ABTS™

ARCHITECTURAL ABTS™

Architectural Bending and Tempering System

The most productive architectural bending and tempering system available for the architectural market today. Glasstech's ABTS processes a wide range of shapes without the need for part-dedicated tooling.

The system is able to produce the following shapes, all without using molds:

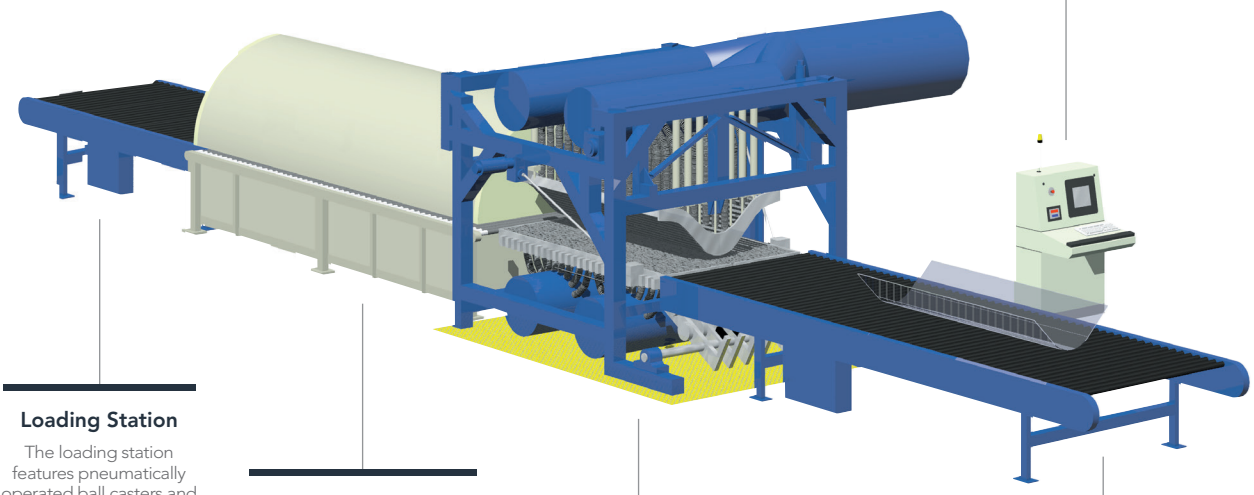
- Cylindrical bends
- Asymmetrical bends
- S bends
- J bends
- V bends

With the shape configurations controlled by a user-friendly Allen-Bradley Logix™-based PLC controller, Glasstech ABTS is probably the most productive, cost-effective and versatile bending and tempering system available for the architectural market.

ABTS is available with Glasstech's Electric Radiant Heater, which features outstanding uniformity for heating, or Glasstech's Forced Convection Heater, the most effective heating system available for all glass types.

PC Interface

An Allen-Bradley Logix-based PLC controller with a user-friendly PC interface regulates all conveyors, speeds and shape configurations. To reduce changeover time, variables can be recalled when changing parts.



Loading Station

The loading station features pneumatically operated ball casters and an independently driven line shaft drive. It is computer-controlled to ensure correct glass positioning in the heater.

Heater Options

The electric radiant heater (pictured) creates a thermally stable environment and provides optimal temperature uniformity with minimal sensing requirements. A natural gas fired forced convection heater is optional.

Bending/Quenching

In the bending/quenching section, computer-controlled, articulated platens form the glass without the need for part-dedicated tooling. Quench air is evenly directed onto the glass surface, tempering and cooling the part.

Unloading Station

The unloading station is independently driven by a line shaft drive.

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ARCHITECTURAL ABTS™ TECHNICAL FEATURES

In actual operation, continuous production rates will be between 50% and 75% of the available load area and will depend on glass dimensions, edgework quality and load area utilization. Production rates for ceramic frit-coated panels will vary depending on part size, thickness and the specific type of frit used, the frit pattern and the consistency of the frit thickness.

Production Capability – Loads/Hour

Glass Thickness		Maximum Production Rate – Load/Hour		2140mm (84") Wide System				2440mm (96") Wide System			
				Maximum Load Area		Maximum Single Piece		Maximum Load Area		Maximum Single Piece	
(mm)	(in)	Single Cycle 5.5m (18') Heater	Double Cycle 11m (36') Heater	(mm)	(in)	(mm)	(in)	(mm)	(in)	(mm)	(in)
5.0	3/16	16	32	2140 x 3660	84 x 144	2140 x 3660	84 x 144	2440 x 3660	96 x 144	2440 x 3660	96 x 144
6.0	1/4	13	26	2140 x 3660	84 x 144	2140 x 3660	84 x 144	2440 x 3660	96 x 144	2440 x 3660	96 x 144
8.0	5/16	10	20	2140 x 3660	84 x 144	2140 x 3660	84 x 144	2440 x 3660	96 x 144	2440 x 3660	96 x 144
10.0	3/8	8	16	2140 x 3048	84 x 120	2140 x 3048	84 x 120	2440 x 3048	96 x 120	2440 x 3048	96 x 120
12.0	1/2	6	12	2140 x 3048	84 x 120	2140 x 3048	84 x 120	2440 x 3048	96 x 120	2440 x 3048	96 x 120

Installed Electric Power

System Width			Heating	Quenching	Cooling	Drives	Total
(mm)	(in)	Heater Length	(kW)	(kW)*	(kW)	(kW)	(kW)
2140	84	Single Cycle – 5.5m (18')	800	150	–	22	972
		Double Cycle – 11m (36')	1500	150	–	22	1672
2440	96	Single Cycle – 5.5m (18')	900	150	–	22	1072
		Double Cycle – 11m (36')	1800	150	–	22	1972

* Quench power based on ANSI Z97.1-1984 capability for 6mm (1/4") thickness.

Bending Capability

2140mm (84") Wide System

Examples – Minimum R: 1028mm (40.4"), Maximum R: Infinity (Flat Glass)

	1028mm (40.4") Min R 254mm (10") Each Leg 2140mm (84") Dev Lg
	1028mm (40.4") Min R 2140mm (84") Dev Lg
	1372mm (54") Min R 2140mm (84") Dev Lg

Bending Capability

2440mm (96") Wide System

Examples – Minimum R: 1028mm (40.4"), Maximum R: Infinity (Flat Glass)

	1028mm (40.4") Min R 400mm (15.7") Each Leg 2440mm (96") Dev Lg
	1028mm (40.4") Min R 2440mm (96") Dev Lg
	1560mm (61.4") Min R 2440mm (96") Dev Lg

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