

T-ONE Automatic Folder Gluer FFG2000

A. Feeding Section



- a. Computerized control, easy for operation and order change.
- b. Automatic adjustment of feeding baffles as per order.
- c. Receive paperboard from printer.
- d. Two more dust remover motor to clean cutting confetti.
- e. 1400mm longer arms.

B. Gluing Section



- a. Electric peristaltic pump used for glue pumping: Easy maintaining and lower cost.
- b. Gluing position adjust by motor.

C. Folding Section



- a. With new type folding structure: precise folding promises gap accurate.
- b. The two folding arms are motorized and also will be adjusted automatically when you set the order in the computer.
- c. Perforated main belts controlled by absorption blower to ensure smooth transition.
- d. Strengthened rigidity of the folding rail: strengthened lower rail and vertical steel plates on both sides, and completely eliminate the vibration when the paperboard passes.
- e. Folding belts speed on both sides is adjusted independently by independent motors as per different length and width.
- f. Equipped with independent speed-adjusted motor shaping belts on back part of folding section to reduce scissor deviation.
- g. Pressure of main belts on both sides, gap between upper and lower folding bridge are adjusted by independent motor.
- h. Independent correction servo motor equipped on back part of lower folding bridge to avoid influence from main belt. Equipped with 25 correction wheels on each side.
- i. Air cylinder applied on lower folding bridge for micro-adjustment to ensure shaping effect.
- j. Independent motor for belt adjustment on lower folding bridge and independent flapping motor.
- k. Four vacuum absorption blowers (two on each side) for stronger absorption.
- l. Independent servo motor applied to adjust both sides of folding bridge.
- m. Upper and lower folding arm moved by screw, upper and lower folding bridge moved synchronously.
- n. Linear applied on both sides of feeding and flapping to ensure stabler movement.

D. Counter Ejector Section



- a. Paperboard transit smoothly at high speed.
- b. Accurate quantity counting of boxes and eject bundle of boxes with several servo motor control.

- c. Strong fan installed on the top of counter ejector to avoid boxes inclined, and the fan mouth direction could be adjusted
- d. All kinds of glued cartons is ensured stable and smooth transition.
- e. Protection doors are automatically locked when folder gluer is running to ensure operation safety.
- f. Independent motor applied for counter ejector movement, matched with screw and linear.
- g. Racks applied for arms movement.
- h. Press blower and rubber plates is added.
- i. Press servo motor is applied on counter ejector section.

E. Control Panel

- a. HMI color touch screen for setting and also for false alarm.
- b. With remote control function.

F. Parameter Data

Length	15m
Weight	20.6 tons
Power	96KW (AC380V), 50/60Hz, 3 phase
Air flow	70/Litre (Air compressor 220V 1.5KW)
Flute	A, B, C, AB, BC, EB

G. Auto Folder Gluer Motor List

Description	Brand Name	Quantity
(1) Four-pole Inverter Motor	TECO	1PCS
(2) Servo Motor	SIMENS	3PCS
(3) Servo Motor	ANKA (CT)	5PCS
(4) Blower	GAO RUI	1PCS
(5) Gear Reducer	DALE	2PCS
(6) Reducer	CPG	7PCS
(7) Reducer	JING YAN	15PCS
(8) Blower	TAI OU	10PCS

H. Speed Limit Diagram

1) 10pcs/bundle

Scale: pcs/min

width \ Speed	110	125	140	155	170	185	200	215	230	245	260	275	300	325	350
900	○	○	○	○	○	○	○	△	×	×	×	×	×	×	×
800	○	○	○	○	○	○	○	○	△	×	×	×	×	×	×
700	○	○	○	○	○	○	○	○	○	△	×	×	×	×	×
600	○	○	○	○	○	○	○	○	○	○	△	×	×	×	×
500	○	○	○	○	○	○	○	○	○	○	△	×	×	×	×
400	○	○	○	○	○	○	○	○	○	○	○	△	×	×	×
280	○	○	○	○	○	○	○	○	○	○	○	○	△	×	×
260	○	○	○	○	○	○	○	○	○	○	△	×	×	×	×

○ Feasible

△ Theoretically feasible

× Not Available

2) 20pcs/bundle

Scale: pcs/min

width \ Speed	110	125	140	155	170	185	200	215	230	245	260	275	300	325	350
900	○	○	○	○	○	○	○	○	○	○	△	×	×	×	×
800	○	○	○	○	○	○	○	○	○	○	○	△	×	×	×
700	○	○	○	○	○	○	○	○	○	○	○	○	△	×	×
600	○	○	○	○	○	○	○	○	○	○	○	○	○	△	×
500	○	○	○	○	○	○	○	○	○	○	○	○	○	○	△
400	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
280	○	○	○	○	○	○	○	○	○	○	○	○	○	△	×
260	○	○	○	○	○	○	○	○	○	○	○	○	△	×	×

○ Feasible

△ Theoretically feasible

× Not Available

▲ SPECIAL NOTES

- a. Speed restriction occurs in the following cases:
- b. Feeding length (H dimension) and piled (batch) blanks;

Operating conditions, such as:

- a. Sheet flat
- b. Printing area and state
- c. Air temperature
- d. With/without water repellency or degree of water repellency
- e. Die-cutting shape
- f. When feeding length (H dimension) of the blank is long or depth of the box is deep, the operating speed may have to be reduced to keep the specified folding accuracy in the folding area.

A) Machine Speed		1.8 Model	2.0 Model	2.4 Model	2.8 Model
Max speed		350pcs/min	300pcs/min	250pcs/min	230pcs/min
Carton length(L2)	Max	550	700	750	800
	Min	135	180	180	200
Carton width(W1)	Max	500	650	700	750
	Min	120	150	150	150
L2 + W1	Max	870	1000	1200	1400
	Min	285	330	335	350
L2:W1	Max Ratio	2:1	2:1	2:1	2:1
Carton widthD2)	Max	600	900	1200	1200
	Min	230	280	300	300
Paste width(mm)		25-30	30-40	30~40	30~40

