

## Candy forming dies



As well as supplying 'Uniplast' type dies for the CF4 machine, we can also provide dies suitable for other machines, such as **Super Robust**, **Super/Baby Rostoplast**, **'Strada'** type chain dies etc. We even supply dies for lollipop forming machines. Die lifting and die washing machines are also available.



## CR81/82 Cooling conveyor

The **CR81/82** machine comprises of a high quality mild steel fabricated enclosure, housing three chain-edged wire mesh (or plastic) conveyor bands. Each one metre wide band is driven individually by a variable speed drive unit, to give optimum cooling periods. The enclosure incorporates removable clear unbreakable panels, ensuring convenient observation and easy cleaning and access to the product. Since the unit is air pressurised, uniform cooling is ensured throughout the length of the machine.

The air supply to the Cooler can be ambient or refrigerated. All air handling equipment is mounted on top of the machine as standard, or as an option supplied as a free-standing unit. The machine normally discharges onto the **EL91** Elevator.



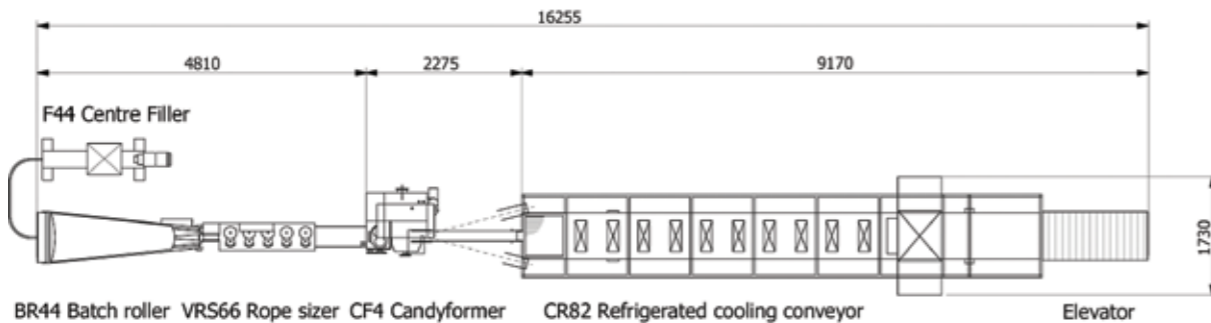
**Optional extras**  
Stainless steel belts, side guards or scrap trays.

### Technical specifications

CR81 (Ambient)	Belt drive	Input fan	Extract fan
	3 @ 0.55kw	2kw	0.5kw

CR82 (Ambient)	Belt drive	Condenser fan	Circulating fan	Compressor	Refrigeration
	3 @ 0.55kw	2 @ 2.5kw	2 @ 2.2kw	11kw	44kw

### Typical line layout



The full range of Candyformer equipment can be supplied either as a complete automated manufacturing system or alternatively as single machines to integrate into Clients' existing lines.

### Additional equipment

Other machines supplied by A.M.P-Rose that are used in the candy manufacturing process include:

- Twist, pillow-pack, stick and roll wrapping machines
- Vertical form, fill and seal, weighing and packing lines
- Hard candy and lollipop depositing lines
- Continuous and batch cookers
- Kneading, flavour mixing and pulling machines
- Laboratory cooking, pulling and coating machines

# A.M.P-Rose



## CF4 candy forming line for solid and filled sweets



## A.M.P-Rose

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# A.M.P.-Rose

Your partner in the confectionery industry



## CF4 candy forming line for solid or filled sweets

The **Candyformer** range of equipment has been designed for the continuous production of seamless sweets, using a 'Uniplast' type rotary die arrangement. Outputs in excess of 1000kgs/hour can be achieved.

Solid and centre-filled products of the following varieties have all been successfully manufactured;

- Hard candies
- Toffee éclairs
- Chewy candies

The machines have been designed to withstand the rigours of high-output confectionery production, and are manufactured to 'CE' safety standards.

A typical production line comprises of the **F44** Centre filler, **BR44** Batch roller, **VRS66** Rope sizer, **CF4** Forming machine and **CR81/2** cooling conveyor.

### F44 Centre filler

Suitable for many different types of masses, such as chocolate, jam, fondant, cream, peanut butter, etc. The machine has a variable speed drive to a positive displacement, non-pulsating pump. This ensures that the centre is always accurately and consistently metered. The centre is fed from the pump via a flexible food quality hose to a teflon coated stainless steel tube. The tube is placed inside the batch roller with the outer candy placed around the tube. The A.M.P. Rose candy laminating machine can be used to automatically feed and consistently maintain the level of product inside the batch roller, thereby providing complete automation of the line.

The machine can be provided with electrical heating, or jacketed for hot water. The **F44** machine can also be replaced by a **fill-extruder** when producing candies with chewy or gum centre. A separate machine can be supplied for filling powders.



#### Technical specifications

Hopper capacity	Heaters	Main drive	Nett weight
50 litres	0.6kw	1.5kw	300kgs

### BR44 Batch roller

The **BR44** machine reduces a batch of confectionery product into the optimum diameter for feeding to the **RS66/67** Rope sizers. The batch roller can be fed manually, automatically via a laminator, or direct from a candy cooling band. The machine has a 75kg capacity trough, which is equipped with either steam or electrical heaters. These are used to maintain the correct batch temperature even if the line is stopped. The trough can be raised or lowered by push button controls from the operator control panel. The rollers can be operated in either forward or reverse motion, or reversed after a pre-set time delay.

#### Technical specifications

Capacity	Rope dia.	Roller drive	Lift/lower drive	Electric heaters	Steam heaters	Nett weight
75kgs	31-83mm	0.55kw	0.75kw	6kw	18kgs/hr. approx.	650kgs



### RS66/67 Rope sizers

The **RS66/67** range of rope sizers can be supplied to various specifications to suit the product and manufacturing line. In the candy forming line the **VRS66** machine receives the candy batch from the batch roller via a pair of vertically arranged sizing rollers. The rope is then gradually reduced in size by four or more pairs of horizontal rollers, to achieve the desired final rope diameter for feeding the **CF4** Candy forming machine. The rope sizer is equipped with electrically heated sizing rollers and an AC variable speed main drive. An automatic rope control unit ensures that the confectionery rope is maintained at the exact tension to ensure perfect feeding to the **CF4**. This is particularly useful when manufacturing centre-filled products.

#### Technical specifications

Capacity	Final rope dia.	Main drive	Electric heaters	Nett weight
Up to 120 metres of rope/minute	10-33mm	1.5kw	1.5kw	500kgs

### CF4 Candy forming machine

The **CF4** is at the heart of the candy processing line and has therefore been designed with strength and durability as its main assets. A substantial cast iron frame supports the drive, candy feed rollers, die head and the integral conveyor/spreader discharge.

The machine has a number of features, which make it an ideal choice for candy manufacturers.

- Die rotation speed is variable by AC Inverter
- The speed of the infeed rollers can be varied relative to the speed of the die, which is particularly useful for difficult products like chewy candy
- The main drive is through timing belts to reduce noise level and moving parts
- Spreader conveyor motor is independent and adjustable
- Integral fan to force air to the spreader conveyor, die and candy feed rollers
- Scrap tray under the die with outlet for connection to a dust extraction unit
- Spring loaded one piece pressure cam with cam rollers (optional pneumatic control)
- Automatic lubrication to cams and bearings
- Automatic matrix ring pressure relief to reduce die wear
- Fast die removal by use of clamps and sliding pull back cams
- Overhead crane feature to allow easy removal of die front cover
- Smooth lines for easy cleaning

#### Output

A maximum of 100 die revolutions per minute can be achieved. For a sweet diameter of 20mm weighing 5 grams this equates to 1320kgs/hour.



The speed of the candy rope is adjustable relative to the speed of the die



The use of clamps and slides allows the die to be quickly installed or removed

The automatic lubrication system increases the life of dies and cams.

#### Technical specifications

Main drive	Spreader	Fan	Heaters	Compressed air	Nett Weight
4kw	0.37kw	1.5kw	0.7kw	0.002m3 per hour @ 5 BAR	1300kgs