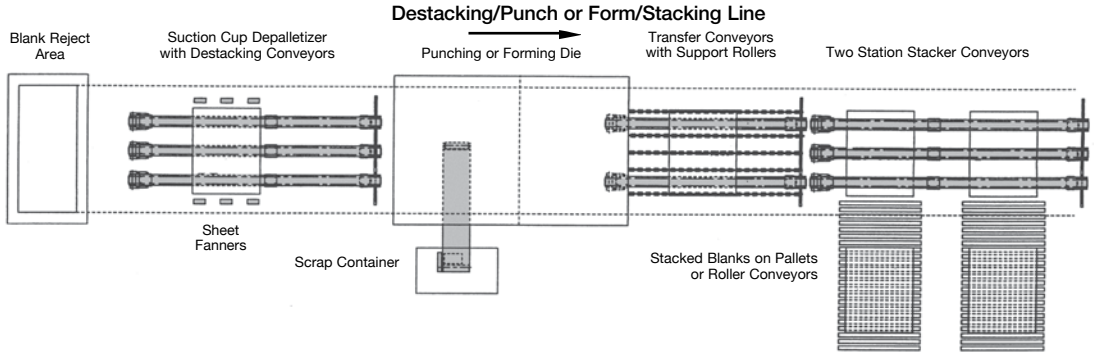
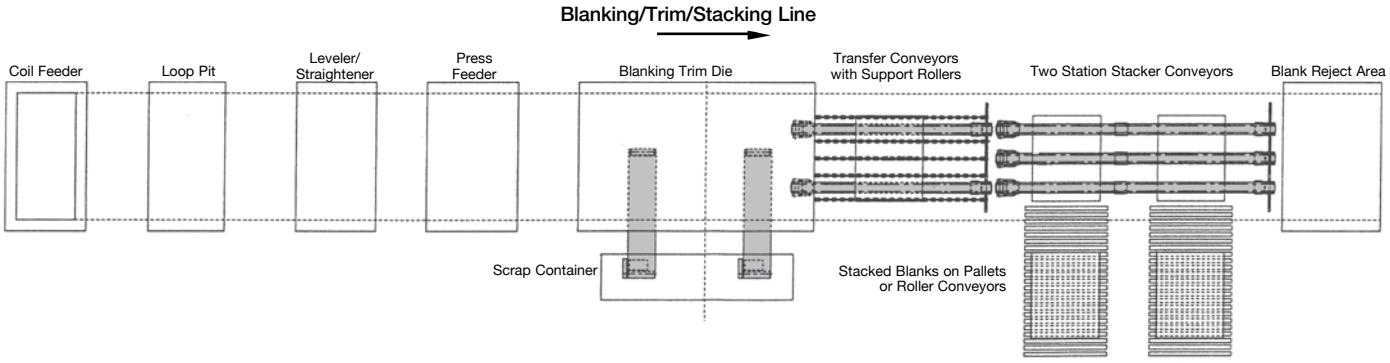
Stack, Destack, Transfer, and Position Sheets, Blanks, and Parts Automatically

Components are boosting productivity and cutting costs in a wide range of industrial settings. We have the equipment and the expertise to help you configure and integrate units that will fit your specific needs, your plant layout, and your budget. Typical applications use a combination of custom-engineered and standard material handling components. Our engineers use the latest computer-aided design technology and CNC production techniques to custom fit each unit to the customer's requirements. We'll tailor equipment to your cut-to-length line, sheet-fed line, blanking line, or other production line operation.

Bunting Destacking Conveyors working in conjunction with Bunting Sheet Fanners separate and destack sheets. Sheets are then transferred to the next workstation via Bunting Transfer Conveyors with "Skate Rail" support rollers designed to move sheets with minimal scuffing. During transfer, blanks can be inspected with a variety of sensing devices. If double blanks or defects are detected, conveyors can be reversed or the problem items rerouted onto a separate conveyor line. Blanks that pass inspection continue on to secondary operations, such as forming or punching.



Bunting Stacking Conveyors eliminate one of the most common bottlenecks in metal-forming operations by providing an automated alternative to the manual stacking of sheet metal components as they come off the production line. Ruggedly built Bunting Conveyors can be used to move sheets or blanks directly from punch presses or stamping and blanking operations or other production machinery. These parts can then be transferred to Bunting Stacking Conveyors for stacking in predetermined quantities, ready to be transferred to another part of your plant or shipped out. Stackers can also be set up to convey rejected parts to separate locations.



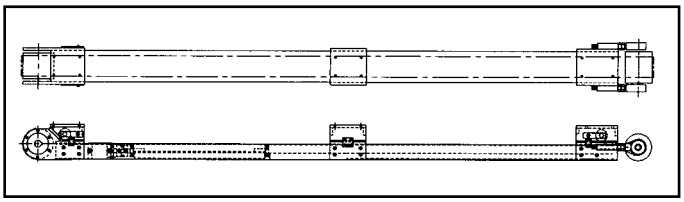
Custom conveyors with “Skate Rail” Support Rollers

Standard Stacking/Destacking and Timing Belt Conveyor Specifications

Bunting Stacking/Destacking and Timing Belt Conveyors are designed and built to meet customer specifications. Normal limits on sheet size are between 0.008 and 0.125 inches in thickness. Standard components include endless urethane belts that carry ferrous parts over high-energy permanent magnets tailored to each individual application. Rare Earth magnets are optional. Speeds of 40 to 400 fpm are typical, but other speeds, reversing, and indexing are also available. Conveyor frames are made of formed or machined materials for added strength and rigidity. Standard modules have 4” belts and come in lengths from 3’ to 50’. They can be built to transport parts any desired distance. Stacker frames are made from rigid tubular structural steel with conveyor mounts precision machined for reliable belt tracking. Drive pulleys are all steel, heavily knurled, and crowned. Controls are selected and configured to individual applications.

Magnetic Stacking/De-stacking Conveyors Reduce Bottlenecks, Labor, Part Damage, and Costly Accidents

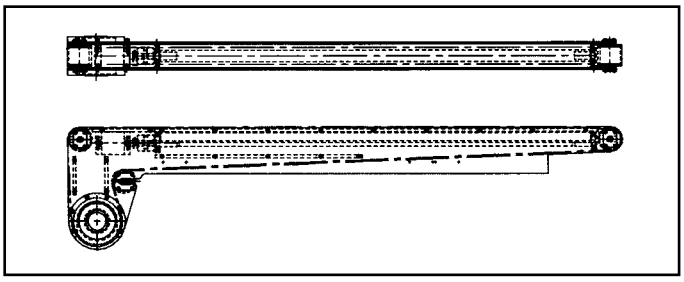
Powerful permanent magnets behind endless belts on our Bunting Stacking/De-stacking Conveyors hold each ferrous sheet, blank, or part securely in place as it is transported. Materials touch only the Stacker belts, avoiding damage to delicate parts and finished surfaces. No special handling is required for painted or oily parts. The permanent magnets will not wear out or drop parts during power outages.



Typical Magnetic Stacking/De-stacking Conveyor (MDC)

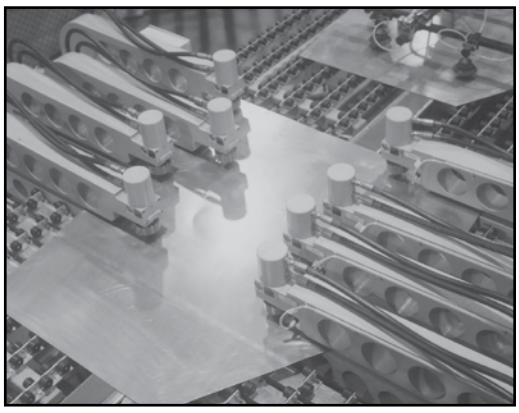
Timing Belt Conveyors Position and Index Sheets and Blanks

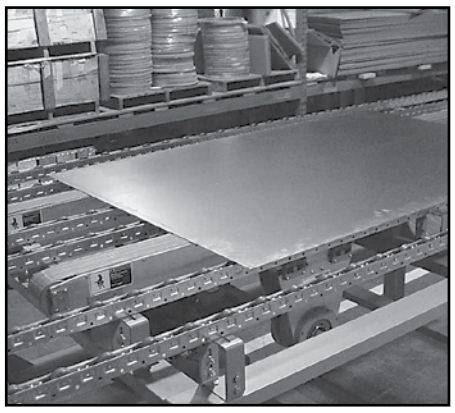
Bunting Timing Belt Conveyors add the advantages of precise speed control to the productivity-enhancing features of our Stacking/De-stacking line. Objects stay in position for integration with production line operations and robotics. Timing Belt Conveyors let you process parts as they are being conveyed and allow on-conveyor indexing and multiple pickup options. Precise conveyor belt timing maintains the spacing of sheets, blanks, and parts from initial placement on the conveyor until they are removed by robotic devices, transferred to another conveyor, or stacked.



Typical Timing Belt Conveyor (TBC)

Bunting Transfer “Skate Rail” Conveyors move sheets without slippage or damage





Bunting Transfer Conveyor moving sheets through dimpling station in VIL Laser Welder.