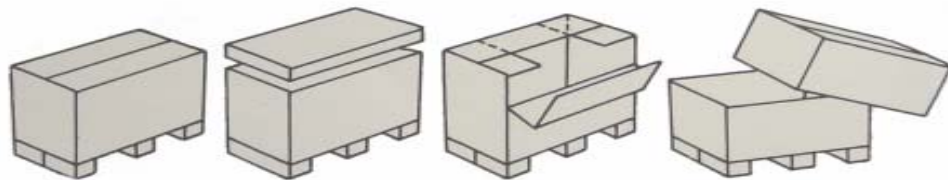


## SGR 3 X / B 36-78 (X-P 25/4 A)

Pneumatic Stapling Device with 3 coiled stapling heads for fixing cardboard sleeves onto the bottom flaps of a box for use as a carton pallet

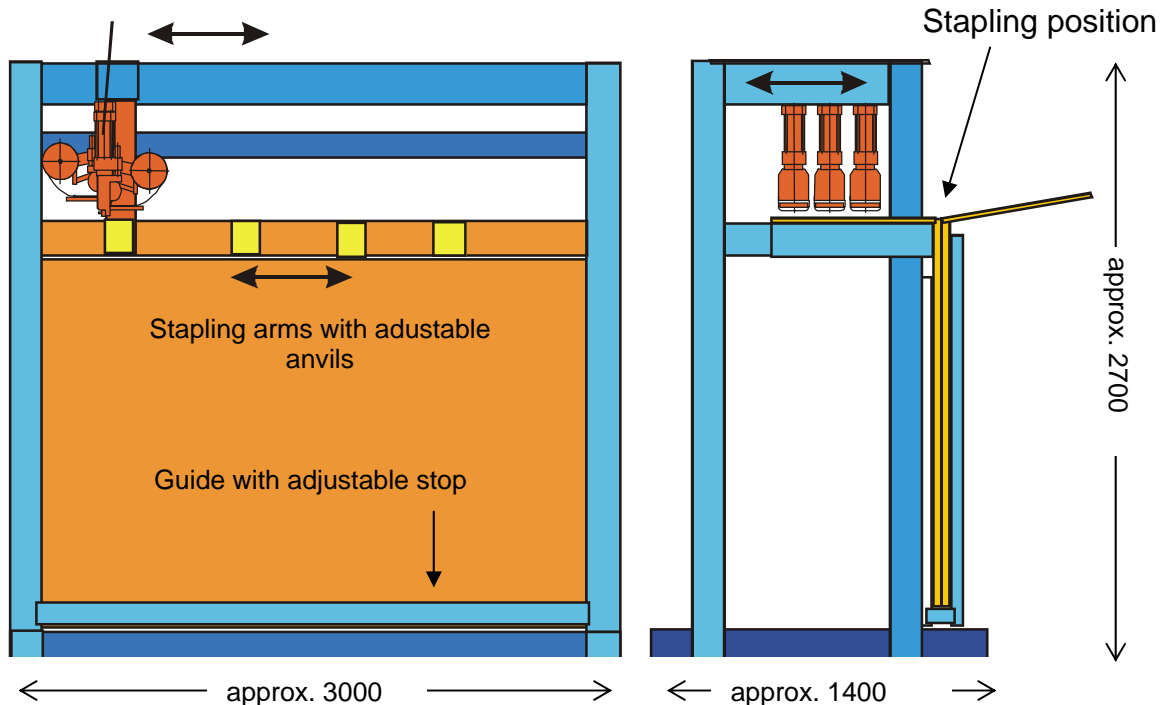


### Contents

### Page

1 Function .....	2
2 Sequence of Operations: .....	2
3 Adjustable Carton sizes .....	3
4 Capacity .....	3
5 Technical Datas .....	3
6 Equipment.....	4

### 3 Stapling Heads B 36-78: 4 - 8 Adjustabilities



## 1. Function

A pneumatic stapling device with three linear moveable stapling heads B 36-78 for fixing cardboard sleeves onto the bottom flaps of a box for use as a carton pallet. Two up to four cardboard sleeves can be mounted onto the folding box.

The SPS SIEMENS S 7 control can be programmed for up to 940 different carton sizes. The Stapling Device will be activated and drives through 4 - 8 stapling positions (= 2 - 4 sleeves) to fix each sleeve by two stapling operations of each 2 up to 3 staples

## 2. Sequence of Operations:

The stapling device will be adapted manually according to the box size and up to 4 prefolded cardboard sleeves are being put on the arms with the stapling anvils.

The folding box will be introduced into the carriage, the flap has to be folded and pushed over the stapling anvils against the stop.

The stapling device will be activated and conveys to the spot of four up to eight stapling positions (= equivalent to 2 – 4 sleeves).

Two stapling operations with up to 3 staples each are released at each sleeve. The carton with the attached cardboard sleeves will be removed from the device, turned manually by 180° and another four sleeves are manually put over the stapling anvils and the second flap can be pushed over the stapling anvils back to the stop. The ready carton pallet may now be removed from the stapling device.

### 3. Adjustable Carton sizes

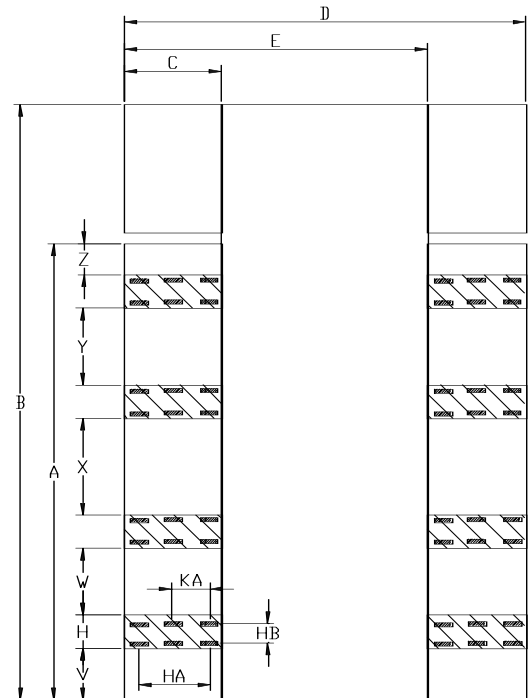
The device can be adjusted to the following max. carton sizes:

#### Carton measurement:

width of flap (A): **max: 2490 mm**  
 cardboard sleeve (C): 155 - 530 mm  
 Height of carton including 1 flap (E): **max: 1700 mm**  
 width of sleeve (H): 106 mm  
 pieces of sleeves: **2 - 4 pcs.**

#### Staling measurements:

Stapling length of sleeve (HA): max. 480 mm  
 sleeve may be longer!  
 Min. stapling distance (KA): min. 100 mm  
 stapling distance (HB): 64 mm  
 distance V,W,X: variable



### 4. Capacity

The real stapling time is ca. 2 seconds/stapling. According to the size of the carton the time to drive the heads into the next position will be ca. 45 seconds.

The capacity of the machine depends of the time to load the machine with sleeves and the cartons as well as to reload the stapled carton.

After 4000 stapling operation the stapling heads have to be reloaded. Reloading time of one head approx. 1 minute.

### 5. Technical Datas

Current/Voltage: 400 VDC, 50 Hz  
 Air pressure: min. 4 bar, max. 6 bar  
 Air consumption: 4,6 NL pro Stapling Head and Stapling  
 Stapling coil: M B 78; 4000 pcs/coil  
 Space: ca. 3 x 1,4 m<sup>2</sup>  
 Height: max. 1700 mm (height of anvils)

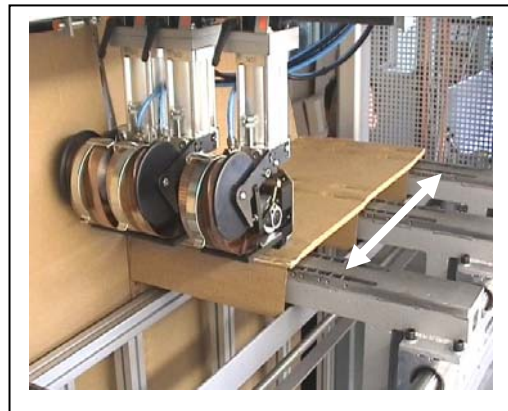
## 6. Equipment

- 1 Stapling Device
- 3 Stapling heads B 36-78, adjustable
- 4 Stapling anvils adjustable
- 1 Electromechanical axis
- 1 SPS SIEMENS S 7 control can be programmed for up to 940 different carton sizes
- 1 Servicing unit

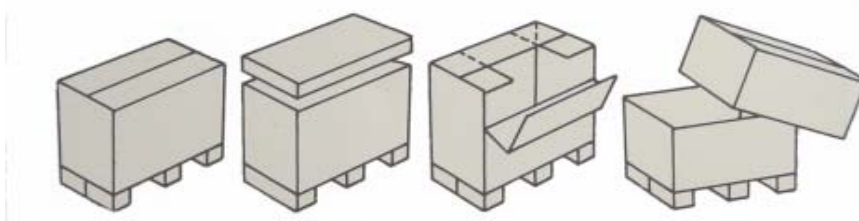
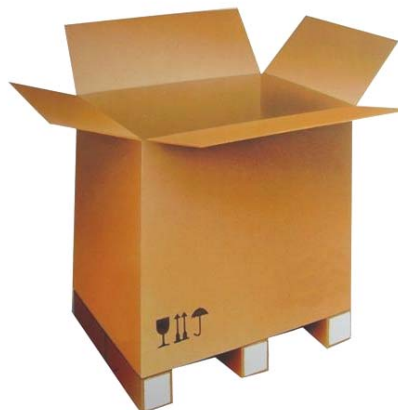
The Stapling Device will be delivered in silver grey color:



Stapling arms with 3 sleeves and with 3 stapling heads.



Same but with flap onto sleeves .



[www.mezger.eu](http://www.mezger.eu) > Pos A 1+2 > SGR 3 B 36-78 > with Video