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## Conveyor, Batching

A heavily embossed 18" long sheet needed to be collected into stacks of 50. The acceleration conveyor ran at 30% over press speed and sent the sheets to channeled edge supports of the collection system. The edge supports actuated when the sheet reached the end of the collection box dropping the sheet into a vertical stack. Upon reaching the sheet count, the bottom of the collection box opened up dropping the stack onto a slow-moving take-away conveyor. A press helper palletized the stacks for further processing. The process ran at 160 FPM.



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