

## **HOMAG Feeding and Stacking System STACKTEQ C-500**

### **STACKTEQ C-500 (Profi TSH501/QU30/12)**

HOMAG STACKING SYSTEM WITHOUT PIT SINGLE-SIDED TRANSVERSAL, LEFT-HAND EXECUTION

For smooth and fully automatic transport of panel shaped wooden material and continuous stacking behind production lines, stacking systems are compatible with all machines in through-feed section and, due to their high capacity and long life cycles, the solution for an efficient material handling.

### HIGHLIGHTS

- Higher total availability
- Space need reduced to a minimum
- Higher utilization degree
- Safe material flow
- Effective layer arrangement
- Absolute safe part collection also on large layers

### BASIC MACHINE

- Main frame made in steel sheet construction Height total line: 950 - 1000 mm
- Operating with protective boards or pallets by choice
- Centrica! arranged lubricating nipple Centralisation of the lubricating points (6 - 8) per components

### OUTFEED TRANSPORT OUT OF OPERATING MACHINE

- Belt conveyor to collect the workpieces in the stacker
- Automatic speed input from the operating machine
- Fixed side on left hand in transport direction
- Operating side on left hand in transport direction

Advantage:

- Dock timing workpiece accumulation

### TAKE OVER TRANSPORT

Take over of workpieces on a roller-belt conveyor to collect multi-rows stacks with up to 4 layers after another layer width max. 1000 mm with more than 2 rows

Advantage:

- + Leveling and collecting in one station

### TRAVERSE

Complete equipped suction cup device to build up single workpiece layers to a stack

Advantage:

- + Size change-over is not required

### STACK POSITION

Stack position designed with chain lifting platform with integrated driven stack roller conveyor, rollers zinc coated.

Advantage:

- Pitless with even transport level

### PROTECTIVE BOARD-/PALLET DISPOSAL

Driven stack roller conveyor with zinc coated rollers to disposal the empty protective boards, supply by hand

Advantage:

- Steady enter of base plates

### BEHIND MOUNTED STACK TRANSPORT

Behind mounted driven stack roller conveyor with zinc coated rollers

Stack roller conveyor v: approx. 12 m/min Height stack roller conveyor: 300 +/- 15 mm

Administration of different types of stacks Keyboard request for stacks via hand switch to start the roller conveyor

Vantage:

- Coupling to an additional transport unit is possible, incl. interlocking

### GENERAL

lacquering of the machine and safety fence posts in RAL 9003 signal white design strips, safety fence fields, safety doors and stela in RAL 7021 dark grey Minimum compressed air 6 bar constant, dry, oil-free, filtered, according to DIN standard ISO 8573-1, quality class 3 Industrial floor with steel, minimum thickness 180 mm, quality C25/30 XC 1, tension and pressure loadable, surface evenly. Construction tolerance according to DIN 18202

### WORKPIECE AND STACK PARAMETER

Min. workpiece size	250 X 100 x 12 mm
Max. workpiece size	2500 x 1200 x 60 mm
Max, workpiece weight	75 kg
Cover sheet overhang	on all sides 0mm
Workpiece design:	rectangular, closed, without cuts
Base material:	chipboards, MDF boards, HDF boards, plywood, glue wood, solid wood
Waviness:	maximum 0,2 % of diagonal, but max. 5 mm
Workpiece surface material:	raw, lacquer, veneer, laminate, melamine, foil; plain, clean, separable and absorbent
Edge material:	Raw, veneer, PVC, ABS, melamine, paper
	Workpiece transfer in longitudinal direction relation length to width max. 1:1,2
-	Actual stack height 1600 mm incl. base board, dependent on stack stability
-	Top of stack 1900 mm to floor Max. stack weight 3500 kgs
-	1 row layer arrangement,
-	1 up to 4 pieces per row on common base plate Stack arrangement one sort

Protective board construction:

- the stacks have to be transportable, protective boards without cuts and non black surface and not reflecting Protective board dimensions:
- Minimum size 800 x 400 x 18 mm
- Maximum size 2500 x 1200 x 50 mm
- Protective board layers are possible, but not in combination with option no. 2041!
- Pallet construction:
  - Only for using euro-pallets longitudinal! Pallet size 1200 x 800 x 150 mm (+/-5)
  - Pallet weight max. 25 kg
  - Pallet construction according to data sheet no, 9-506-00-706\_
  - Without base plate: min. workpiece length 800 mm

**NOTE:**

With using small pieces or stacks we recommend a minimum protective board thickness of 22 mm to avoid a melting of the stacks.

CAPACITY SPECIFICATONS

- Capacity specifications based on the basic machine without options and effected with workpiece thickness 12 - 22 mm.
- Thickness > 22 mm apply to a factor of 90 %.
- Thickness > 30 mm apply to a factor of 80 %
- The workpieces have to be separable within 0J2 sec. and have to be absorbent and clean. Change-over time 50 sec. from one workpiece size to another workpiece size.
- Stack changing time with stack height 1000 mm 80 sec. each stack position.

Exem12lary illustration:

Layer= number of pieces in length/width) referred to stack moving direction

Layer	Length	Work Piece	Capacity
1/1	Max.	400 mm	18
1/1	Max.	800 mm	18
1/1	Max.	Max.	17
2/1	500mm	250 mm	23
2/1	1000mm	400 mm	20
3/1	500mm	250 mm	23
n/>1	Max.	<400mm	32
n/>1	Max.	>400mm	26

POWERCONTROL PC23 POWERTOUCH

Modern control system based on a Windows PC

The control of the machine is not suitable to process personal data within the meaning of EU-DSGVO.

Hardware:

- operating panel with FULL-HD multitouch display in widescreen format
- PLC control accord. to International Standard
- IEC 61131
- modern industrial PC with operating system Windows backup manager and storage medium for com- fortible data backup
- USB connection

- digital field bus system for inputs/outputs and decentral unit and antivirus software network connection ETHERNET. Homag uses data networks with the identification 192.2.2.x.
- If this identification is also used in the customer network, the customer has to provide a router in order to avoid network conflicts your HOMAG machine is already prepared to connect with tapio a functionality that gives you the opportunity to use innovative digital products from tapio and tapio partners and to be ready for the future inform yourself also at your HOMAG Sales or under [www.tapio.one](http://www.tapio.one) please consider that the offers and services of the tapio platform only can be used when you register for this and when you activate the corresponding functionalities otherwise "tapio ready" functionality only establishes a connection to the tapio agency service which checks by means of the machine number if the corresponding machine is activated for using the tapio platform

#### Software:

- equal HOMAG operating surface powerTouch
- ergonomic touch operation with gestures such as zooming, scrolling and swiping
- easy navigation for equal and intuitive operation of the machine intelligent display of readiness of production by light function machine data capturing MMR basic for maintenance depending on need and for the representation of important operating figures (e.g. number of pieces, production time) expendable to MMR professional for optimization of production by capturing and evaluation of the downtimes of the machine as well as the reasons for disturbances error message in plain text via diagnosis system woodScout
- operating system Windows
- system conditions for office PC: operating system at least Windows 7

#### ELECTRICIAL EQUIPEMENT

- Operating voltage 400 volts (+/- 10%), 50 Hz,
- Control voltage 24 volts (+/- 5%)
- DC Motor voltage: 400 volts (+/- 10%), 50 Hz.
- Negative anode potential: 400 volts (+/- 5%), 50 Hz.
- Electric control is located in a switch cabinet which is directly mounted at the station
- Hand operation at operating desk
- Installed according to euro standard EN 60204 Working temperature +10 up to +35 degrees C
- Air condition for switch cabinet
- Cable laying on floor, instal of wiring and cable tracks from machine to switch cabinet by customer
- The machines are not suitable for connection to a RCD due to operational leakage currents, Instead the recommendation is to route the supply in such a way as to prevent ground faults or short circuits (e.g. in accordance with DIN VDE 0100-520/521.11)
- Interface to HOMAG machines, incl. interlock or network cable

#### SAFETY AND PROTECTIVE DEVICES

- The complete station is protected with a protective fence with automatic sliding doors in stack area against inadmissible entry.

- Manual stacking via separate door
- EC conformity (CE) according to the currently valid Machinery Directive for individual machines in operation
- For linked machines in operation (cells/ several cells) an additional EC conformity assessment (on site) is necessary. The assessment has to be done by the user (customer) himself or optionally by the supplier option no, 8945
- Wood dust protection max. 2 mg/m<sup>3</sup>, subject to the required extraction capacity being provided by the customer according to the suction plan
- Condition for our warranty/product liability is the unrestricted observance of the original production instructions delivered along with the machine including the safety instructions

#### HOMAG QUALITY KIT

- TOV certificate accord. to DIN EN ISO 9001: 2015
- The machine will be run-in and delivered accord, to HOMAG standard program
- Energy saving functions: when the machine is not producing, the control voltage is disconnected by means of preset time the function can be switched on and off

#### BASIC EQUIPMENT OPERATING MANUALS:

Language as indicated under position D.01

1. operating manuals consisting of operating and maintenance manuals on a DIN A4 paper and data carrier
2. spare parts denominations on data carrier
3. wiring diagram on data carrier in German and English
4. help texts are integrated into the machine control
5. operating system dialogues in English

#### EXECUTION AS FEEDTEQ/STACKTEQ C-500 RIGHT

Feeding or stacking station without pit, single-sided transversal, right-hand execution  
Data sheet no. 9-506-00-XXXX

#### **NOTE: STACK LAYER ARRANGEMENT**

- For max. 5 rows and 4 parts/row
- Parts:
  - 5x 200 mm in width
  - 4x 250 mm in width
  - 3x 350 mm in width
  - 2x 550 mm in width
- Min. parts width 120 mm

#### FEEDING/ OUTLET TYPE 25/12

stack roller conveyor for baseboards and stacks will be shortened for max. 2500 mm stacks/pieces.

## **ENERGY AND SUPPLY**

#### INSTALLATION ACCORDING TO REGULATIONS

Switch Cabinet executed according to UL specification

OPERATING VOLTAGE 480 VOLT

FREQUENCY 60 HZ.

## **BAT-MACHINE**

PLATS - CHANGE OF STACK TRIGG. BY CHANGE OVER\*

- Communication via interface including software for data transfer.
- The unit receives the data from the Homag main computer and resets the corresponding data for changeover of the machine.
- Whenever the stacker is changed over a change of stacks is triggered.

## **PERIPHERAL COMPONENT**

AIR CONDITIONING FOR COOLING THE SWITCH CABINET

Air conditioning for cooling of the switch cabinet for a surrounding temperature exceeding 35 degrees C.

LANGUAGE SELECTION: ENGLISH

operating manuals and on-screen operator control texts for machine operators in English

COPY OF DIGITAL DOCUMENTATION FOR SSC/SSP

consisting of manuals and maintenance guidelines, spare parts lists and electrical plans on data carrier the language of the documentation corresponds to the language sold for the machine in case of various sold languages per machine this sales no. can be used several times

TELESERVICENET – SHARED

- For the integration of the machine into an existing HOMAG production cell
- package does not include hardware fast and high-performance remote maintenance access by secured VPN connection via the internet
- TeleserviceNet on the machine offers additional e-Service possibilities
- wired broadband internet connection has to be provided by the customer, the services and fees for Teleservice or for remote diagnostics are separately charged network integration see data sheet 9506006450