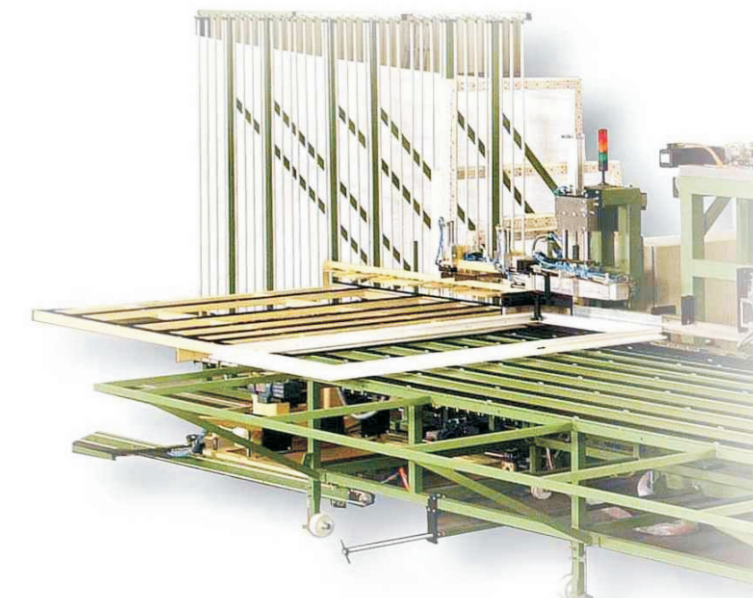
- Projekt management
- System planning
- Factory planning
- Construction
- Electrical project management
- Component production
- Installation
- Start-up
- Staff training
- Documentation

And included in the software field:

- PLC programming of the system control
- Programming of the industrial PC interfaces
- Network connection to the company network
- Networking the window construction system



998_255 Prospekt AS165_2014_englisch - Technical modification reserved

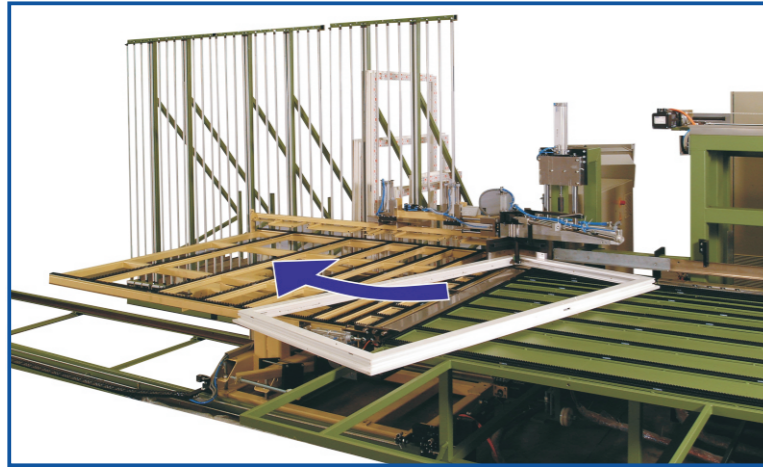


AS165

Automatic stacking device

Automatic stacking of frames or sashes

The stacking device *AS165* is an ideal addition to automated production lines. Depending on the model used, the frames or sashes are deposited either in roller trolleys or compartment racks. It is possible to integrate a slewing unit to adjust the turning position of the window. Different levels of programming enable the stacking device to specifically suit the requirements of your production line.



Stacking in roller trolleys and/or compartment racks

For stacking, roller trolleys are connected to the stacking device. Depending on the model, a roller trolley can take up to 10 frames or sashes and there can be as many roller trolleys used as required. The roller trolleys can easily be pushed by one person. A capacity of up to 40 units can be taken by the standard model when stacking in the compartment rack. The combination of compartment rack and roller trolley is also possible.

Slewing unit for correct turning position

If the components of the preliminary machine are not off-loaded in the correct turning position, then a slewing unit can turn the window unit around 90° from the transfer edge to the raised edge before stacking takes place. Thus the window always stands up on the correct side in the compartment, which is preferable for further processing.

Free choice of stacking direction

The manufacturing concept and space proportions in the work area determine the type of stacking unit. As a result, the windows - according to the selected stacking direction - can be transported and stacked lengthways or sideways to the transportation direction of the preliminary machine.

"Stupid" or "clever" stacker

The programming of the machine defines the "intelligence" of the stacking device. While stackers without data transfer feature to the subsequent machine are described as "stupid" stackers, models with data transfer are termed "clever" stackers. When stacking without data transfer, the window units are deposited each time in the correct order of the flow of components in the next available compartment. "Clever" stackers pass on the information, that they receive during the onloading process through online databases, serial interfaces or barcode scanners, to a subordinated work area e.g. to a framehinging work area. With this model the stacking takes place in a numbered compartment rack, in roller trolleys with trolley identification or in a combination of both. Further special functions, like special faulty component handling, can likewise be integrated.

Equipment of the plant

For the stacking of wood or aluminium elements, compartment-type wagons/racks are lined with felt to eliminate the risk of damage. In the case of sashes with glass panes or when automatic removal is required, the compartments contain driven conveyor belts as the support.

