



A.M.P.-Rose

7IST Double Twist Wrapping Machine



Wrapping Materials

All common twist wrapping materials can be used. The inner wrap, if required should be waxed paper or paper-backed aluminium foil.

Optional extras

- Candy size grading unit
- Plastic tray style feeder for sticky products such as toffee éclairs
- Photocell registration unit for printed wrappers
- Product counter
- Hot air blowers / air assist parts for PP/PVC films
- Static eliminators
- Tungsten carbide paper knives
- Automatic paper reel splicing
- Under-rim heater for sticky products
- Un-wrapper sweet separator
- Pneumatic reel holding unit
- Remote diagnostics

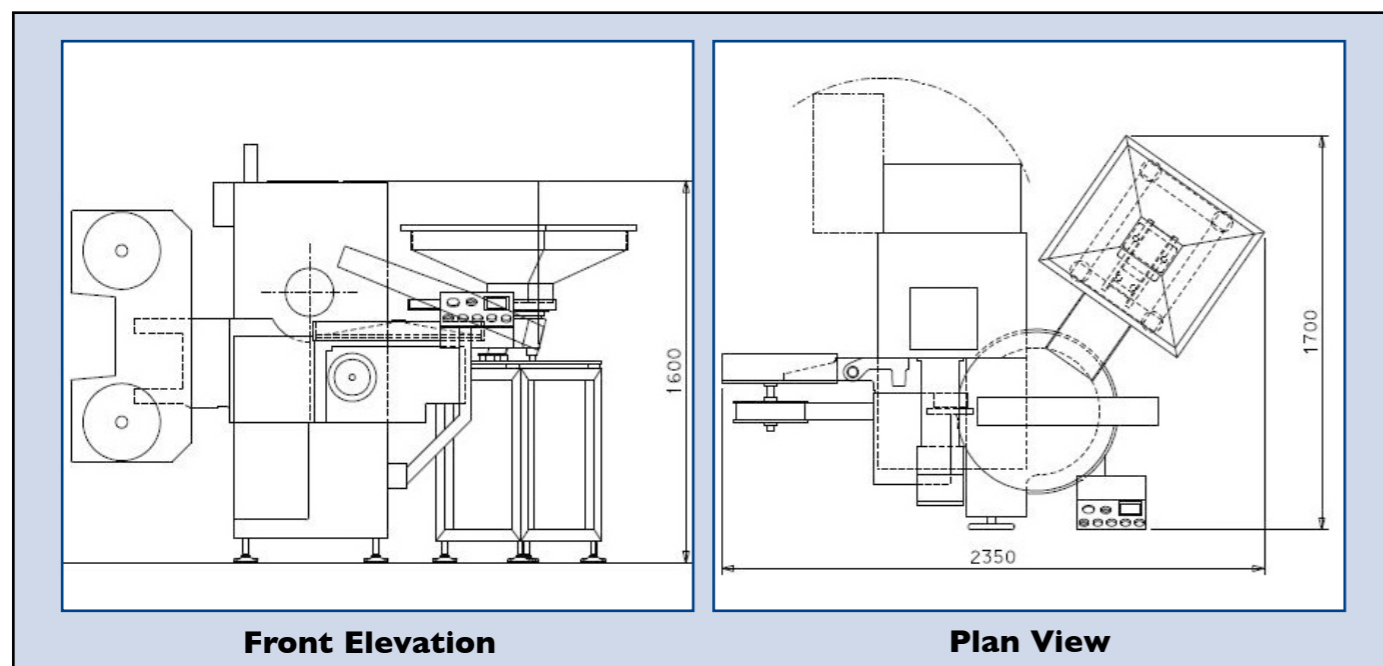
Services required

- Connected load: 32 AMP
- Compressed air @ 6 BAR max.

Shipping

- Nett weight: 2000kg
- Gross weight: 2200kg

Floor Plans



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The '71ST' is a versatile machine used to wrap a wide variety of pre-formed sweets including solid and centre-filled high boiled lines, die-formed and deposited toffees, chocolate balls etc, in double-end twist style.

Benefits of the machine are its ability to handle variations in product size and shape, and the speed and simplicity of change-overs from one product size to another. Operator convenience, ease of cleaning and maintenance, and safety factors have been incorporated into the design.

Sequence of Operations

The products are fed from a vibratory hopper into a feed disc with pockets cut to suit the size and shape of the product. The wrapping material is fed in reel form and accurately measured in length using a servo motor drive. Single or double wrappers and laminates can be used. A scissor type knife allows a wide variety of films to be handled. The candy, together with the cut wrapping material is transferred from the feed disc into a six station wrapping wheel. The double twist wrap is completed in the wheel and the wrapped products are discharged down an inclined chute.

Features

Automatic operation

The machines require minimal operator intervention – one operator can attend to multiple machines. Alternatively, fully automatic delivery systems can be provided to feed sweets from the down-stream production machinery to multiple wrapping machines.

A level sensor located above the feed disc ensures that the vibrating candy feed tray operates at the correct time to optimise the feeding of product. A no-sweet-no-wrapper mechanism ensures that paper wastage is kept to a minimum. An optional automatic paper splicing unit can be provided if desired.

Servo-driven paper feeding system

The machine uses a sophisticated paper feeding system, which is driven by a servo motor. This minimises the mechanical parts and ensures very accurate paper cutting and minimal wasted paper. Changes in paper length are done simply through the operator panel, thereby avoiding the need to change paper length gears. Should the paper feeding roller become worn after a period of use, the intelligent software can be simply re-programmed to accommodate this wear and still provide the correct wrapper cut-off length.

When using registered wrapping material and photocell system, the operator can simply load a new reel and press the 'measure' button on the HMI – the machine will automatically feed and measure the paper, and store the exact cut length between the registration marks.

The HMI allows numerous pre-set recipes to be stored, which can be quickly and easily retrieved by the machine operator.



Long, efficient life

The machines have been designed to withstand the rigours of high-speed confectionery production. Precision machined components are housed in a solid cast iron frame and are constantly lubricated with oil. External parts are designed for easy removal for cleaning and maintenance purposes. The machines therefore require little servicing, maintenance or spare parts.

Simple yet sophisticated control system

Control of the machine is achieved through a PLC system, which has diagnostic features such as warnings of wrapper ruffles or guards incorrectly positioned. A servo motor system is used for the paper feeding unit, which ensures accurate wrapper length and minimises waste. All electrical/electronic components are of the highest international standards and are housed in a single enclosure with a hinged door for easy access. Operation of the machine is via the conveniently located control panel.

Health and Safety assured

A clear, un-breakable polycarbonate canopy style guard provides excellent vision of the moving parts of the machine whilst at the same time giving protection to the operator from noise and movement hazards. The 71ST meets current health and safety and 'CE' standards.

Reduced cleaning/maintenance times

The design of the guards makes it easy to access all internal and external areas of the machine. The entire paper feeding and cutting unit can also be swivelled away from the machine. These features reduce the time required for routine cleaning and maintenance to a minimum.

Versatility

The '71ST' machine can handle a wide variety of confectionery products, such as hard candy, caramel and toffee, chewy sweets and chocolates. The machine is highly tolerant of variations in product size and shape.

Style of Wrap

Double-end twist wrap with a longitudinal seam, unsealed, on the face of the sweet.

Machine Speed

The machine is variable by AC inverter to a maximum of 650 cycles per minute. Actual output under production conditions depends on the size and type of product and wrapping materials used.

Product Size Range

Oval, round, square and rectangular sweets within the following size limits can be handled:

Length: 16 to 35mm
Width: 13 to 19mm

Thickness: 6 to 17mm
Diameter (round shapes): 16 to 29mm

Note: Products outside this size range will be considered.

Product Size Change

A change of size involves interchangeable parts (feed disc and elevator) and minor adjustments. All adjustments are on the outside of the machine, and a size change typically takes 15-20 minutes to complete.

Wrapping Material Size Limits

Reel width: 50 to 110mm
Cut-off length: 51 to 95mm
Standard reel core diameters: 57 or 77mm
Maximum outside diameter of reel: 350mm