

ASK-4KK

Automatic teabags packing machine with cartoning module.

Operating Range.

The automatic packing line **ASK-4KK** is designed for packing tea into pillow bags by means of 4 lines packing machine and simultaneously putting twins bags into cartons which are erected from flat blanks by means of cartoning module with the traditional tuck-in carton closure or with a completely glued lid closure.

This kind of packing guarantees, of course, a considerable saving in packaging materials. For traditional closure it is possible to use either the traditional final carton overwrapping or the use of adhesive labels positioned on the lid closures.

The weight can be controlled on the checkweigher, and automatically adjusted to the required dosage, it is an option.



Efficient and economical line for packing teas.

One can diversify range of production,

One can save money on cost of labour,



<http://www.miflex-masz.com.pl>



ASK-4KK

Characteristics

- Fully automatic line for packing tea,
- easy changing of parameters,
- easy setting of dose of tea,
- possibility packing different teas,
- full error diagnostics.

Structure

ASK-4KK line composed of four basic parts.

As an option Miflex-Masz can provide this line with weight automatic control and automatically adjusting to the required dosage.

There can be an attachment, connected to a checkweigher unit at the end of line, rejects automatically the cartons not reflecting the exact weight previously selected by the operator.

Packing carton manufacturing

The cartons are erected from flat blanks. Conveyor transfers cartons to teabags packing machine where teabags are stacked and filled by means of cartoning attachment, finally carton is closed. One option is traditional tuck in carton closure.

The second option is hot-melt cartons which allows the automatic filling of cartons, provided with a safety closure with a completely glued lid closure. The carton is opened by tearing the appropriate strip positioned on the closed lid, which may be re-closed easily after use.



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1. Square teabags automatic packing machine.

All parts in contact with the product are made in stainless steel.

Basis components:

- Two unwinders of filter paper reel
- Two accumulation reserve of material which keeps material under during unwinding process
- Tank of product
- Rotating hopper
- transfer the filter papers to the central position
- product feeding and dosing unit
- heating drums
- tigger reels
- roll-knives and perforating knife
- rotary knife
- main drive
- teabag stacking and counting station
- electrical cabinet
- control panel

All components are placed on self-supporting carbon steel frame covered by protections. The machine is equipped with case-by-case regulation of temperature of each drum and variable adjustment of speed. The breakdown cases are appeared and described by the display.

2. The module of sachets collecting, equalization and placing for input to boxes,

This group counts and stacks the filter bags, and inserts them directly into the carton reaching the maximum safety and working efficiency level.

- unit for collecting sachets into groups,
- positive sachets placing unit,
- sachets equalization unit,

3. The carton erecting module from flat blank cartons,

The carton erecting module is designed for forming and gluing boxes

All components are placed on self-supporting carbon steel frame covered by protections.

Basis components:

- container of flat blank cartons
- carton erecting and gluing of boxes border unit,
- setting-up boxes into line for filling with teabags.

4. teabags loading and carton closing module

Basis components:

- teabags top loading,
- carton closing unit



ASK-4KK

The checkweigher with metal detector. as an option.

The weight is controlled on the checkweigher, and automatically adjusted to the required dosage.

Specification

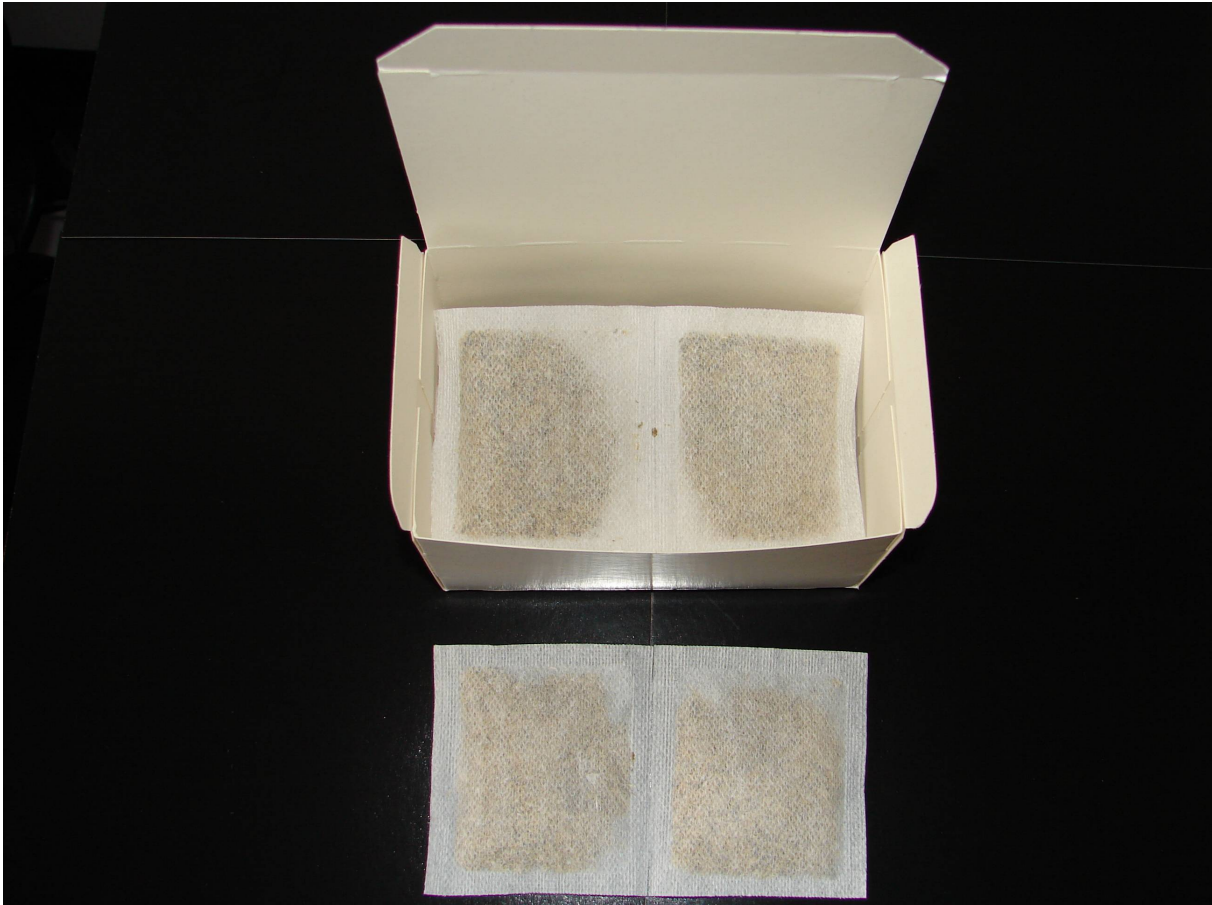
Packing material for teabags:	heat sealed filter paper 16.5gram/m ²
Width of roll of packing material	-264mm
Diameter of material reel	-500mm
reel core diameter	-76mm
number of reel installed on machine	2 reels
Dimensions of teabag	2 x 65mm x 70mm(twin bags perforated)
Bag s weight	it depend of kind of tea (volume 8 cm ³) 1 3 g
Tea or fruit tea with fraction dimensions	- 4 mm
Dimensions of box	135mm x 70mm x 70 mm
Efficiency:	
The packing 2 overwrapped stacks of twin teabags)	
Theoretical output	800 teabags 40 boxes/min

Engineering data

1. Power supply;
 - electrical energy 3 x 380/220 V 50(60) Hz,
 - installed power 6.5 KW ,
 - compressed air 6 bar,
 - air consumption 25 m³ /hour,
2. Dimension of machine 6500mm x 3500mm x 2300mm,
3. Conveyor (length) 1.5 m
3. Weight 1500 kg,
4. Service 1 person
5. collection of boxes 1 person



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