

## ST42 OCMI

The ST42, ST48 and ST60 are continuous-action rotary stretching machines with 42, 48, 60 spindles for processing one-piece stemware.

The machines are made up of the following units:

### Base:

houses the machine body and gripper rotation pinions and the height-setting cams.

### Main body:

houses either 21, 24 or 30 cast iron sections, each one containing two spindles that rotate on bearings, with the lower spindle running on ball guides. Each spindle is fitted with universal grippers that hold the glassware items in position, with the lower grippers settable to either internal or external clamping. As an optional, vacuum-operated grippers can be fitted, connected to a central distributor.

### Burners:

fitted around the main body and synchronised with the movement of the machine, the burners heat the glassware items prior to stretching and then complete the final shaping of the article. The height and radial spread of each burner can be adjusted, as can the height of the ring that the burners are fitted on.

### Lubrication circuit:

the centralised point-to-point recycling lubrication circuits serve the following parts of the machine:

- the rotating parts of each section
- the machine and gripper rotation gears
- the central shaft and its bearings

### Loaders:

the machines have two rotary transfer units (one for loading and one for unloading). Each unit has 12 arms that can be fitted with different grippers according to the shape of the glassware items. Each arm has both linear and polar movement and can be fitted up for vacuum operation.

### Electronic stretching management:

the electronic control system manages the following aspects of the work process:

- production changeovers, with the input of the new size parameters and work rates
- automatic control of the distance between the grippers in relation to one-piece article height, ensuring maximum quality of the stretching

GENERAL INFORMATION OF MACHINE

ocmi

Mod./Mod.

Tipo/Type

Matr./Model

Anno costr./Year

DESCRIPTION OF PARTS

DIMENSIONI	Mod.48				DIMENSIONI
Diametro macchina (A) (escluso caricatori)	3200			mm	Machine diameter (except for loader)
Altezza (B)	2230			mm	Height
Peso	17000			Kg	Weight
Potenza inst	12			kw	Inst.power
	GAS GAS	ARIA AIR	OSSIGENO OXYGEN		
consumi	6.5-7.0	10	6.5-7.0	m <sup>3</sup> /h	consumption
Pressione	0.4-0.5	0.7-1	0.4-0.5	bar	pressure
Max productivita		70		Pezzi/h	Max production capacity
Pressione acustica		<70		dB(A)	Acoustic radiation pressure
Potenza acustica inst		<70		Pa	Inst. Acoustic radiation pressure
ARIA COMPRESSED/ COMPRESSED-AIR					
Consumo	10			m <sup>3</sup> /h	consumption
Pressione	6			bar	pressure

Control panel	
pos	Description
1	Sealing cam Up/down
2	Cooling cam up/down
3	Burner cam up/down
4	Home machine request
5	Chuck rotation start
6	Chuck rotation stop
7	Alarm reset
8	Moving cam preparing mode
9	Mode preparing mode
10	Plug
11	Cycle start
12	Cycle stop
13	Mains
14	Emergency
15	Alarms signal
16	Auxiliary circuit power-supply ON
17	Auxiliary start
18	Emergency
19	Mains on

OIL LUBRICATION-Summary and characteristics table

pos	DESCRIPTION	castrol	Agip	Esso	Shell	Q .tY
A	FORCE FEED LUBRICATION Hydraulic gearcase (see relative manual)	MAGNA PD 68	EYIDIA 68	FEBIS K68	TONNA OIL T68	180lt
B	SPLASHILUBRICATION Spindles rotation control reduction unit Turnstile rotation control reduction unit Burner lifting and lowering control. Reduction unit Bevel gear pairs on loader-unloader Reduction unit	ALPHA SP 320	BLASIA 320	SPARTAN EP 320	OMALA OIL 320	3 lt lubr. for life 1.2 lt
C	MANUAL LUBRICATION Burners and moving burner Cams	MAGNA PD 68	EYIDIA 68	FEBIS K68	TONNA OIL T68	
GREASING LUBRICATION (manual)						
	DESCRIPTION	castrol	Agip	Esso	Shell	Q .tY
D	SADDLE LUBRICATION Of positioned , locking cams and ball or relief blow-by screw		RADULA 150			
E-F	GENERAL LUBRICATION Universa joint SAFETY JOINT	SPHEEROL APT 2	GRMU EP 2	BEACON 2 ESSO GP GREASE	GALVANING SUPER GREASE	
G	CENTRAL MANIFOLD LUBRICATION (only in case if vacuum )	GRAPHITED GREASE	GR NG GREASE	GRAPHITED GREASE 2	BARBAN GREASE	
H	RING GEAR LUBRICATION Of worm screw loader	GRAPHITED GREASE	GR NG GREASE	GRAPHITED GREASE 2	BARBAN GREASE	automatical
I	LUBRICATION FOR HANDLING of GRIPPING CHUCKS AND RELATIVE CAMS	GRAPHITED GREASE	GR NG GREASE	GRAPHITED GREASE 2	BARBAN GREASE	
L	GRIPPING CHUCKS LUBRICATION	GRAPHITED GREASE	GR NG GREASE	GRAPHITED GREASE 2	BARBAN GREASE	