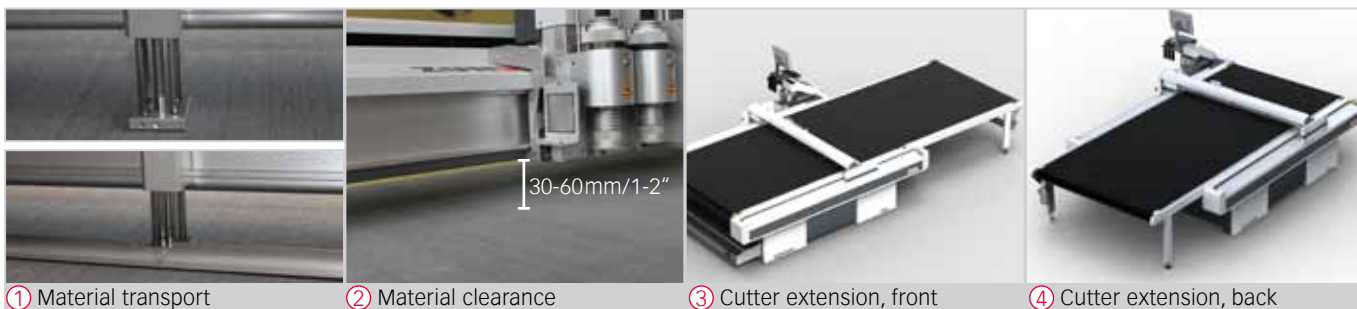


Material Transport Overview



① Material transport

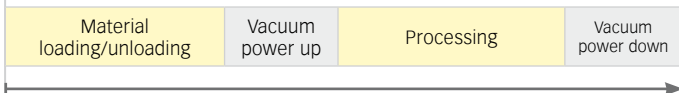
② Material clearance

③ Cutter extension, front

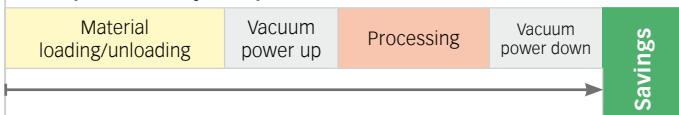
④ Cutter extension, back



Standard production cycle



Short production cycle (optional)



⑤ Cycle time



⑥ Feed direction

⑦ Compressed air

ZST-09-2010-pho/tra

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① Material transport

Two options exist for stabilizing the material during the advance: several individual transport elements or a transport bar. Both are available for 30mm/1" and 60mm/2" beam clearance. The transport bar is the recommended option for thinner, flexible materials from rolls or sheets; the preferred option for rigid materials is individual transport elements which can be positioned to accommodate narrower boards/sheets.

Specifications
3 Transport elements for cutter sizes M, L, XL
5 Transport elements for cutter sizes 2XL, 3XL

Benefits
Reliable stabilization of material during advance.
Upgrade from individual elements to transport bar (and vice versa) possible.

② Material clearance

Available options are 30mm/1" and 60mm/2". Material clearance is the space between cutting underlay and beam. It differs from max. material thickness, which varies based on the module/tool used for processing the material.

Specifications
60mm/2" clearance is standard on all G3 models.

Benefits
Option designed to meet specific cutting requirements. Upgrade possible.

③ Cutter extension, front

A cutter extension (CE) can be added to the front (off-load area) of the machine. Extensions are available in various lengths, depending on the model; it is possible to add full extensions (equal to the active cutting area) or half.

Specifications
Cutter extensions CE800 and CE1600 available for 1600mm/63" cutter lengths.
Cutter extensions CE1250 and CE2500 available for 2500mm/98" cutter lengths.
Cutter extensions CE1600 and CE3200 available for 3200mm/118" cutter lengths.

Benefits
Increased productivity. Being able to quickly and efficiently remove cut materials from the active cutting area onto the conveyor extension reduces interruptions to the cutting process.
Upgrade possible.

④ Conveyor extension, back

A cutter extension (CE) can be added to the back (load area) of the machine. Extensions are available in various lengths, depending on the model; full extensions (equal to the active cutting area) or half are possible.

Specifications
Cutter extensions CE800 and CE1600 available for 1600mm/63" cutter lengths.
Cutter extensions CE1250 and CE2500 available for 2500mm/98" cutter lengths.
Cutter extensions CE1600 and CE3200 available for 3200mm/118" cutter lengths.

Benefits
Increased productivity. Preloading materials on the conveyor extension saves time and keeps the machine in continuous operation.
Upgrade possible.

⑤ Cycle time

The complete processing cycle consists of the following:
Load material + power up vacuum + material processing + power down vacuum + off-load cut materials.

Specifications
Standard cycle time with 9kW turbine min. 30 seconds.
Short cycle time with 9kW turbine min. 15 seconds.
Standard cycle time with 15kW turbine min. 60 seconds.
Short cycle time with 15kW turbine min. 30 seconds.

Benefits
Higher productivity even with short cutting jobs or cycle times.

⑥ Feed direction

Forward advance motion is standard direction for production. Reverse direction is intended only for occasional off-loading of material remnants.

Specifications
Production in reverse is not possible.
If the cutter configuration requires an auxiliary drive for forward advancing, a separate auxiliary drive is required for reverses.
Reverse motion requires firmware v1.43 or higher.

Benefits
Makes switching over from one job to the next simpler and more efficient.
Automatic off-loading/reversing of material remnants reduces manual intervention.
Upgrade possible.

⑦ Compressed Air

Compressed air can be supplied via external or internal compressor. The internal compressor is intended for lower, non-continuous demand for air. For greater, continuous demand, a higher-volume external supply is required.

Specifications
Internal compressed-air supply is sufficient for pen up/down, material transport, vacuum-zone adjustments.
External air supply indispensable for POT (pneumatic oscillating tool), PUM/RM modules.

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