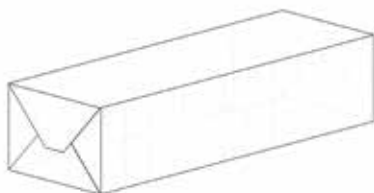


340/342 Stickpack Cut & Wrap Machines



**Individual Pieces
'on Edge'**



**Individual Pieces
'on Flat'**





The **340/342** is a medium speed cut and wrap stickpack machine, which has been designed for strength and durability as well as ease of operation and low maintenance. The machine sizes, shapes, cuts to length and wraps toffee, chewy candy, bubble gum or high boiled sugar in end or under fold style. The individually wrapped pieces are then collated into the desired number of pieces and over-wrapped into a 'stick', with heat sealed and folded ends. The '342' presents the products in flat pack, whereas the '340' machine provides an 'on-edge' presentation.

The machine is capable of up to 600 individual pieces/minute, or 180 sticks/minute.

Sequence of Operations

The rope of confectionery product is fed from an A.M.P Rose batch roller/sizer or an extruder to the infeed section of the machine. Two pairs of sizing rollers feed the rope into the infeed rollers and size it to the desired width and thickness. The presence of the rope is detected by a sensor which signals the paper feed to engage at the correct time, thereby avoiding wrapper wastage.

Paper feeding rollers provide the correct length of paper, which is cut-off by a rotary knife. The candy rope is cut to the desired length by a pair of water-cooled guillotine type knives and then pushed with the cut wrapper into the primary wrapping wheel.

The folds are initiated in the wrapping wheel and completed in the rake discharge.

The individually wrapped pieces are transferred through a collation unit, which gathers them into groups of the required number of pieces per stick. The outer wrapper starts to feed as the 'stick' of products enters the second wrapping wheel. The required length of wrapper is provided by feeding rollers and cut-off by the rotary paper knife. The 'stick' is then cross-pushed with the outer wrapper into the wrapping wheel where the stick-pack tube is formed. Double point end folds are made by ploughs and a rake discharge.

The longitudinal and end folds are sealed using heater blocks, with subsequent water-cooling. The heaters have digital controllers for accurate temperature control. The complete end-seal and folding unit can be easily accessed due to its hinged design, so any blockages or incorrectly wrapped packs can be removed.

Finished packs are discharged onto a belt conveyor.

Features

Long, efficient life

The machines have been designed to withstand the rigours of high-speed confectionery production. Precision-machined components are housed in solid frames and are constantly lubricated. External parts are designed for easy removal for cleaning and maintenance purposes. The machines therefore require little servicing, maintenance or spare parts.

Simple yet sophisticated control system

Control of the machine is achieved through a PLC system, which has diagnostic features such as warnings of paper ruffles or guards incorrectly positioned. All electrical and electronic components are of the highest international standards and are housed in sealed control panels with hinged doors for access. Operation of the machine is via the conveniently located push button controls.

Health and Safety assured

Electrically interlocked sound-proofed guards are used, affording protection to the user from noise and movement hazards. The machines meet current health and safety and 'CE' standards.

Automatic operation

The machines require minimal operator intervention – a sensor detects the presence of the incoming candy rope and automatically activates the paper feeding mechanism, ensuring no wrapping material wastage. Optional paper reel splicing units are available for additional automation.

To ensure that only complete packs are wrapped, on start-up and shut-down of the machine any pieces not making up complete sticks are removed by an air blast mechanism.

Reduced cleaning/maintenance times




The design of the guards makes it easy to access all internal and external areas of the machine cutting the time required for routine cleaning and maintenance to a minimum.

Versatility

The '340/342' can handle a wide variety of confectionery products, such as hard candy, caramel and toffee, chewy sweets and bubble gum with the minimum of adjustments. Change-over parts can also be supplied if a change in product size is required.



Wrapping Styles and Specifications

340 ('on edge' version)			
Style of wrap for individual:		Style of wrap (stick)	
Option 1	Option 2		
			
Maximum output: 600 individual sweets/minute Pack output is calculated by dividing 600 by the number of sweets per pack, to a maximum of 180 packs/minute			
Size Range:	Length:	Width:	Thickness:
Individual	16 to 32mm	11 to 25mm	Range 1: 7 to 9.5mm Range 2: 9.5 to 15mm
Stick	38 to 130mm	16 to 32mm	11 - 25mm
Number of pieces per pack 4 to 17 Subject to max. pack length of 130mm			




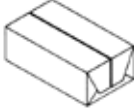

342 ('on flat' version)			
Style of wrap for individual:		Style of wrap (stick)	
Option 1	Option 2		
			
Maximum output: 600 individual sweets/minute Pack output is calculated by dividing 600 by the number of sweets per pack, to a maximum of 180packs/minute			
Size Range 1:	Length:	Width:	Thickness:
Individual	16 to 44mm	11 to 25mm	5 to 10mm
Stick	38 to 130mm	16 to 44mm	5 to 10mm
Size Range 2:	Length:	Width:	Thickness:
Individual	16 - 25.4mm	11 - 25mm	8 - 15mm
Stick	38 to 130mm	16 -25.4mm	8 - 15mm
Number of pieces per pack 2 to 10 subject to maximum pack length of 130mm			



Illustration shows optional third set of candy feed rollers.

Wrapping materials

Individual pieces

Waxed paper, cellophane, PVC, suitable polypropylene or paper back aluminium foil.

Stick Wrap

Various types of heat-sealing laminates, cellophane, PVC, waxed paper. The wrapping reels are fixed to the reel shaft using a quick release mechanism.

Reel Sizes

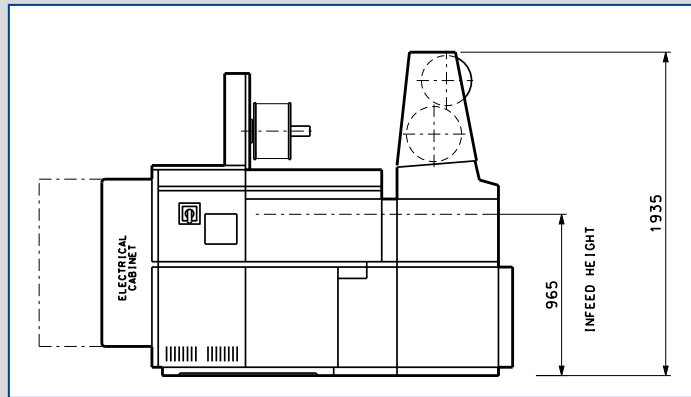
Standard core sizes of 57mm and 76mm. Other sizes available if required. Maximum outside reel diameter 355mm



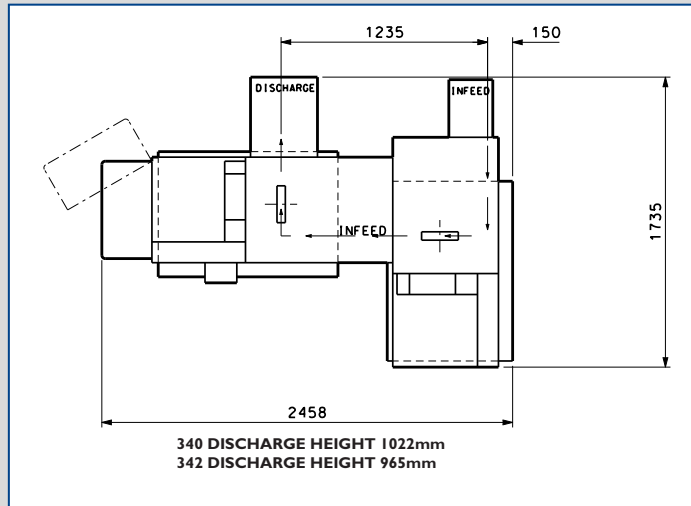
Options

- 3rd set of candy feed rollers.
- Heated candy feed for use with high boiled sugar
- Photo Electric Cell Registration on individual wrap (Standard for outer wrapper)
- Tear Tape unit on the outer stick wrap
- Date coder for outer wrapper
- Electronic link to up or downstream machinery
- Product/pack counter
- Automatic paper splicing units for individual/stick wrappers

Floor Plans



Front Elevation



Plan View

Technical Specifications

Power	Heaters	Chilled water	Nett Weight	Dimensions (mm)
Motor: 4kW Motor Controlled by an Inverter.	1.2kw	150 litres/hr @ max 15C	3000kgs	Case: 2770 x 1930 x 2200mm

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