

# Fully automatic from plastic pellet to finished/packed in box product

- // Utmost accuracy in forming and cutting process
- // Higher speed in forming deep-draw containers
- // On-board RIM-rolling device available



The E76 is a fully automatic, electro mechanically driven, thermoforming machine with in-mould trim, which nullifies shrinkage effects on trim accuracy. It has been designed to process all types of thermoplastic and coextruded materials.

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## E76 – the wild one

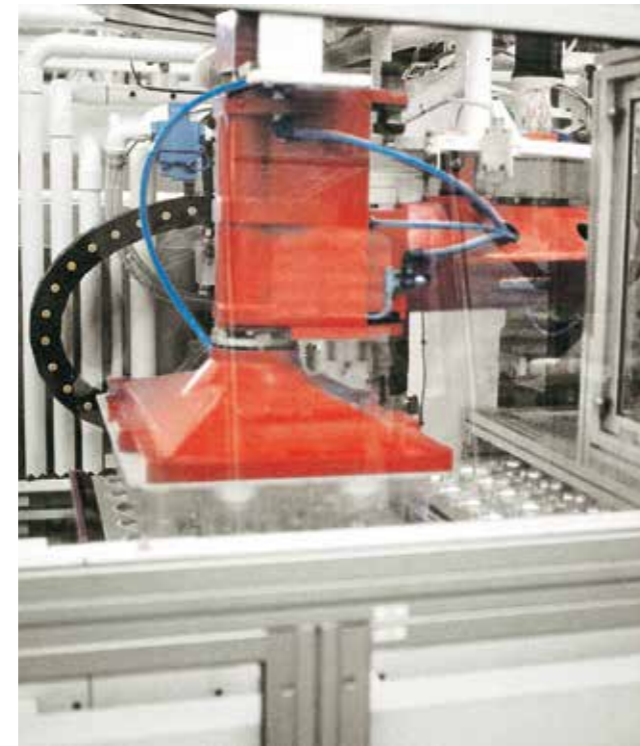


OMV international patent „shuttle mould“ forming technology for higher production requirements

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# Process with high speed and close tolerances using polyolefin materials

- // Patented "Shuttle-Mould" system
- // Much longer products cooling time without reducing the cycle-speed
- // Refined handling/stacking/conveying for all kind of products



SELECTION OF MOST WIDELY USED PRODUCTS - CHARACTERISTICS									
Shape	USE	Dimension mm	Depth mm	Weight gr	Content	PS / ABS / PVC			
						Cavities	Cycles	Prod. p. hour	
	COFFEE CUP	Ø 58	60	3	100 CC	76 S	30	136.000	
	DRINKING CUP	Ø 71	94	4,5	200 CC	60 S	30	108.000	
	DRINKING CUP	Ø 78	102	5,5	300 CC	45 S	29	78.000	
	YOGURT CUP	Ø 75	184	6,5	200 CC	53 S	26	82.680	
	YOGURT CUP	Ø 97	119	16	500 CC	30 S	23	41.000	
	DELI CONTAINER	Ø 116	150	18	960 CC	20	22	26.000	
	ICE CREAM CUP	Ø 146	102	24	1000 CC	12 L	23	17.000	
	MARGARINE TUB	Ø 101	58	7	250 gr	30 S	26	47.000	
	MARGARINE TUB	Ø 120	76	13	500 gr	20	25	30.000	
	MARGARINE EUROTUB	129 x 87	45	10	250 gr	21	26	33.000	
	MARGARINE EUROTUB	142 x 92	65	17	500 gr	18	25	27.000	
	TRAY	120 x 120	30	6,8	-	15	29	26.000	
	TRAY	120 x 180	30	10	-	10	29	17.000	

The E76 features the international OMV patent "Shuttle Mould System" which allows a much longer cooling process, 3,5 times longer than in any conventional machine, that has been especially studied for materials like polyolefin that need longer cooling period. This system, thanks to the reduced opening stroke of the forming press, allows a thermoforming polypropilene cycle speed as high as the polystyrene's one.

This machine incorporates a special Rim-Rolling System by compression, an OMV international patent, that doesn't require further products heating. In addition, it also let unloading and stacking different heights products.

## Index drive

- // Electronic servo-motor allowing to program the translation index from the control panel
- // Adjustable frame supports for different sheet widths

## Oven

- // C-shape oven with top and bottom ceramic heaters, arranged in longitudinal zones and electronically controlled

## Forming station

- // Cutting device is by excentrics placed under the toggle base and operated by one hydraulic cylinder (an OMV international patent)
- // Mould assembly including a fixed upper male part and two lower female tools (Shuttle Mould System)
- // Two groups of vacuum extraction plates, taking the products out of the mould and conveying them to the collection system
- // Quick mould fastening by pneumatic system
- // Quality control system, programmed and controlled by software

## Plug-assist

- // Servomotorized plug-assist cylinder (as standard)

## Technical Specifications of E76 THERMOFORMER - In-line System

Materials	D 140	HIPS - PP - ABS - HDPE
Gross output HIPS	kg/h	1.240 - 1.340
Gross output PP	kg/h	1.100 - 1.140
Sheet thickness HIPS	mm	0,2 - 2,2
Sheet thickness PP*	mm	0,4 - 2,2
Extruder size	mm	140
L/D ratio for water/air cooled	mm	33/1
Extruder motor power	kW	386
Max. screw rev.	Rpm	160
Flat die width	mm	950
Lip opening	mm	0,2 - 2,5
Gear pump capacity	cm³/turn	371
Calender roll diameters (Upper-Middle-Lower)	mm	383 - 500 - 500
Pull roll diameter (haul-off)	mm	238
Rubber roll diameter	mm	200
Effective rolls width	mm	1.000
Max. cooling required (at 8° - 10°C)	kcal/h	208.800
Total installed motor power	kW	828
Total installed heating power	kW	422

\*PP Sheet thickness can be reduced to a minimum of 0,2 mm with the additional air knife (optional)

## Technical Specifications of E76 THERMOFORMER - In Mould Trim

Materials	PS - PP - ABS - PE
Max. forming area	mm 760 x 540
Min. forming area	mm 400 x 250
Max. sheet width	mm 820
Sheet thickness	mm 0,2 - 2,5
Max. forming depth	mm 150 (180)
Max. positive forming	mm 10
Forming with compressed air	bar 6
Dry cycles	strokes/min 35
Oven size	mm 2.410 x 1.010
Mould closing/cutting force	daN 80.000
Max. cutting lenght	mm 17.800
Max. air consumption	NI/min. 15.000
Max. cooling required (at 8°-10°C)	kcal/h 72.000
Max. vacuum consumption	m³/h 160
External dimensions	mm 9.000 x 15.100 x 3.200
Weight	kg 36.000
Total installed motor power	kW 139
Total installed heating power	kW 159