Goessling USA, Inc.
Conveyors and Connecting Systems

Conveyor Equipment for Stamping Industry

Modern material handling systems for cleaning stamping dies and press interiors
For discharging stamped/punched parts
For underground scrap removal
For scrap collection and feeding scrap containers

Scrap discharging station for 5 to 8 containers (dumpsters)

Scrap discharging station for automatic filling of semi-truck trailer

Low profile magnetic sliding conveyor (for Dies)
Low profile flat belt conveyor (for Dies)
We are specialists for the modern conveying technologies in and around the stamping and punching presses.

We deliver low profile Conveyors such as: Mini-flat belt conveyors, Mini-magnetic belt conveyors, Mini-magnetic sliding conveyors, Mini-steel hinged belt conveyors to fit perfectly into the stamping dies for the discharging and cleaning of the small stampings and scraps produced.

We manufacture various types of conveyor systems for discharging finished stamped parts or scraps from the press interior.

We deliver complete underground scrap removal and collecting systems, including long main scrap conveying lines and automatic feeding and loading stations for large containers.

All sizes of flat belt, magnetic sliding, and steel hinged belt conveyors are available.

We have Engineered special designs to avoid jamming of scrap inside our conveyor systems and have closed the gaps in our hinged belt conveyors to less than 0.0118" (0.3 mm).

Our main Engineering interest is the delivery of conveyors that will not cause production to shut down press working due to jamming inside the discharging conveyor line(s).

We are not the largest conveyor manufacture in the world, but we believe that because of our great effort in preventing jamming makes us have the best Engineering and construction features available world wide. We are the specialists for stampings and scrap handling. Our worldwide delivery program for the stamping industries makes us an important partner for the solution in your stamping problems.

We deliver:
- Magnetic belt conveyors for steep ascending or vertical transport of cans, boxes, tins, canisters, containers, caps and covers.
- Different types of hopper belt loaders, vibratory feeders, magnetic feeders, vibratory and centrifugal feeder bowls.
- Also wire mesh and steel hinged belt conveyors of all types and sizes, magnetic belt separators for vibrating grinding bowls, and various types of lifting and tipping units for discharging boxes and containers.
- Light weight flat belt conveyors and roller conveyors.
- Material handling devices for interlinking different machines.
- Workpiece table carriers for automation of manufacturing and assembly.
- Washing and degreasing machines.
- Deoiling centrifuges and centrifugal dryer.
- All kinds of Chip conveyors (Magnetic sliding, hinged steel belt, chain drag-scrappers).

For any material handling problems in the stamping/punching industry you should contact us. It will be to your advantage.

For the discharging and cleaning of stamping dies, we deliver several types of very low profile conveyors:

- Flat plastic belt conveyor | Height 1-3/16" (30mm)
- Flat steel hinged belt conveyor | Height 2-9/16" (65mm)
- Magnetic sliding conveyor | Height 1-3/8" (35mm)
- Magnetic belt conveyor | Height 2" (50mm)

All of the "mini" types above are Engineered with very low profile heights to fit into the small die channels. Small flat belt conveyors help to discharge the finished stampings from the press interior.

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- Also wire mesh and steel hinged belt conveyors of all types and sizes, magnetic belt separators for vibrating grinding bowls, and various types of lifting and tipping units for discharging boxes and containers.
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In order to reduce the belt damages by cutting and stiffing effects of stampings or scraps, we have developed a very low profile steel hinged belt conveyer which can be used in small die channels. The steel hinged elements are insensitive to sharp and pointed stampings.

To clean small die channels from very small scrap parts, we deliver Mini-magnetic sliding conveyers, which can transport even the smallest oily slugs, strips, rounds and blanks.

Multi-flat belt conveyors for handling sheet metal pieces for palletizing

Mini-steel hinged belt conveyors for use inside the dies

For steep handling and ascending transport we deliver magnetic belt conveyors.

The ferromagnetic parts (stamped, punched, or deep drawn) are transported by a flat belt (plastic textile or stainless steel wire mesh) over fixed inside permanent magnets which attract the parts on the belt surface. Even vertical transport is possible for cans, containers, covers, etc.

These conveyors can run up to 3 ft/s (approx. 1 m/s).
For feeding/loading machines, magazines, etc., we deliver hopper loaders (Lastikus) with a hopper and steep feeder conveyor in a complete unit. These loaders transport metered charges of small quantities very gently and carefully. Using a hinged steel belt with a curve shaped movement through the bottom of the hopper keeps the parts in a gentle circulation.

For discharging mass parts in an orientated position following the loader we deliver parts loader with hopper and orientating chain plate system.

Lastikus hopper loader with weight check control for a specific weight discharge.

Vibrating bulk feeder with part loader including orientation of parts.

Vibratory feeder bowl.
We deliver several different types of washing and deoiling machines for cleaning stamped parts using hot detergent water solutions, hot clear rinsing water and hot air drying.

We deliver units with stainless wire mesh belts, perforated hinged belts, or a drum type with inside worm flights. The infeed part can be operated as a submerged part of the machine. To eliminate the oil from the water solution, an oil skimming system works continuously.

For more details, please ask for more literature.

Magnetic Sliding Conveyors

For discharges out of stamping presses, magnetic sliding conveyors are used especially for little scraps or small oily stampings. With the use of magnetic sliding conveyors small shaped parts, light weight parts, or even parts with oily surfaces will be conveyed to clean and discharge the parts from the presses interior.

All conveyor configurations can be delivered corresponding to the space dimensions in and around the press. There is a wide variety in the effective width and infeed height of the conveyors.

Magnetic sliding conveyors
are mostly placed under the mounting table of the press. The sliding surface is produced by an antimagnetic stainless steel or manganese hard steel plate under which permanent magnets are moved by an electric gear motor.

Magnetic sliding conveyors cannot be used for handling long shaped stampings because these parts can cause a “magnetic” short circuit within the system.
Hinged steel belts are used for different and large stampings or heavy weight scrap. There is no limitation in conveying length, transport line configuration or bulk loading. Our hinged steel belt conveyors are used for underground central scrap removal and filling/distributing large containers, especially semi-truck trailers.

Discharge station of a long underground scrap collection line (automotive body scrap)

Underground scrap line for dynamo sheet metal scraps (AC - motors)

Underground scrap line for automotive car door scrap

Hinged steel belt conveyors

Our hinged steel belt conveyors have a smooth plain (mostly dimpled) top surface. There is no difference in height between the back plate of the hinged elements and the hinged joints, therefore there is no chance that dirt nests form causing small parts to glue and stick.

The following hinged elements pitches can be delivered: 

- \( P = \frac{3}{4}, 1-1/2, 2, 2-1/2, 4, 5, 6 \) (inches)
- \( T = 19.05, 38.1, 50.8, 63, 100, 125, 152.4 \) (mm)

All hinged elements are cold stamped and punched of high strength steel. The gaps between the elements can be reduced to 0.0118" (0.3 mm).

Similar to the magnetic sliding conveyors we deliver, our hinged belt types in L and Z-shaped for direct discharging of the press stampings. For light weight stampings our Drahtboy version \( P = 3/4" \), and for all other stampings our Stahlboy versions \( P = 1-1/2" \) and 2-1/2" are used.
To avoid jamming of scrap and stampings we pay close attention to the tightness of the side plates and chains. We introduced machined side cover rails into the construction of stamping conveyors that no one in the conveying industry does. With the use of our PS-side plates gaps are reduced to less than 0.005" at the hinged elements. We are known as being one of the best manufacturers of trouble free steel hinged belt conveyors.

We paid close attention to produce a jam-free conveyance – we paid closer attention for the advantages for our customers.

Discharge point with a swivel chute for scrap distribution to several containers (dumpsters)

Discharge point of an underground scrap line

Ascending part of a underground scrap line

Variable height swivel chute of a scrap conveyor

Scrap Container Filling

For best and complete filling of scrap containers we have Engineered different constructions for distribution. We deliver motor driven swivel chutes or additional distribution conveyors to fill each location of the container the best way. To fill two containers without time delay, we swivel or reverse the distribution conveyor controlled by an ultra-sonic sensor. For filling semi-truck trailers, we have Engineered special platforms to move the trailers during the filling (without the truck) totally automatic by ultra-sonic sensors and observed by TV-cameras and sent to a TV monitoring system at the scrap recycling service center. Now arrangements for container replacement are made earlier with these new modern logistics.

We ARE the specialists for a quick and automatic container filling system.
Our Delivery Program for the Stamping Industry

Low profile conveyors for dies:
- Mini flat belt conveyors (plastic textile)
- Mini-flat wire mesh belt conveyors
- Mini-magnetic sliding conveyors
- Mini-magnetic belt conveyors
Multi lane mini-conveyors
Magnetic sliding conveyors (Z-Shaped)
Steel hinged belt conveyors (Z-Shaped)
Drahtboy - Stahlboy
Magnetic steep belt conveyors
Hopper Loaders (Lastikus)
Parts loader with sorting and orientation
Vibrating feeder bowls
Steep loaders
Magnetic palletizing units
Interlinking conveyors
Tumbling loader
Lift and tipping units
Hydraulic tipping units
Vibrating conveyors
Screening machines
Deoiling and washing machines
Deoiling Centrifuges
Parts dryer
Submerge conveyor systems
Chip conveyors (magnetic, hinged belt, and drag chain)
Roller conveyors
Ghost - shift chargers
Circular conveyors with fixed work piece platforms
Metering and sorting units
Lifting-/ revolving-/ turning devices
Stop-/ accumulating-/ accelerating devices
Automation assembling equipment

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