kohmann

▸ **F-1120 Servo**
▸ **F-1440 Servo**
Window Patching Machine
for Cardboard Packaging

▸ **Open and versatile**

Fenstereinkleben
Futterstoffeinkleben
Faltschachtelkleben
Spezial
Gebrauch
Standard
Service
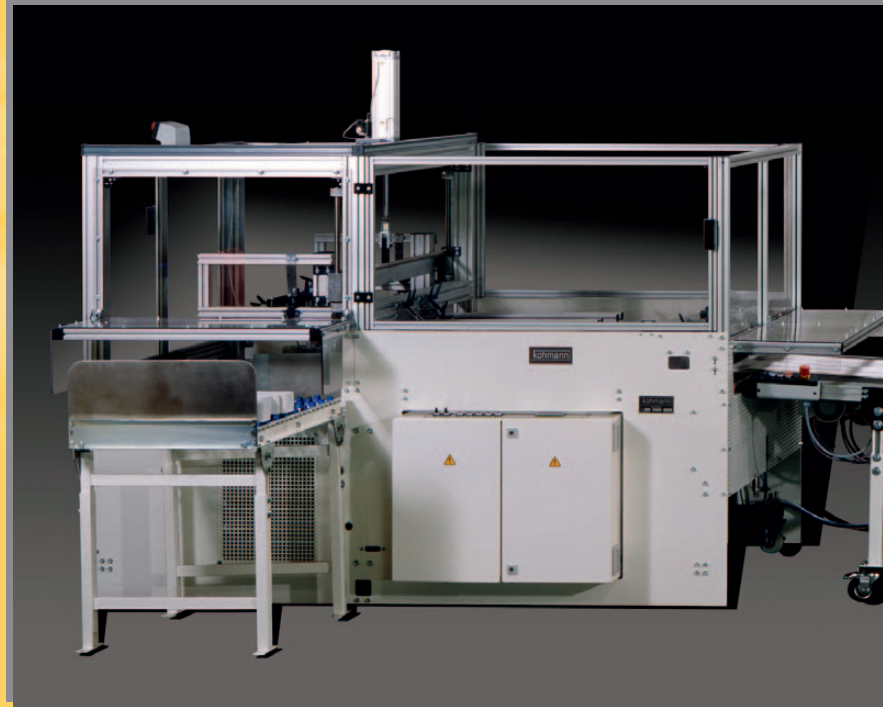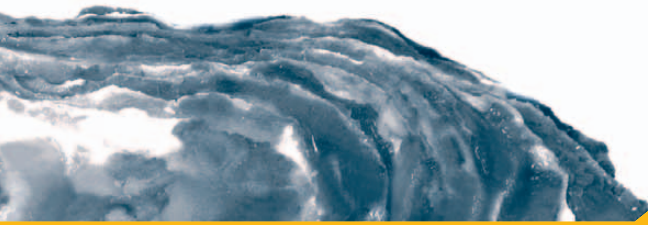
▶ Gigantically Expandable

Our window patching & lining machines are very easy to operate and to maintain and are made for high stress conditions. Besides the basic version we offer **more than 20 different designs** always suitable for various operations and multiply expandable.

The basic machine includes:

- servo technology for the timed belt feeder
- all cylinders are driven directly by servo motors
- glue unit with separate drive
- input and automatic adjustment of carton relevant dates are made via a large colour operator interface panel

- storage of more than 4000 carton data for repeat orders is possible
- Advance and retard of the stereo cylinder to the carton is carried out from the operator side
- Right/Left adjustment of the stereo cylinder is carried out from the operating side even with 2-stream operation
- max. 4-up operation possible
- Larger size ranges for 2up and 3up operation
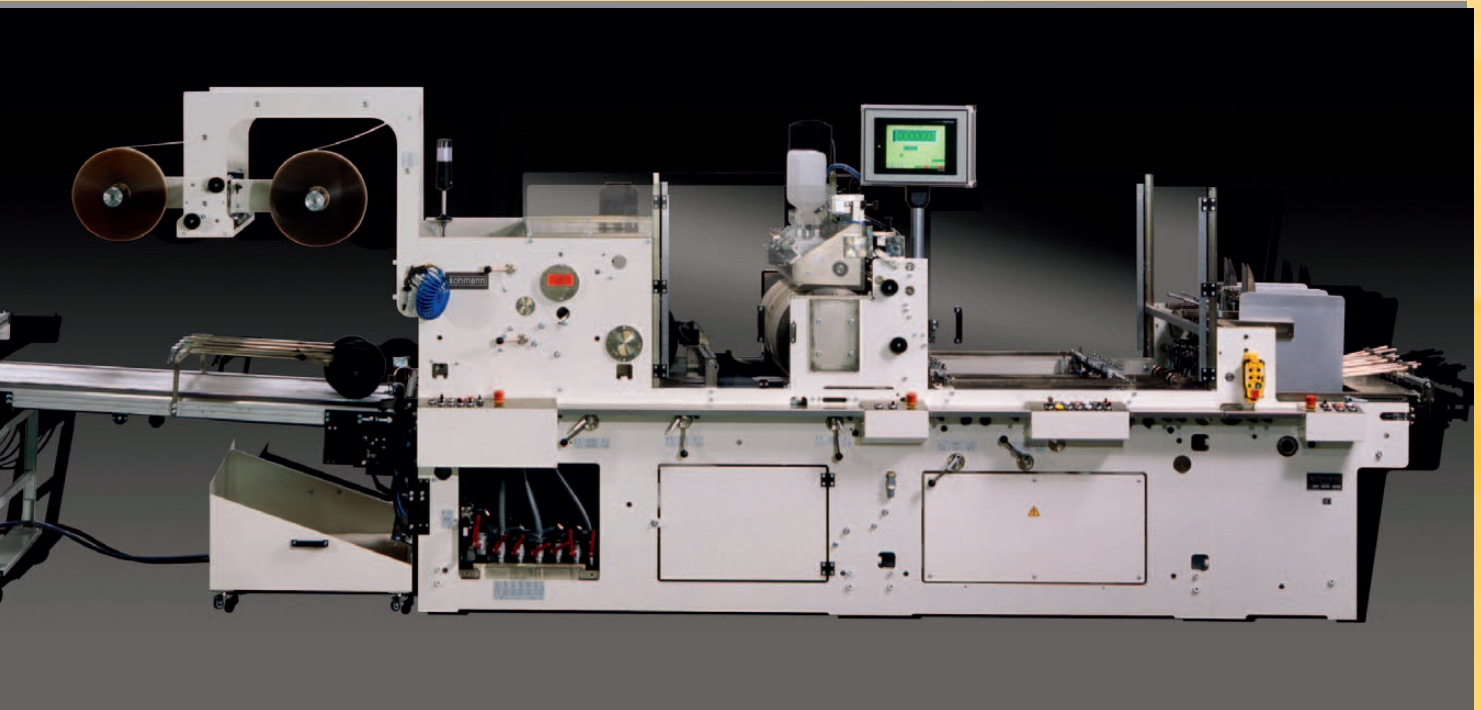
- Micro-fine adjustments of board to glue and foil position whilst machine is running
- Online maintenance via modem worldwide
- Up to 4 streams possible
- operator friendly
- high production quality
- minimum change-over times
- computer-driven production control system with automatic adjustment

- maintenance free drive concept
- the machine is accessible for adjustment and maintenance work
- Infinitely variable delivery speed by separate drive
- all-purpose due to the ability to add extra modular devices

▶ Customized Solutions:

- New high-speed belt lifting system decrease carton damage and increase optimal blank spacing at high speeds, servo driven with automatic speed compensation.
- Standard timed belt feeder with timed stack lifters. The adjustable lifters with timed suction will allow for all types and configurations of cartons. This feed will allow all solid board and up to 6 mm corrugated, servo driven with automatic speed compensation.

Subject to changes

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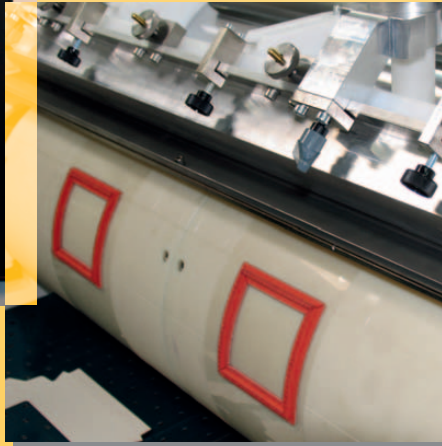
▶ Quality control systems

Our quality control system allows zero
defective cartons to the customer:

- double sheet control
- missing foil control
- missing sheet control
- jam-up detectors at all machine positions
- signalling and automatic kick-off
- machine data readable by PPS systems

▶ Details that make a difference

- The single roller glue unit with doctor blade
  and side dams allows the operator to put the
  glue only where it is needed. This small area
  of glue will not dry out in production. Clean-up
  is very quick. The glue unit slides out on tracks.
- Glue pads are made off line on a make ready
  table. Stereo mounting the foil is used to mount
  glue pads on and than the foil clips onto the
  stereo cylinder. These stereo blankets can be
  saved for future jobs.
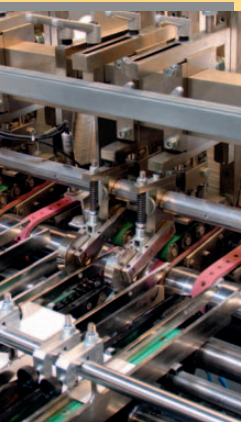
▶ Innovations

The programme for the PLC control developed by our engineers **controls and protects all machine functions:**

- Automatic setting programme of all quality control systems
- Suction belts drop in case of missing cartons
- Adjustable timed vacuum for feed belt
- Large production display

- Rate display in carton per hour
- Easy operation by multi function display
- Indication of incorrect operations
- Indication of security units
- Picture displays for set-up
- Online user manual
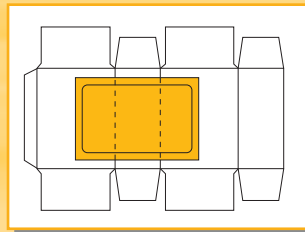- Picture displays for faults
- Many other functions

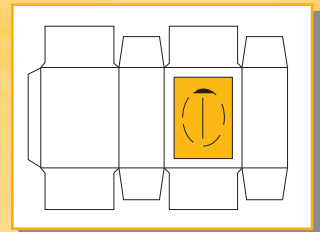Subject to changes

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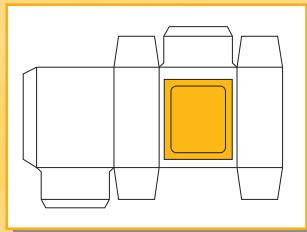
Normal window	Continuous perforation or creasing	Continuous perforation or intermittent length slitting
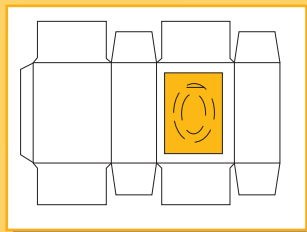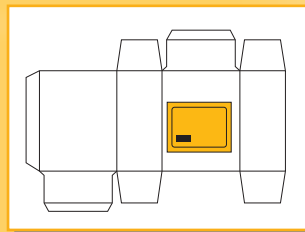
Form slitting	Pre-printed foil	Inner lining
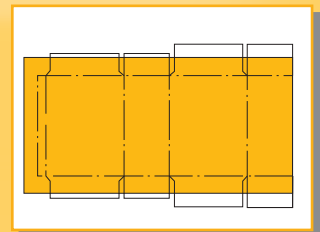
▶ Universal modular device

- Special feeder for special cartons
- Bag-in-box device for forming and sealing of inner tubes
- Continuously or intermittent running length cutting and perforating station
- Timed profile knife unit
- Photo-electronic register control for the converting of printed rolls
- Punching & scoring unit for windows glued over edges, coming from rolls or as pre-cut blanks
- Pre-feeder for cartons
- Handle applicator
- Special pneumatic unwind unit for big rolls
- Semi and fully automatic unwind systems available
- Automatic stacker with transfer station
- Many other functions

▶ Technical Data F-1440 Servo:
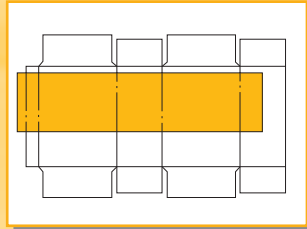
Format range, 1-stream operation			
		min.	max.
carton length,	mm	100	1230
	inch	$3^{15}/_{16}$"	$48^{13}/_{16}$"
carton width,	mm	80	1440
	inch	$3^1/_8$"	$56^{11}/_{16}$"
foil length,	mm	60	800
	inch	$2^3/_8$"	$31^1/_2$"
foil width,	mm	30	1130
	inch	$1^3/_{16}$"	$44^7/_8$"

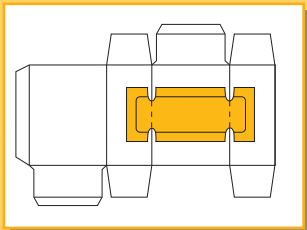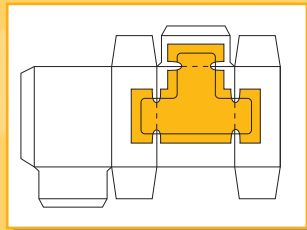| Format range, 2-stream operation		
carton width,	mm	705
	inch	$27^1/_8$"
foil width		depending on blank position
foil thickness		max. 300 microns
		min. 30 microns
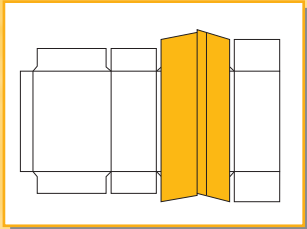
Sealed inner tube

Inner partition placement
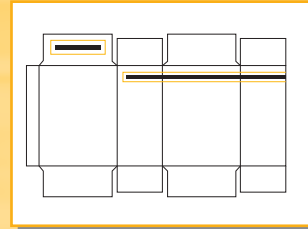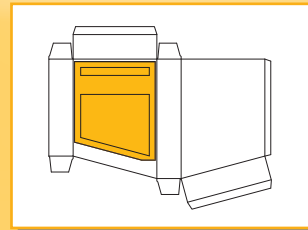

Carrier handle and/or tear strip

Scoring with punch-out coming
from the reel or as a blank

Scoring with punch-out
as blank

Oblique window

▶ ▶

F-1120 Servo:

Format range, 1-stream operation

		min.	max.
carton length,	mm	100	1230
	inch	$3^{15}/_{16}$"	$48^{13}/_{16}$"
carton width,	mm	80	1120
	inch	$3^{1}/_{8}$"	$44^{2}/_{16}$"
foil length,	mm	60	800
	inch	$2^{3}/_{8}$"	$31^{1}/_{2}$"
foil width,	mm	30	840
	inch	$1^{3}/_{16}$"	$33^{1}/_{16}$"

Format range, 2-stream operation

carton width,	mm	545
	inch	$21^{7}/_{16}$"
foil thickness		max. 300 microns
		min. 30 microns

Required Space

length,	mm	5500/5800
	inch	216"
width,	mm	1900/2200
	inch	82"
height,	mm	1700/1800
	inch	66"

Total power requirement

kW		approx. 34

Production Speeds (mechanical possible)

	1-stream	2-stream
1-up operation cartons over 610 mm	max. 200 pcs./min.	max. 400 pcs./min.
2-up operation cartons below 610 mm	max. 400 pcs./min.	max. 800 pcs./min.
3-up operation cartons below 385 mm	max. 600 pcs./min.	max. 1200 pcs./min.
4-up operation cartons below 270 mm	approx. 600-700 pcs./min.	approx. 1200-1400 pcs./min.

3- and 4-stream operation: values must be multiplied accordingly

Subject to changes

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▶ Our Product Range:

- Window patching machines for carton blanks
- Pick & Place window patching machines
- Folding box gluing machines
- Automatic stacking systems for
  – window patcher
  – narrow web flexo printing machines
- Compact disc sleeve machines
- CD/DVD tray placing machine
- Machines for special applications
- Film sealing machines for Gable Top Cartons

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