

Handle Making Machine Millenium01-System (M01-Sys). DATA-SHEET.**DataSheet (Updated Dec. 2015).**

The Millenium 01 Sys enables (see diagram) to:

- manufacture & apply double patch handles with rope as MINOR, MINI, MEDIUM, MINIGIGA and GIGANT size (see Handles-diagram).
- manufacture a various kinds & dimensions of semi-finished shoppers (the "J" pre-cut+ Handle+Creasing; etc.);
- manufacture bulk handles made in double patch with rope as base-handle (MINOR, MINI, MEDIUM, MINIGIGA and GIGANT) and No. 14 SubSizeHandle as MINIs, MEDIUMs, MEDIUMss, etc. (see Handles-diagram).

All this Handles-Sizes can be manufactured in single pieces (bulk) to be applied by hand on the luxury shoppers.

All the base-Handles-Sizes can be applied in an Automatic-Production-Line of paper bags (see Handle Diagram).

On base standard version of M01-Sys are included four sizes of Handles: the Mini, Medium, Minigiga and Gigant.

In the future at any time it is possible to install the necessary tools to produce other handle sizes.

The set-up of the machine to change handle size takes about 30 minutes.

The patch may have any sizes of band height between 40mm and 70mm.

The patch paper may be 50 to 150g/m² and coupling two of them you can use difference ones.

The bobbins of patch must must have an inner diameter of 76.2mm (3") and an outer diameter up to 1200mm (47").

The rope* diameter can be 1 to 6mm and there are no limits about its nature, rigidity or about the mechanical resistance (rope in twisted paper, rope in cotton & paper or in soft cotton, etc.).

For the using rope, there are only the following limits:

- compatibility with HotMelt glue and/or with the Vinyl glue used to form the handle "sandwich";
- aptitude for longitudinal cut;
- minimum necessary flexibility to assume the handle form;
- supplied in distaff form (for rope in twisted paper) or in bobbin form (for all the other kind of ropes);
- it's suggested do NOT use stockpiled and non wound ropes.

The handles, in all of its sizes, always consist of two patch and the handle-rope, glued on with HotMelt like a "sandwich".

Two applicators of cold-vinyl glue are installed on to supply the necessary glue to apply the couple of handles on bag-paper.

Others characteristic are:

- Electronic Phasing of the Handles applied on the bag-paper;
- Electronic Phasing of the PreCuts executed on the bag-paper prior handles application;
- Electronic Changing of the Working-Step for the pre-cuts (gearless),
- Electronic PIV of the Rolling Applicator to optimizing the Paper-Tension during the tube formation;
- Possibility to move any group composing the System (PreCut, Applicator and HandleMachine) during setup when the Line is stopped.

The machine has a massive, safe and comfortable structure, and a platform that serves to support the handle machine and all the other groups composing the whole system. This platform is also used like a conveyor of hoses and cables and to protect the shopper-paper in transit on the under position.

* As an alternative exists the possibility to directly supply the Handles Machines M01 with twisted rope simultaneously manufactured by the Rope Machine M09 in order to avoid the purchase of twisted rope and its associated costs.

Mechanical and powerful machine members enable to work up to 270 beats per minute (=540

MINI handles per minute producing bulk handles) the production speed decreases in direct proportion to the increase of handle-size.

In Automatic modality the machine is able to satisfy any production speed of any bagging machine present on the market, so that the production speed will be always between the said limits and from time to time it will depend also and especially on current-global-production-conditions where the most important of them are: *Competence of the operators, Workability of material in use, Consistence of the Lot in Production and Conditions of Use & Maintenance of the machine.*

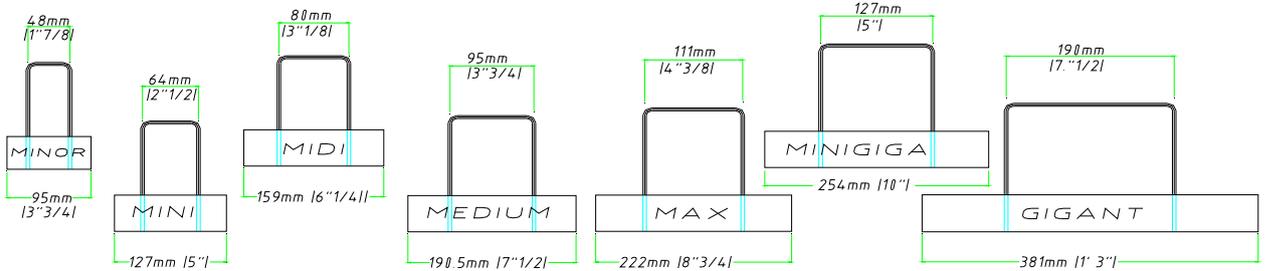
The machine weight is about 3800 Kg; the space it takes is m6x2x2.0(H); its supplying is about 150 l/1' of 6 bar-compressed air (dry and filtrate). The machine consumes maximum 11kw/h of electrical energy (3x400/600 Vac+N+G at 50/60Hz) and all its units (3) are autonomously motorized.

During the handle-production the machine maintains uniform quantity of HotMelt and of Vinyl glue proportioning the HotMelt pump and the pressurized tank of Vinyl glue with the current production speed.

Two comfortable control panels + a PC installed assure a simply use and a fast programming of various operative modalities that can be formulated, changed, memorized and called back at any time.

The machine is provided with all safety measures, with CE (European Community) Certificate and with CE Handbook in accordance with CE directives, and there's a qualified Technical Aid Service ready to support the customer. The machine has one-year guarantee excepting parts subject to fair wear and tear.

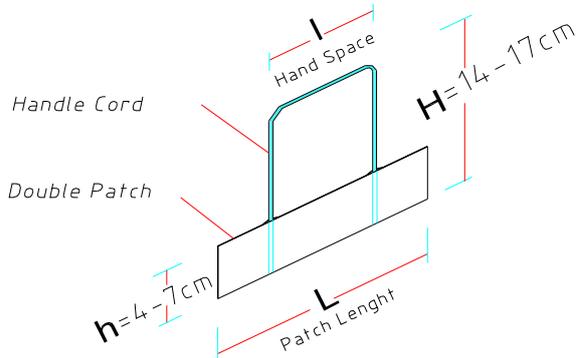
Paper Handles Made & Applied Inline with SOS BagMachine by M01-Sys



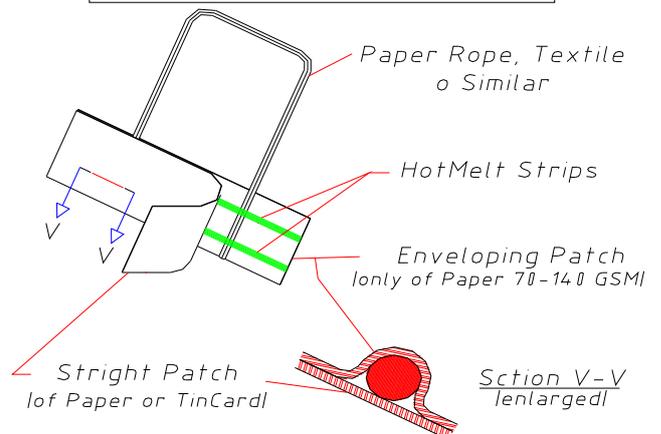
Bulk Ifreel Paper Handles producible with M01s, M01ss and M01-Sys, (to be applied by hand)

HANDLE Size	Hand Space <I>	Patch Dimention <L>	NOTE
MINOR	48mm 1"7/8	95mm 3"3/4	on request
MINI	64mm 2"1/2	127mm 5"	included as standard
MINIs	64mm 2"1/2	95mm 3"3/4	included as standard
MIDI	80mm 3"1/8	160mm 6"1/4	on request
MIDIIs	80mm 3"1/8	127mm 5"	on request
MEDIUM	95mm 3"3/4	190mm 7"1/2	included as standard
MEDIUMs	95mm 3"3/4	160mm 6"1/4	included as standard
MEDIUMss	95mm 3"3/4	127mm 5"	included as standard
MAX	111mm 4"3/8	222mm 8"3/4	on request
MAXs	111mm 4"3/8	190mm 7"1/2	on request
MAXsss	111mm 4"3/8	160mm 6"1/4	on request
MINIGIGA	127mm 5"	254mm 10"	included as standard
MINIGIGAs	127mm 5"	222mm 8"3/4	included as standard
MINIGIGAss	127mm 5"	190mm 7"1/2	included as standard
MINIGIGAsss	127mm 5"	160mm 6"1/4	included as standard
GIGANT	190mm 7"1/2	381mm 15"	included as standard
GIGANTs	190mm 7"1/2	349mm 13"3/4	included as standard
GIGANTss	190mm 7"1/2	318mm 12"1/2	included as standard
GIGANTsss	190mm 7"1/2	286mm 11"1/4	included as standard
GIGANTssss	190mm 7"1/2	254mm 10"	included as standard

Handles Dimentions References



Components & Manufacturing Data



www.picnumeccanica.com

HANDLES DataSheet (on M01 s.machine)

Picnumeccanica srl -Italy

ESEMPIO di LINEA Sacchettatrice Speciale composta di: Triumph 3A d'occasione+ManigliatoreMillenium01+Stampa4C+ Doppio Foglio

DESCRIZIONE TECNICA (vedi Figural.

La Linea Sacchettatrice Speciale è una Linea Automatica per la produzione principale di Shoppers di carta con manici.

Essa è in grado di produrre shoppers da 16 a 32 cm di larghezza con dimensioni del fondo da 7 a 18cm e con una lunghezza di taglio da 24 a 90cm, il tutto partendo da un rotolo di carta di altezza massima pari a 103cm.

Il sacco-base è eseguito dai gruppi Svolg. Bobbine+Formaz. Tubo+Sacchettatrice+Raccolta, che, seppure usati, sono di buona marca, sono revisionati e funzionanti e sono resi sicuri.

Ognuno di detti sacchi a fondo quadro può montare una coppia di maniglie o di cartoncini di rinforzo di varie dimensioni e tipologie. Le dimensioni delle maniglie che la presente macchina può eseguire sono due: la MINI di 6.3cm e la MEDIUM di 9.5cm; mentre la MIDI 8cm, la MAXI 11cm, la GIGANTE 19cm ed il FAGIOLLO è possibile installarli in futuro. Ogni tipo di maniglia è producibile con due o più Lunghezze di Pateletta, fermo restando la dimensione dell'impugnatura. Qualsiasi corda va bene purchè compatibile con la colla utilizzata per l'assemblaggio del sandwich che, a sua volta, è formato da due patelette di carta lo di carta e cartoncino tra le quali sono incollate le due estremità della detta corda piegata ad "U" e che forma l'impugnatura della maniglia.

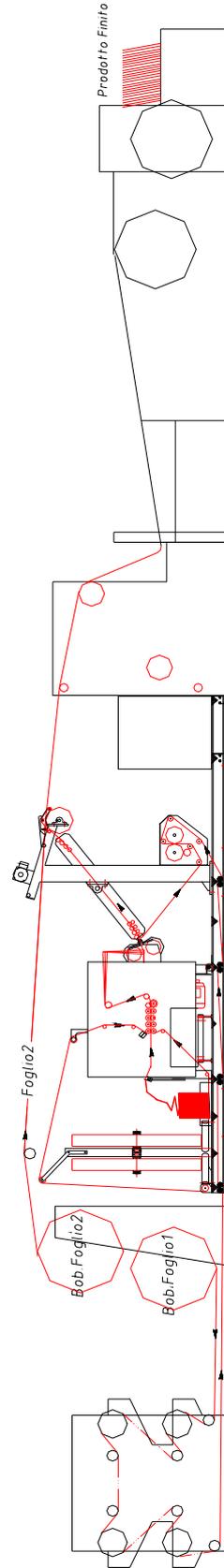
Il tutto è eseguito dal Sistema Millenium01 composto dai gruppi Pedana+Pretagli polifunzionale+Manigliatrice+Applicatore. Il sistema M01 ingombra 6x2mt, pesa 3800kg, è di nuova costruzione, incorpora tre assi elettrici di controllo ed è marcato CE.

Un apposito gruppo di stampa flessografica a 4 colori lusato ma revisionato e reso sicuro provvede alla personalizzazione dello shopper ed è provvisto di asse elettrico attraverso il quale viene pilotato dalla sacchettatrice-base.

Il gruppo Incollatore Foglio2 lusato ma revisionato e reso sicuro serve solo nella eventuale produzione di sacchi a doppio foglio.

I materiali utilizzati nel processo sono Carta, Colle e Inchiostri, mentre le velocità di produzione vanno da 40 a 100 Sacchi/min.

La Linea ingombra 21x2x2.2Hl mt circa, pesa circa 25000 kg e necessita di 20kw di Potenza El. e di 500 Lt/ora di Aria Compressa.



Stampa 4C Svolg. Bobine SISTEMA MILLENIUM 01 Incoll. Foglio2 Form. Tubo Sacchettatrice Raccolta Shoppers
 (Manigliatr.+Pretagli+Applic. Maniglia)

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