

Pre-Assembly Roller Units - Nippers



Model SG1550 Air Nipper - with pneumatic / clutch tilt

Glassline Roller Units (Nippers) are made of the highest quality to meet your fabrication/assembly requirements. They are uniquely designed for the pre-assembly of spherically curved laminated safety glass sheets. Units are available with the force being applied by springs or air cylinders.

The Glassline Model SG1550 and SG1300 Nipper roll presses are used to take out the air that is trapped between the two glass sheets and the vinyl after they are assembled – when the assembled glass unit (e.g. windshield) passes through the press, its rubber coated pressure rollers squeeze out all the air trapped in between. This enables the adhesion of the two glass sheets to the vinyl without any bubbles of air inside. The nipper assemblies are designed to allow for variations in bend from glass to glass.

The design of the roll presses is similar to a swing – the glass sheets to be laminated and compounded are placed on the entry table and passed to the rubber coated pressure rollers of the roll press. The swinging frame of the press is set to an angle which matches approximately the entry angle of the edge of the glass. As the glass pane passes through the pressure rollers, the swinging frame is swung due to the weight of the glass pane (or as programmed) until it rests on the conveying belts of the delivery table, and then further on until the frame is at an angle which matches the outgoing edge of the glass unit. Once the part is clear, the frame swings back to the starting position. Servo Rotation is also available.

Glassline Corporation can provide a complete line including flipper, de-airing and tacking ovens, rotators, nipper entry/exit tables, etc. We have many different layouts to suit the plant space requirements. Many options are available for automatic set up of the entry/exit tables, squaring, heating and monitoring, etc.

GLASSLINE

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SPECIFICATIONS

Model SG1550 (SG1300)	Specifications
Number Roller Couples	24 (20 for SG1300)
Top Roller Diameter	90 mm
Bottom Roller Diameter	200 mm
Roller Width	59.94 mm (combined dual rollers)
Floating Drive Roll Assemblies	2 (1 for SG1300)
Fixed Drive Roll Assemblies	1
Glass Sheet Thickness	3.9 mm - 7.1 mm
Glass Width (Maximum)	1524 mm (1300 mm for SG1300)
Glass Width (Minimum)	400 mm
Glass Length (Maximum)	2.2 meters with support frame (approximately)
Glass Length (Minimum)	1 meter (approx.)
Maximum SAG	40 mm * (approx.)
Operating Speed	Variable - typical maximum 35 fpm
Pre-Assembly Force/Lineal cm	Minimum 2.65 Kg. (springs only) Maximum - Variable up to 12.5 Kg. at 65 psi (compound force of compressed air and spring)
Required Compressed Air	80 PSI
Motor Power	1 HP
Maximum Turn Angle	+/- 65 degrees
Roller Working Pressure	Maximum 65 PSI

*The current design allows for approximately 44mm between mounting channels. The smile setup must be well centered for optimum SAG allowance. The current cylinder design allows for +/- 17mm of stroke. T-slots allow for approximately +/- 1.5" of adjustment.

Note: A new Glassline design utilizes curved cylinder mounting channels at a radius of approximately 475" (radius can be customized), which allows for the cylinders to be set at an average smile with all cylinders mounted at a nominal position. Therefore, on a 60" wide machine, SAG of approximately 1" is already built into the machine, and the cylinders can be adjusted up/down from this point as noted above. Additional cylinder stroke is also possible, and being reviewed.

FEATURES

- ▶ Spring or Air over Spring Cylinders
- ▶ Calibrated Cylinders

OPTIONS

- ▶ Servo Tilt
- ▶ Squaring Tables
- ▶ Entry Tilt Tables – with or without squaring
- ▶ Complete Lines
- ▶ Calibration Unit

GLASSLINE

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