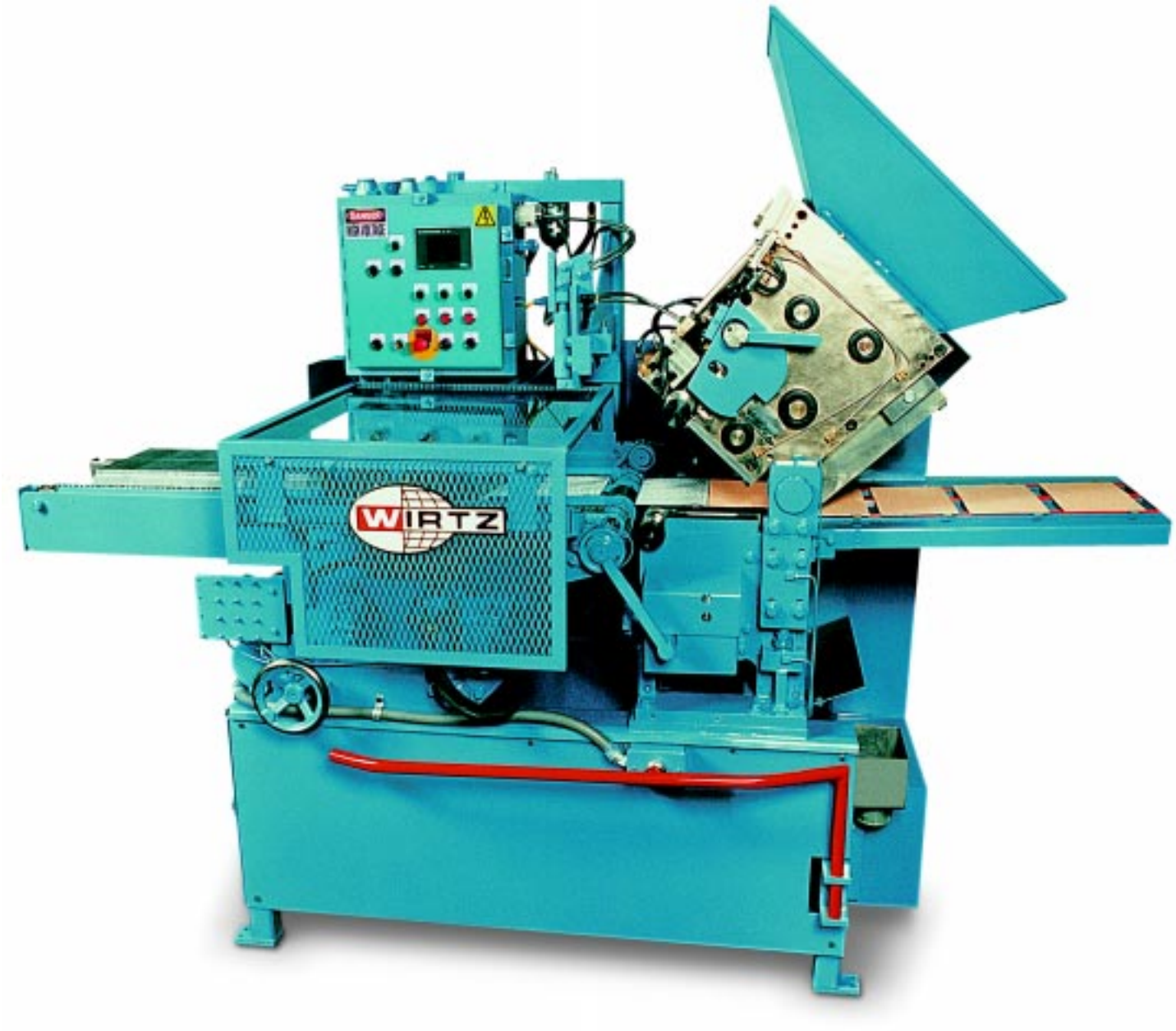
FIXED ORIFICE PASTING MACHINE

CONSISTENT EXACT PLATES CAN ONLY BE PRODUCED ON A PRECISION PIECE OF EQUIPMENT.

Plates pasted on the Wirtz Fixed Orifice Paster (FOP) have extremely uniform thickness and weight. Plates are held to less than +/- 0.002" (0.54mm) of thickness and +/- 2 grams of paste weight. The uniformity minimizes problems in the cast-on-strap process and ensures proper fit at assembly.

The Wirtz FOP starts with a frame of heavy gauge tubing which is machined after welding to maintain accuracy. The remaining components are then precision machined and cmm inspected. Prior to assembly parts are treated to resist corrosion and allow easy disassembly. Heavy duty components greatly reduce pasting operation downtime and ensure machine reliability.



FIXED ORIFICE PASTING MACHINE

Greater Production for Less Cost

The production speeds of our paster range from about 100 to well over 240 double panel plates per minute. That means over 130,000 plates per shift for certain plate designs. The grid delivery system is vacuum feed with mechanical carrier chains. The feeder magazine is 30 inches long to allow greater running time between refilling the magazine. Lower pasting pressures are used due to the internal design of the hopper assembly. This results in lower horsepower and reduced energy costs. Generously sized drive train components and sealed ball and roller bearings ensure long life and low maintenance. The FOP paste hopper has an independent drive motor to allow speed control to be separate from the machine drive and has an internal roller design which allows crushing of oxide particles or lumps in the paste. This machine has been designed for continuous use in a harsh environment.

The Wirtz Fixed Orifice Paster can be used for pasting of continuous strip. The FOP would come with a continuous strip feeder and provisions for adding paper to the top and bottom of the strip are available.

The Wirtz orifice paster will give you the edge you need for the future. An edge in plate quality, in production, in the working environment, and in cost.

- Paste weight tolerance of plus or minus 2 grams.
- Plate thickness of plus or minus 0.002" (0.54mm).
- Increased plate and battery performance.
- Increased productivity, machine speeds in excess of 240 double panels per minute.
- Cleans up environmental problems.
- Plates completely overpasted on both sides.
- No cloth pasting belts.
- No shovelback of paste into the hopper.

Physical Dimensions

Overall length:	73.18" (1859mm)
Overall width:	35.00" (889mm)
Floor to top of hopper	
Down position:	53.57" (1361mm)
Up position:	59.42" (1510mm)

Production

From 100 to above 240 double panels per minute, dial selectable.

Grid Size Range Capability

Overall Length (over panel frames):
6" (152.4mm) min to 12" (304.8mm) max.

Lug Size:
.50" (12.7mm) to .75" (19.05mm) wide x
.50" (12.7mm) to .88" (22.35mm) long

Trim Width:
4.25" (107.95mm) min to 6.38" (162.05mm) max

Grid Thickness Range:
.040" (1.02mm) to .100" (2.54mm)

Pasted Plate Thickness

Range: .048" (1.22mm) to .125" (3.17mm)

Plate thickness (overpasted) can range as desired from .008" (.2mm) to .025" (.64mm) over the nominal thickness as long as it does not exceed 30% of nominal grid thickness.

Utility Requirements

Electrical
Standard 230/460 volt, 3 phase, 60 hertz, 9.5 kw special electrics on request.

Compressed Air
100 PSIG max, 80 PSIG min

Water
Required for machine clean up only.

Recommended Parameters

Grids:

Planished (coin pressed) grids consistent thickness throughout.
Minimum thickness 0.040" (1.016mm) +/- 0.003" (0.07mm).
Rigid square grids.
Free of flash with no missing wires.

Paste:

Cubic weight of 62-74 grams per square inch.
Moisture content 11 - 13.5%.
Globe #1 penetrometer reading of 20 - 30+.
Fiber less than 0.09" (2.286mm) max in length, non-balling type.
Mixer and paster must be thoroughly cleaned daily.

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