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ASIAN PRINTING & PACKING TECHNOLOGY PTE LTD

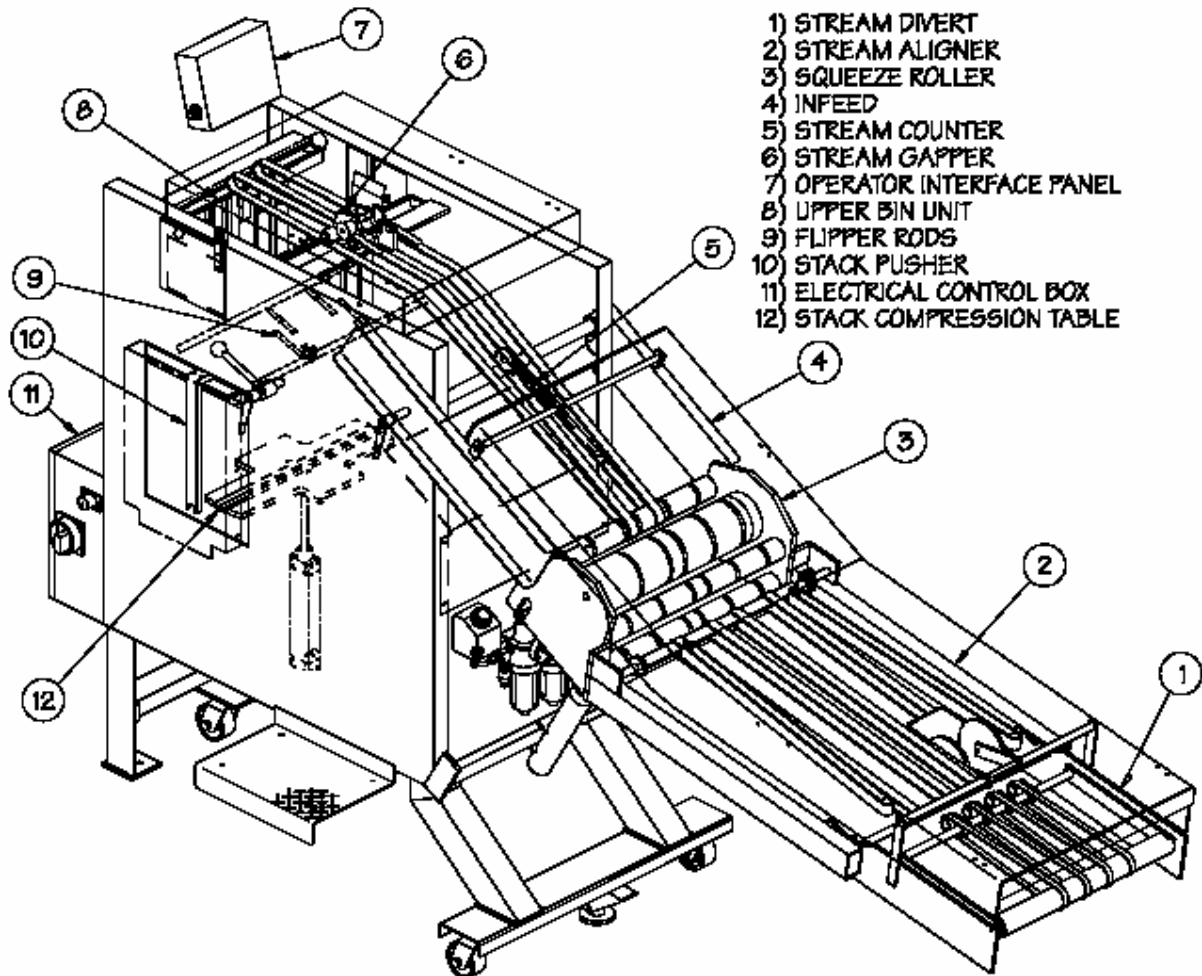
COMPENSATING COUNTER STACKER



MODEL: PRIMA TK 1

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APPLICATION

The APPT Prima TK1 is rated at up to 100,000 products per hour and works directly in line with most standard press deliveries or rotary trimmer to produce counted, compressed and compensated stacks of superior quality, of inserts or signatures with minimum manning.



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FUNCTION

The product enters the stacker in stream form and a detector will determine if the stream is properly aligned. If not, the skewed products are immediately diverted downward before they can cause a jam. The divert is also activated when there is a jam in the stacker, thus allowing the press to continue to run while the jam is cleared.

Once past the divert area, the product enters the stream aligner which ensures that the edges of the stream are perfectly uniform. The product subsequently passes through a squeeze roller which tightens the fold of the product. Precision counting of the product occurs as the next step in the process followed by forming a gap which breaks the stream into pre-selected batch quantities.

The batch flows into the upper bin unit which uniformly aligns the stack. The batch quantity of products cannot exceed the height capacity of the upper bin unit. The batch is then dropped into the lower bin. To minimize the drop, the customized turntable is raised.

The turntable lowers the stack while compression pins for all four corners are extended above the stack. As the turntable raises, it then compresses the stack removing the air and firming the stack. (This is the key operation used in forming the excellent quality stacks.) While the turntable is compressing the stack, it can also be rotated 180° to provide for a compensated stack. The batches are accumulated in the lower bin until the total stack count is reached. The gates of the lower bin are then opened and the pusher moves the stacks onto the delivery table.

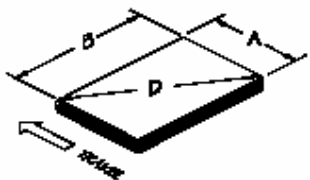
ADVANTAGES

- Excellent quality stacks
- Lower skid heights and more products per skid
- Manpower reduction
- Low infeed height
- Low space requirement
- Very open for viewing product flow and ease of maintenance
- Large, satisfied customer base (newspaper mailrooms) with more efficient stuffing operation
- Reduce waste
- Minimal marking
- Mobile
- Operator interface panel and industry standard high speed PLC. Simple text prompts to set counters and timers. Job parameters such as counter and timer values may be assigned a job number and stored on-line for recall when the same format is run again. Improved counting accuracy. Screen displays running speed and totalizer. Interface to printer available for production run data, fault reports, etc.

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STANDARD SPECIFICATIONS

<div>Product Size</div> <div></div>		Minimum	Maximum
	"A" Dimension	133mm (5.25")	320mm (12.63")
	"B" Dimension (Overside Option)	152mm (6.00") 152mm (6.00")	470mm (18.50") (489mm {19.63"})
	"D" Dimension (Overside Option)	Limited by "A" & "B" Limited by "A" & "B"	520mm (20.50") Limited by "A" & "B"
	Thickness	4 Page 57g/m² 35lbs	96 Page 57g/m² 35lbs
Operating Speed	100,000 Products Per Hour (Product Permitting)		
Stack Height (Maximum)		Size 431mm (17.00")	
	Upper Bin	177mm (7.00")	
	Total Stack	431mm (17.00")	
Infeed Height (See Floor Plan)	Minimum	609mm (24.00")	
	Maximum	1321mm (52.00")	
Infeed Stream Lap	Minimum	19mm (.75")	
	Maximum	102mm (4.00")	
Delivery Conveyor Height	876mm (34.50")		
Product Orientation	Spine Leading (Preferred)		
	Spine On Side (Acceptable)		
	Spine Trailing (Acceptable)		
Input Power	3 KVA (See Voltage Selection Specifications)		
Air Requirement	170L/min. @ 5.5 bar (6 cfm @ 80 psi)		
Weight	900 kg (2,000lb)		
Noise Level	Maximum 85 dB (A)		

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STANDARD SPECIFICATIONS

TURNTABLES

The turntables must be customized to each customer's requirements. By doing so, the optimum stack quality can be obtained.

To specify the "custom" turntable, the dimensions of the products to be run must be known along with the orientation of the product. The table should be specified in terms of the "A" and "B" dimensions of the product. The "A" dimension of the product is in the director of flow as it enters the basic stacker. The "B" dimension of the product is measured perpendicular to the director of flow. See the product size specification for further clarification.

The custom turntables should be sized to the most commonly run products. Other product sizes can effectively be run on a custom turntable, if they are within 76mm (3.00") larger for the "B" dimension for the table, and not more than 10mm (.38") larger for the "A" dimension. Any products that are smaller than the table cannot be run.

Size specifications given for the custom turntables should be the dimensions of the actual product. The turntable will be machines 6mm (.25") smaller on the "B" dimension and 4mm (.16") smaller on the "A" dimension to provide adequate clearance.

Each stacker includes three turntables customized to the customer's specifications at no charge. If a customer does not initially require all three turntables, they can be specified to be supplied at a future date. When a customer is ready with the serial number of the machine at hand, a phone call to APPT will suffice. As all turntables are custom made, allow 2 – 3 weeks for manufacturing.

NOTE

APPT PRIMA TK1 comes with the following:-

Skewed stream condition detector and divert gate, stream aligner, squeeze rollers, stream separator, Denex counter, side joggers in upper bin, flipper fingers, integrated turntable and stack compression, air operated delivery gates, pneumatic controlled programmable stack pusher, tachometer drive generator, operator interface panel, programmable logic controller, associated drives, and pneumatic and electrical controls. One turntable is included per stacker; size must be defined on order form.

For more information and assistance, please contact

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