STACKING . SRDZ SERIES

Intelligent Core Stacking Line

SREE

SRDZ1300 / 1400 / 1500 / 2200 class

What it is for

Robotic stacking lines that lay transformer core laminations automatically. Linear-motor gantries move pick-and-place carriages at up to 3 m/s while servo alignment stations set centre limbs, side limbs and yokes, holding step-lap joints tight.

Headline specifications

Stacking speed	**4,000 - 6,000 sheets/h**
Joint gap	**under 0.3 mm**
Layer thickness error	**under 0.1 mm**
Cores per 10 h shift	**4 or more (approx. 5,000 sheets/core)**
Core load-in / out	**under 20 min**
Installed capacity	**approx. 48 kW (SRDZ2200)**

Why customers choose this line

- One line replaces a stacking crew and removes the manual bottleneck after the cutting line.
- Automatic centre-limb angle correction keeps joints tight, which is what lowers loss and noise in the finished core.
- Linear motors instead of racks: no wear surfaces to reset, positioning stays accurate over years.
- Proven components: Yaskawa control and linear motors, Siemens and Schneider electrics, SMC pneumatics, HIWIN guideways.

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Full specification, configuration and acceptance

Full technical parameters

SRDZ1500 lamination width	**50 - 300 mm**
SRDZ1500 limb / yoke length	**600 - 1500 mm**
SRDZ1500 sheet thickness	**0.20 - 0.35 mm**
SRDZ1500 max core height	**400 mm**
SRDZ1500 throughput	**approx. 30,000 sheets / 8 h**
SRDZ2200 lamination length	**1400 - 2200 mm**
SRDZ2200 throughput	**approx. 20,000 sheets / 10 h**
Step pattern	**7 steps across, 9 steps lengthwise**
Gantry speed	**up to 3 m/s**
Power supply	**380 V / 50 Hz; approx. 62 kVA (SRDZ2200 incl. compressor)**

Standard and optional configuration

- Sheet carrier tables, separation station, precision positioning station, stacking table, pick-and-place gantries, pneumatic system.
- Options: robot loading, AGV or RGV interface to core storage, turnover station, MES interface.

Acceptance and service

- Joint gap, layer thickness and cycle time measured on your own lamination set at FAT.
- Incoming lamination tolerance stated in the technical agreement, typically length and angle within 0.2 mm.
- Installation, commissioning, training and remote support.

Figures are reference values from delivered builds and technical files. Actual performance depends on material grade and flatness, lamination geometry, punching pattern and plant conditions. Binding specifications, scope of supply and acceptance criteria are fixed in the project technical agreement.