

## Palletiser mod. DM1

### Automatic palletising:

- shrink packs;
- cartons;
- other containers.

### Application:

- In every industry where pallets are being used.

### Characteristic features:

- High efficiency: 2500 packs/ minute;
- Fully automatic products' palletising;
- PLC drive with self programmed function;
- Designed in compliance with European quality and safety norm.

### Cycle of work:

Infeed products from production line is property divided and grouped into successive layers, according to pre- set palletizing programme. Then layers are formed and put on a pallet in a defined quantity. DM1 model is equipped with device for simultaneous layers' grouping and putting on two half pallets.

### Scope of supply:

#### Conveyor with double speed belt

It is used for separating products so as to count them and possibly rotate in two lanes in pre former. Conveyor is controlled by photocells and stops when there is no product flow.

#### Pre former with middle platform

It is composed of roller part, pushing device and middle platform for products accumulating. Roller part is equipped with separating devices for different palletising patterns' forming. Pushing device moves layers from pre former to palletiser. Pushing device pushes products onto middle platform and only when layer is complete, it is pushed into palletiser.

Pre former is equipped with a device for packs/ cartons 90°, rotating, if it is needed.



## Palletiser DM1

### Electronic control panel

On a control panel, there are placed: all control switches, EMERGENCY STOP button, switches for making changes in a palletising programme and warning lights for assuring proper palletiser's functioning. Keyboard and display are used to indicate errors, change formats, monitor production data. PLC drive is used for controlling and steering functions.

### Pneumatic system

Pneumatic installation is manufactured in compliance with safety regulations. Different connections supply air from air container to sets of electromagnetic valves. Layout of pneumatic installation is attached to user's manual.

### Layercard placing device

It is a device to place layercards between layers to make it more stable. It is composed of many suction nozzles which take layercard from pallet magazine and put on a pallet. Indicating point lets the device apply, lift and lower layercards in a automatic manner with possible check if a layercard is not lost while transferring.

### Safety guards

They are equipped with control entry doors with safety system. Microswitch, mounted on safety guards, activates EMERGENCY STOP, when doors are open while operating. Safety guards comply with all European safety norms.

Pallet infeed and outfeed points are protected by safety barriers mounted on separate columns, which distinguish between material and personnel passage.

### Infeed conveyor for empty pallets, roller, motorised

Roller conveyor is protected by a cover and equipped with two devices for: blocking and stopping an empty pallet.

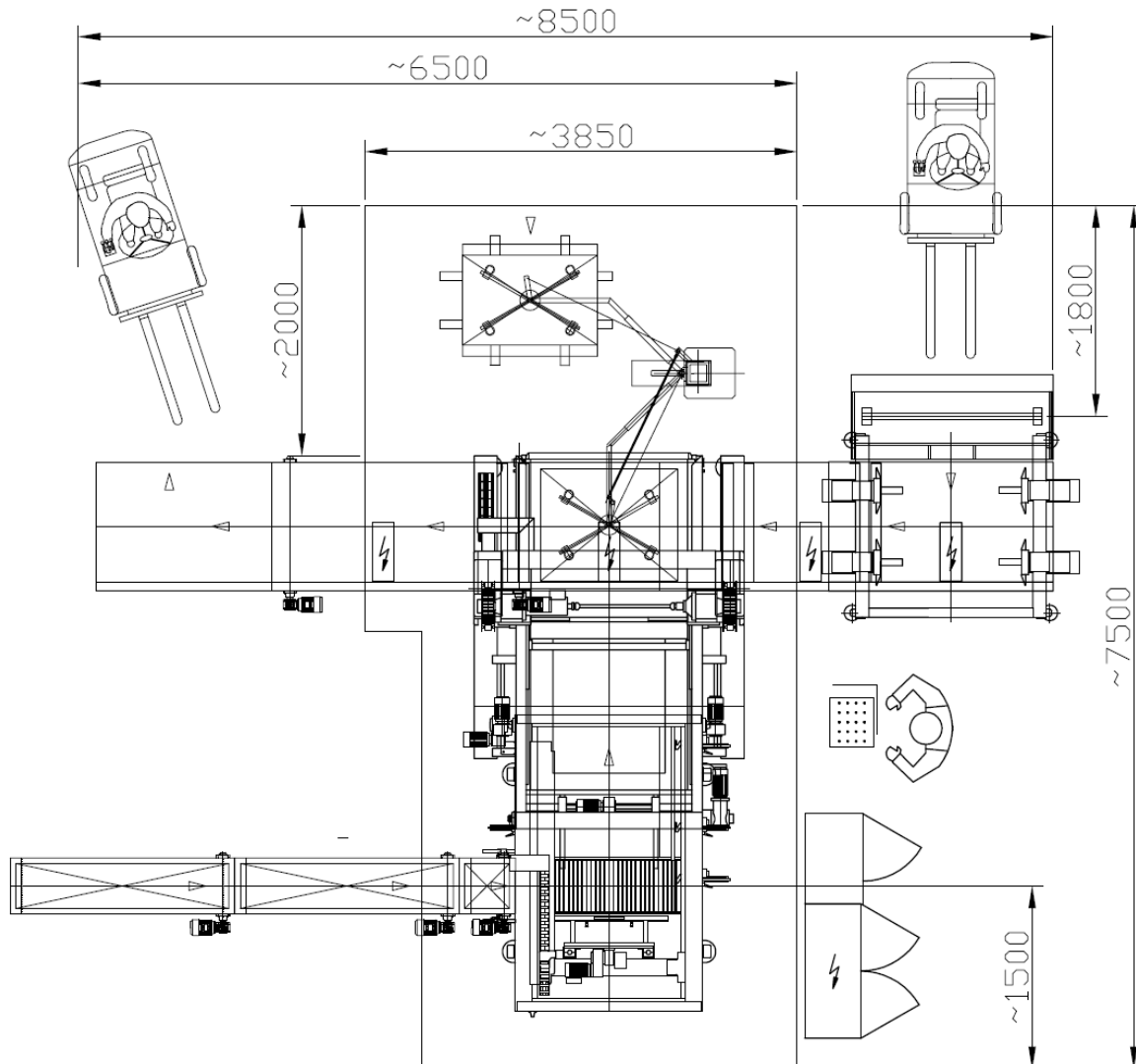
### Motorised, roller conveyor for full pallets.

### Outfeed conveyor for full pallets, idle

Roller conveyor is protected by a cover. It is equipped with pallet brake and micro switch.



### DM-1 palletiser layout





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No	Technical data	Value
1	Efficiency	Up to 2500 packs/ h
2	Speed	To be defined on basis of number of packs and layers
3	Infeed packs height	750 +-50 mm.
4	Standard pallet dimensions	800x1200 mm or half pallets 800x600 mm
5	Maximum pallet height	1800 mm
6	Pallet conveyor height	500 mm
7	Installed power	16 kW
8	Voltage	380V – 50Hz + zero
9	Compressed air	6 bar
10	Air consumption	150 NL
11	IP	IP 54
12	Noise level in a 1 meter distance	Below 78 decibels

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