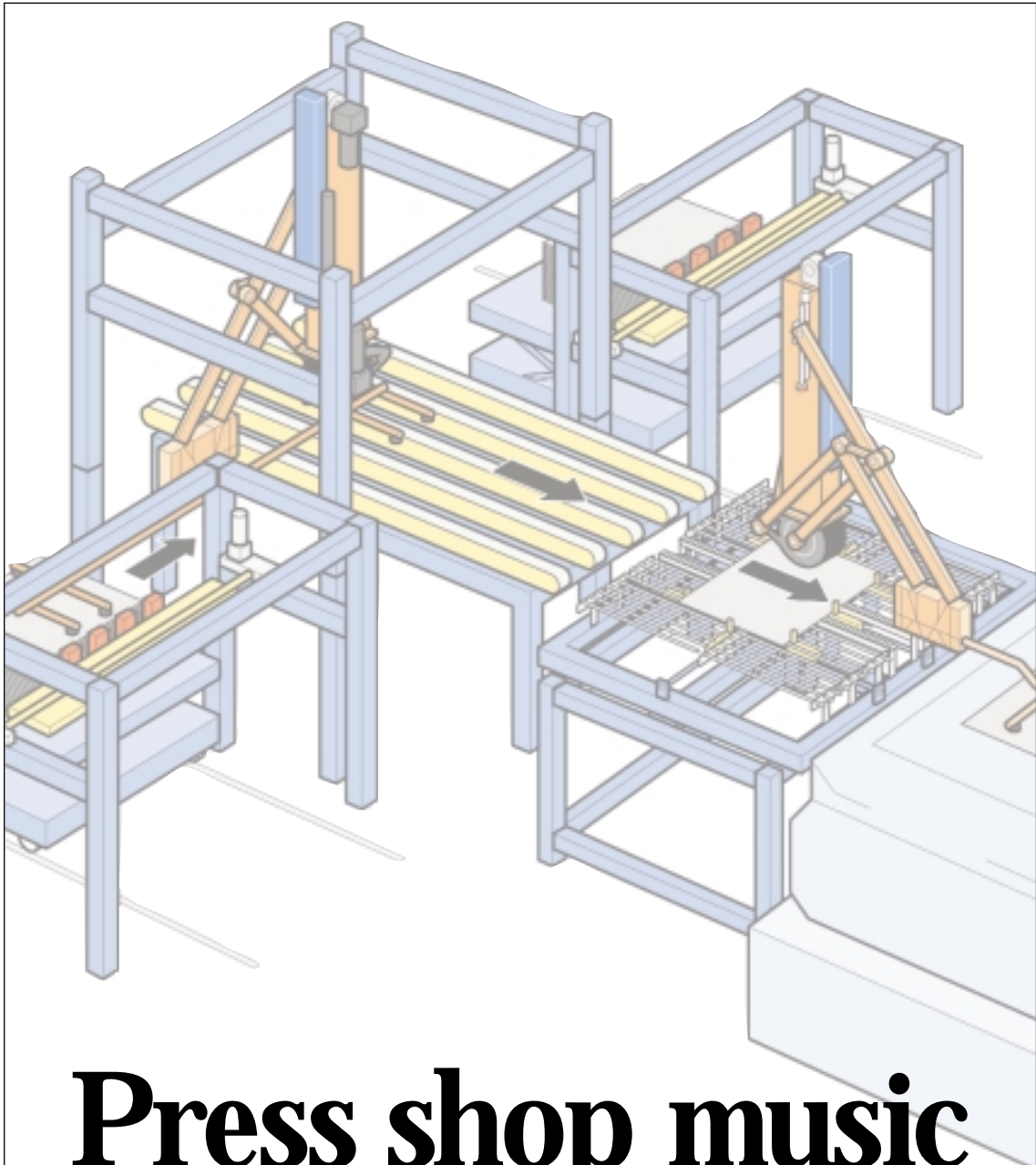


# Press Automation Systems

DOPPIN DD5, DD6 and DD7  
LINEFEEDERS/DESTACKERS



# Press shop music

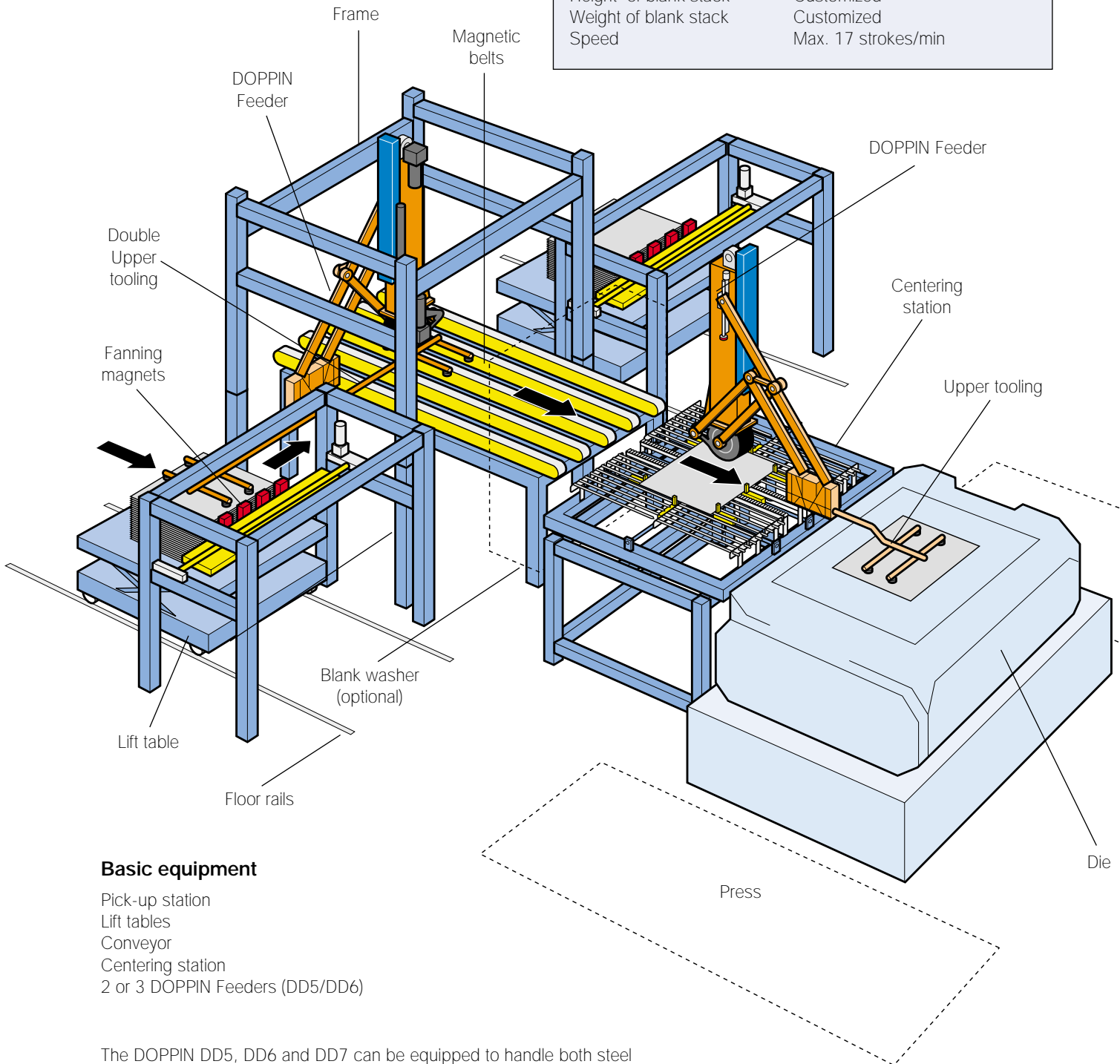
**ABB**

# Music in the ears of

## DOPPIN DD5 Linefeeder/Destacker

### Handling capability, DOPPIN DD5 and DD6

Blank size in feed direction	Front to Back = 200 – 2000 mm
Blank size in cross direction	Left to Right = 500 – 3400 mm
Height of blank stack	Customized
Weight of blank stack	Customized
Speed	Max. 17 strokes/min



### Basic equipment

- Pick-up station
- Lift tables
- Conveyor
- Centering station
- 2 or 3 DOPPIN Feeders (DD5/DD6)

The DOPPIN DD5, DD6 and DD7 can be equipped to handle both steel and aluminium (patent pending) and other nonmagnetic materials, as well as multiple blank stacks and dual blank stacks.

They are excellent examples of how easy flexibly the DOPPIN system can be adapted to individual user's needs.

# of the engineer:

The DOPPIN DD5, DD6 and DD7 Linefeeders/Destackers are advanced and integrated components of the programmable DOPPIN system for automated production on press lines.

They are excellent instruments for separating flat blanks and feeding them into the lead press in the line. As an option, all can be fitted with special separation equipment for handling aluminium or other non-magnetic blanks.

## Fast, precise action

Two rolling electric lift tables deliver stacks of flat blanks to the pick-up station. The stack is positioned and elevated to the pick-up position.

In the DOPPIN DD5 the blanks are effectively separated by fanning magnets and lifted one at a time to a magnetic conveyor belt by a DOPPIN Feeder equipped with a double set of suction-cup upper tooling. The belt transfers the blank to a centering station.

The centering station is equipped with a number of automatically adjusted stops. From here the blanks are picked up and placed in the die of the lead press by another DOPPIN Feeder equipped with suction-cup upper tooling.

## DOPPIN DD6

To handle large blanks, The DD5 can be equipped with an additional DOPPIN Feeder at the pick-up station instead of a single one with double tooling. This gives a smoother and faster flow of work. This version is called the DOPPIN DD6.

## DOPPIN DD7

The DOPPIN DD7 has an electrically driven shuttler equipped with tooling to pick blanks off the lift table, where the blanks are separated by fanning magnets on an adjustable boom.

## Options

Equipment for handling aluminium or other nonmagnetic blanks.

Blank washing or lubricating accessory.

Equipment for handling dual blanks.

## Control system

DOPPIN UHS/OS44, S4C Plus.

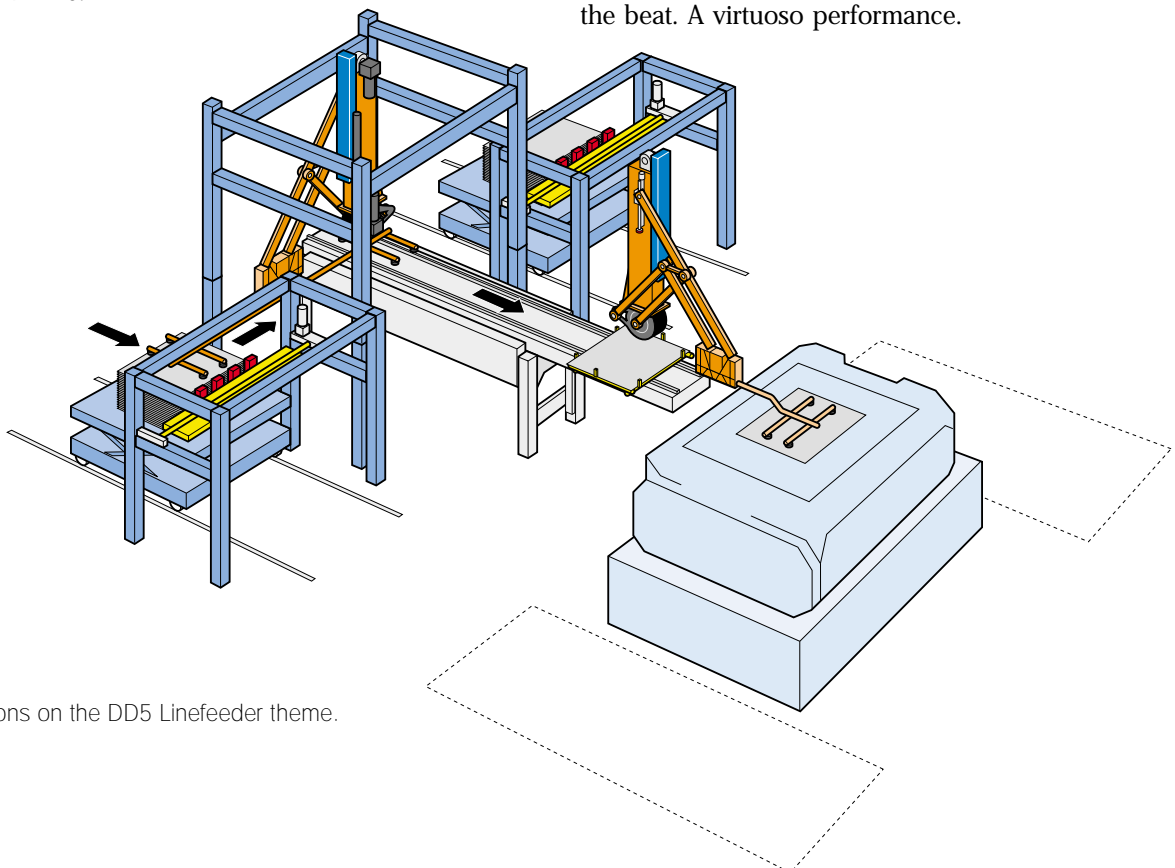
## Variations on the Linefeeder theme

Instead of magnetic belts and a centering station, the DOPPIN DD5, DD6 and DD7 can be equipped with a self-centering conveyor which moves blanks to the pick-up position for the lead press Feeder. This alternative is also suitable for feeding transfer presses.

The self-centering conveyor does not have the lubricating/washing option.

All variations on the DOPPIN Linefeeder/Destacker theme can be operated manually from the control panel or by the PLC system.

The flow of work is always optimal, with smooth acceleration and deceleration. In strict tempo, right on the beat. A virtuoso performance.



Variations on the DD5 Linefeeder theme.

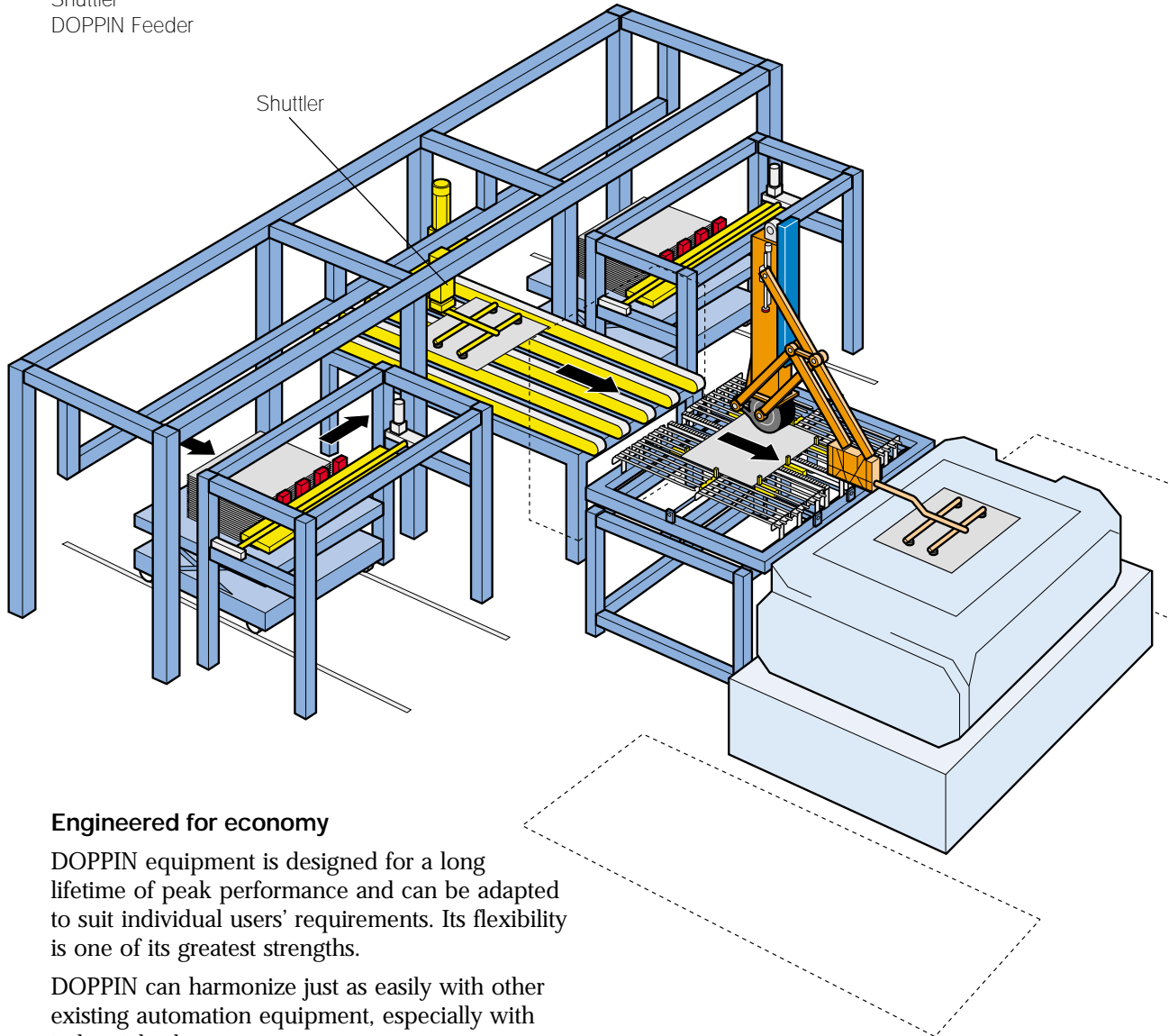
## DOPPIN DD7 Linefeeder

### Basic equipment

Pick-up station  
Lift tables  
Conveyor  
Centering station  
Shuttler  
DOPPIN Feeder

### Handling capability, DOPPIN DD7

Blank size in feed direction	Front to Back = 200 – 2200 mm
Blank size in cross direction	Left to Right = 500 – 4500 mm
Height of blank stack	Customized
Weight of blank stack	Customized
Speed	Max. 13 strokes/min



### Engineered for economy

DOPPIN equipment is designed for a long lifetime of peak performance and can be adapted to suit individual users' requirements. Its flexibility is one of its greatest strengths.

DOPPIN can harmonize just as easily with other existing automation equipment, especially with industrial robots.

When all the parameters of speed, load and endurance are finely tuned, DOPPIN makes really beautiful music – the kind that both engineers and controllers love to listen to.

We are talking here about the world's arguably fastest, most powerful and most durable precision equipment for automated production on press lines. We are talking about quality. Quality pays.

*The manufacturers reserve the right to change specifications, components, etc. without notice.*

# the controller:

When you invest in DOPPIN systems to automate a press line you are investing in real know-how, because real know-how is based on first-hand experience.

## **First-hand experience from the automotive industry**

The people who developed DOPPIN are specialists in systems and equipment for optimized processes for car and truck production. That and nothing else.

They have designed and installed fabrication and automation equipment, whole assembly lines and even whole factories.

In doing so they not only created their own technology, but also made maximum use of existing equipment and so developed production flows to the point of excellence.

The DOPPIN system passes every test: always the shortest path, always the simplest solution. The simple solutions are always the best ones. Every component of the system is selected and designed according to that principle.

## **Real know-how**

We are talking about quality based on in-depth knowledge of how to achieve optimal, cost-effective flows in production processes.

The DOPPIN system as a whole and all its individual components have been tried and proven on the toughest test bench there is: in real life, in daily production in hundreds of press shops all over the world. With unfailing long-haul speed and precision, even when handling large and heavy stampings.

It is flexible too. DOPPIN can be adjusted even during a production run, without holding up the flow and without loss of quality.

## **Customized systems**

The DOPPIN system is easily adapted to any requirement, whether functional or economic. It can be set up as a complete, fully automated line, or parts of it can be used to boost speed, precision and uptime in co-operation with existing equipment.

It can be combined with industrial robots. With the right tempo and the right loads, that makes the press line truly flexible.

That's the way it is.

Everything is there. Real know-how. And everything is easy to maintain, service and operate.

## **Service and training**

Each piece of equipment comes with practical servicing and training material, easy-to-follow manuals and instructions. Training and service packages, like the equipment itself, are matched to the needs of the individual user.

## **A guarantee**

So DOPPIN in a press line is really a guarantee – of functionality and smooth flow. That's why DOPPIN is music in the ears of controllers as well as engineers. Real know-how pays off. You can count on it.

## **Talk to us**

We can help you all the way, from needs analysis to the finalized design and on to installation, commissioning, training and service. We can do it quickly, so that payback time starts that much sooner. We take pains to look after our customers – who are also the first to be informed about new DOPPIN developments.

You are welcome to talk to us about all aspects of press line automation. Financing problems, for example, need not stand in the way of your investment in an optimum system. As part of ABB, we have both the technical and the economic resources to satisfy your requirements.

## **Your own request concert**

There is a questionnaire enclosed with this folder. You can use it to tell us what kind of instruments you have in your press line so that we can suggest an optimum ensemble.

To save time you can fill out and forward the questionnaire and we will get right back to you with a proposal.

If you want to discuss other kinds of production or assembly lines, we'll be happy to talk to you about that too.

Whatever your requirements, we promise to do our utmost to compose a request concert to your liking.



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