



CONTAINER GLASS

TABLE WARE

GLASS DECORATION

SPECIALITY GLASS

FLOAT GLASS

PATTERN GLASS

## 1-Axis Servo Stacker LS 300 / HLS



The side stroke is executed by use of a cam assembly and maybe adjusted according to needs of up to 250mm. The lifting stroke is also 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 control consists of two panels, the main control panel and the operator panel which is located directly at the stacker. The control and monitoring is directly executed from the servo inverter, which in addition contains the software motion program. Speed settings and special operational modes, such as “stop in front” are selected at the operator panel.

In addition, the stacker is prepared for the installation of the ware steady bar system that allows the support and stabilizing at the bottle finish during its forward stroke onto the lehr belt.

However, the stacker is also equipped with the unique stacker bar cooling system. Therefore this unit has the pressure controller installed at the back end in order to fine tune the stacker bar straightness on the run.

The start impulse may be connected as a potential free contact, generated from the ware transfer or coming from the forming machine. The start impulse may be shifted by use of an electrical differential gear (advance and retard).

## 1-Axis Servo Stacker LS 300 / HLS

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

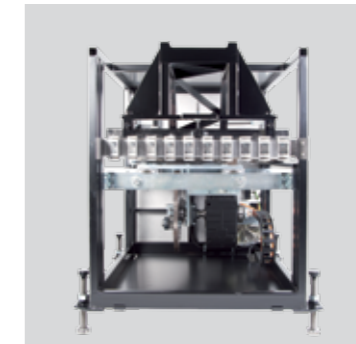
This reliable lehr stacker has been designed for slower operating forming- or IS machines of up to 300 BPM and at a maximum cross conveyor speed of 30 m/min.

The stacker is placed on a trolley and rail assembly on the factory floor and may be withdrawn from the heat for maintenance and job change reasons.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

After each stacking cycle, the stacker will return to its home position, in order to wait for the next row of bottles, according to the number, set in the control before restarting the cycle.

Due to the use of the frequency controlled servo drive, the stacking motion becomes smooth and careful.



Front view without machine cover



Side view without machine cover



## Features

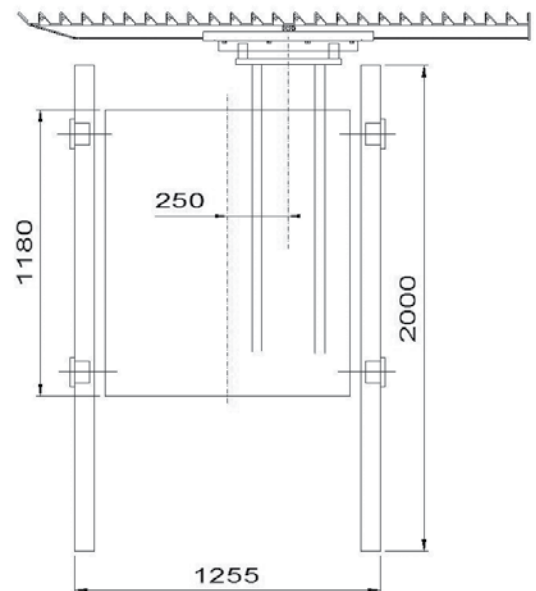
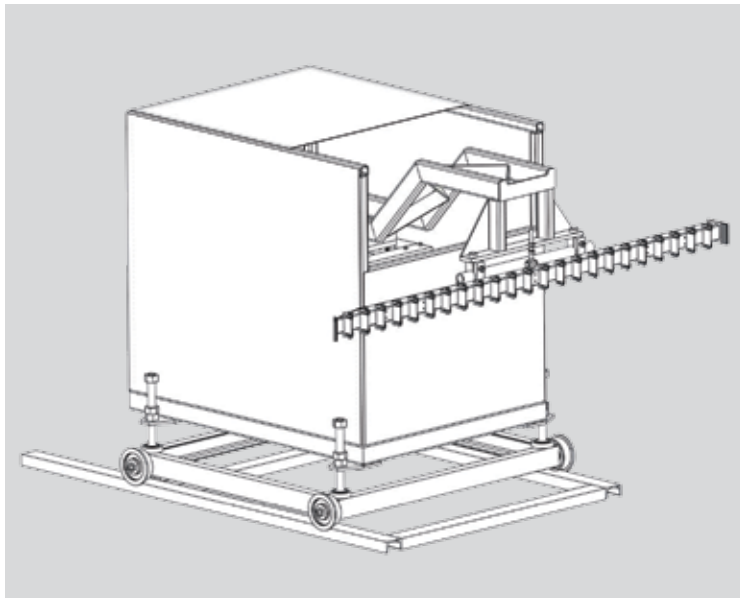
- Solid drive system by servo inverter
- Cam system for side stroke motion
- Can system for lifting motion (cam 250 or 400mm)
- Adjustable stroke length forward motion
- Adjustable stroke length side motion
- Adjustable speeds and operational modes at operator panel (on stacker)
- Electrical differential to advance or retard start signal (synchronization)
- Rail/trolley system for stacker withdrawal
- Stacker bar air cooling system

### Option:

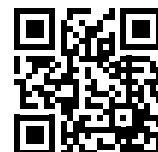
- Operational mode „stop in front”
- Steady bar system
- Air cooled pocket stacker bar
- Air cooled flat stacker bar

1-Axis Servo Stacker LS 300 / HLS

Length/Depth	1.180mm
Width	1.010mm
Height	1.350mm
Working height	850 - 1.070mm
Voltage	400V 50HZ*
Profusing	10A
Compressed Air Pressure	2 - 6 bar
	28 - 84 PSI
*others on request	



Ernst Pennekamp GmbH & Co. OHG  
 Königsfelder Straße 38 · 58256 Ennepetal · Germany  
 Phone: +49 2333 605 0 · Fax: +49 2333 605 200  
 E-Mail: info@pennekamp.de



Please visit our Web site  
 and receive more detailed  
 information about our  
 company and our products.  
[www.pennekamp.de](http://www.pennekamp.de)