



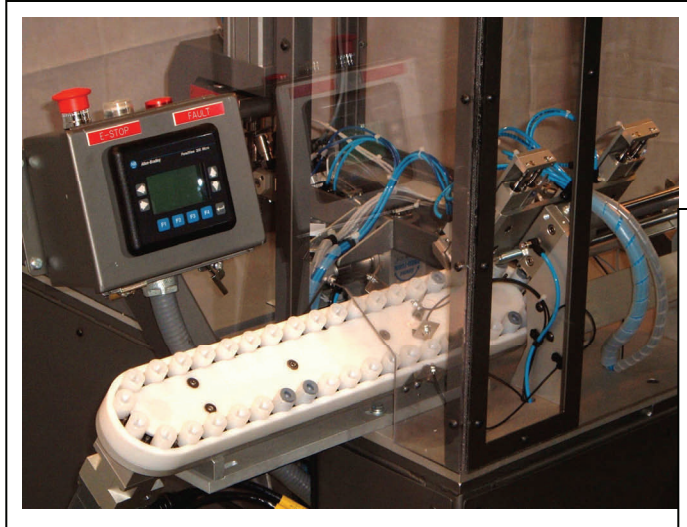
## STOPPER PUNCH



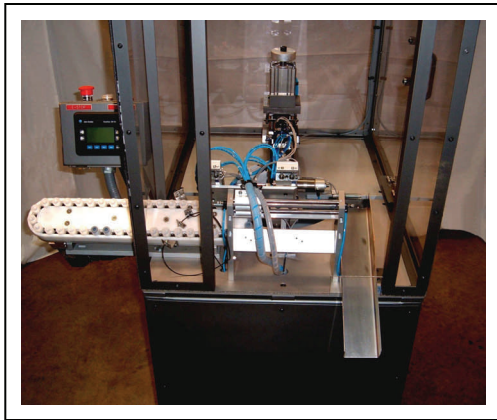
KEYSTONE built this specialized machine for a major pharmaceutical supply company. The machine **punches two holes in two different locations on two different type bottle stoppers.**

The stoppers are about  $\frac{1}{2}$ " in diameter and the holes are around  $\frac{1}{8}$ " in diameter. The machine is currently hand loaded and is also capable of being loaded automatically from a bowl feeder with amendments.

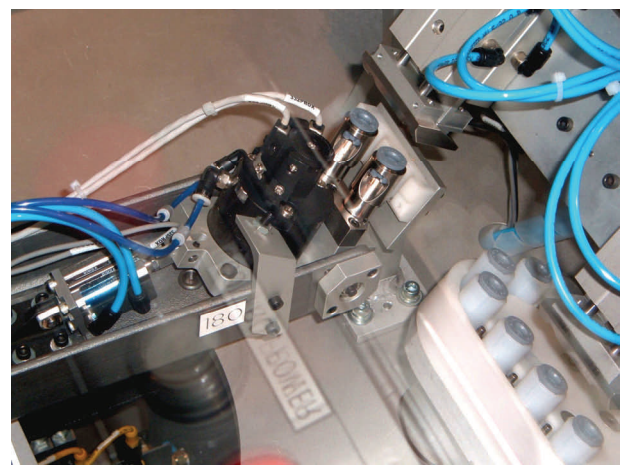
Stoppers are loaded into an indexing conveyor. A transfer picks up two stoppers and loads them into a rotary fixture while unloading finished stoppers and dropping them in a discharge chute. The rotary transfer indexes the stoppers under the punch where they are punched, rotated either 180 degrees or 140 degrees and punched again. Cycle time is 6 seconds.



Infeed (above); Side detail (below)

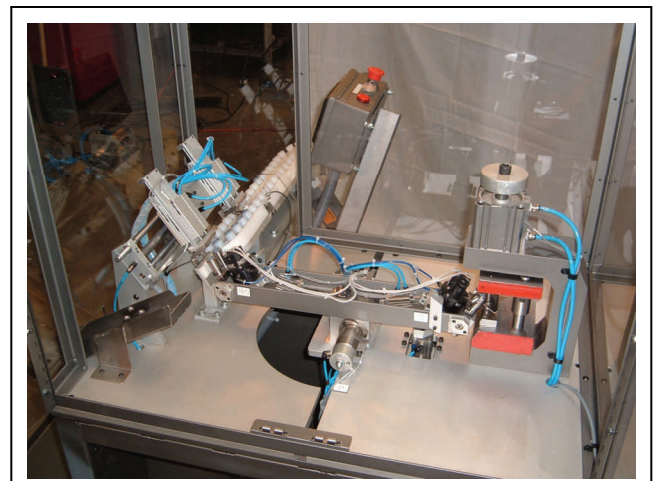


## Stopper Puncher details



Transfer detail (above)

Transfer (below)



## FEATURES:

- 6 second cycle time – 2 stoppers per cycle
- Hand loaded – easily converted to auto load
- Servo driven infeed section
- Allen-Bradley Micrologix PLC and touch screen
- Punches two stopper types with different hole alignments
- Easily replaced tooling
- Machine passed full FDA validation and factory acceptance testing