



## Casting and stacking plant



## Success piled high

Exact, robust and reliable during continuous operation. That's what foundries say about casting and stacking plants by Bartz Maschinen- und Anlagenbau. The casting belt, ingot turners, foot building unit, stacking table, lifting beam unit with integrated stacking weighing and the stacking storage are the key components of the casting and stacking plant. Complementing these components are the central hydraulic assembly and the complete electrical installation consisting of control cabinet, operator panel and PLC control system.

The plant functions as follows: Ingots are automatically transferred direct from the casting belt to the stacking plant. Stacking is also fully automated with the aid of a rotary lifting platform and can be completed with either single or double ingot feet. Stacking heights of up to 17 layers are possible.

The weighing station, which can be calibrated, is located immediately behind the stacking table. The data recorded is transmitted via Profibus to the control system, from where it can be transferred directly via Ethernet interface to the production planning system. An optional label printer can also be connected to the control system.

The stacks are then strapped with aluminium, steel or plastic straps. Depending on the design of the stacking plant, up to four buffer stations are available downstream from the tying station. The finished stacks can then be conveniently removed from the buffer stations by forklift truck.



## Simple operation via control panel

The plant is controlled from a separate control cabinet and an operator panel. Operators can use the menu-guided interface on the operator panel to specify the required number of layers per stack and select a single or double layered stacking foot.

Batches and customer numbers, the current stack weight on the weighing station, the overall weight of the stacks weighed previously, as well as a display showing the status of all limit switches, the hydraulic assembly and possible fault messages.



### Features

- Compact design
- Ingots are transferred directly from the casting plant
- Automatic stacking with single or double ingot foot
- Stacking via rotary lifting platform
- Exact weighing of the stacks
- Semi-automatic strapping
- Large buffer storage area with up to five stacks

### Advantages

- Every plant is adapted to the customer's requirements
- Can be adapted to existing casting plants
- Air or water cooling possible

### Technical data

- Casting capacity of up to 8 tons per hour
- Dimensions of ingots circa:  
610 mm x 90 mm x 80 mm, approx. 6 - 10 kg/unit
- Casting capacity of up to 1,000 ingots/hour
- Minimum stacking height: 3 layers
- Maximum stacking height: 17 layers
- Connected electrical load: 20 kW

- Simple regulation of ingot size by varying the speed of the casting belt
- Simple 2-man operation



## Kontakt

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