

smt installed 2 Destacker-Retrofits at an automotive manufacturer in Osnabrück, Germany

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smt was awarded with the Retrofit of the Destacker at Press Line 1. The complete Retrofit had to be carried out during the Christmas shut-down. By the performance shown, and above all, the compliance with the tight time schedule, the second Destacker-Retrofit project was also awarded to smt. This order was also carried out over the turn of the year, and reached over 96% availability within a very short time.

Both complete Destackers were assembled and commissioned in our plant in Siegen.



- Line 1 with blank sizes 3.300 x 1.800 mm
- Incl. smt Washing Machine WEB, smt Cross Brush Cleaner CBC and smt Spray Lubrication System SLS
- Optical Centering Station



- Line 2 with blank sizes 2.400 x 1.500 mm
- Incl. smt Washing Machine WEB und smt Spray Lubrication System SLS
- Optical Centering Station



- Pallet cart with fanner magnets on Pantograph arms
- Traversing area secured with scanners
- Incl. Rail system in floor, cart with motor drive
- Last blank control via sensor, manual setting



- Destacking area with infeed conveyor
- Round belt conveyor with additional double blank measurement and blank upper edge detection



- Infeed area at Line 2
- Camera station with Matrix-Camera above the centering conveyor
- Centering conveyor has moved upwards for the tool change
- Robot in waiting position

The main components of the equipment are:

- Destacker for blank sizes of max. 3.300 x 1.800 mm or 2.400 x 1.500 mm in steel and aluminum
- Modification and overhaul of the existing Washing Machine with additional integrated traversing gear
- Integration of a **smt** Cross Brush Cleaner CBC with integrated hot steam brush cleaning for material coated with dry lube at Line 1 (preparation for later integration at Line 2)
- Integration of a **smt** Spray Lubrication System SLS
- New conveyor technology:
 - Infeed conveyor with double blank monitoring
 - Centering conveyor with optical alignment via a matrix camera system, incl. lighting
- The entire centering belt can be moved laterally or vertically on the press, to change the tool in order to clear the traversing area of the tooling tables
- 2 complete pallet carts with manual fanner magnets and air nozzle preparation
- All machine parts are designed movable on an in-floor rail system
- Integration of existing robots into the overall concept and new programming
- New control (Siemens) and interface to the Press control
- Complete protective housing with roller doors and fencing
- Integration in the safety circuit of the press line
- Commissioning and buy-off in our plant in Siegen, and assembly and commissioning on customer's site with our own technicians

Both lines have therefore been largely automated. Where blanks were previously taken by hand through the Washing Machine to the centering area, today a modern and reliable system has been installed with two autonomic pallet carts, incl. fanner magnets, a robot destacker and new conveyor belts, up to the optical centering station, which was kept very flexible especially for the customer.

In addition to steel and aluminum blanks as single or double blanks, variants can also be processed with the **smt** Washing Machine WEB or the **smt** Cross Brush Cleaner CBC (dry cleaning) in combination with the **smt** Spray Lubrication System SLS. And also for small batch sizes.

For further information and any questions, please do not hesitate to contact our team on +49 (0)271 7751 212 or by email m.stahlberg@schleifstein.de.