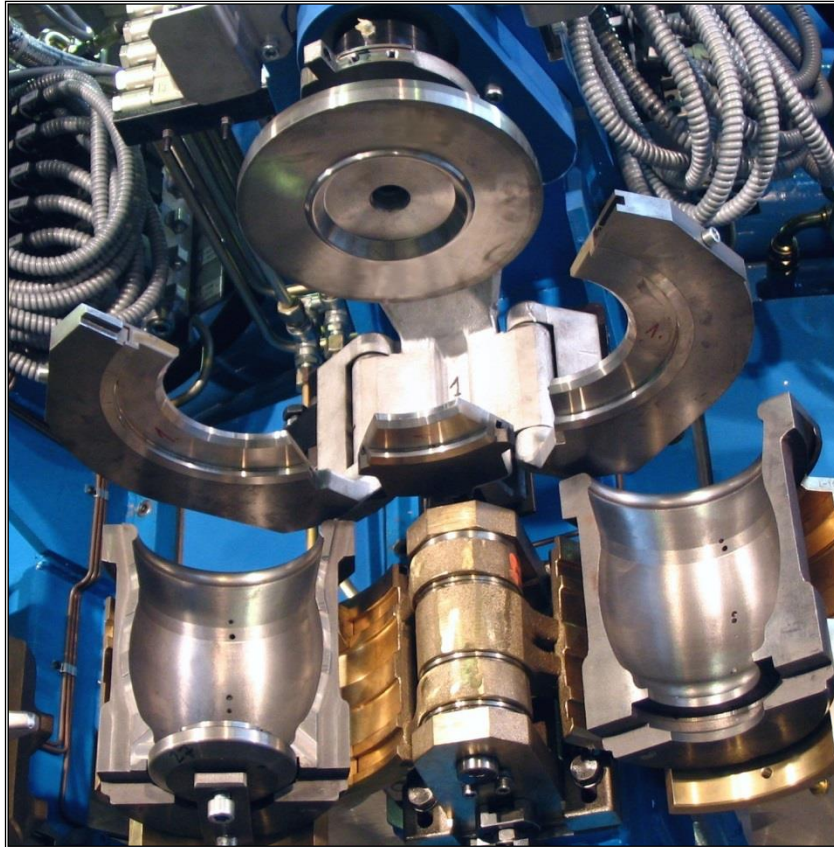


Divided Working Tables



Divided Working Tables on GLAMACO Glass Blowing Machine RBM 16

Technical description:

Divided working tables allow the glass articles to be removed together with the residual tablet by means of a removing unit. Unlike one-piece working rings, the divided types are not subject to wear and their geometry gives a better glass distribution. As glass grit is not produced the process leaves work tables clean.

As in the older form, the divided working tables are attached to the screw of the blow stations. The working ring consists of a stationary and two movable segments. The latter segments are moved by means of a sliding crank situated on the back of the working table and locked in the closed position of the working table.

The lifting unit that raises the crank is mounted on the rotary table behind the blow station in a central or lateral position (depending on machine type). A pneumatic cylinder situated above the rotary table of the automatic machine provides the lift force. This cylinder operates a lifting rod supported in a low-maintenance linear guide assembly and extending downward through the rotary table. The lifting rod carries a crosshead which engages the crank at a point behind the working table.

Flow control valves which control the opening and closing speeds of the working table are accessible during automatic machine operation.

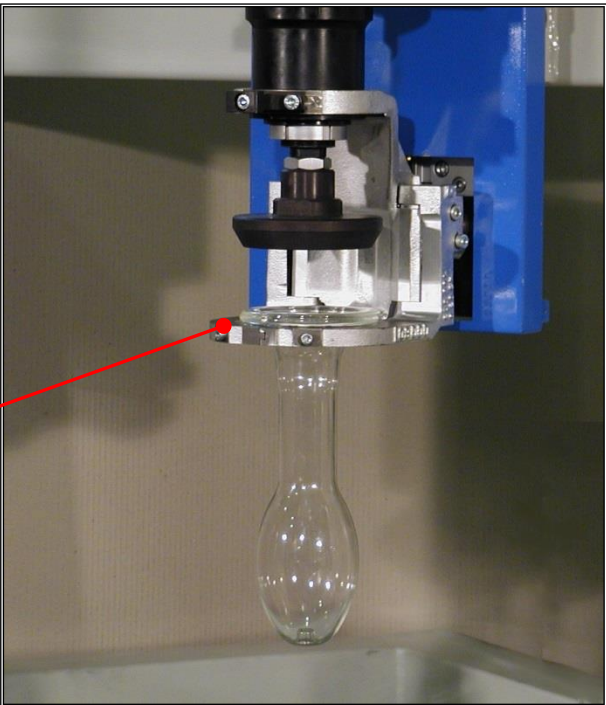
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Lifting unit

Divided Working Table

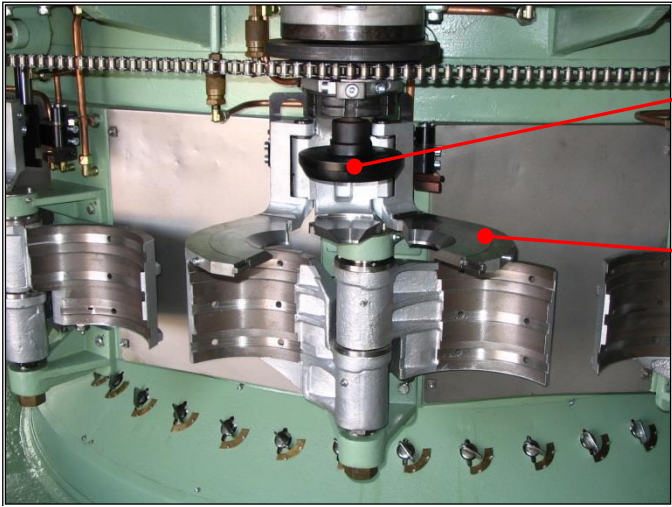


Divided Working Table

Divided Working Tables with light bulbs

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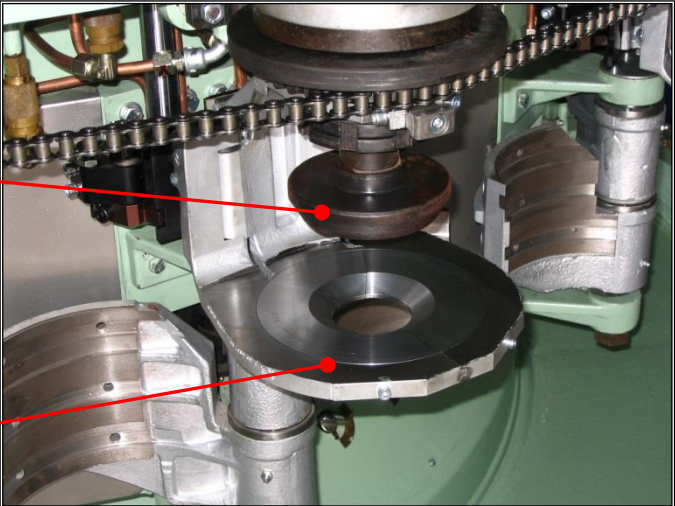
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Blowing head

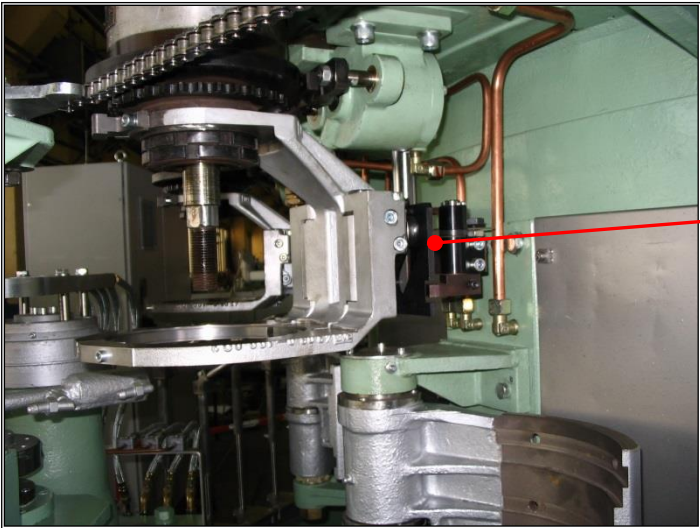
Divided Working Table (open)

Divided Working Table on LH 12 NEG



Blowing head

Divided Working Table (closed)



Divided Working Table (lifting unit)

Specification:

Type	DWT-AT 125	DWT-AT 190	DWT-AT 218
Number of working ring elements	3	3	3
Opening angle of segments (degree)	33	33	33
Divided Working Table height (mm)	142	215	215
Weight (kg)	8	11	13.5
Inside diameter of working rings, max (mm)	80	140	170
Outside diameter of working rings (mm)	125	190	218
Air pressure for lifting unit (MPa)	0.3	0.3	0.3

Advantages of divided working tables:

- Improved quality and consequently higher yield
- Removal of glass articles with residual tablet
- Process produces no glass grit
- Continuous glass handling in production line mode
- Improved glass distribution by more effective working ring geometry
- Existing blow machines can retrofitted with this feature

All points of support of the Divided Working Tables and lifting unit are equipped with maintenance free and exchangeable side bearings.

Currently GLAMACO has updated the following types of Blowing machines with Divided Working Tables:

- LH 12 NEG
- LH 16 NEG
- H 18 NEG
- H 24 NEG
- IBS 20 FORMA

We have also equipped our Blowing Machine RBM 16 with Divided Working Tables DWT.