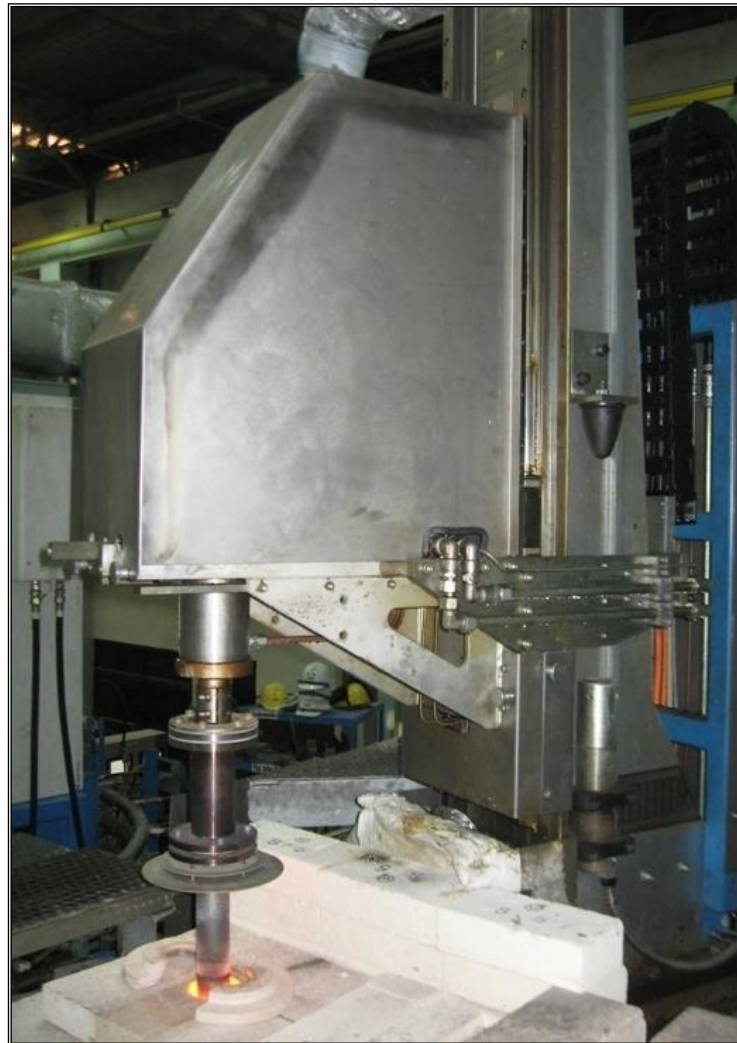


NC Feeder



NC Feeder with linear motor drive

NC Feeder for blowing machines, developed by GLAMACO using the company's 50 years of experience in glass technology and machine construction. GLAMACO machines are used by glass manufactures all over the world, where they are appreciated for their reliability, performance, high productivity and cost-effective operation.

Features of the NC Feeder

- processor controlled trouble-free operation
- simple and quick job change
- easy operation and maintenance
- economical operating costs

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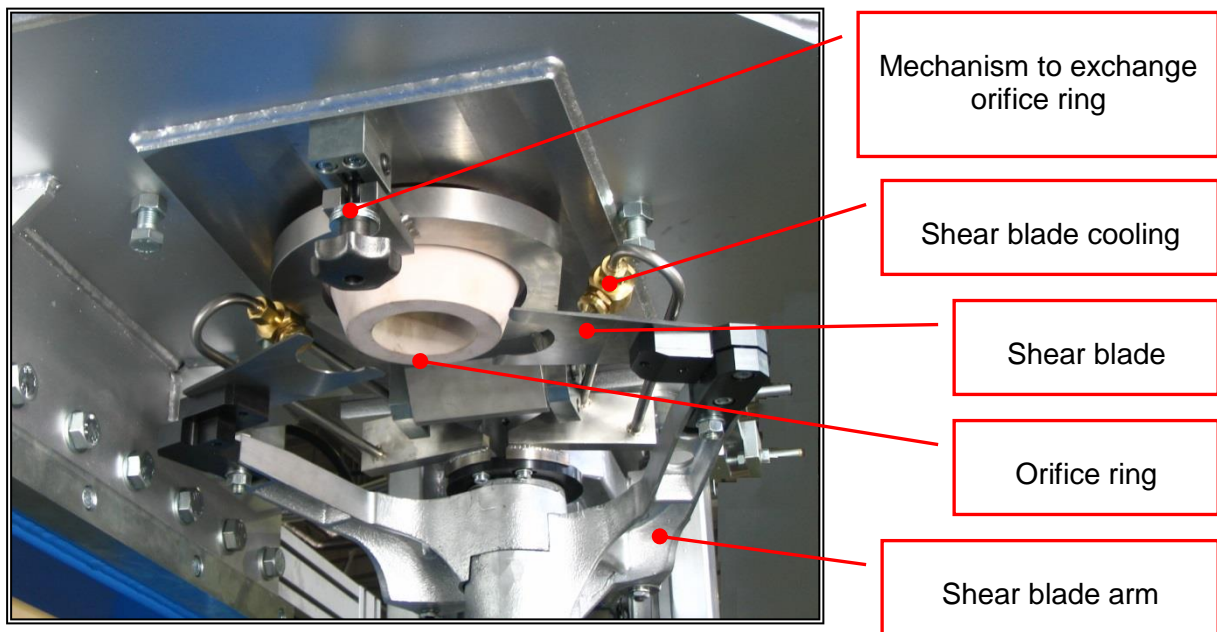
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The machine consists of:

- Plunger mechanism with computer controlled servo drive
- Shears with computer controlled servo drive
- Stroke device for plunger change
- Feeder bowl including orifice ring take up and flap
- Complete control cabinet incl. PC-control

Shear drive

The angular shears are opened and closed by two coupler bars mounted on a recirculation ball slide. The recirculation ball slide is driven by a crank drive, operating from the servo motor with planetary gear train. The computer controls the shears crank drive by a servo motor allowing variable shear blade speed. Speed can also be altered using a monitor.



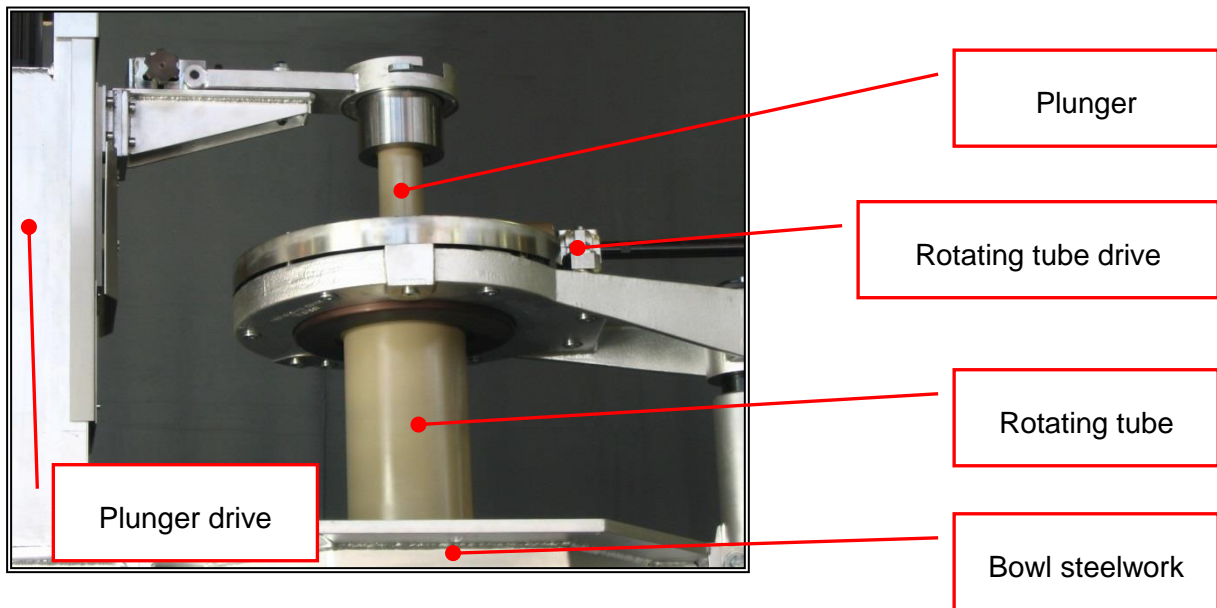
Front view of shear

The basic shear setting for upper and lower arms is easy. They are adjusted by a standard setting tool. Furthermore the setting tool is usable for centring the cutting centre point to the orifice centre. In case of emergency or power failure the shear machine possesses a powerful electric capacitor to open the shear arms.

The shear is easy adjustable in x, y and z-direction. The zero-position is marking on the base frame. The shear blades overlapping and the tensioning device are easy to handle by standard tools. In open position the blades are sprayed from above with coolant. The spray pulse can be regulated by computer.

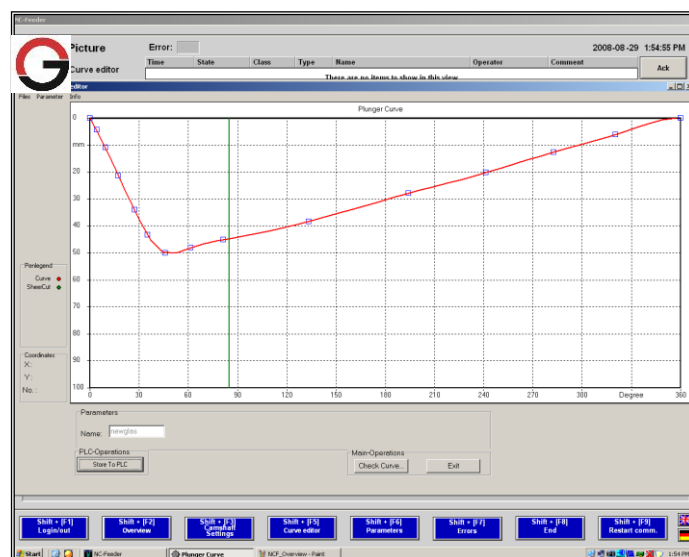
Plunger mechanism for Feeder NCF - 40

The plunger stroke drive is guided vertically by a recirculation ball – slide system and moved with a ball thread drive. A gearless servo motor drives the ball thread movement. A computer controls the stroke movement according to the known plunger curves, while the plunger curve can be varied graphically. In case of power failure or emergency the plunger is movable by hand wheel



Rotating tube mechanism

The rotating tube has a frequency controlled motor. The height adjustment of the rotating tube is made by a hand wheel. (Delivery includes a lifting unit to change the revolving tube and plunger.)



Computer display view for feeder control

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Plunger drive for Linear motor driven Feeder

This type of feeder has a several frequency controlled motor for plunger rotation drive.

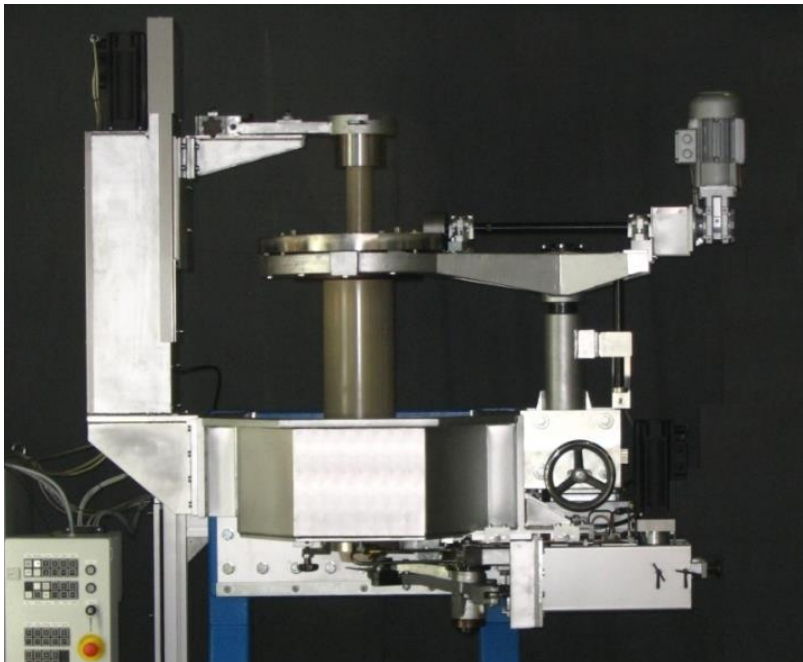
NC-Feeder Control

The feeder is controlled by an industrial PC system. This ensures a reliable, operator friendly and accurate repeat operation of the feeder.

The control is menu driven on the computer display: plunger stroke and plunger stroke position are fed digitally from computer display into the operator table of the machine.

The required plunger curve (plunger movement run, path-time-curve) can be requested from the memory on the computer display (monitor) or changed directly according the technological requirements using the mouse on the display.

Also the movement curve of the shears arms can be requested from the memory on the monitor or changed using the mouse.



Specifications:

Drop weight	[g]	150 - 1,500 (depend on glass and temp.)
Number of cuts	[cycles / min]	5 – 50 (mechanical guarantee)
Plunger stroke	[mm]	0 – 200
Central lubrication		
Shear blade cooling system		

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