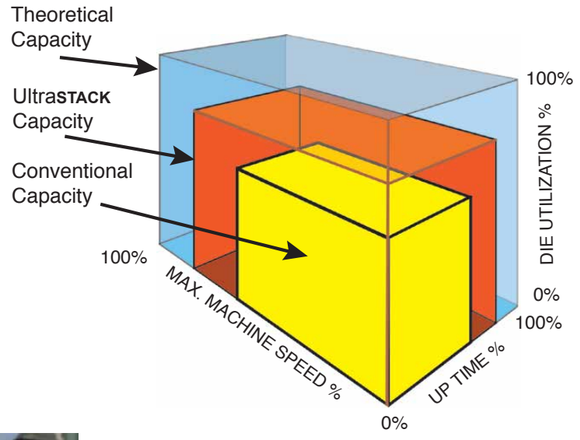
UltraStack™ Rotary Die Cut Stacker

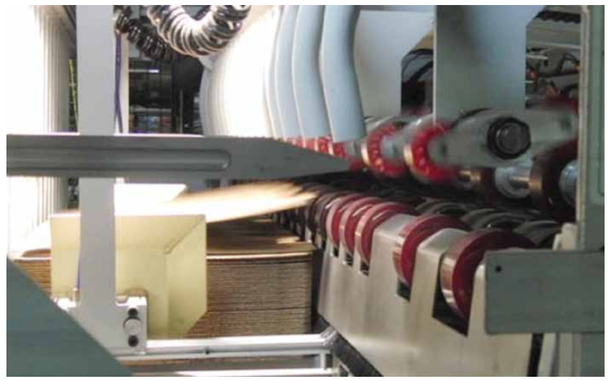
Superior Production Performance

Designed for Productivity

Today's rotary die cutters (RDCs) require the highest productivity to produce boxes at the lowest cost. Ultra**STACK** was engineered from the ground up to provide superior productivity by allowing the die cutter to run at full speed.

Ultra**STACK** further enhances productivity by allowing full die utilization and eliminates the need for shingling and feed interrupts. Ultra**STACK** handles up to six out and up to four around the die without the need for a bundle breaker, while delivering superior bundle and stack quality. More than just a stacker or bundler, Ultra**STACK** is the base platform for integrated die cutting and palletizing.





Bundle Formation System

The bundle formation system delivers from one to six-out, and up to four-around the die. Batch forks interrupt the flow of boxes at exactly the right moment to ensure precise bundle counts even if the count falls between "arounds". The batch forks hold and index the blanks as the bundle count increases, allowing time for the previous bundles to exit the bundle formation area. Once clear, the batch forks exit and reposition to start the formation of the next bundles. All bundles are tamped on three sides against a backstop for superior bundle quality.

Trailing Edge Deceleration Device (TEDD)™ (patent pending)

1. *Blanks enter the TEDD at machine speed or higher*

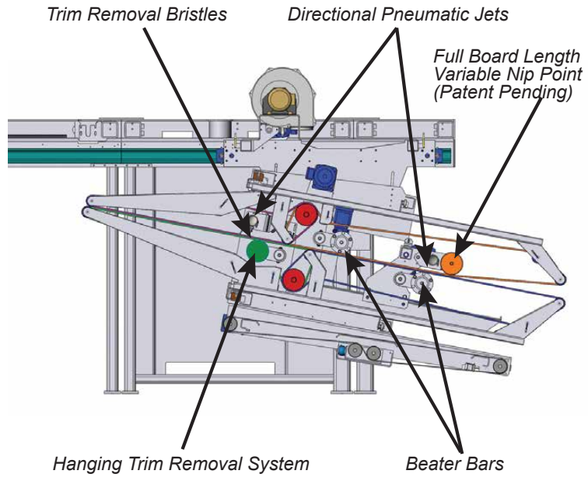
2. *TEDD captures and decelerates the blanks*

3. *Blanks are released into the hopper at low speed*

The servo driven TEDD technology is the heart of the Ultra**STACK** TEDD allows the UltraSTACK to move board through the machine at speed, decelerates the board just prior to entering the bundle formation hopper thus eliminating the need to decelerate the board through shingling. Shingling is prone to jams and traps scrap that could be transported to the final load.

Enhanced Trim Removal

With the longest trim removal section in the industry, Ultra**STACK** utilizes multiple sets of beater bar devices, directional pneumatic jets and trim removal bristles, strategically located throughout the trim removal section to assure loose scrap is eliminated.

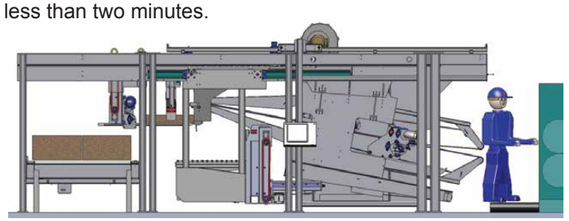


Hanging Trim Removal System

The Hanging Trim Removal System removes semi-attached trim hanging below the board line.

Full System AutoSet

All axes of Ultra**STACK** are set automatically on order change. No operator interaction is required. Adding deviders takes less than two minutes.



Side view with operator at die drum

ALLIANCE®
Machine Systems International, LLC
Intelligent Productivity

True Zero Feed Interrupt

High productivity demands zero feed interrupts. For example, on an RDC running 200 KPM, two around and 100 count bundles, a two second feed interrupt can drop productivity by 12% or more. The Ultra**STACK**'s servo driven technology cycles the batching system without interrupting the machine feed.

Safety and Accessibility

Operator safety is paramount in today's manufacturing environment. Ultra**STACK** is completely enclosed for normal operation. The sectional design and multiple entry points allow the operator access for jam clearing, housekeeping and maintenance. Without need to climb on the machine, the operator's feet remain on the floor.

Operator at bundle formation section