

# ACCUMULATION STATION



**The Union Tool Corporation**

P.O. Box 935  
Warsaw, IN 46581-0935  
Phone: 574/267-3211  
Fax: 574/267-5703

PB #18062

E-Mail: [info@uniontoolcorp.com](mailto:info@uniontoolcorp.com)  
Website: [www.uniontoolcorp.com](http://www.uniontoolcorp.com)

## ACCUMULATION STATION

The Union Accumulation Station provides a conveyORIZED means to accumulate printed circuit board substrates on a horizontal plane. The panels are supported on non-marking accumulation forks and may be stored for a variable length of time before being placed back into the production flow, with the first panel in being the first panel out.

The printed circuit board material may range in length and width from 10" to 24". The thickness may range from .004 to .250. Various sizes may be run through the Accumulation Station without setup or adjustment.

As the PC materials exit a preceding conveyORIZED process, they are carried by the built-in powered conveyor. A sensor detects the position of the substrate and the conveyor stops when the substrate is in a predetermined position. The accumulation forks are raised vertically by air cylinders, lifting the substrate from the conveyor. In this manner, the accumulation forks and PC materials move up vertically with each cycle until they reach the top; at which time the forks and PC substrates are moved horizontally to a position above the offbearing side of the conveyor. The forks on the offbearing side index down with each cycle, allowing the PC materials to be placed back on the conveyor and moved into further production processes.

### MECHANICAL SPECIFICATIONS

SERIES, MODEL NO.	Union Accumulation Station 1024
OVERALL DIMENSIONS	Length: 61" Width: 40" Height: 79"
PC BOARD SIZE RANGE	Length: 10" to 24" Width: 10" to 24" Thickness: .004 to .250
CONVEYOR ROLLS	Diameter: Approximately 2" Covering: Polyethylene
ACCUMULATION FORKS	Powder coated, 67 accumulation positions
P.L.C.	Cutler-Hammer
DRIVE	Conveyor: 1/15 H.P. DC horizontal chain: 1/4 H.P.
SPEED	Conveyor: 0-30 l.f.p.m. Cycle: 8 per minute
POWER	110 volt
AIR	80 psi
GUARDS & COVERS	PVC and Lexan
PAINT	Polyurethane blue
OPTIONS	Castors, 220/440 volt, 3 phase, 60 cycle, hepa filter, capability of larger PC substrates

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