



**CHOSEN BY LEADING  
COMPONENT MANUFACTURERS  
WORLDWIDE**

# **STACKING MACHINE**

## **ST - series**



- Automatic sheet handling from cassettes
- Carrier palettes automatic loading / unloading
- Automatically removes carrier film before stacking
- Automatic vision alignment
- High force pre-lamination press included
- Suitable for high layer count stacks

**AUTOMATIC HIGH LAYER STACK  
PRODUCTION SOLUTION**

## BASIC CONFIGURATION:

The **ST** series of stackers were specifically developed for high layers count applications where up to 8 different patterns need to be stacked automatically. These stackers are available in automatic or manual versions. On these machines the carrier film is removed first, then the sheet is pressed on to a previous one using relatively low force. After the stack is built up, it moves to the pre-lamination press, where it is pre-laminated with a higher pressing force. The sheets are handled with a vacuum chuck, so these stackers are not suitable for components with through-holes or cavities. Stacks up to 12 mm are normally built on a carrier block. Higher stacks are built in a cavity, which prevents the layers from becoming misaligned. Using this approach stacks of up to 100 mm in height can be made. The stacks are built on a single carrier block.

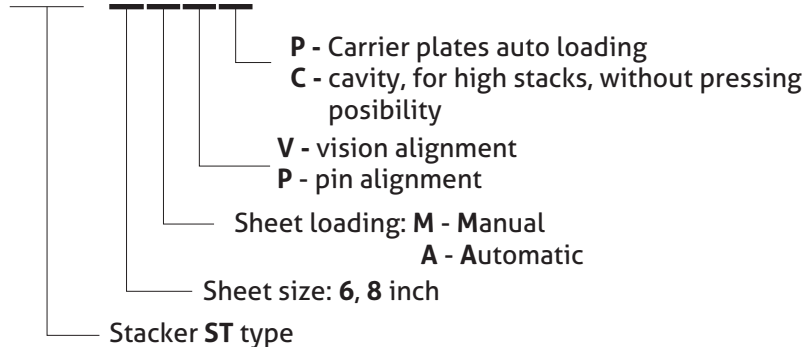
Up to 20 carrier blocks can be processed simultaneously.

Carrier blocks are loaded automatically from a magazine and placed back into the magazine after the stacking sequence is finished. On the fully automatic units the sheets are automatically loaded from sheet cassettes, aligned using a vision system, the carrier film is removed and finally they are stacked. On the manual version, sheets are loaded by the operator. The stacking sequence is programmable via a touch screen interface. Two high resolution cameras controlled by a PC vision system detect the sheet position. A short cycle time and high stacking accuracy make the ST stackers the best choice for high layer count individual sheet stacking machine available on the market today.

Tehcnical specification			
Number of cassettes	up to 8	Pre-laminating force	up to 200kN
Number of carrier blocks magazines	2 (one empty, one full)	Typical cycle time	12 sec. (depends of stacking time)
Number of carrier blocks in magazines	20 PCS	Cavity option	compatibe with Keko TPR-Thermal lamination press
Stacking force	up to 80 kN	Control	PLC + PC vision
Stacking temperature	Up to 80 °C (180 °F)	Pre-laminating temperature	up to 120 °C (250 °F)

How to order: \*

# ST-XXXX



\* Options and other requirements have to be specified separately.



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