Cantec's high-speed rotary liner enters the market

To complete their high-performance END-O-MAT endmaking system, so far comprising a multi-die endmaking press with various feeder systems for coils and sheets and end curlers with matching capacities, Cantec have recently developed a rotary liner. After the machine successfully passed the prototype stage, an innovative and powerful rotary liner for water-based compound is now available. In its standard version, which is based on Cantec's wealth of experience with CAN-O-MAT systems, the machine has 3, 4, 6 or 8 spindles and an output between 120 epm and 2,000 epm. Its diameter span ranges between 46 mm and 153 mm.

A flat belt transfers the stamped and curled ends to the upper end of a vertical spreader chute where they are accumulated. The lower end of the magnetic chute is provided with an end destacker. This enhanced version of the destacker also used for the CAN-O-MAT system can to destack 2,000 epm. An infeed starwheel then feeds the destacked ends to the lining chucks where they are accelerated to centrifugalspeed. After the compound has been injected and distributed, the ends leave the machine at the end of the cycle on an outfeed belt. The lining chucks are driven separately by their own motor and are independent of the machine speed. The speed of the lining chucks reaches up to 4,500 rev./min. and can be individually adjusted to any end diameter and type of compound. The compound is injected by electronically controlled lining guns. Their needles are opened by solenoids and closed by springs. A second solenoid is provided for fine-setting of closing force and closing speed. The needle stroke can be set electronically from outside for each individual linig gun. Manually adjustable lining guns are available as an alternative. The lining guns can be set radially and axially to the end, independently of each other.

The machine has a very operator-friendly den. Only the parameters for machine speed (dependent on line speed), spindle speed (dependent on end diameter and type of compound), number of lining rotations and centrifugal rotations need to be entered at the operating panel. There is no necessity to calculate times. To determine the quantity of compound for a given compound pressure and nozzle diameter, the needle stroke of each gun can be adjusted individually. The needle closing behaviour can be influenced by individual setting of the closing force.

The hood can be lifted and allows good access for setting and cleaning.