

MODEL HFF-15 AUTOMATIC IN-LINE FLOW WRAPPER



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GENERAL DESCRIPTION

The model HFF is designed to operate at speeds up to 74 packages per minute (12" length) on a continual basis. Instead of the infeed conveyor and the sealing conveyor being geared together to provide fixed spacing for the product, we have separated the two. By doing this we are able to program, via the user interface panel, the package length. The machine will then adjust the speed of the two conveyors to provide automatic indexing. The speed at which the machine will run will be adjusted automatically by the number of packages being fed to the machine by the infeed conveyor, and the values input for low and high infeed conveyor speeds.

The infeed conveyor speeds are regulated by the number of products available. If any stations are empty, the conveyor will remain in the low speed setting. If the infeed conveyor stations remain filled, the machine will then select the high speed until a station is empty, at which time it will select low speed. This ensures that the sealing head and belt conveyors always start and stop in the low speed setting. As a result all harshness resulting from high speed starts and stops are eliminated and longer drive component life is achieved.

Standard infeed is a flighted lug conveyor. A push button is provided at the infeed end of the conveyor so that the conveyor can be advanced when changing the drive lugs. For safety the machine must be set in the maintenance mode before this feature can be used. Custom infeeds can be manufactured for long or unusual products.

Transportation of the package and film after leaving the infeed section is supplied by the vacuum belt conveyor which is zone controlled for different width packages. Following this the package moves on to the sealing conveyor which incorporates the reciprocating sealing head carriage, which is adjustable in stroke length from 0 - 12" and would normally be set to approximately 1/2 of the film draw length.

Operation of the sealing head is independent of the carriage. This allows for constant sealing time rather than a percentage time of one cycle. The sealing head also incorporates automatic package height compensation. What this means is that when a package is being sealed the sealing head will move to approximately half the height of the package.

An operator interface panel is provided for input of user functions. These would typically be stroke length, low and high infeed speeds and sealing dwell times. In addition, the interface panel will display alarms for guards open, vacuum not on and indication of any drive failure. A counter is also provided for number of packages produced. The unit also reminds the operator after a preset number of cycles to check the oil and water levels of the pneumatic system.

The operator interface connects directly to the programmable controller which is used to control all functions related to indexing and sequencing of the machine. Servo motor controllers are digitally controlled and can be adjusted through the interface display panel.

All bearings are either linear units running on hardened ground shafts or are sealed ball type. Framework of the machine is tubular steel welded construction with panels and guards to enclose open and operating parts.

For ease of access the machine is equipped with a two part sliding front guard system. These, together with a hinged electrical control panel on the rear of the machine, provide full exposure of the internal parts.

SPECIFICATIONS

Package Sizes:	Minimum -	3" wide, 4" length
	Maximum -	15" wide length to order 6" height
Film	Maximum -	33"
Drive Systems		Brushless Servo
Voltage		208/220V Single Phase 20 Amps 60 Hz.

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