HHA6002070

Automated High Speed Food Packaging System

The Form Plastics Company HHA6002070 is the most durable, versatile, safe and efficient food packaging machine in the industry. The dual lane conveyor has adjustable pockets with sliding tray supports which allow you to seal 20 different tray styles with one machine at speeds up to 6000 trays per hour. The HHA6002070 is engineered to include the most complete set of safety features available. The length of the machine can be customized (in 4' increments) to fit your production requirements.

Our compact, variable speed Lazy Susan, model #LS100 will save space in your production area. The design provides for economy of motion, and will enhance production efficiencies.

Lid 20 Tray Styles with One Machine!

Simply by sliding the flight, you can alter the conveyor pocket size enabling you to lid snacky packs, hoagies/subs, a variety of entrees, club and cut sandwiches!

FORM PLASTICS COMPANY
3825 STERN AVENUE ST. CHARLES, IL 60174
630/443-1400 fax: 630/443-1492
www.formplastics.com
"Your Complete Packaging Solution"

Working Together for a Safer Work Place

The HHA6002070 Lids up to 6,000 Trays Per Hour!

INTERCHANGABLE POSITIVE TRAY DISCHARGE RISERS

Accommodates different tray widths.

LEVEL SWITCH

Shuts the entire system down when hood is raised, exposing rotating cutting blades. Steel guard at discharge area of machine protects operators.

SINGLE FILM ROLL ACROSS DUAL LANES

Single film roll seals both lanes. Machine slits film between lanes reducing change over and film waste.

CYCLE STOP STRIPS

Cycle stop strips run the length of the loading area on both sides and are easily activated by pressure at any point. Immediately stops the conveyor.

FILM THREADING

Simple and easy film threading. Minimal film to start means less waste.

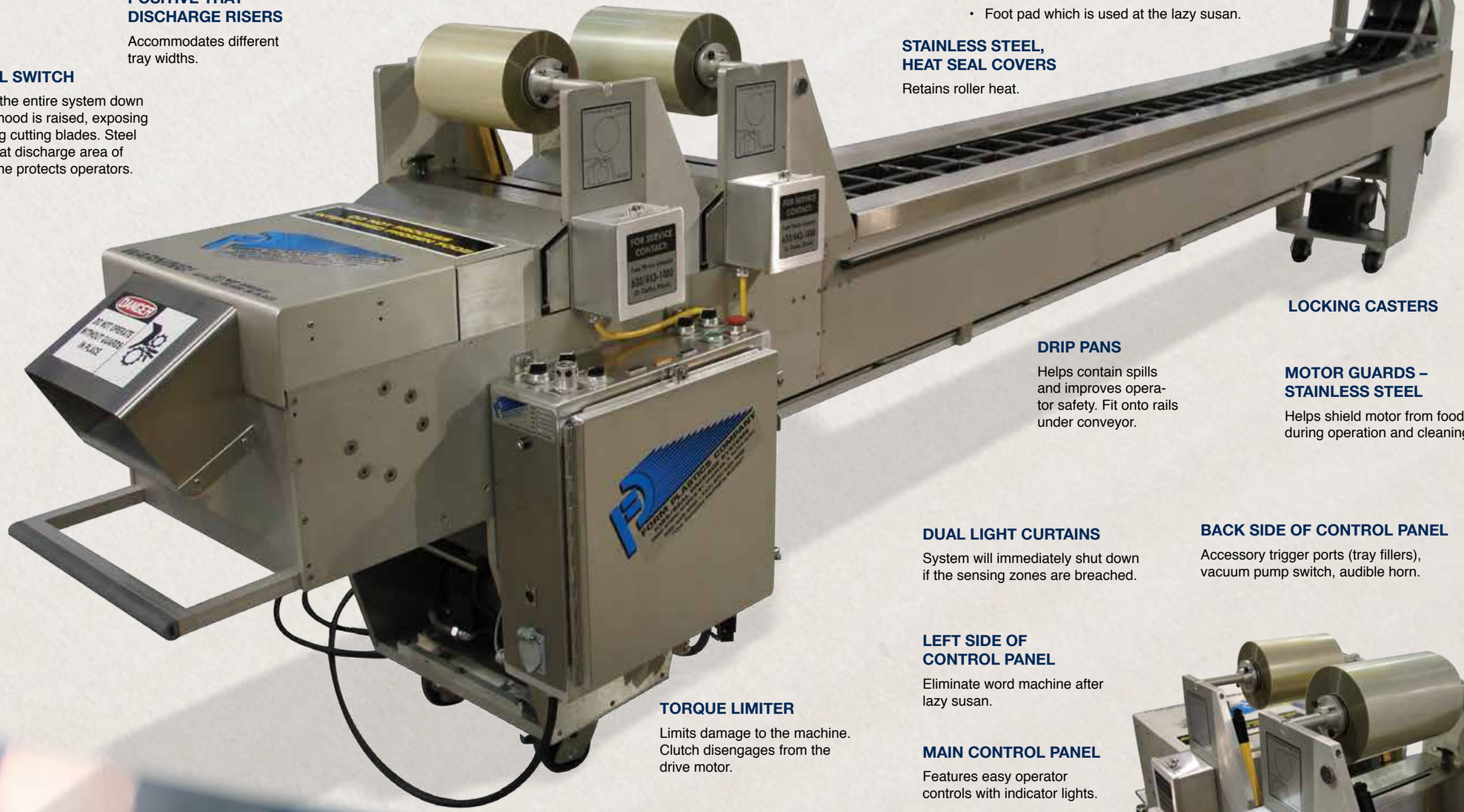
ELECTRONIC BRAKING SYSTEM

Stops the conveyor instantly when any of the following occurs:

- Cycle stop strip is pressed
- Light curtain is breached
- Hood is raised activating level switch
- System shut down from main control panel (estop button) Foot pad which is used with the Lazy Susan
- Electronic braking system.
- Foot pad which is used at the lazy susan.

STAINLESS STEEL, HEAT SEAL COVERS

Retains roller heat.



T200 TRAY DENESTER

Mounted directly onto and fully Integrated with HHA600. Dispenses trays onto line via vacuum power. Easy to load. Quick change manifolds for different trays. Includes safety hood.

FLIGHT GUARDS

Stainless steel guards cover tray flanges during filling, making post-production cleaning easy, and protects roller from food debris.

120V

Low cost installation. No special power requirements.

LOCKING CASTERS

DRIP PANS

Helps contain spills and improves operator safety. Fit onto rails under conveyor.

MOTOR GUARDS – STAINLESS STEEL

Helps shield motor from food/water during operation and cleaning.

DEDICATED VACUUM SUPPLY

Dedicated supply improves tray dispensers accuracy.

TORQUE LIMITER

Limits damage to the machine. Clutch disengages from the drive motor.

DUAL LIGHT CURTAINS

System will immediately shut down if the sensing zones are breached.

BACK SIDE OF CONTROL PANEL

Accessory trigger ports (tray fillers), vacuum pump switch, audible horn.

LEFT SIDE OF CONTROL PANEL

Eliminate word machine after lazy susan.

MAIN CONTROL PANEL

Features easy operator controls with indicator lights.

RIGHT SIDE OF CONTROL PANEL

Communication ports (fillers-tray, labelers, printers), Vacuum pump switch, Audible horn (machine is jammed).

HHA6002070

Specifications

Overall Length	Conveyor Width	Width Including Electrical Box	Height to Conveyor	Height at Highest Point	Height to Control Panel
21'.5"	20"	27 ¼"	36"	66"	33"

TRAY SPECIFICATIONS 5" x 6½" plastic meal trays (1, 2 or 3 compartment) as well as snack trays hoagie trays and wedges. Sealing speeds up to 100 trays per minute, average sealing speed is 60 trays per minute. Conveyor flight pockets are designed to accommodate these specific size film-sealable plastic trays.

CONSTRUCTION Stainless steel, acrylic, and aluminum guards and covers enclose all pinch points and open areas. All bolt heads are flush mounted to the machine frame eliminating possible injury, difficulty in cleaning, etc. No exposed bearings to leak oil and grease. All wiring is interior mounted.

Aluminum plate, clear anodized
Frame . . . . . ½"
Uprights . . . . . ¾"
Legs. . . . . ¾"
Cross members . . . . . ¾" & 1"

MOBILITY HHA6002070 has (4) locking casters for easy mobility and placement.

CONVEYOR FLIGHTS Sixty eight (68) 7" x 13" x ¾" thick, double - pocketed flights mounted on 7" centers.

FLIGHTS Conveyor flights are non-gasketed and permanently mounted to conveyor chain from the backside of the flight. Permanently mounted flights maintain factory set tolerances requiring minimal maintenance. Conveyor flights have a smooth sealing surface allowing for quick cleaning and maximum sanitation.

DUAL FLIGHT INSERTS The conveyor flights function as nesting pockets for aluminum inserts. The permanently mounted inserts sit inside the conveyor flights and, when slid into place, are locked into place with non-removable locking pins to accommodate 3 ½" x 6 ½" trays

CONVEYOR CHAIN The conveyor chain, made of coated steel, is completely covered on top to maximize sanitation and safety of operation.

BEARINGS Bearings are mounted on the interior of the machine. Machine is equipped with quick lubrication "zirk" fittings for easy maintenance.

HEAT SEAL ROLLER Each heat seal roller is a hollow aluminum core with 1/8" high temperature silicone cover.

FILM TENSIONER The film tensioner is placed adjacent to the roll of heat seal film on the film arbor, facing the operator side of the machine. As the heat seal film roll gets smaller, the tensioner is used to add or lessen the tension on the film roll to ensure a proper, consistent seal with no wrinkles.

AUTOMATIC TEMPERATURE CONTROL FOR HEAT SEAL ROLLERS Factory precision set, non-operator adjustable temperature controller with digital temperature display. Controller automatically monitors and maintains heat seal roller temperature eliminating the need for operator involvement. Heat seal roller temperature does not need adjustment for different sealing speeds or product

SEALING FILM CUTTING HEAD ASSEMBLY Factory mounted, timed, and keyed with four (4) stainless steel serrated cutting blades; two (2) ½ moon slitter blades and two (2) straight blades.

CUTTING HEAD Four (4) half-moon solid aluminum cylinders designed to hold trays in position while sealing film is scissor cut by four (4) blades in the continuous motion cutting head. The cutting head is factory adjusted and timed. Adjustment during normal operation is usually not required.

SEALING FILM SLITTER The stainless steel serrated slitting blade is mounted in the center of the cutting head. This design allows for a single-dimension roll of sealing film. This eliminates the need for two individual rolls of film, film wrinkling, and staggering roll changes when using multiple rolls of film.

INTERCHANGEABLE POSITIVE TRAY DISCHARGE Interchangeable lifters on the discharge drum automatically lifts trays out of the flights, allowing trays to slide out of the machine on the discharge plate.

AUTOMATIC HEAT/SEAL ROLLER LIFT; DUAL HEAT SEAL STATIONS The hollow heat seal rollers are air operated. The active heat seal roller automatically engages in the down position during the heat-sealing operation. The inactive heat seal roller automatically retracts to the up position. Both heat seal rollers retract to the up position when the machine is off.

CHAIN DRIVE The chain drive consists of single link chain driven by single sprockets for reinforced operation.

CONVEYOR DRIVE MOTOR Variable speed, reversible 7.9 AMPS DC drive motor, ½ horse power.

CONVEYOR START SEQUENCE The conveyor is equipped with a two (2) second start delay. When the "START" button is depressed, a buzzer will sound for two (2) seconds prior to conveyor movement warning users of upcoming conveyor movement. The control panel light bar is equipped with a solidly-lit green light indicating that the conveyor is in motion.

VISUAL LIGHT INDICATORS The visual light indicators are mounted on top of the control panel on a highly visible light bar. There are three (3) different colored lights: Red, Amber, and Green. The red light indicates the machine is turned on. The amber light is continuously lit while the heat seal roller is heating. The amber light will flash when the heat seal roller has achieved the proper sealing temperature. The green light is continuously lit when the conveyor is in motion.

SAFETY FEATURES A level switch is located in the discharge cover and automatically stops the conveyor when access to this area is attempted. Double-walled stainless steel guard protects the heat seal roller station and limits operator access.

Additional guards have been installed on several other areas of the machine to limit access: motor, infeed cover, discharge cover, flights.

An emergency stop button is located on the control panel allowing the operator to stop the conveyor for any reason. The stop button must be manually reset prior to initiating restart of the conveyor ensuring the operator has taken all necessary safety precautions.

Cycle stop strips run virtually the entire length of both sides of the machine. Only four (4) pounds of pressure is required on any spot of the strip to instantly stop the conveyor from advancing.

A micro switch foot pad is located on the floor by the lazy susan accumulator, at the discharge end of the machine. Just a tap of the foot will instantly stop the conveyor from advancing.

Fast Stop Dynamic Braking instantly stops the machine if any safety systems are activated; i.e., level switch, emergency stop, cycle stop strips, infrared safety guarding device, torque limiter.

Infrared Safety-Guarding Devices are located in front of both heat seal roller stations. Should anything (i.e., hands, foreign objects) breach the infrared safety shields, the conveyor will instantly stop.

The machine is equipped with a torque limiter. It instantly disengages the conveyor when it meets with any resistance not part of the normal process. This prevents the machine from trying to force advancement and jamming the conveyor. Benefits include less down time, reduction in flight breakage, and less impact on the roller extending its lifetime.

The precision temperature control unit on the heat seal roller has a safety circuit to prevent the roller temperature from rising above the factory set temperature limiting any potential damage to the roller.

A key switch, located on the side of the control panel, is used to override safety breaches and allows the machine to be used in jog mode only. This is especially helpful when cleaning and servicing the machine.

CONTROL PANEL Water resistant construction protects all electrical components. Dual fuse design separates conveyor and heating circuits.

The control panel height is only 33" and located on the outside of the machine for easy operator access.

POWER ON SWITCH The red light on the control panel illuminates when the machine's power is turned on.

CYCLE START SWITCH The start switch is recessed as a safety precaution preventing it from being depressed accidentally.

FORWARD/REVERSE SWITCH Reverses the conveyor direction but does not affect the forward speed setting. This is especially useful when cleaning the machine. The reverse speed is factory set at a slow speed and cannot be adjusted.

SPEED CONTROL Adjustable speed control allows the conveyor speed to be adjusted to match production rates.

EMERGENCY STOP SWITCH Instantly stops conveyor when depressed.

HEAT ROLL ON-OFF SWITCH Heat on-off switch activates heaters for selected heat seal roller (station #1 or station #2) while maintaining power to the conveyor.

HEAT SEAL ON - #1, #2 SWITCH This switch controls the heat seal roller lift operation. The active heat seal roller automatically engages in the down position during the heat-sealing operation. The inactive heat seal roller automatically retracts to the up position. Both heat seal rollers retract to the up position when the machine is off.

JOG SWITCH This switch activates the conveyor (forward/reverse) in small increments as long as the button is depressed. The jog switch is utilized when cleaning, threading film, etc. The jog speed is factory set at a very slow speed and cannot be adjusted.

TRAY DISPENSER The tray dispenser is constructed of anodized aluminum with stainless steel hoppers. Designed with interchangeable manifolds, each tray being sealed has a specifically designed manifold, allowing for precision dispensing. This dispenser is designed to dispense only 5 x 6 ½" plastic trays.

VACUUM PUMP SYSTEM FOR DISPENSER Oil-less vacuum pump, 6 CFM, 25" Hg, .44kw, 110 volts has a totally enclosed fan-cooled motor, 5 micron inlet filter, vacuum regulator valve, exhaust silencer, and a noise level of 61 dBA. Vacuum pump system also includes a receiver tank.

Optional LAZY SUSAN ACCUMULATOR The lazy susan accumulator is located at the discharge end of the machine and provides for efficient handling of the filled, sealed trays. It has a variable speed controller that can be adjusted to match production rates. Anodized aluminum and stainless steel construction; 35 ½" diameter PVC top, 4 casters (2 locking).

COMMUNICATION PORTS There are three (3) communication ports located at the control panel of the machine, for use with tray filling systems.

SPK HHA6002070 Spare Parts Kit for the HHA6002070

SPKT200 Spare Parts Kit for the T200 Denester

MINIMUM REQUIREMENTS to be supplied by customer

ELECTRICAL 60 Hertz, single phase, 120 volt, 20 AMP circuit; NEMA type 4 plug configuration. Machine includes an 8' power cord. Electric to be supplied by customer. NEMA #5-20P plug.

AIR Minimum pressure at machine: 90 PSI, 7 CFM. Air must be clean and dry at the machine. Air to be supplied by customer.

Form Plastics Company
3825 Stern Avenue • St. Charles, IL 60174 • 630.443.1400