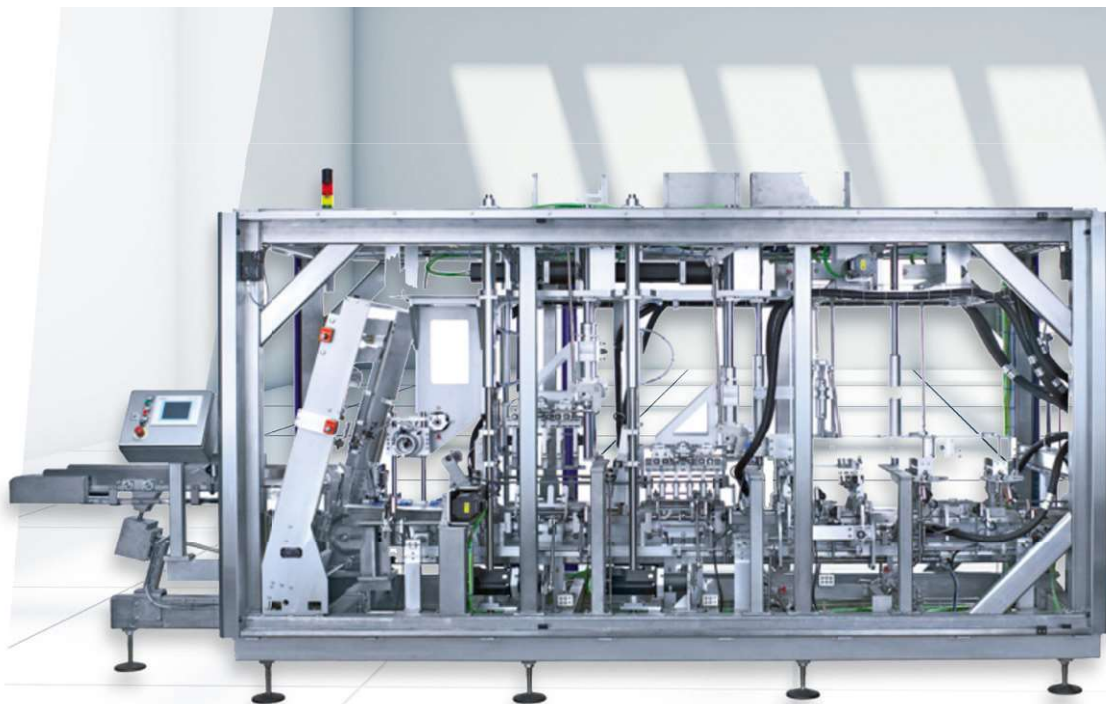


## TRAY ERECTOR | SHL-THL-V



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### Technical Performance Characteristics

- Servo-controlled tray erector for compartment trays. All movements are servo-driven
- Horizontal blank magazine with a high loading capacity of up to 900 blanks  
Magazin loading height: approx. 800 – 1000 mm, depending on blank thickness
- Safe blank extraction from the magazine by means of vacuum suckers
- Reliable indexed conveying of the tray blanks with exact positioning
- Progressive forming of the compartment trays in one level
- High accuracy and repeatability: All format-relevant forming operations are performed against rigid counter-parts.
- High flexibility in tray size and shape. Fast and easy format change by hand-operated spindles/stops. Fully automatic movement processes according to the preselected program.
- Integrated hotmelt system
- Reliable, flexible control based on standard components: PLC: Schneider Electric PacDrive3 or Rockwell Allen Bradley on option
- Operation via 12" touch panel with fault message display

### Technical Data

- **performance:** up to 3,600 trays/h
- **tray/case size:**  
format size range min./max.  
tray length (L) 180 mm - 400 mm  
tray width (W) 180 mm - 400 mm  
tray height (H) 25 mm - 50 mm  
corner flap height 25 mm - 120 mm
- **cardboard quality:** corrugated cardboard, E-wave, approx. 1.5 mm solid cardboard 0.8 mm
- **trays/cases:** open cases and compartment trays side wall fully vertical, inside or outside tapered, with or without stacking corners

### Functional Description

Completely servo-driven, cycle-operated tray erector with up to 17 servo axes which are driven by a virtual master shaft. All drives are located close to the folding elements to ensure a high speed capability. There are no additional transmission gears.

#### Blank Magazine

Two-lane belt magazine with a reception capacity of up to about 1,300 mm in length.  
A separate control compensates for a blank shift.

#### Blank Supply

The blanks are extracted from the magazine and placed into a carrier conveyor while the side walls are folded up. Speed compensation of the vacuum system in a range from 20 – 60 cycles/min.

#### Carrier Conveyor

In support of the high dynamics a direct toothed-belt drive is used, with carriers fitted to it.

#### Glueing

A Nordson Pro Blue hotmelt system with AOAC (air/air controlled) application heads is used as standard.  
All modules are independently driven via the rotary encoder of the blank carrier conveyor.

#### Folding Stations

Hole plate and supporting flaps are folded around rigid counter-parts. While moving into the next folding station the corner flaps are glued for being sealed to the front flaps of the tray bottom. The folding is done against 4 counter-parts which are hinged for reasons of speed.

During movement into the next folding station the front flaps are glued from above for being sealed to the hole plate. Counterpressure plates help to secure a stable glueing.

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