

## Projectgegevens

### Tray Erector TF40

#### ***AUTOMATIC TRAY FORMING MACHINE MODEL TF 40 Imola FOR FOLDING AND GLUEING CORRUGATED BOARD TRAYS IN CITRUS VERSION***



#### Main features:

- Welded and painted steel frame
- Paint: Frame RAL 7035; paneling RAL 9016
- Horizontal cardboard-blank magazine (800 mm high)



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- Cardboard picking from the magazine by vacuum cups controlled by Venturi system.
- Cardboard blanks transferred by a driven and hooked conveyor chain
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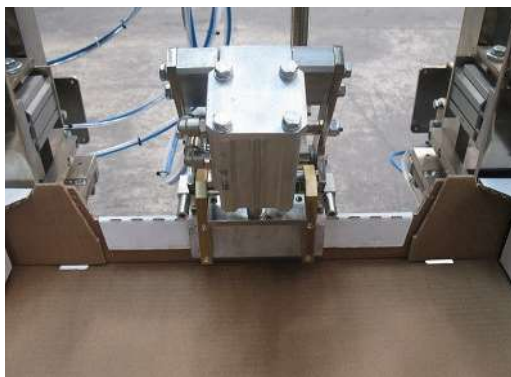
- AC motor-operated forming press.
- Quick size changeover by hand wheels with position indicators
- Machine working in indexed motion to assure perfect squaring of the corners
- Glue applicators: NORDSON MESA 14/6
- See-through guards with aluminum frame and interlocked access doors
- User's interface with touch-screen control panel to easily enter and read all machine operating data (product size, machine state, faults)



- Machine designed in compliance with current European Council Directives, decrees: 89/392/CEE, 91/368/CEE, 93/44/CEE, 93/68/CEE

### Long side doubling device for citrus hopper:

It is a mechanical device that allows to fold and glue the doublings on the long sides of the tray. Its pneumatic movement guarantees mechanical squaring control. Long side doubling device includes a pre-folder which facilitates its gluing.



### Short side doubling device:

It is a mechanical device that allows to fold and glue the doublings on the short sides of the tray. Its pneumatic movement guarantees mechanical squaring control.

Kit for short side doubling is installed inside the hopper (in the forming area ) of the TF40 and is equipped of an independent system of adjustment for the short sides gluing, after the tray flaps closure.

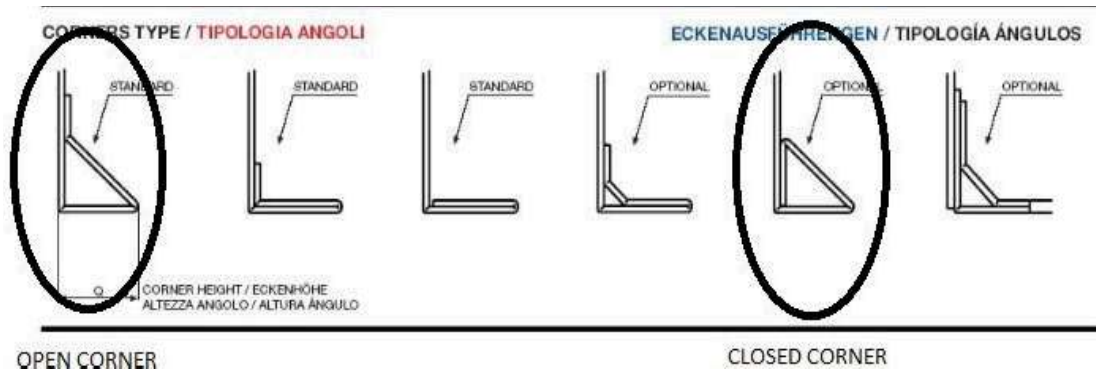
### Additional glue gun for short side doubling device:

This gun is installed like the others on the same fusion unit and handled from the program with a separate and different outlet.



### Closed corner system:

In standard configuration the tray forming machine Model TF40 Imola is able to erect "open" reinforced corners. By installing the mechanical device for "closed" corners the machine can run them both.



**Configurazione TF40 IMOLA standard  
angolo esterno**

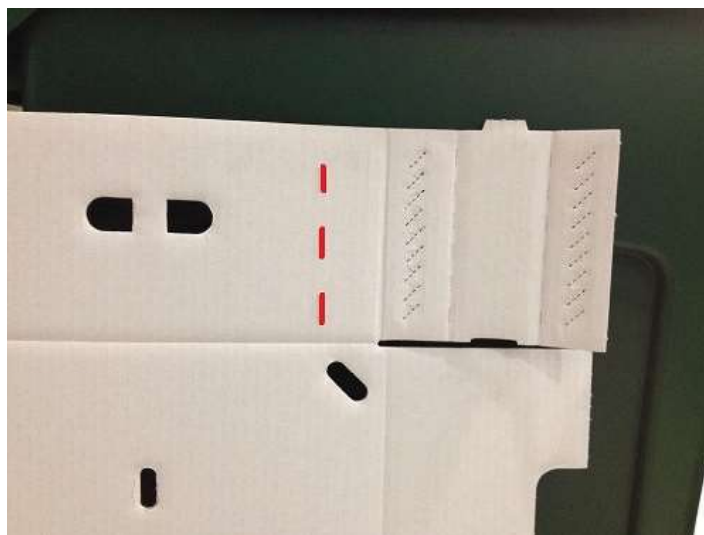


**Configurazione TF40 IMOLA opzionale  
angolo interno**



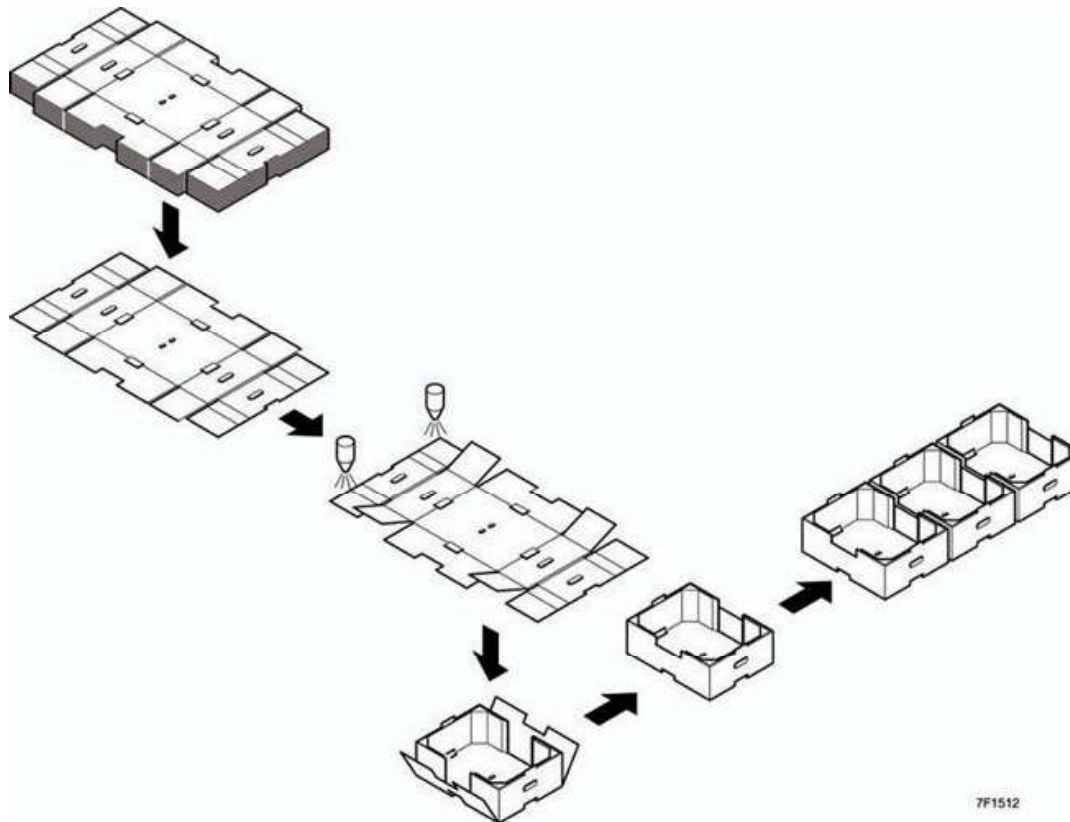
### **Glue Saving Kit:**

This kit is composed of a complete rapid electro valve group, with double effect and wiring to the additional PLC that handles the functioning in order to save hot melt glue. The glue line splitting is easily handling through the touch screen display into the format data menu, selecting length of the glue lines and number of electro valves to activate.



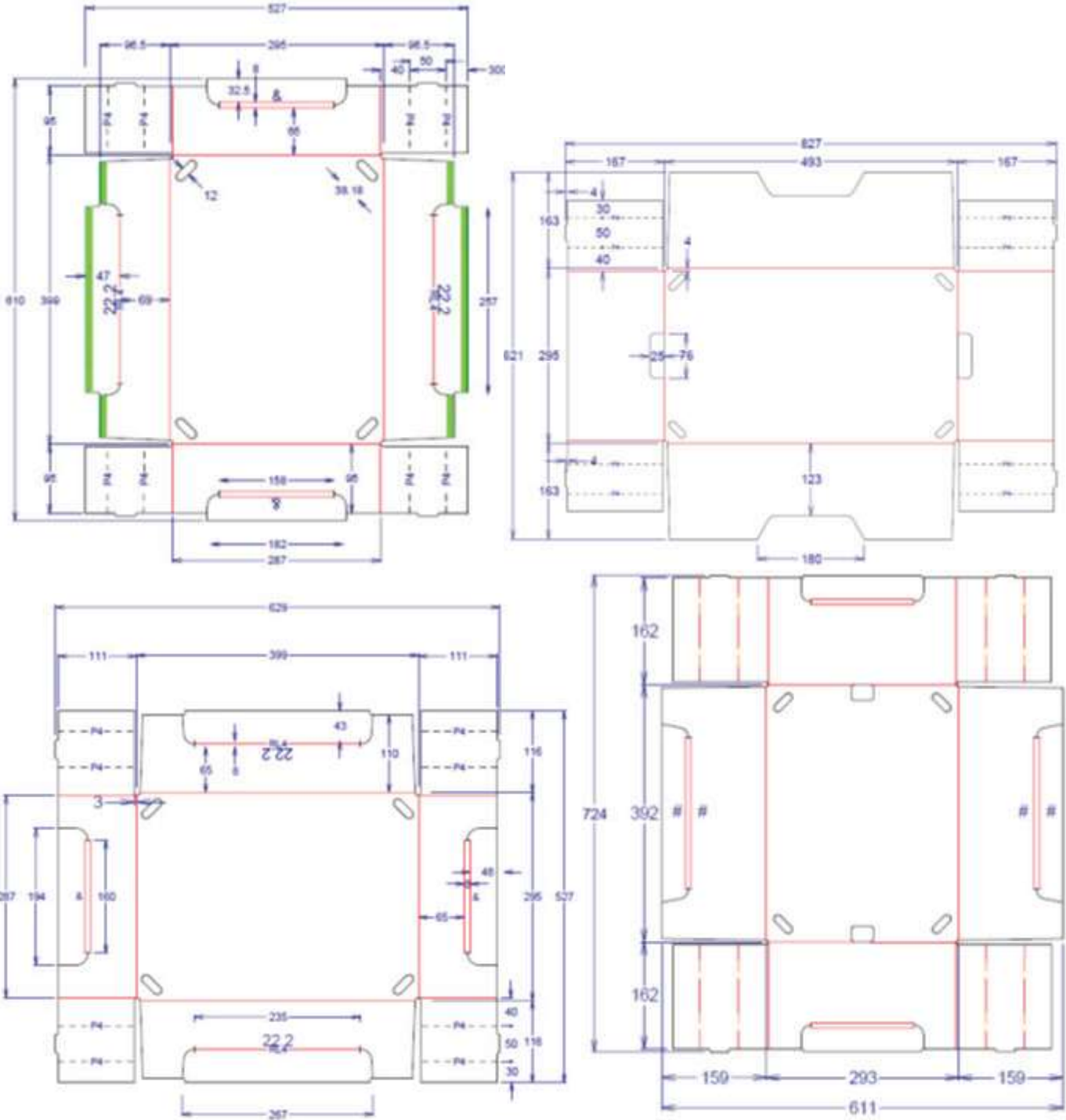
The blank is picked from the horizontal magazine and placed on the main rails. The main chain push the board from behind under the applicators that apply the glue lines dedicated on the blanks. A pre bending system, composed of 2 cams mechanically synchronized with the main chain, pre fold the flap to 90°. Then the blank is placed under the mold perfectly in center. The mold start it cycle pushing the board inside the forming section; the motor is controlled by a frequency control device in order to optimize the forming speed. During the stroke the carton is pre-formed by the guided and two fingers stops the tray to help slipping out the mold. The front and rear flaps are folded by two independent pneumatic benders (one per side that follows the natural bending of the board) and the side flap pressed by four lateral pressers. During this operation, to control the squaring and the height, the tray is slightly pressed on four bottom references.

When the parts for Plaform style tray are supplied (optional Kit) the machine will be able to form also that type of tray in the forming station simply by installing the specific parts.





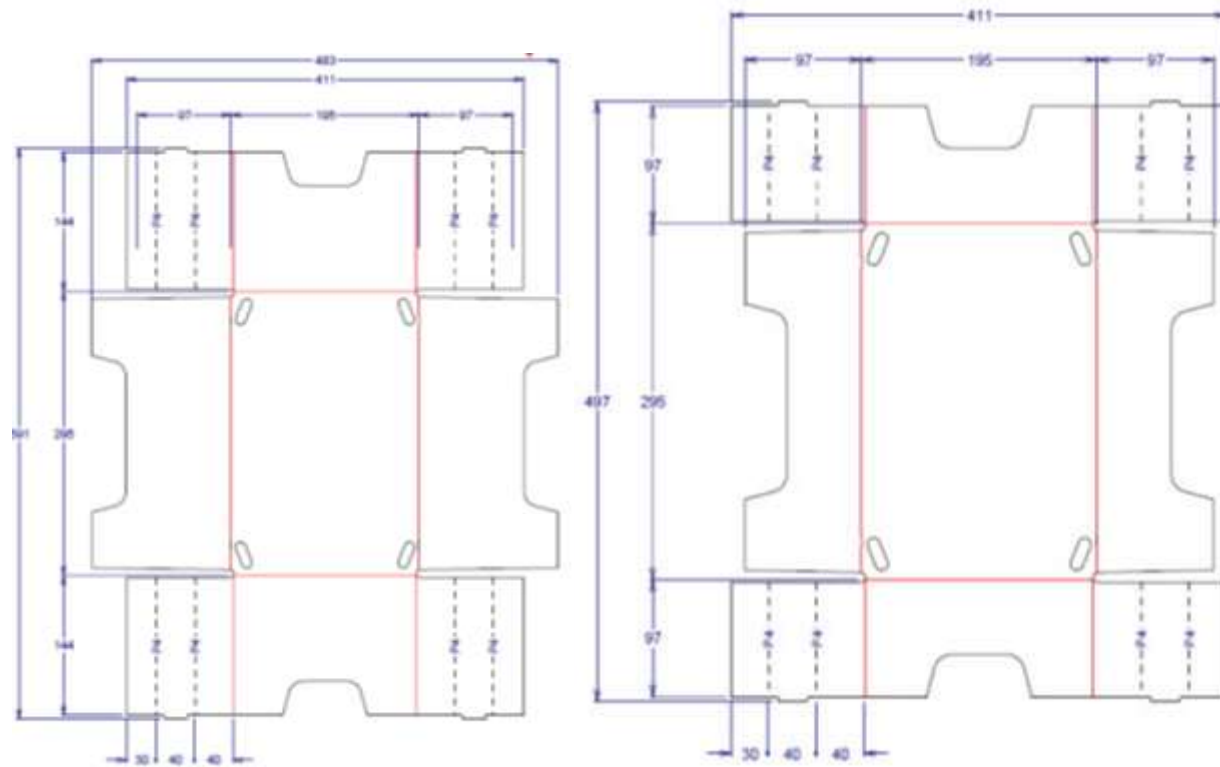
## CORNER TRAY FORMING PLATE CORNER 30x40





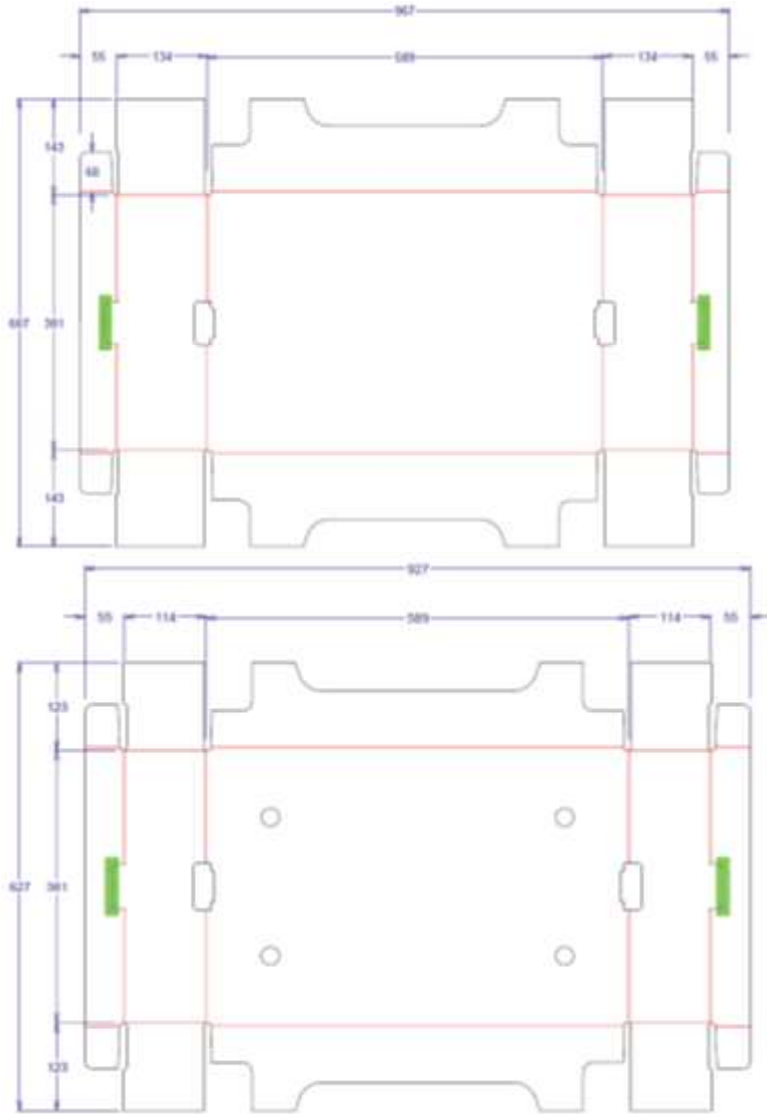


### CORNER TRAY FORMING PLATE CORNER 20x30

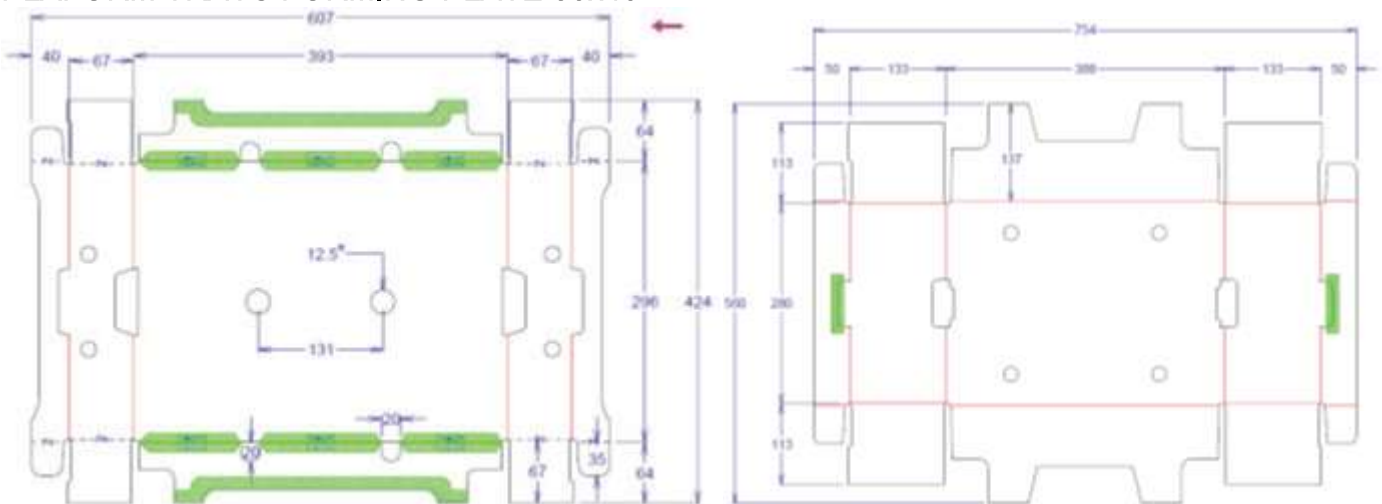


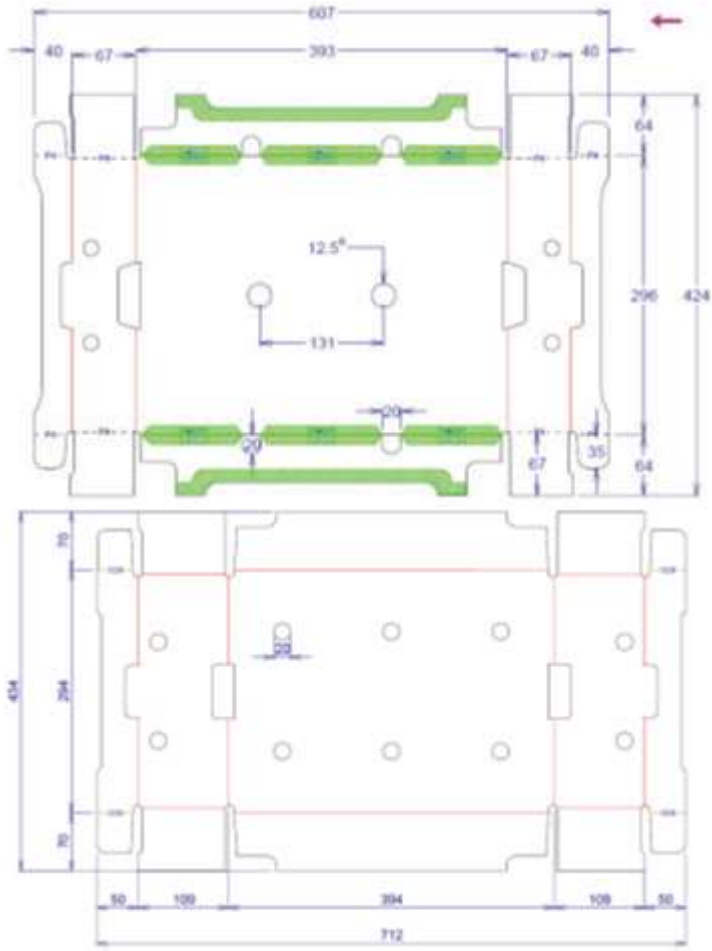
### PLAFORM TRAYS FORMING PLATE 40x60



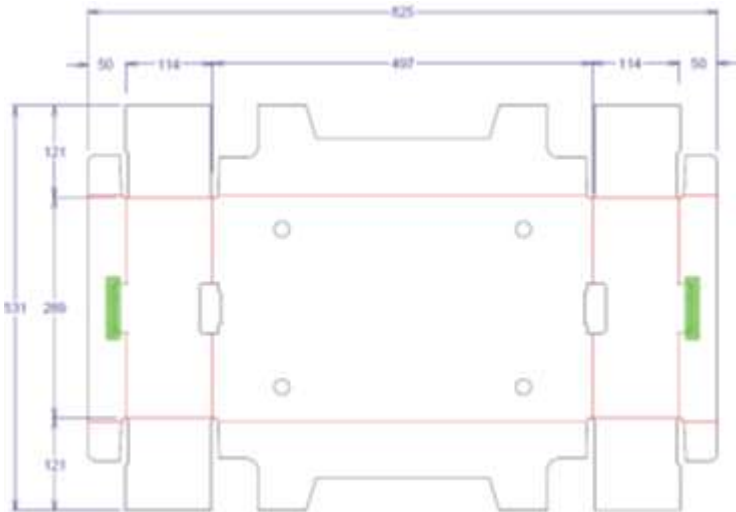


### PLAFORM TRAYS FORMING PLATE 30x40





PLAFORM TRAYS FORMING PLATE 30x50



### Technical Specifications:

- Maximum operating speed: 30 cycles / min (depending on format and type of the packaging)
- The production rate depends on the shape and size of the trays being produced
- Steeples speed variation through the use of inverters
- Electric standard supply: 400 V – 50 Hz + GND + N
- Control voltage: 24 VDC
- Power requirements: 10 kW
- Compressed air requirements: 45 NI /cycle at 6 bar
- Weight: 1700 Kg
- Operating temperature: 5°C to 35 °C

### Formats that can be handled:

- **Cardboard blanks**

420 x 340 mm (minimum)

1300 x 1000 (maximum)

- **Trays (PLAFORM AND CITRUS )**

200 x 300 x 60 h mm (minimum)

600 x 600 x 250 h mm (maximum)

### Citrus tray features:

Forming hopper for "citrus" type trays **including parts to form "plaform" plateaux.**

Forming press controlled by electric motor and adjustable speed controlled by inverter

Parts for "citrus" corner forming and short side doubling glueing.

## Tray stacker TS43 IMOLA



Automatic stacker Model TS43 Imola equipped with conveyor belts. The trays are stacked by a vertical movement and divided by a motorisations electronically synchronized. Pneumatic device ejects pile of trays that it can be double or triple according to trays dimensions. Max. trays dimensions stackable is 600x800 mm (WxL) to unlimited height.

Stacker must be connected to Sacmi Packaging tray forming machine, in order to run it.

### **Technical specifications:**

Trays stacks maximum height: no limits

Maximum speed: up to 30 trays/min lifting a double pile

Installed power: 1 kW

Weight: 500 kg

Maximum dimensions (conveyor in working position in mm): 1100x4900 H=2000

## Automatic glue filling system



AutoFill V3



Container met venster



Luchtfilter



Niveausensor V2

### AutoFill V3

The Autofill V3 is the updated version of the Autofill system. User-friendly, reliable and available for every hotmelt unit.

#### New:

- Level indication with LEDs in the tank
- Easy to use calibrating function
- Integrated valve

#### Technical specifications:

- Control box equipped with:
  - Hand / autofunction
  - Interface with hotmelt unit and / or machine
  - Level indication
  - Alarm system with lights
- Container, volume 120 liters with window
- Venturi incl. protection and vibration element
- Standard hose length 4 meters
- Funnel provided with PTFE coating
- Control box can be rotated by 30°
- Transfer height > 4 meters
- Transportlength > 10 meters

## Prijsoverzicht

1	x	Tray Erector TF40
1	x	Fixed format parts only for included packaging as shown in the offer
1	x	Platform for Citrus hopper
1	x	Nordson central glue gun
1	x	Long side doubling device
1	x	Pneumatic pre-folding device
1	x	Short side doubling device
1	x	Closed corner device
1	x	Glue saving unit
1	x	Tray stacker TS43 IMOLA
1	x	Automatic glue filling system
1	x	Transporteren from Italy to The Netherlands
1	x	Installation (1 day 1 engineer)
1	x	Training

Totaal, excl btw € 116.300,00

### Betaaltermijnen

Termijn	%	Betalingsconditie
50% bij order	50%	Contant
40% na FAT, voor transport	40%	Contant
10% bij SAT	10%	30 dagen factuurdatum

De verwachte levertermijn is: 8 weken

Deze levertermijn gaat in na ontvangst van de door alle partijen getekende orderbevestiging en de betaling bij order.

Indien een van de onderstaande voorwaarden niet voldaan is kan dit invloed hebben op bovenstaande levertermijn:

- Bij order dienen de tekeningen en voorbeeld verpakkingen ter beschikking te worden gesteld om al de technische aspecten te kunnen bekijken.
- 300 dozen, per formaat en type, dienen 3 weken voor de FAT aanwezig te zijn bij de constructeur om de machine correct te kunnen testen en inregelen.
- De machine wordt pas geleverd na een correcte FAT (Factory Acceptance Test)