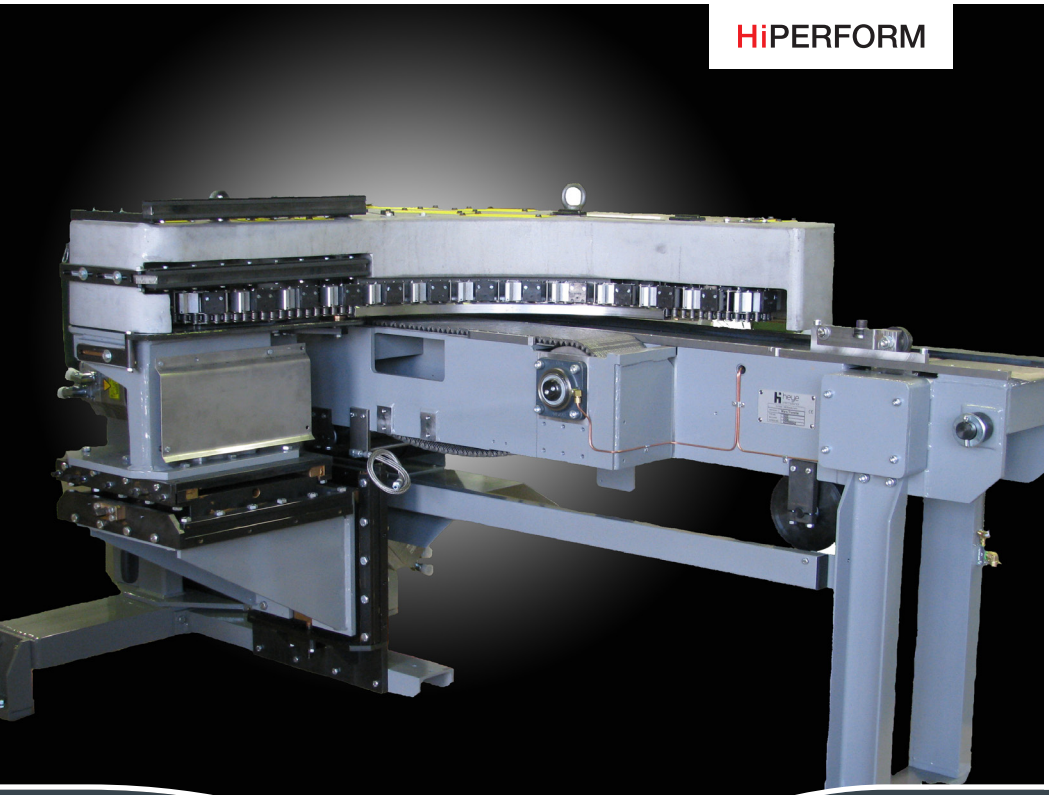
WE ARE GLASS PEOPLE

HEYE
WARE TRANSFER

Type 4222



heye international

THE WARE TRANSFER

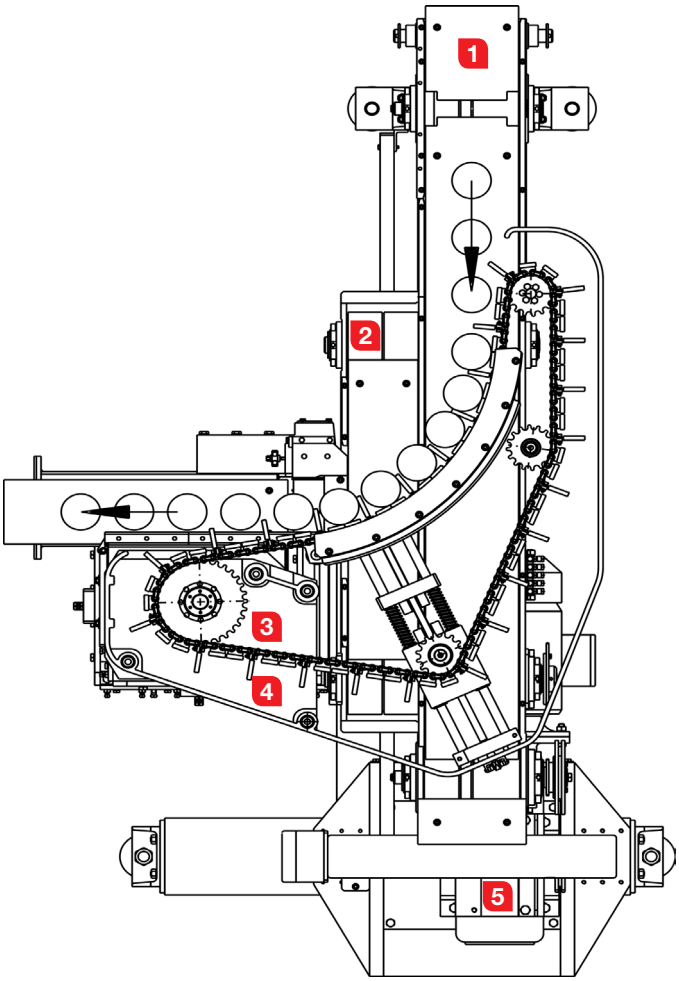
The Ware Transfer serves to guide hot glass articles from the machine conveyor to the cross conveyor which is arranged rectangular to the machine conveyor.

Function

The transfer motion takes place on a large radius. During the transfer one short additional conveyor (2) which is arranged parallel to the machine conveyor supports the article transfer instead of the transfer plate used up to now.
The Ware Transfer is designed for fast-running production machines.
By the graduated speeds between the machine conveyor (1) and the additional conveyor (2) it is ensured that the frictional force which is acting on the bottom of the articles is always guided in direction of the “pockets” during the transfer. Thus, the articles are transferred onto the cross conveyor in a defined distance without contacting each other.

Finger chain

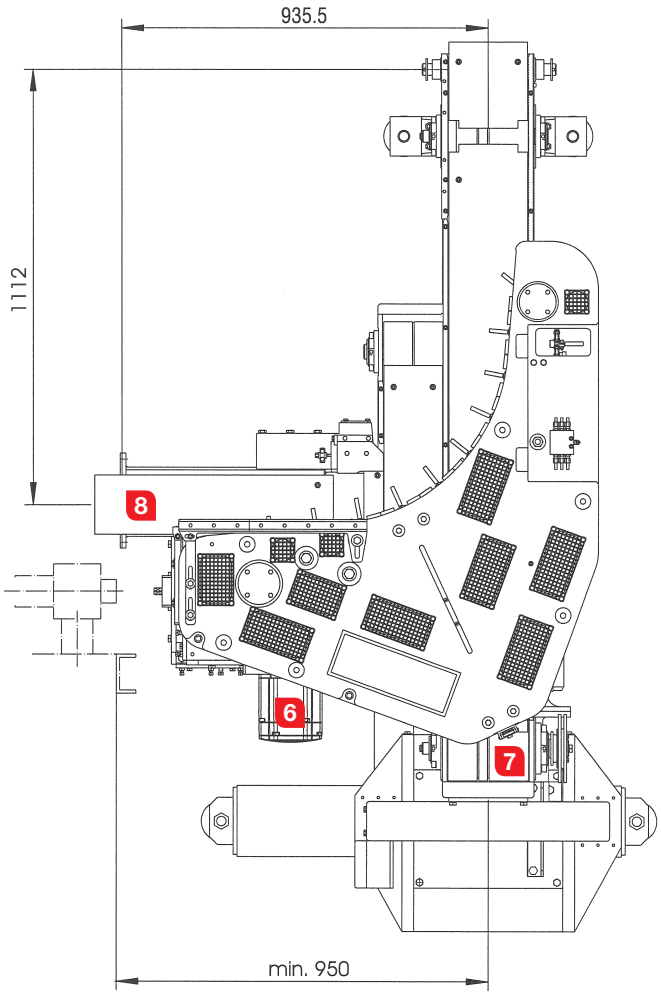
The machine conveyor drive and the adjustment unit can be mounted with the same components either as LH or RH type. The deflection of the articles is carried out by a finger chain (3). The fingers (4) of the chain are fixed in a distance of n x 3/4”. Different pockets from 4 x 3/4” to 8 x 3/4” and corresponding lengths of the fingers from 40 mm to 66 mm are available.



The complete unit consists of:

- Transfer unit; LH or RH type
- Machine conveyor drive with parallel additional conveyor
- Drive- and adjustment unit for the transfer unit mounted at the machine conveyor drive
- Cross conveyor connection with deflection roller for a transport chain width of 125 mm and 150 mm

- Optional:
  Conveyor pitch control for the machine conveyor



Operation
Both, the speed of the machine conveyor drive (5) and the speed of the transfer unit drive (6) are set separately according to the desired article distance. Then they are commonly adapted to the number of articles.
The article distance on the machine conveyor has to be larger than the finger distance of the chain. The distance on the cross conveyor can deviate from the finger distance up to 20 %. Depending on the thickness of the fingers a clear distance of at least 10 mm to 13 mm should remain between the bottles on the cross conveyor. The finger position is adjusted in phase to the arriving articles with the inverter of the transfer unit drive.

Options
The drive wheel for the machine conveyor (7) can either be used for a nominal width of 200 mm or for a nominal width of 150 mm.

The cross conveyor connection (8) is available for chains with nominal widths of 125 mm and 150 mm. The length of the cross conveyor connection is 650 mm at a nominal width of 150 mm.
At a nominal width of 125 mm the length can be adapted to the local space conditions provided that the minimum length is more than 480 mm.

As option quick change fingers can be used. They have the advantage that repair times are considerably reduced.

The conveyor pitch control permits to measure the pitch increase of the machine conveyor silent chain permanently during operation of the system. The speed of the drive can be corrected corresondingly via the belonging inverter.

Drive
As drive a Simotion® servo motor is used. On demand also motors of the size DIN/IEC 90 to 132 can be installed.
For further information please contact us.

1 Machine conveyor silent chain
2 Additional conveyor
3 Finger chain
4 Fingers
5 Machine conveyor drive
6 Transfer unit drive
7 Machine conveyor drive roller
8 Cross conveyor connection

® = Simotion is a registered trademark of Siemens

OVERVIEW

Advantages

- Very precisely adjustable height adaption between additional conveyor and cross conveyor connection
- Precise article transfer on a large radius
- Smooth article transfer in connection with very fast-running production machines
- Machine conveyor drive and Ware Transfer form one unit
- Simple exchange of the cross conveyor roller incl. bearing

Scope of Delivery

- Transfer unit with finger chain, equipped with fingers and plates according to customers' specification, outlet guiding rails
- Drive and adjustment unit consisting of:
  3-directional adjustment unit with attachment for the transfer unit, mounting plate for the drive motor.
- Machine conveyor drive with integrated additional conveyor (with transport silent chain),
  drive head for the machine conveyor (without transport silent chain),
  mounting plate for the drive motor
- Cross conveyor connection with a nominal width of 150 mm or 125 mm, without transport silent chain consisting of deflection roller, cross conveyor connection 650 mm long (for Heye Cross Conveyor Type 4216, nominal width 150 mm). For a nominal width of 125 mm (for Heye Cross Conveyor Type 4217), conveyor body length according to customers' specification (min. 500 mm) possible

Optional

- Integrated conveyor pitch control (for the machine conveyor)

Emissions

- Airborne Sound:
  The operating noise of the Ware Transfer is below the general noise level (approx. 94 dB(A)) at the installation place
- Oil vapours, caused by the oil lubrication of the drive chains

Technical Data

- Dimensions
  width / height / depth 1220/935 -1100/2270 mm
- Weight approx. 900 kg
- Max. conveyor speed approx. 60 m/min
- Max. number of articles approx. 500 /min
- Speed finger chain up to 0.75 m/sec

Finger chain t = 3/4"	No. of elements	Finger distance n x t = mm	Article limit Ø [mm]
Standard	150	3 x 3/4" = 57.15	≤ 37
		5 x 3/4" = 95.25	≤ 77
		6 x 3/4" = 114.3	≤ 90
Option	152	4 x 3/4" = 76.2	≤ 60
		8 x 3/4" = 152.4	≤ 120
Option	154	7 x 3/4" = 133.35	≤ 105

Finger chain t = 5/8"	No. of elements	Finger distance n x t = mm	Article limit Ø [mm]
Option	180	3 x 5/8" = 47.625	≤ 34
		4 x 5/8" = 63.5	≤ 47
		5 x 5/8" = 79.375	≤ 61

(other article diameters upon request)

- Lubrication:
  Machine conveyor drive and chain lubrication: via the IS central lubrication
  Ware Transfer bearings: manually actuated central grease lubrication

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