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P/96E_XXL

MOLDING MACHINE FOR BIG BRA CUPS IN FABRIC WITH TWO MOLDS AND ROTARY TABLE

MOLDING MACHINE FOR BIG BRA CUPS WITH TWO MOLDS AND ROTARY TABLE P/96E_XXL

The machine P/96E_XXL is a high productivity two molds unit with rotary table that can mold different types of fabrics (cotton, elastomeric fabrics, micro fibres, multi-layer fabrics) including pre-cut pieces (i.e. cups with the shape to be sewn on the bra, no need of die cutting after molding) and in some cases even the finished garment (post-molding).

The unit is equipped with an industrial PC where you can store all the thermoforming parameters for each individual article, color and size.

TECHNICAL FEATURES

- Machine consists of a rotary table with two loading/unloading stations and two molding stations on the opposite side.
- The operator positions the pieces on the two loading/unloading areas while the machine is molding the pieces on the remaining two stations.
- The molding cycle consists of the descent from the top of a heated bell to keep uniform the temperature around the fabric and then a heated mold moves upwards for molding the cup.
- This exclusive system reduces the molding time to 25 - 35 sec or even less.
- Once the cycle is finished, the table turns of half revolution to enable the loading/unloading of the thermoformed pieces while the machine is molding the new materials. The total cycle time is about the same of the molding time as the machine does not wait for the positioning of the pieces and therefore the productivity is much higher than machines without the rotary table.
- Upward / downward movement of the molds with a wormscrew (electric cylinder) controlled by brushless motor with the possibility of programming at the terminal the cup depth and the speed of rise of the mold during thermoforming into the upper oven.
- All thermoforming parameters (time, temperature, position, speed of rising molds, pressure of the upper oven) are programmable by operator panel with industrial PC functions.
- A production supervisor has the possibility to load into the machine memory a data base with all the thermoforming parameters available by article, fabric, color and sizes.
- All setting of temperature and times are adjustable with digital timers and thermoregulators.
- Machine equipped with PLC and operator terminal to set machine data and display alarm messages.
- The operation of changing a mold and/or a disk is easy and fast, no need to do any electrical connection.
- Presettable timer for automatic start-up and shut down of the unit standard on the machine.

TECHNICAL DATA

- Maximum diameter of the mold : 300 mm (11" $\frac{3}{4}$)
- Maximum height of the mold (3D part) : 200 mm (4")
- Minimum diameter of the mold : 140 mm (5" $\frac{3}{4}$)
- Upper disc diameter..... : 400 mm
- Maximum molding temperature : 250°C.
- Installed power : 20 kW 400V $\pm$ 5% 50 Hz Three phase + Neutra + Ground.

- Compressed air: 6 bar minimum (200 lt/hour).
- Size changeover time: 3 min (with preheated molds)