

Title (en)

METHOD FOR OPERATING A SHEARING AND COMPACTING PRESS AND SHEARING AND COMPACTING PRESS

Title (de)

VERFAHREN ZUM BETREIBEN EINER SCHERPAKETIERPRESSE UND SCHERPAKETIERPRESSE

Title (fr)

PROCEDE PERMETTANT DE FAIRE FONCTIONNER UNE PRESSE A PAQUETS PAR CISAILLEMENT ET PRESSE A PAQUETS PAR CISAILLEMENT

Publication

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Application

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Abstract (en)

[origin: US6546855B1] The invention relates to a method and to a shearing and compacting press for the production of pressed parts, preferably packages (20) from waste material, especially scrap and sheet clippings. The material used is pre-compacted in a first compacting step. In a second compacting step, the material, which has been pre-compacted to the width of the package, is subjected to intermediate compacting until the height of the package (20) is reached. In a third compacting step, final compacting of the material to the final width or length of the package (20) is carried out. According to the invention, the material is pre-compacted with a continuous force and optionally sheared until the compressor (3.1) reaches its final position. The compressor (3.2) is securely adjusted and guided to its end position on a parallel plane. Subsequently, the compressor (3.3) is guided in a position in which the compressor (3.1) releases the opening of the package chamber (2.3) when the compressor (3.1) is driven back. Finally, the compressor (3.1, 3.2, 3.3) is subjected to a pressure that is lower than the maximum pressure available in the compressors (3.1, 3.2, 3.3) at the beginning of the working and return strokes. The compressor (3.1) is subjected to maximum pressure for shearing and/or the compressors (3.2, 3.3) are supplied with maximum pressure to end pressing. The invention is also characterized in that the pressing pressure for the compressors (3.1, 3.2, 3.3) is gradually controlled depending on the degree of compression or the corresponding length.

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