

686 Dual Liner

686 Dual Liners are Industry Proven Over Decades
For Water Based and Solvent Based Compounds
Parts & Tooling Uniformity with Grace 686 Dual Liner
Electronic Compound Lining Accuracy
Use Eurocan EF or Grace EP Compound Guns
Full Range of Accessories
CE Mark & EU Declaration of Conformity

The 686 Dual Liner is a high speed dual lane machine for the application of water based and solvent based compound on tinplate ends.

Built on a cast iron frame, all the component parts and tooling sets of the Eurocan 686 Dual Liner are interchangeable with the Grace 686 Dual Liner manufactured by FMC in Belgium.

The machine is designed for use with Eurocan EF electronic compound guns or Grace EP electro-pneumatic compound guns.

Radial Cut-Off Knife Tooling

Ends are accumulated in a pair of infeed downstackers incorporating an electronic stack height control system, to ensure a quantity of ends is kept in the hoppers when the supply of ends from the press is interrupted.

An end is released from each stack on to the feed bars by the action of the radial cut-off knives, and then drops off the feed bars on to the table as they continue their backward stroke. The end is positively controlled by magnets in the table surface.

The end is then pushed on to the lining chuck under the hold down pad by the forward stroke of the feed bars.

The mechanically driven chucks lift the end under the pressure of the hold down pad to bring it up into position near the tip of the nozzle on the compound gun.

The rotational speed of the chucks is determined by the ratio of the helical drive gears. The standard ratio is 7.44 turns of the chuck to one machine revolution, which is equal to a chuck speed of 2604 rpm at a machine speed of 350 rpm. Machine speed is controlled by an electronic inverter.

Electronic Accuracy

An electronic sensor is actuated by the presence of the end on the chuck, and the signal from it is used to actuate the firing of the compound gun. With EF electronic compound guns, separate electrical signals are generated to open and close the gun. The timing of these signals is automatically adjusted to compensate for varied response times from the electro-magnetic solenoids in the guns.

This electronic control ensures very accurate turns lining control, which is the basis of exact and consistent compound weight accuracy and consistency.

After the gun has cycled, the chuck drops the end down on to the table and it is pushed to the discharge conveyor by the pusher fingers on the front of the feed bars. Another end is placed on the chuck in the same cycle.

Mechanical Durability

Manufactured and assembled using high quality castings and machined parts from a UK foundry and CNC tool rooms, the Eurocan 686 Dual Liner has built on a worldwide reputation for durability and reliability founded by the original Grace design.

All moving parts are kept constantly lubricated by a mechanical gear pump which circulates oil from a sump around the drive system.

All proprietary parts are of UK or European origin, and our electrical control panels are designed and assembled in-house to suit your specific company and factory specifications and standards.

A comprehensive inventory of spare parts ensures we can despatch replacement parts ex-stock when required.

Health & Safety

For European markets the machine is supplied with electrically interlocked safety guards designed in accordance with the Machinery Directive 2006/42/EC. A CE Mark and Declaration of Conformity are provided as required by EU legislation. For other markets this guarding package is optional.

Accessories

A range of accessories is available for the 686 Dual Liner including pressurised compound supply tanks, pressure regulators, compound pumping systems for stirring and dispensing water based compound from drums, and heated compound hose assemblies.

Specification

End Diameter Range	50 - 99mm (200 - 401)
Machine Speed	Up to 800 epm total in 2 lanes
Chuck Spindle Speeds	
Optional Chuck Spindle Gear Ratios	Chuck Spindle RPM @ Machine RPM of 350
5.15	1803
6	2100
6.32	2212
6.66	2331
7.03	2461
7.44	2604 (Standard)

Chuck Lift 9 mm **Stroke of Feed Bars** 135 mm **Main Machine Drive** 2.2 kW, 3 phase, 50/60 Hz
Electrical Supply 220 V, 3 phase, 50/60 Hz
380/415 V, 3 phase + Neutral, 50/60 HZ **Control Voltage** 24 V DC **Material Specifications**

Exterior Finishes

Change Parts	Electroless Nickel Plated
Guards & Cover Plates	Powder Coated

Lubrication

Crankcase Capacity	12 Litres
Pressure	Up to 1.5 Kg/cm ²

In-Line Filtration	Yes
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Electrical Component Types

Contactors	<i>Telemecanique</i>
Push Buttons	<i>Telemecanique</i>
Variable Speed Drive	<i>Control Techniques Type SK</i>
Isolator	<i>Allen Bradley</i>
Sensors	<i>Omron</i>
Timers	<i>Omron</i>
Power Supplies	<i>Calex & Traco</i>
Breakers	<i>Merlin Guerin</i>
Terminals	<i>Weidmuller</i>
Cabinet	<i>Rittal</i>
Motor	<i>Siemens</i>

EF Compound Guns

Open Voltage	<i>24V DC</i>
Close Voltage	<i>12 or 24V DC</i>
Guaranteed Accuracy	<i>+/- 0.1 Turns Lining</i>
Compound Weight	<i>+/- 5 mg Dependent On Compound Condition</i>
Maximum Needle Lift	<i>1.5 mm</i>
Maximum Rated Speed	<i>800 spm</i>
Needle	<i>Stainless Steel</i>

Dimensions

Length	<i>860 mm</i>
Width	<i>616 mm</i>
Table Height	<i>800 mm</i>

Shipping Data

Crate Size	<i>105(l) x 115(w) x 155(h) cms</i>
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