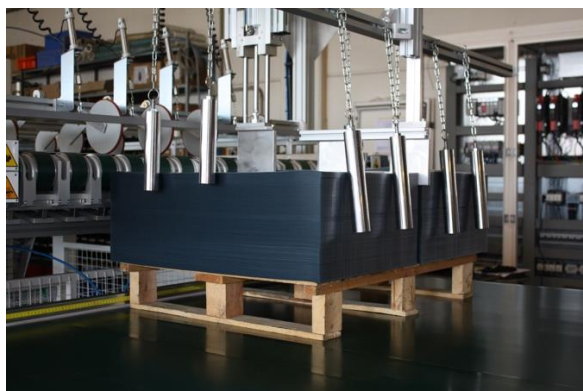


IN-LINE SHEETER

PASQUATO
CUTTING TECHNOLOGIES



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General overview

In-line sheeter allows you to cut the web/plastic foil downstream the extrusion/calender line.

The Pasquato IN-LINE SHEETER is composed of three sections:

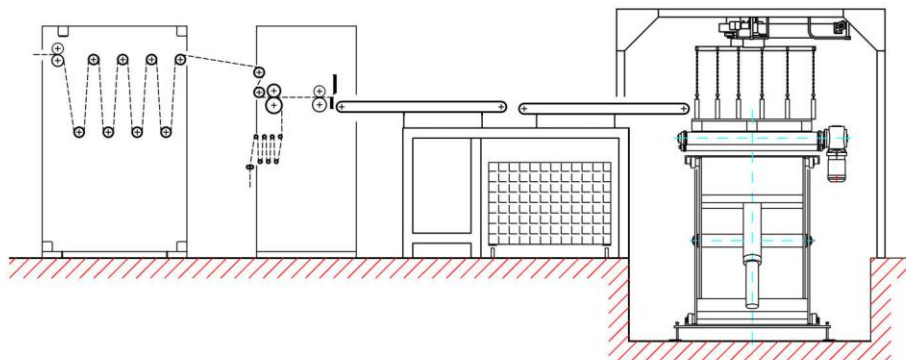
1. Dancer rollers system;
2. Feeding and cutting section;
3. Stacking section.

The cross cutting blades on the Pasquato IN-LINE SHEETER use the scissor action, which provides flexibility, reliability, ease of setting as well as durable sharpening.

As long as the cross cutting action is stationary, there is a dancer rollers system before the feeding and cross cutting section which accumulates the material during the non-stop feeding of the extruder/calender.

The sheeting process includes the trimming (i.e. the slitting of the edge), the cross cutting, and, in necessary cases, the slitting through shear rotary knives.

The sheets, which come from the feeding and cutting section, are stacked on a custom device. Pasquato provides several solutions in order to handle the sheets piling according to the Customer's needs.



Material

In-line sheeter IN-LINE SHEETER model can cut across a wide range of rigid materials, such as PET, PP as well as PSAI, from 0.1 to 3.0 mm (0.004" – 0.19") thickness.



This machine does not enable processing of high-electrostatic materials.

Technical specifications

	SI	US
Standard working width	1500 – 1700 – 2100 – 2500 mm	59 – 67 – 82 – 98 inch
Min cutting length	500 mm	19 inch
Max cutting length	9999 mm	394 inch
Max stacking length	1500 mm	59
Max speed*	20 - 60 m/min	65 – 196 fpm

* The max speed is strictly related to the material properties.

All the above data are strictly related to the type of material and its properties.

Tension control

The web/foil that comes from the extruder/calender, goes through the dancer rollers system, which stores the material during the stationary cross cutting action.

The rolls used in such system are 100 mm (3.94") diameter, made of lightweight materials, and fitted on bearings.



Trimming and slitting

The trimming section includes both the slitting knives and the removal device. Here it is necessary to avoid any jam of the trim which may cause an unexpected stoppage of the line.

The bottom knives are driven by an inverter motor. The top knives are idle and push against the bottom ones through a pneumatic knife-holder.

The operator manually sets the slitting position of the blades through a handle, even while the machine is running.

The trim is tight through a small NIP-roller, while a small dancer rollers system controls the tension. The trim has to be removed at the output of the NIP-roller either by hands, through a vacuum suction system, or any kind of waste handling device.



Feeding

The feeding of the web/foil into the cross cutting section occurs through the NIP-rollers. The bottom NIP-roller is driven by a brushless motor (servomotor) while the top NIP-roller is idle and drives the encoder of the cutting length.

The CNC positioner controls the accuracy of the cutting length.



Cross cutting section

The NIP-rollers feed the web/foil into the cross cutting section. The cross cutting blades work via a scissors effect so that they are able to cut materials of many different types and thickness without any set-up change.

The top blade is hinged to the cross bar and there are springs which push it against the bottom fixed blade.



Air assistance on the stacking area

The bottom cross cutting blade is equipped with an air blower. The air blown by the small holes makes a slight air-cushion under the sheet that is coming out from the cross cutting section.

The air compressed must be clean, dry and oil free.



Accuracy

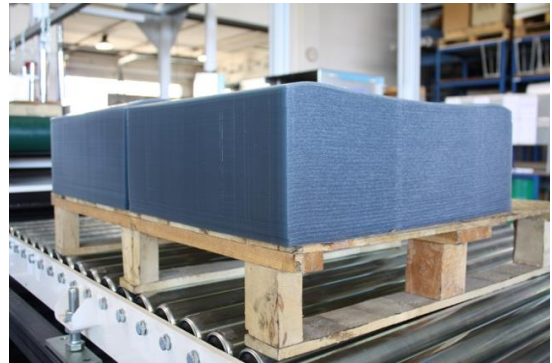
	SI	US
Cutting length	700 mm	27.5 inch
Accuracy of the cutting length	+/- 0.5 mm	0.02 inch
Accuracy of the stacking	+/- 3 mm	0.1 inch
Accuracy of the diagonal 700 x 1000 mm Only with sheeter equipped with trimming system	+/- 1 mm	0.04 inch

Stacking solutions

OPTION 1 - STACKING WITH AUTOMATIC CHANGE OF THE PALLET

When each sheet comes from the cross cutting section, it lays down onto the N1 conveyor belt, which moves the sheet toward the N2 conveyor belt.

The N2 conveyor delivers the sheets to the top of the pile, which stacks on the self-lowering platform. The air blower aids the stacking process of the sheets.

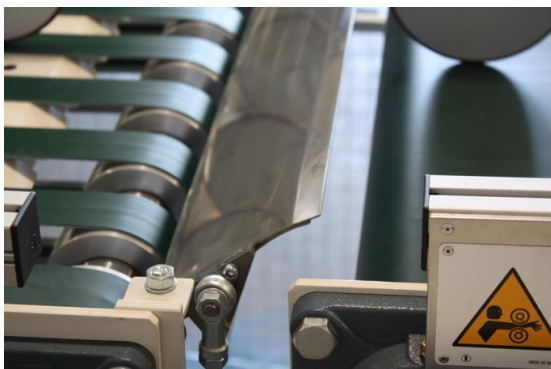


The photocell controls the position of the top of the pile, automatically lowering the pallet when necessary.

The max stacking height is 1000 mm (40"), depending on the top platform level.

Every sheet is set in place through the side guides. The positioning of such guides is operated by gear-motors.

In between the N1 and N2 conveyor belts there is an opening flat which diverts the sheets into the waste bin in case of defect.



When the pallet is full, the operator sets a new pallet on the conveyor belt and automatically swaps the full one with the empty one.

OPTION 2 - STACKING ON BOARD

In this system, the stacking process is not an automatic operation. The operator should check by sight the quality of the stacking.

After the cross cutting process the sheets are stacked on the self-lowering hydraulic platform aided by both the antistatic bar and the air blower.

The max height of the pile is 800 mm (31.4") plus the pallet.

The max load of the delivery table is 600 Kg (1,322 lbs).



At the output of the stacking, the operator lowers the platform and removes the pallet from the stacking area.

During this operation, the sheets which come out from the cross cutting section are removed by hand.

OPTION 3 – STACKING ON A STANDARD TABLE

In this system, the stacking process is not an automatic operation. The operator should check by sight the quality of the stacking.

After the cross cutting action, the sheets are stacked on a delivery standard table aided by the antistatic bar and the air blower.

The standard fixed level delivery table must be set in angle according to the material.

The max load of the delivery table is 100 Kg (220 lbs).



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