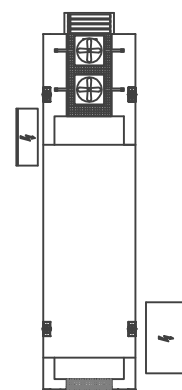


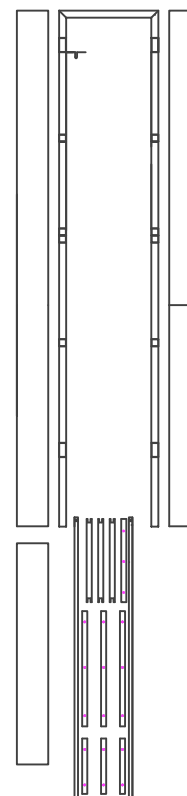


GETTING EXPERIENCE, BUILDING INNOVATION!

LFY - 10 - SHRINK WRAPPING MACHINE FOR TRAYS AND CARDBOARD SLIPSHEET



| <i>PERFORMANCE PLANT</i> | |
|----------------------------|-----------------------------|
| <i>DISPOSITION 500 gr</i> | <i>6x4 Single Layer 35'</i> |
| | <i>4x3 Single Layer 50'</i> |
| | <i>4x3 Dual Layer 50'</i> |
| <i>DISPOSITION 1000 gr</i> | <i>3x4 Single Layer 35'</i> |
| | <i>4x3 Single Layer 50'</i> |
| | <i>4x3 Dual Layer 25'</i> |
| <i>DISPOSITION 3000 gr</i> | <i>3x2 Single Layer 35'</i> |



MACHINERY FUNCTIONS CONTROLLED BY ELECTRONIC PARTS

An inverter controls the principal engine of machinery and transmits a signal that drives other two inverters. The first provides for the movement of plastic belt, while the second for wire mesh and the belt system that allows the stability of product during the tray development.

The speed of the wire mesh and the upper belts remains constant. In the wrapping station, the upper planks of compaction and load product are connected to the principal engine. The planks for wrapping product are controlled by an electric axle subordinated by a brushless engine.

The engine that controls the tunnel net is commanded by an inverter which changes its speed according to machinery and format speed in operation at that time.

MACHINERY OPERATION

The product fueled by a plastic belt goes to tracks thanks to a swinging system. The boxes are separated by a separator that consists of a wire mesh and a system for the product balance.

The belt speed inflow (<) that is different from the speed of mesh system and upper belt (>) allow working fragile products to low noise threshold.

The separated product is compacted and moved to the wrapping zone through specific planks.

When the product crosses, the wrapping phase starts.

The wrapping system consists in 4 phases:

1. The film taken from reel is connected to the product base at the same speed;
2. The wrapping plank by a vertical movement upwards determines the film length;
3. Then, the plank stops for 0.2" and the film is cut;
4. The plank finishes the wrapping by a planned speed according to the format, before the passage of the product.

CARTON GRAB

A mechanical arm picks up the carton from the storage. Its vacuum cups are subordinated by vacuum generators.

The carton storage is adjustable and can hold 700 cartons. Their progress is guaranteed by a progress belt step-by-step. Then, the carton is deposited in a conveyor, which connects it to the product.

COMPONENTES

| | |
|--|---------------------------|
| <i>SISTEMA DE GESTIÓN MOVIENT</i> | <i>ACOM</i> |
| <i>INVERTER</i> | <i>Control Techniques</i> |
| <i>INTERRUPTOR DE BLOQUEO DE LA PUERTA</i> | <i>Magrini</i> |
| <i>CONTACTORES Y RELÉS DE SOBRECARGA</i> | <i>Telemecanique</i> |
| <i>PORTAFUSIBLES</i> | <i>Magrini</i> |
| <i>INTERRUPTORES MAGNETOTÉRMICO</i> | <i>Telemecanique</i> |
| <i>RELÉ AUXILIAR</i> | <i>Finder</i> |
| <i>BOTONES Ø 22,5</i> | <i>Telemecanique</i> |
| <i>LUCES DE LA LÁMPARA Ø 22,5</i> | <i>Telemecanique</i> |
| <i>FOTOCÉLULAS</i> | <i>Telemecanique</i> |
| <i>SENSORES DE PROXIMIDAD</i> | <i>Telemecanique</i> |
| <i>PROTECCIÓN DE SEGURIDAD LÍMITE</i> | <i>Telemecanique</i> |
| <i>CAJAS DE CONEXIÓN</i> | <i>RTA</i> |
| <i>VÁLVULAS SOLENOIDES</i> | <i>Camozzi</i> |
| <i>MOTORES - REDUCTORE</i> | <i>SITI - Motovario</i> |
| <i>MOTORES FRENO</i> | <i>Control Techniques</i> |
| <i>RODAMIENTOS</i> | <i>SKF - FAG - NSK</i> |
| <i>CINTAS TRANSPORTADORAS DE PLÁSTICO</i> | <i>Habasit</i> |

TRAY DEVELOPMENT

The tray development takes place non-stop by a system wrap-around. During the progress of carton, the product is loaded simultaneously with the progress of the same carton.

The wrapped bundle goes to the shrink tunnel by a conveyor.

In the shrink tunnel there are deflectors for the management of hot air both in the lower part of mesh and in the shrink chamber; at the exit of the tunnel, the bundle is cooled by blower. The whole cycle is controlled by PLC.

All phases are controlled by sensors, the possible anomalies determine the interruption of the machinery and they are highlighted by sound/bright alarms; at the same time, on the control panel there is the kind of anomaly and necessary operations appear for the machinery reinstatement.



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ACOM S.r.l.

Via I Traversa Ugo foscolo ,5/7 - Tel . 081 954461

84010 S.Egidio M.Albino (SA)

www.acomimballaggio.com - info@acomimballaggio.com



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