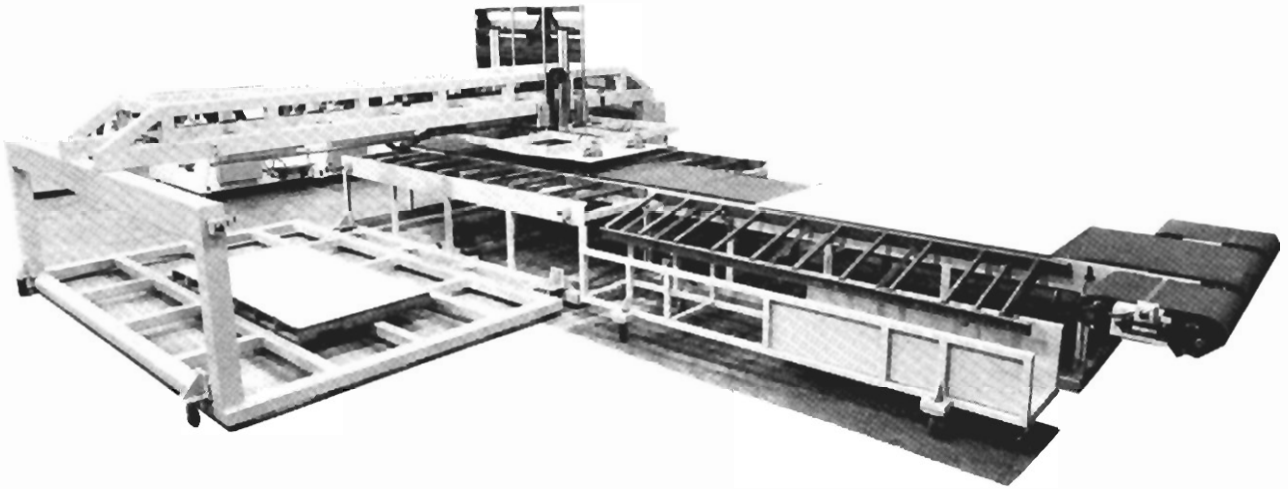


VACUUM SHEET STACKERS



**VACUUM SHEET STACKER FOR
SIDE STACKING HEAVY GAUGE SAWED SHEET
(Shown with Edge Scrap Ejector Option)**

DESCRIPTION:

Vulcan's Vacuum Sheet Stacker consists of a powered conveyor backed up to a customer furnished shear or saw. After the sheet is cut and released to the conveyor, the conveyor accelerates the sheet to a position under the vacuum cup carriage. The sheet is then transferred to the carriage for subsequent transportation to the pallet and release to the stack.

MODELS AVAILABLE:

Sheet Width (Inches)	Sheet Length (Inches)			
	72	96	120	144
48	VSS46	VSS48	VSS410	VSS412
60	VSS56	VSS58	VSS510	VSS512
72	VSS66	VSS68	VSS610	VSS612
84	VSS76	VSS78	VSS710	VSS712
96	VSS86	VSS88	VSS810	VSS812
108	VSS96	VSS98	VSS910	VSS912
120	VSS106	VSS108	VSS1010	VSS1012
132	VSS116	VSS118	VSS1110	VSS1112
144	VSS126	VSS128	VSS1210	VSS1212

FRAME:

- Frame is constructed of structural tubing and plate
- Unit is equipped with V-grooved casters and hold-downs

BELT CONVEYOR:

- The belt is of two ply construction with center guide
- The conveyor design allows for 12 inch take-up of belt length
- Conveyor is driven by 1 HP DC-SCR variable speed drive
 - Drive will accelerate the belt to above line speed to develop gap between sheets
 - Drive decelerates sheet to stop for transfer of sheet to vacuum cups
- Belt conveyor length exceeds maximum sheet length

VACUUM CUP SHUTTLE:

- Shuttle drive is 48 In. Lb. servo motor
- Drive train arrangement includes a rack and pinion assembly to provide precise horizontal positioning and repeatability of the carriage movement during each cycle
- Shuttle assembly moves on a lineal bearing / lineal shafting assembly

CARRIAGE VERTICAL MOVEMENT:

- Vertical movement of the carriage to the stack is powered by 1-1/2 HP, DC-SCR drive
- Drive train includes vertical rack and pinion assembly to provide vertical movement of the sheet to the stack
- Unique rack design ensures parallel carriage movement even with non-symmetrical loading

VACUUM CUP ARRANGEMENT:

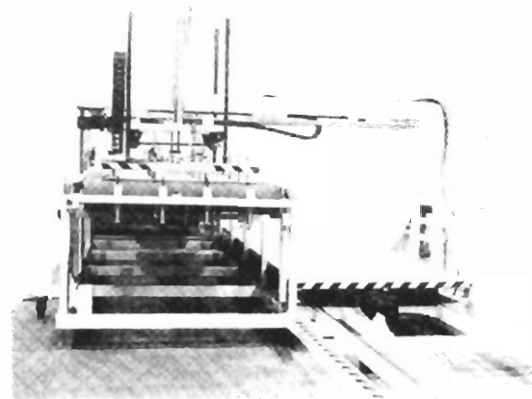
- Vacuum cup size, number and location designed for specific requirements of customer's application
- Vacuum cup location adjustable in cross-line direction
- Individual shut-off valves located on each cup
- Pick-up mode - compression of vacuum cup against sheet trips limit switch which evacuates the cup and reverses the direction of the carriage
- Drop-off mode - compression of cup by sheet contact with stack, actuates limit switch that releases vacuum and reverses the direction of the carriage
- Vacuum generated via customer furnished compressed air source for Venturi type vacuum system
- Multiple independent vacuum circuits ensure sheet holding capability in the event a cup does not seal

ELECTRICAL:

- Standard Electrical is 230 V/3 Ph/60 Hz

OPTIONS:

- A hydraulic lift table of 6000 pound capacity will have an empty table height equal to the drop-off height of the carriage. As sheet is loaded on the lift table the stack increase is photo sensor detected and the hydraulic table is lowered to the desired incremental amount
- Electrical other than 230V/3 Ph/60 Hz
- A pallet shuttling system consisting of a platform at least three times the sheet length mounted next to the sheet stacker with the center position located in the stacking station. Two pallet shuttles are rail mounted to the platform. When the pallet being loaded is at full count, the shuttle is actuated and the full pallet is moved on the rails to the unload station and concurrently an empty pallet is shuttled into the stacking station
- The addition of a servo motor driven carriage or the application of scissors tables to reduce cycle times



Vacuum Sheet Stacker
(Shown with Pallet Shuttle Option)

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