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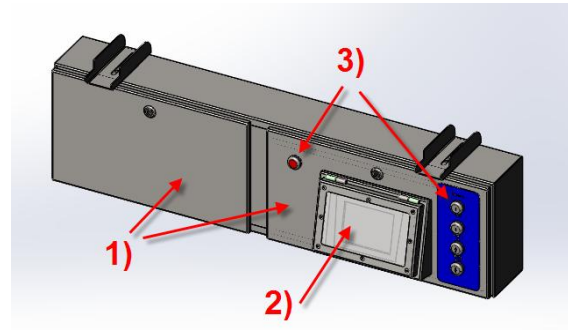
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New Setup forming machine in combination with Stick inserter

Introduction

After several requests we have the forming machine converted from pneumatic control to electric. The entire electrical control system is built into a Stainless steel Cabinet that clear and easily accessible by means of two hinge doors (see Figure No. 1). In one of the two doors is the Touch Panel (see Figure No. 2) built-in. The operation of the machine is done with push-buttons for the most common operations (see picture No. 3). The rest is regulated through the Touch Panel. The Touch Panel is secured by means of an additional viewing window for cleaning the machine.



Different control functions

The hydraulic valves are directly electrically driven. Further, the air cylinders etc. are directly driven from a pneumatic valves island at the rear of the forming machine. Also, we have the possibility water/air knock out built in. Furthermore, we have made the option to regulate the water system. In the TP is possible to give the time how long the water needed to spray on the formplate or into the water/air knock out. It will reduce the water consumption substantially. It is also possible to stop the formplate at the filling position with a time which you can give into the TP. In the past you have to lower the speed from the formplate to get a good filled formplate. Also this is a simple setting in the main menu.





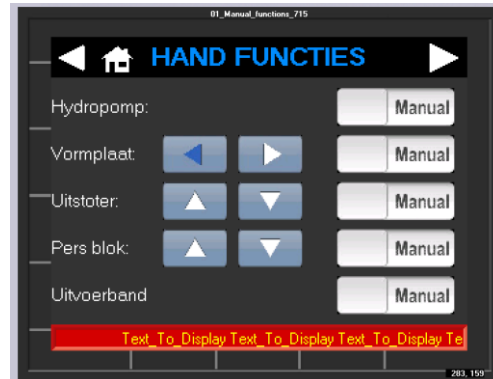
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Maintenance adjusting forming machine

In the TP you have the possibility to move the formplate /press block and knock out manually. By either pressing one of the buttons, the formplate/press block or knock out make this movement. If you put the button longer than 3 sec. this signal shall be held onto the movement you make. In this case it is very simply to controlled the hydraulic pressure for the formplate or press block.



Also it's easier to find the problem when the machine is not working. This of a default message on the TP which problem occurs (some example's front cover not in, knock out is not in the upper position etc.)

Capacity

By these changes, it is also possible to the forming machine to run slightly faster. Most capacity profit can be booked by applying an additional intermediate plate with the filling slot to the front. The profit to achieve here is around 5 cm movement from the formplate in and out. This works out at maximum form plate speed of about 0,2 sec. Representing: 25s/min → 27 s/min, at 40s/min → 45 s/min and 50 s/min → 60 s/min when testing without product we made with the possibility Stick inserter instead of 39s/min → 45s/min. Important is that the speed of the Satay Unit itself has not changed. So the Unit would run just the same in speed Satay. This is necessary for a good working off the stick inserter.

Conclusion

With these modification of the "old" type forming machine HD it becomes more a machine from this time. Easy to operate and maintain. Furthermore, the capacity increase thanks to the easier adjustment of the forming machine on the product. What can give a production increase of about 10s/min at maximum adjustment.

