

- // One system for rectangular or square or round containers
- // Controll interface for all process funtions
- // Many functions ajustable while machine working
- // Capability to make both containers and lids by the same machine
- // Substantial savings in raw material if compared to the traditional IML-Injection



The F25/5 IML-T is a fully electrical, automatic thermoforming machine with forming and cutting operation in one station.

Mould closing and cutting operations are performed through a servo actuated mechanical toggle system. The whole machine inclusive discharge devices is controlled over the control cabinet.

Over the OMV Operator Interface with LCD screen, all process functions are controlled with a Siemens PLC. All functions adjustable while the machine is working. Machine cycle speed stepless adjustable and continuously changeable while the machine is working. Press with two different strokes, depending upon the required forming depth.

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F25/5 – the face former



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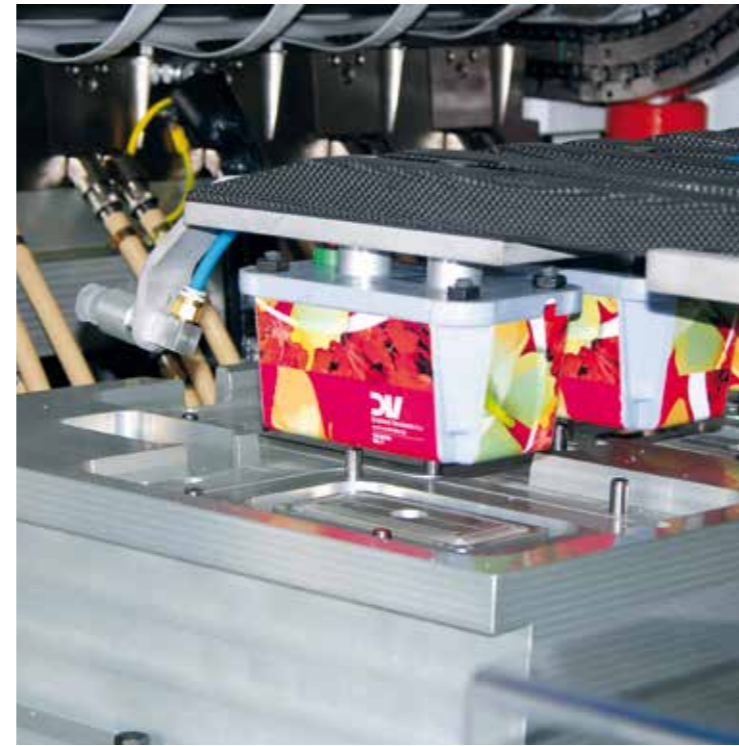
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The IML thermoformer for containers, cups and lids

One system for many product forms

- // Operators-friendly equipment
- // Large use of carbon-fibre in the moving parts
- // Electrostatic charge system



Technical Specifications of F 25/5 Thermoformer - IML Version		
Materials	PP – PS	
Max. forming area	mm	850 x 250
Max. sheet width	mm	910
Sheet thickness	mm	0,2 - 2,2
Max. forming depth	mm	110
Max. positive forming	mm	15
Forming with compressed air	bar	6
Dry Cycles	strokes/min	40
Oven size	mm	1.280 x 1.000
Mould closing force/Cutting Force	daN	16.000
Max. cutting length	mm	4.500
Max. air consumption	NI/min.	10.000
Max. cooling required (at 8°-10°C)	kcal/h	28.000
Max. vacuum consumption (optional)	m ³ /h	100
External dimensions	mm	7.500 x 6.200 x 2.630/h
Weight	kg	12.000
Total installed motor power	kW	87

The products Stacking in the F25/5 IML is different from the standard machine, as the formed products are unloaded onto a conveyor carrying them to the stacking system. Here the products are blown into the stacker channels which fits them into stacks. After reaching the preset number of products a gate automatically separates the counted stacks.

Heating is accomplished by means of an infrared sandwich oven with independently electronic controlled ceramic heaters. Lubrication performed at regular time intervals by an automatic unit which pumps lubricating oil into all moving parts of the machine.

A Standard 900 mm reel unwinder with hydraulic lifting device is synchronized with the machine cycle. Scrap winder is fixed onto the machine frame and synchronized with the machine cycle.

IML – Robot Handling System

The thermoforming machine F25/5 is equipped with a totally independent “Label-Robot-Handling-System” which is installed on a mobile frame. This facilitates tool changing and offers maximum accessibility to the forming station.

The “Label-Robot-Handling System” shall execute the following functions:

- // Labels supply in change magazines
- // Labels separating
- // Labels forming and precentering in the labels forming device
- // Inserting the labels into the cavities of the thermoforming mould
- // Labelled products unloading on a conveyor belt
- // Reject possibility for bad and start up parts

The above described functions are carried out in one phase of operation; therefore the system can achieve considerable time savings allowing to increase the speed of the “IML thermoforming operation”. The labelled products are unloaded on a conveyor belt, which is located between the forming station and the upper heating oven.

This conveyor belt transports the labelled products to the OMV standard stacking and counting unit, which is placed on the side of the thermofoming station. Only one operator is necessary for running the machine and packing the finished products. With the “IML Robot Handling System”, rectangular or square or round containers can be labelled in connection with the single row thermoforming mould of the F25-IML machine.

The above “IML Robot Handling System” can be designed also to cope with all shape of lids.

Selection of most widely used products – characteristics

	Round yogurt cup	75 mm Ø	5 g	11	11.800*
	Round container	95 mm Ø	12-14 g	8	7.680*
	Euro TUB 500	142 x 92 mm	12 g	7	6.300*
	Euro TUB 250	124 x 84 mm	7 g	8	7.680*
	Lid	148 x 98 mm	5 g	7	7.560*

* Expected Speed: is based on the experience of OMV, but it may change as result of some variables such as: raw material, product weight, product design. Exact speed will be confirmed after receiving final product drawing from the customer.