

# ASK-5KF-30

**Automatic teabags packing line.**

**This line consists of 4-lines square teabags packing machine and cartoning module.**

**Optionally overwrapping machine**



## **Operating Range.**

The automatic packing line **ASK-5KF-30** is designed for packing tea into pillow bags by means of 4 lines packing machine and transfers stack twins bags to **flow-pack** for their air-tight. Cartons 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.



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# ASK-5KF-30

Efficient and economical line for packing teas.

One can diversify range of production,

One can save money on cost of labour,

Then you pack flavoured and good quality tea blends, aromatic herbs  
pharmaceutical infusion you are in a position to protect aroma using a  
overwrapping teabags by means Flow-pack machine.



## Characteristics

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



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## Structure

ASK-5KF-30 line composed of five 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.

Overwrapping stacks of twin teabags into hermetic bags by means of Flow-pack system. 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 as an alternative to the traditional tuck-in carton closure gives a more hygienic package. The carton is opened by tearing the appropriate strip positioned on the closed lid, which may be re-closed easily after use.

## 1. Square teabags automatic packing machine.

All parts in contact with the product is 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
- tugger reels
- roll-knives and perforating knife
- rotary knife
- main drive
- collection conveyor
- teabag stacking and counting station
- feeding conveyor of teabags to flow-pack
- electrical cabinet
- control panel



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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 or are directed to flow-pack.**

This group counts and stacks the teabags, 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. Flow-pack** is designed for packing products into hermetic bags.

- Leading conveyor,
- Receiving conveyor,
- Mechanism of cross-wise heat sealing and cutting and its drive,
- Mechanism of grippers drive,
- Unwinding system,
- Forming unit,
- Longitudinal sealing system

## **4. 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.

## **5. Teabags loading and carton closing module**

Basis components:

- teabags top loading,
- carton closing unit

**The checkweigher with metal detector. as an option.**

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





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## Specification

Packing material for teabags:	heat sealed filter paper 16.5gram/m <sup>2</sup>
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 <sup>3</sup> ) 1 3 g
Tea or fruit tea	with fraction dimensions - 4 mm
Overwrapping material (for Flow-pack):	
Polypropylene foil	30 60 m
Or laminate (paper + polypropylene)	50 60 m
Width of overwrapping material	-150mm
Diameter of material reel	-350mm
reel core diameter	-75mm
number of reel installed on machine	1 reel
Dimensions of overwrapped bags	160mm x 70mm x (15 20 mm)
Dimensions of box	160mm x 75mm x 70 mm
Efficiency:	
The packing 2 overwrapped stacks of twin teabags)	
Theoretical output	500 teabags 25 boxes/min

## Engineering data

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



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