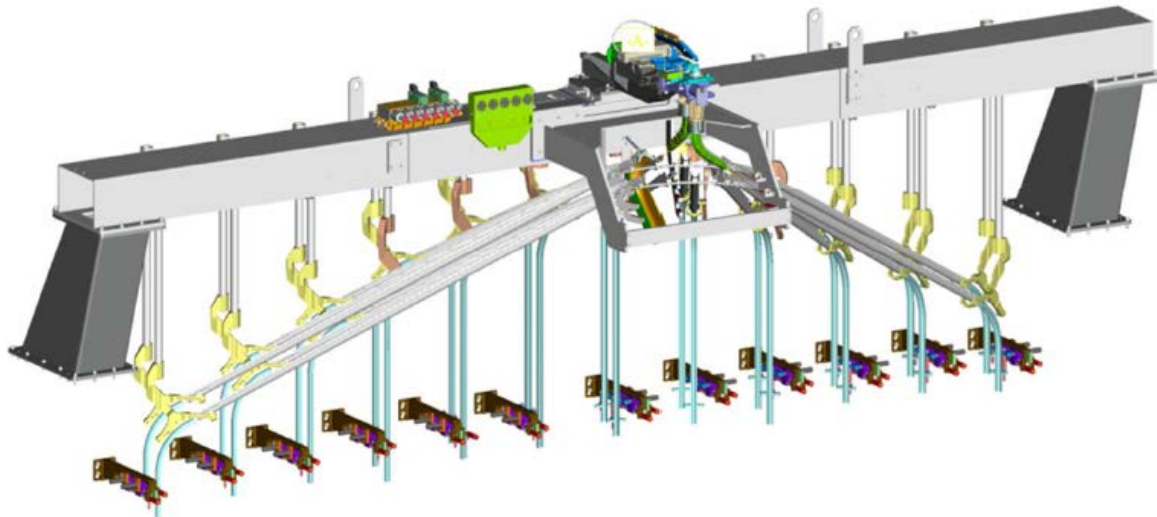


Technical News Bulletin

Steinhausen, September 2015



Constant Cone Delivery Enhanced Gob Loading & Flexible Change of Setups

- Constant Cone Delivery is a development using today's suspended delivery.
- Fast conversions from SG <-> DG <-> TG <-> QG
- Less variations – improved gob loading

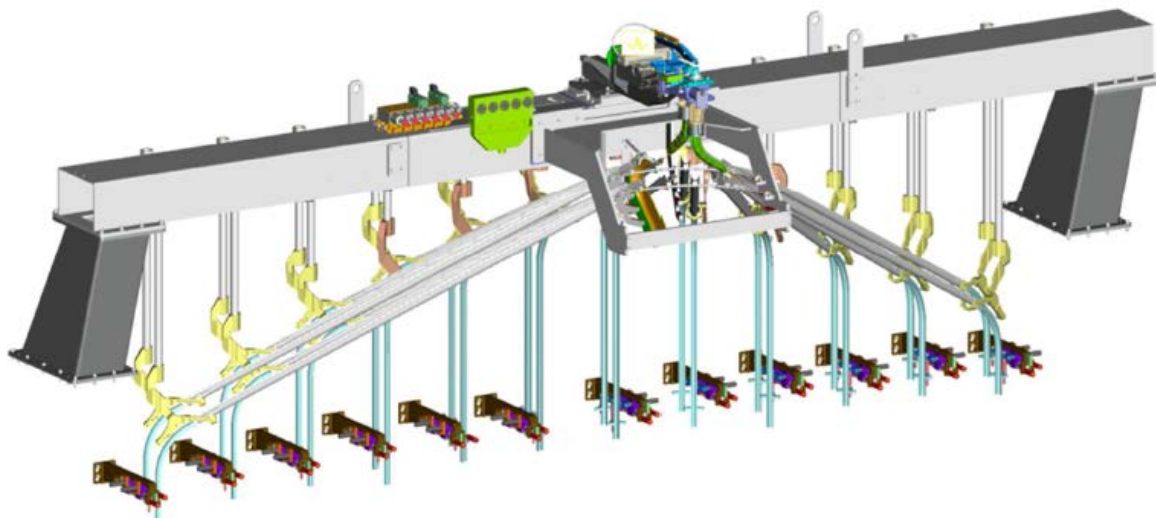
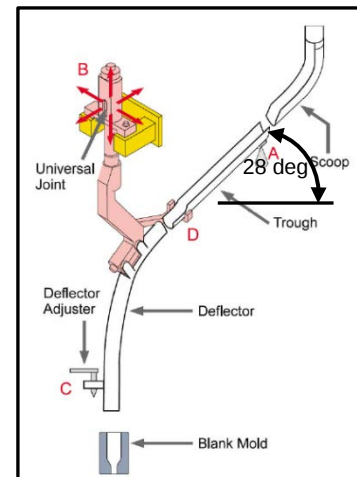
Introduction

The Constant Cone Delivery is a development using today's Suspended Delivery, which has been very successfully introduced by Bucher Emhart Glass 1994 (TNB 024).

All trough angles have now identical geometry for all sections and the historical "wild" compromises are eliminated, enabling an enhanced consistent gob loading. The constant cone concept was previously introduced on the full servo NIS machines and customer reports show a better gob loading.

Faster machine center distance changes are enabled by a universal trough support and suspension and easy replacement of deflector adjuster.

The Constant Cone Delivery is introduced on all IS machines as a standard and requires new delivery variables as it slightly increases the machine height.



Specification

Delivery System Master Lists

IS & AIS

6 Section machine:	210-2075-00
8 Section machine:	210-2072-00
10 Section machine:	210-2069-00
12 Section machine:	210-2055-00

NIS

6 Section machine:	none
8 Section machine:	400-54-00
10 Section machine:	400-53-00
12 Section machine:	400-112-00

BIS

6 Section machine:	none
8 Section machine:	401-108-00
10 Section machine:	401-110-00
12 Section machine:	401-112-00

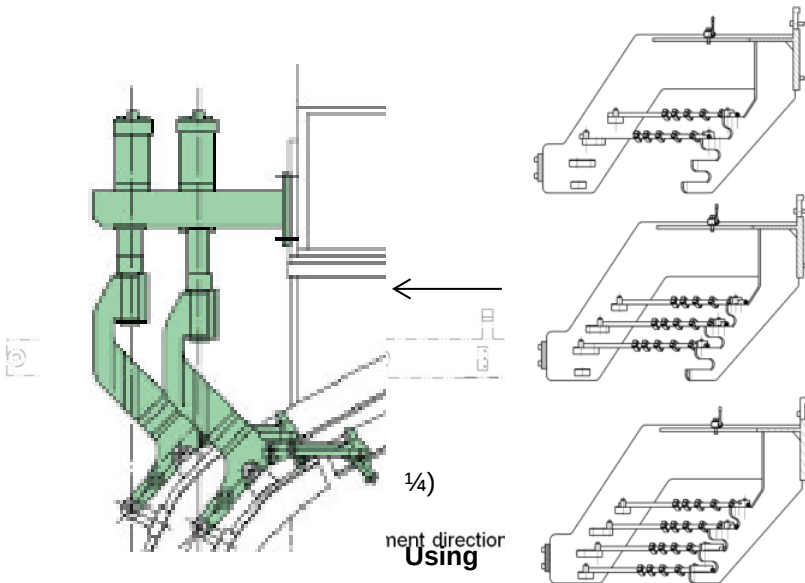
Aligning Fixtures:

For the aligning of the delivery the Bucher Emhart Glass proven laser technology will be adopted.
(Ref. laser fixture, Part Number 94-625 and instruction sheet 94-4963).

Trough Support - Delivery suspension – Gob distributor

If market requirements will change, the new multi-use IS machine is prepared to swap the setup of the various delivery center distances.

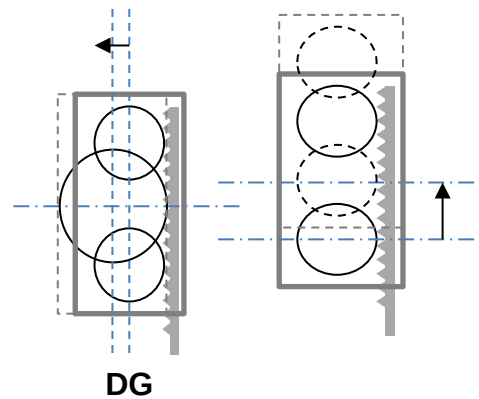
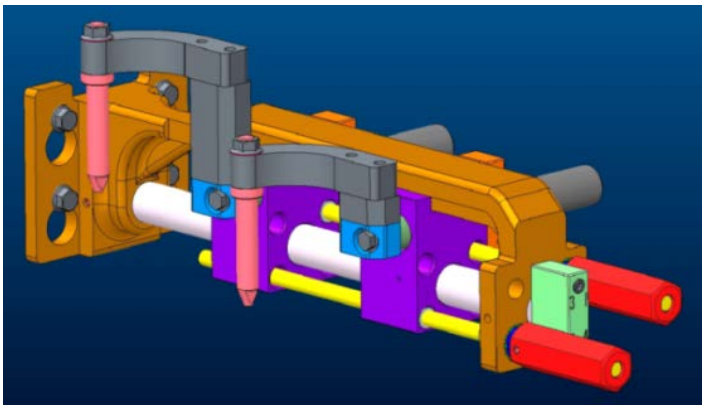
The trough support and the delivery suspension are configurable to match the following setup SG ⇔ DG ⇔ TG (⇔ QG)



restricted)
GD laterally to beam – no need to move beam.

**Simplified Approach for SG ⇌ DG
Conversion** (for deflector size up to 1

DG head for SG (Gob size is
The conversion plate allows moving



For detailed handling and instruction see manuals

Improved Deflector Adjustor:

More rigid deflector adjuster

TG, SG

- For SG, use the radial ring of the TG setup
- For upgrade from DG to TG, the delta items need to be provided only

QG

Deflector adjuster available for SG ⇔ DG ⇔ TG ⇔ QG

Availability

The constant cone delivery is already available on NIS and BIS.

AIS and IS delivery will be ready in 3Q – 2015

Upgrade

Upgrade of non constant cone delivery needs to be checked case by case.

Installation Requirements

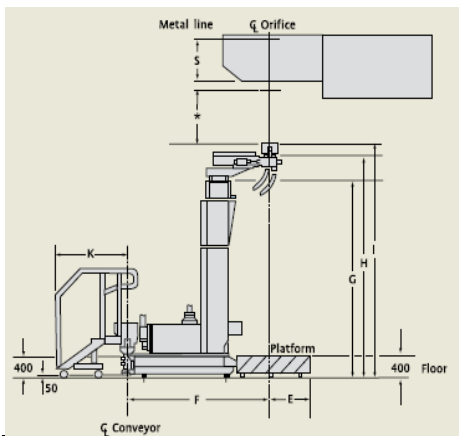
The consistent angle of the troughs for all sections results in an increased machine height (see installation layouts 200-2200-00). This increased machine height reduces the free gob drop. Field experience shows that the "loss" of free gob drop is easily compensated by the improved loading.

Table showing increased heights for constant cone delivery (compare with old delivery)

IS - & AIS: Increase of machine height with new constant cone delivery	Top of beam DG/TG	Top of funnel air ride DG/TG	Top of interceptor DG/TG
6 Section IS 4-1/4	412	372/428	372/416
6 Section IS 5"	285	245/301	245/289
8 Section IS 4-1/4	393	353/409	353/397
8 Section IS 5"	266	226/282	226/270
10 Section IS 4-1/4	278	238/319	238/307
10 Section IS 5"	278	238/319	238/307
12 Section IS 4-1/4	205	164/-	165/-
12 Section IS 5"	205	164/245	165/233
6-Section IS 5-1/2	348	308/-	308/ -
6-Section AIS 6-1/4"	348	308/-	308/-
8-Section IS 5-1/2	410	369/-	370/-
8-Section AIS 6-1/4"	409/384	368/400	369/388

10-Section IS 5-1/2	320	280/-	280/-
10-Section AIS 6-1/4"	320	280/314	280/302
12-Section IS 5-1/2	208	167/-	168/-
12-Section AIS 6-1/4"	208/143	167/184	168/171

Dimension shown in mm



Features / Benefits

Feature	Benefit
Constant Cone trough angle	Improved consistent gob loading
Equal gob transition scoop-trough-deflector	Less variations - improved gob loading
Delivery prepared for different center distances	Fast conversions from SG ⇄ DG ⇄ TG ⇄ QG
Universal trough support covers all center distances	Flexible configuration
Less parts	Faster back-to-pack
Deflector adjuster more robust – less vibration	Even gob loading