

Pile Turner

**Much more
than just
a pile turner**



Top quality – Made in Germany

Originally the machine was used just for turning paper, to replace manpower by machinery. Nowadays it fulfils many more additional tasks, such as

Airing · Dust removing · Drying · Aligning · Jogging

For the demands of the printer or paper and board converter a pile turner with these capabilities represents an indispensable piece of equipment.

The Busch pile turner speeds up and improves both the printing and the finishing process. Different sorts of paper and board with varying weights can be handled on the turner. As the demands for quality increase, the pile turner represents a sensible investment.

In 1976 the first Busch pile turner was designed and delivered. With decades of experience a perfect engineering is guaranteed – and top quality is Busch's first priority. The solid and modern designed machines are well known for their

easy handling – they are used worldwide and prove a notable longevity.

All Busch pile turners are designed and manufactured in own factories in Germany (Seevetal).

The large range of models, with numerous options, fulfils all individual requirements.

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SPEEDTURNER® SWH Series

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Functions of the Pile Turner

Pile turners are available just as a turning unit or with airing and aligning, and with the additional option of jogging. The following pages give detailed information of all available models and options.

Turning – easy and comfortable

Turning is done by hydraulically lifting the pile to the horizontal position and subsequently rotating it through 180°. It replaces time-consuming manual handling.

Airing – what can be achieved?

Dust removing

An important process before printing to achieve better print quality - absolutely essential for the board converter.

Separation of cutting edges

To avoid mis-feeds. The complete pile is filled with an air cushion between the sheets.

Conditioning

The pile is provided with the optimum temperature and humidity.

Removal of spray powder

Removal of surplus spray powder after printing – an advantageous process for finishing.

Drying

Ink and varnish is quickly dried after printing.
Heat inside the pile is reduced.

Odour neutralizing

Important for food packaging.

Airing with ionised air

Ionisation reduces the electrostatic charge which may affect the finishing process of coated and printed paper or plastic foil.

Aligning the pile

The pile is aligned against the aligning gauge in the tilted position with high volume airing.

Bad sheets can be removed without a problem – depending on the thickness of the material.

Jogging

The ideal support to speed-up perfect alignment of the pile – in the tilted position with high volume airing.

Centreing the pile

The pile can be centrally aligned on a larger-sized pallet without problem.



Control desk



Aligning gauge (adjustable)



Transport

Preferences of a Busch Pile Turner

Two model series are available – the efficient low priced **SE series** and the **SPEEDTURNER® SWH series** for high demands.

- With decades of experience, Busch guarantees perfect engineering
- Top quality modern design
- Large range of model variations
- Embedding in the floor or fixing to the floor is unnecessary
- An optimal hydraulic system (counter torque lowering valves) and a powerful airing system
- Blowers for the airing system are integrated in the machine body
- The platforms allow the use of all sorts of transport and machine pallets. Loading and unloading is made from the wide side
- The clear aluminium control desk can be fitted on either side
- The control desk is slewable (on turners with airing) which facilitates the control at the front and rear of the pile during airing
- Models equipped with pressure control flaps ensure that the pile is not compressed, so that the air cushion is preserved in the pile – important for finishing printed sheets!
- Individual control of air jets (at the control desk)
- Regulation of air jet speed (at the control desk)
- The optional equipment with ionised air reduces the electrostatic charge of paper and plastic foil



Loading position



Lifting position

Advantages

- The Busch pile turner speeds up the printing and finishing process
- The press can run permanently at high speed
- The pile turner needs less than 1 minute for turning a pile
- and 4-5 minutes, on average, for turning, airing and jogging the pile
- Any employee can operate the pile turner

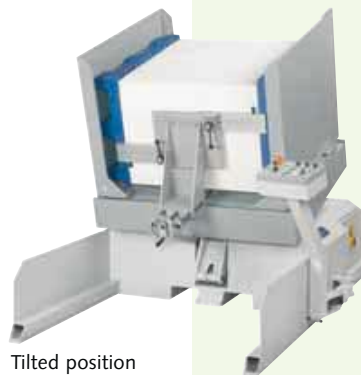
The integrated programmable logic controller (PLC) enables automated airing processes and hydraulic functions as well as a clear fault diagnostic at the display (on all turners with airing)

Pile turners of **SPEEDTURNER®** SWH series with airing include pressure control flaps as standard. The aligning gauge is adjustable according to sheet width and pile height. The jogging intensity is adjustable at the control desk. Air jets are travelling just under the respective pile height. Alternatively it is possible to pre-select the number of air jet travels (start and stop) to enable an airing process without the presence of an operator.

Taking into account all possible options – a wide spectrum is achieved for processing paper and board with extreme variations in quality.



Rotation



Tilted position
airing and aligning



Rear side
removal of bad sheets

SE Series

The efficient low priced SE Pile Turner



SE 90 / SE 125

for turning only



SE 90 RLA / SE 125 RLA

for turning, airing, jogging and aligning

SE 90 und SE 125

for turning only (without airing), with fixed control desk

Options

for SE 90: pressure control flaps (the pile is not compressed)

for SE 125: pressure control flaps (the pile is not compressed), enlarged opening height of platforms for pile heights up to 68.9 inch and increased carrying power (2650 lbs)

SE 90 RLA und SE 125 RLA

with airing (1 blower), slewable control desk, fixed aligning gauge, jogging, tilting (15°), regulation of air volume by hand lever located on the machine body

Option

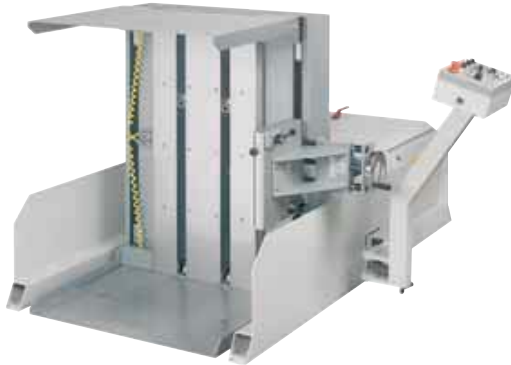
pressure control flaps (the pile is not compressed)

Model Series SE 90 and SE 125

Model		SE 90	SE 90 RLA	SE 125	SE 125 RLA
Max. sheet size	inch	23.7 x 29.5	23.7 x 29.5	31.5 x 47.2	31.5 x 47.2
Max. pile height	inch	47.2	47.2	53.1	53.1
Min. pile height	inch	11.4	11.4	15	15
Platform width	inch	35.4	35.4	49.2	49.2
Platform depth	inch	24.4	24.4	35.4	35.4
Carrying power	lbs	1100	1100	2200	2200

The SWH Pile Turner – powerful and efficient with a lot of options

SWH Series



SWH 90 (R) LA

for turning, airing and aligning,
with the option of jogging



SWH 90 LA

with airing (1 blower),
pressure control flaps, regulation of air volume
(hand lever), adjustable aligning gauge,
tilting (15°), slewable control desk

Options

additional blower,
electrical air volume regulation
at the control desk,
ionised air

SWH 90 RLA

the same as SWH 90 LA
plus: jogging

Model Series SWH 90

SPEEDTURNER®

Modell		SWH 90 (R) LA
Max. sheet size	inch	23.7 x 29.5
Max. pile height	inch	47.2
Min. pile height	inch	21.2
Platform width	inch	35.4
Platform depth	inch	24.6
Carrying power	lbs	1100

SWH Series



SWH 125 (R) LA

for turning, airing and aligning, with the option of joggling



Rear view

SWH 125 LA

with airing (1 blower), pressure control flaps, regulation of air volume (hand lever), adjustable aligning gauge, tilting (15°), slewable control desk

Options

additional blower, electrical air volume regulation at the control desk, ionised air, enlarged opening height for pile heights up to 68.9 inch, catwalk

SWH 125 RLA

the same as SWH 125 LA plus: joggling

Note:

the minimum pile height will be greater on machines with enlarged opening height

Model Series SWH 125

SPEEDTURNER®

Model		SWH 125 (R) LA
Max. sheet size	inch	31.5 x 47.2
Max. pile height	inch	53.1
Min. pile height	inch	25.6
Platform width	inch	49.2
Platform depth	inch	35.4
Carrying power	lbs	2650



SWH 125 RLA (200) Logistic

- for loading and unloading from the front as well as from one or both sides
- for turning, airing, aligning and jogging
- for transferring piles from mill / machine pallets on to system pallets
- for centring the pile on a system pallet
- either with loading ramps or for embedding in the floor

with enlarged opening height (78.7 inch) for higher piles, safety light barriers, manually slewable aligning gauge (adjustable), pressure control flaps, airing with second blower for increased airing power, tilting (15°), slewable control desk, adjustable jogging, electrical air volume regulation

Option

catwalk

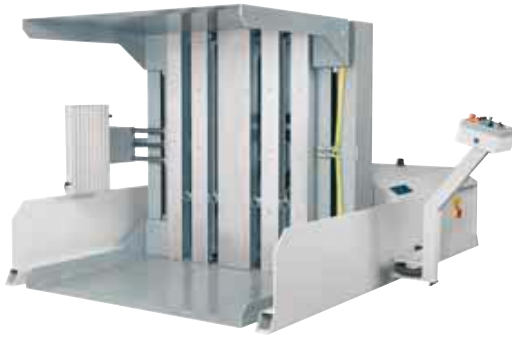
Also available for larger sheet sizes

Model series SWH 125 LOGISTIC

SPEEDTURNER®

Model	SWH 125 RLA (200) Logistic	
Max. sheet size	inch	31.5 x 47.2
Max. pile height	inch	78.7
Min. pile height	inch	36.2
Platform width	inch	49.2
Platform depth	inch	35.4
Carrying power	lbs	2650

SWH Series



SWH 155 (R) LA / 180 (R) LA

for turning only or with airing and aligning, and with the option of jogging



SWH 155 and SWH 180

a machine for turning only - without airing and aligning

Options

pressure control flaps (the pile is not compressed), enlarged opening height up to 78.7 inch for higher piles

SWH 155 LA and SWH 180 LA

with airing (4 blowers), pressure control flaps, regulation of air volume (hand lever), adjustable aligning gauge, tilting (15°), slewable control desk

SWH 155 RLA and SWH 180 RLA

the same as SWH 155 LA and SWH 180 LA plus: jogging

Options

electrical air volume regulation at the control desk, enlarged opening height up to 78.7 inch for higher piles, catwalk, telescopic control desk

Note:

the minimum pile height will be greater on machines with enlarged opening height

Model Series SWH 155 and SWH 180

SPEEDTURNER®

Model		SWH 155, SWH 155 (R) LA	SWH 180, SWH 180 (R) LA
Max. sheet size	inch	41.8 x 57	48 x 65
Max. pile height	inch	63	63
Min. pile height	inch	30, 32.7 (R) LA	30, 32.7 (R) LA
Platform width	inch	61	70.9
Platform depth	inch	42.5	48.6
Carrying power	lbs	4000	4200

Auxiliary airing device

The auxiliary airing device consists of two metal sections which extend automatically by means of a gas pressure spring. The device is positioned to the height of the loaded pile to avoid light-weight sheets escaping during airing. Four different lengths are available, suitable for each type of pile turner.



Installation, step 1



Installation, step 2



Tilted position

Magnet bar

For fixing wheeled metal trolleys – available for model series SE 90, SWH 90 and SE 125, SWH 125.

Material: aluminium



Airing with ionised air

Electrostatic charge may affect the finishing process of coated and printed paper or plastics – especially plastic foil. The charge may be caused by friction of the sheets as well as by UV / IR drying. Compensation of the charge can remedy this effect by creating positively and negatively charged ions. These ions penetrate the pile through the airing system equipped with ionisation, which minimises problems caused by static.

Available for models of the SWH 90 and SWH 125 series with airing.

Centring device

This device centrally aligns piles on larger-sized system pallets and consists of 4 limit stops at the platform sides, 1 dial gauge on the hand wheel of the aligning gauge and spring stop ends at the aligning gauge. After loading and turning the pile the system pallet is placed on top of the pile. After lifting the pile again to the horizontal position the system pallet is drawn on to the limit stops and the aligning gauge is adjusted by means of the dial gauge according to the sheet width for centring the pile on the larger-sized pallet. The aligning gauge is drawn out to its full length; the spring stop ends are pushed in completely. The pile is aired, jogged and aligned in the tilted position; centring is carried out according to the adjustment on the dial gauge. The pile centrally positioned on the pallet can be unloaded.

This device is available for models of the SWH series.



Catwalk and telescopic control desk

A catwalk is available for pile turners of the SWH series 155 and 180 with airing to facilitate the handling of large-sized sheets in connection with the higher working position. The catwalk is equipped with a banister and stairway on both sides and is positioned at the rear of the pile turner. The removal of bad sheets and the shifting of pile sections towards the opposite aligning gauge can easily be made during the airing and aligning process. The telescopic slewable control desk facilitates the air volume adjustment while on the higher working position on the catwalk.

The catwalk is also available for pile turners of SWH series 125 with airing and enlarged opening height of the platforms.



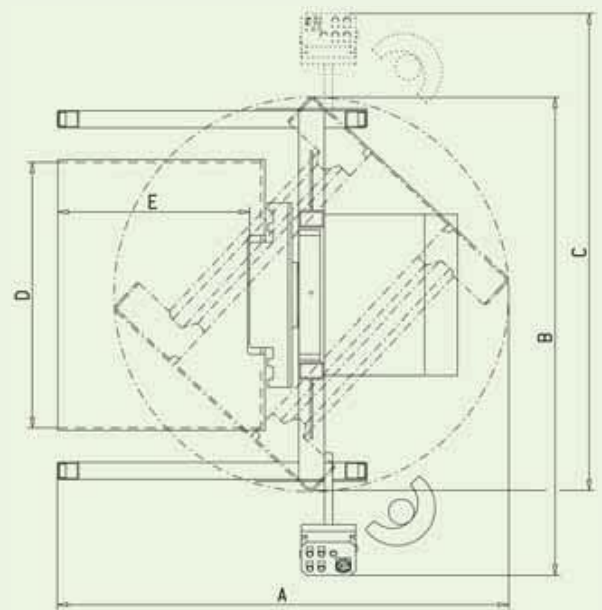
Semi-automatic and fully automatic pile turners for turning, airing, aligning and jogging are offered for sheet sizes 31.5 x 47.2 inch, 41.8 x 57 inch and 48 x 65 inch.

Detailed information can be sent on request.

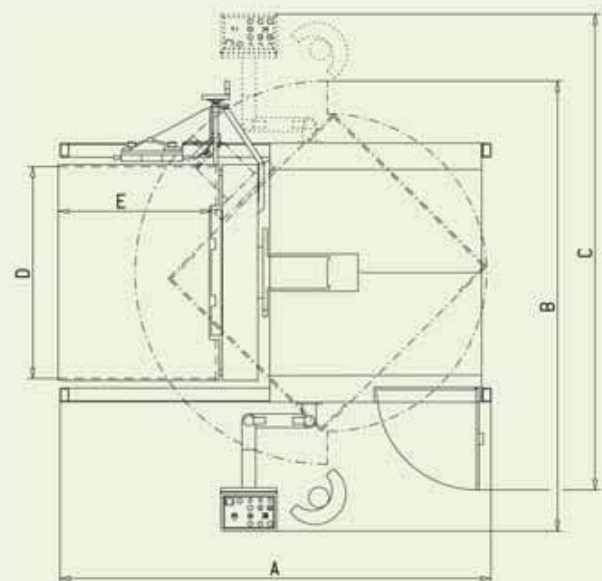
Technical Data

Model Series			SE			
Model			SE 90	SE 90 RLA	SE 125	SE 125 RLA
Max. sheet size	inch		23.7x29.5	23.7x29.5	31.5x47.2	31.5x47.2
Features	Turning Airing Aligning Jogging		●	● ● ● ●	●	● ● ● ●
Carrying power	lbs		1100	1100	2200	2200
Platform width (D)	inch		35.4	35.4	49.2	49.2
Platform depth (E)	inch		24.4	24.4	35.4	35.4
Max. pile height incl. 2 pallets	inch		47.2	47.2	53.1	53.1
Min. pile height incl. 2 pallets	inch		11.4	11.4	15	15
Power requirements (60 Hz)	kW		1,8	4,5	1,8	6,8
Equipment						
● Standard ○ Option						
Pressure control flaps			○	○	○	○
Airing number of air jets				2		2
Aligning gauge	fixed adjustable			●		●
Jogging				●		●
Speed of air jets, continuously adjustable at the control desk				●		●
Air volume regulation by hand lever at the machine body				●		●
Air volume regulation, continuously adjustable at the control desk						
Additional blower for double airing power (60 Hz)	kW					
Ionised air						
Enlarged opening height of platforms	inch				○ 68.9	
Space requirements						
Length (A)	inch		66.9	73.4	83.5	90.6
Width Control desk, right (B)	inch		76	86.6	88.4	95.1
Width Control desk, left (C)	inch		76	86.6	88.4	95.1
Height incl. turning range	inch		68.7	74.4	81.1	87.4
Weight net	lbs		1435	1850	1870	2425

SWH			
SWH 90 LA	SWH 90 RLA	SWH 125 LA	SWH 125 RLA
23.7x29.5	23.7x29.5	31.5x47.2	31.5x47.2
● ● ●	● ● ● ●	● ● ●	● ● ● ●
1100	1100	2200	2200
35.4	35.4	49.2	49.2
24.6	24.6	35.4	35.4
47.2	47.2	53.1	53.1
21.2	21.2	25.6	25.6
4,4	4,9	5,7	6,4
●	●	●	●
2	2	2	2
●	● ●	●	● ●
●	●	●	●
●	●	●	●
○	○	○	○
2,6	2,6	3,6	3,6
○	○	○	○
		○ 68.9	○ 68.9
85.8	85.8	105.9	105.9
85.8	85.8	104	104
94.5	94.5	110.2	110.2
70.5	70.5	82.3	82.3
2270	2330	3150	3300



Model Series
SE 90 and SE 125

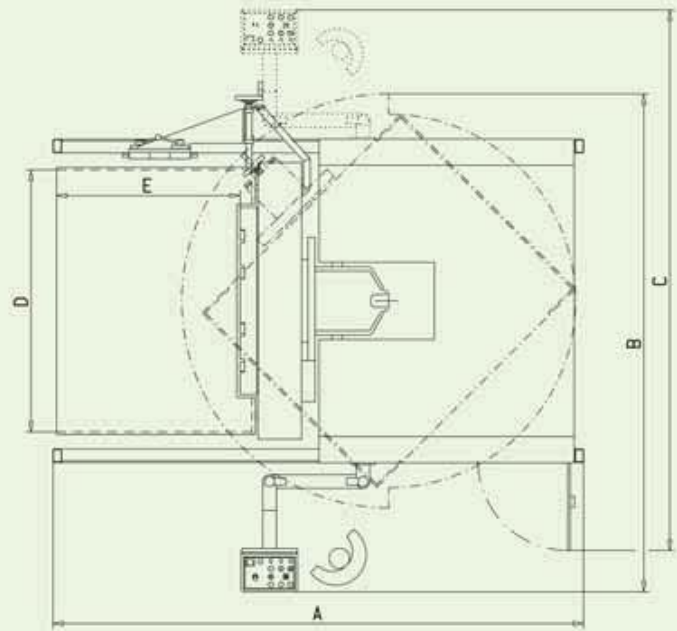


Model Series
SWH 90 and SWH 125

Technical Data

Model Series			SWH		
Model			SWH 155	SWH 155 LA	SWH 155 RLA
Max. sheet size	inch		41.8x57	41.8x57	41.8x57
Features	Turning Airing Aligning Jogging		●	● ● ●	● ● ● ●
Carrying power	lbs		4000	4000	4000
Platform width (D)	inch		61	61	61
Platform depth (E)	inch		42.5	42.5	42.5
Max. pile height incl. 2 pallets	inch		63	63	63
Min. pile height incl. 2 pallets	inch		30	32.7	32.7
Power requirements (60 Hz)	kW		4,8	20	20
Equipment					
● Standard ○ Option					
Pressure control flaps			○	●	●
Airing number of air jets				4	4
Aligning gauge	fixed adjustable			●	●
Jogging					●
Speed of air jets, continuously adjustable at the control desk				●	●
Air volume regulation by hand lever at the machine body				●	●
Air volume regulation, continuously adjustable at the control desk				○	○
Additional blower for double airing power (60 Hz)	kW				
Ionised air					
Enlarged opening height of platforms	inch		○ 78.7	○ 78.7	○ 78.7
Space requirements					
Length (A)	inch		122.8	122.8	122.8
Width Control desk, right (B)	inch		104.7	117.5	117.5
Width Control desk, left (C)	inch		117.5	125.2	125.2
Height incl. turning range	inch		99.4	99.4	99.4
Weight net	lbs		5290	6060	6280

SWH		
SWH 180	SWH 180 LA	SWH 180 RLA
48x65	48x65	48x65
●	● ● ●	● ● ● ●
4200	4200	4200
70.9	70.9	70.9
48.6	48.6	48.6
63	63	63
30	32.7	32.7
4,8	20	20
○	●	●
	4	4
	●	●
		●
	●	●
	●	●
	○	○
○ 78.7	○ 78.7	○ 78.7
131.7	131.7	131.7
112.4	125.4	125.4
125.2	133	133
104.1	104.1	104.1
5730	6500	6725



Model Series
SWH 155 and SWH 180

Gerhard Busch GmbH
Brookdamm 28
D-21217 Seevetal
Phone: +49 (0)40 769159-0
Fax: +49 (0)40 769159-33
E-Mail: info@buschgraph.de
Internet: www.buschgraph.de



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