PRESS AUTOMATION
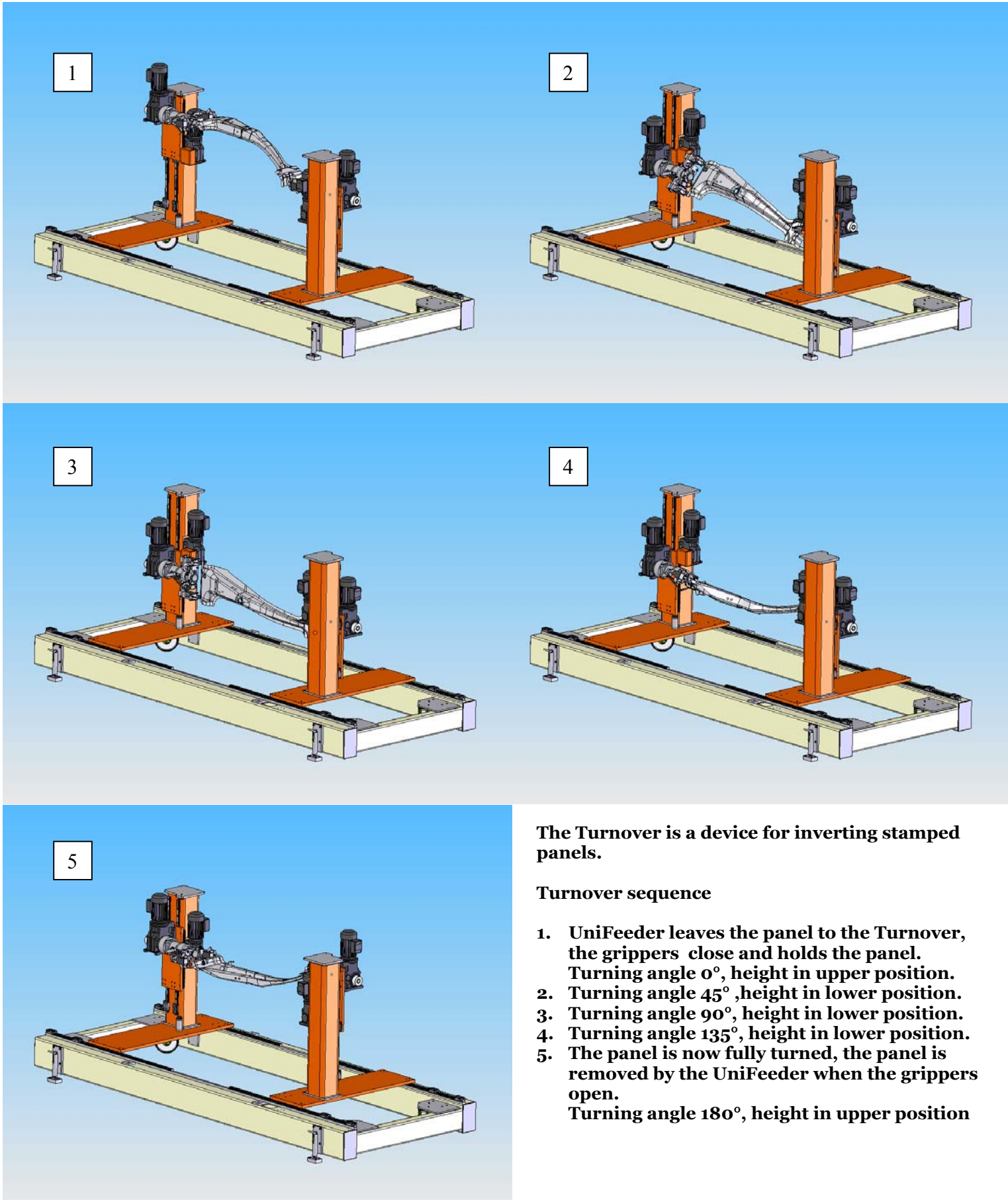
TURNOVER

- Fast and smooth movements.
- Space-saving epicyclical action.
- Simple and solid construction.
- Up to eight programmable axis.
- Many year's experience from industrial controllers and press automation contributes to user friendliness and high productivity.

Turnover

1

2

3

4

5

The Turnover is a device for inverting stamped panels.

Turnover sequence

1. **UniFeeder leaves the panel to the Turnover, the grippers close and holds the panel.**
   Turning angle 0°, height in upper position.
2. **Turning angle 45° ,height in lower position.**
3. **Turning angle 90°, height in lower position.**
4. **Turning angle 135°, height in lower position.**
5. **The panel is now fully turned, the panel is removed by the UniFeeder when the grippers open.**
   Turning angle 180°, height in upper position
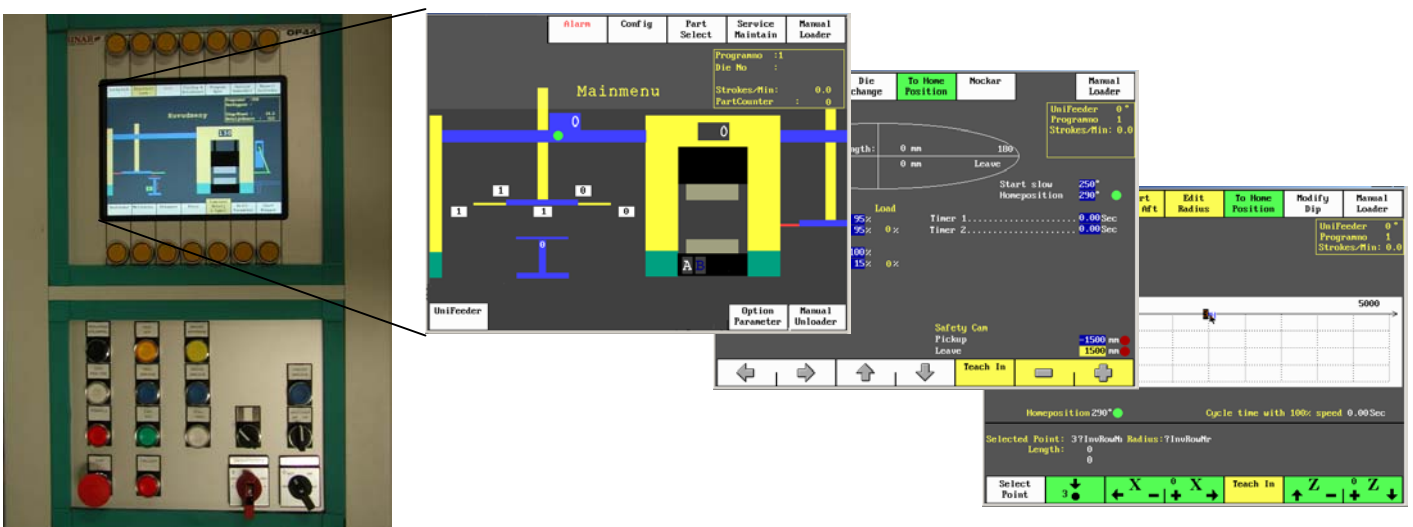
Technical Data and Handling Capability

Handling Capability:

Feed direction	min 100 mm
	max 2500 mm.
Width	min 100 mm.
	max 4500 mm
Heightadjustment	$\geq$ 450 mm to any.
Weight. (panel + tooling).	max 130 kg.
Speed	ca 17 stroke/min.
Weight:	1200 kg
Turnover arc	0 >360° (free rotate)
Sideshifting	500 mm to any

All adjustments are automatically adjustable
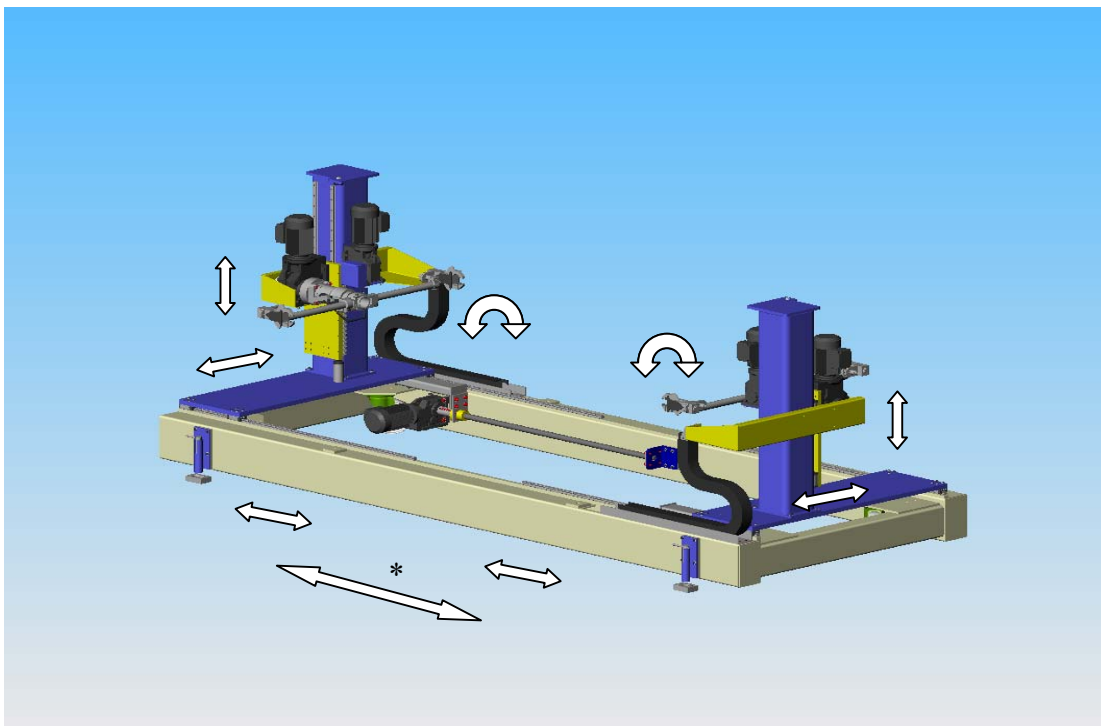
User Friendly Interface

Position and speed are programmed from a User Friendly display.

Functional Principle

The Turnover is a device for inverting stamped panels, normally the Turnover is placed between Press 1 and Press 2.
Two separate turning devices units run synchronized without any mechanical connection. Respectively turning device can be moved up and down during production. The Turnover units can be positioned in different width to fit different size of panels + sideshifting to allow different orientations of the panel in the flow direction.

* The Turnover can also be used for sideshifting.

Data for position and speed for respectively panel is stored in the control system.