

## **Bulk Bin Laminator Operation and Specifications**

Crittenden Conversion Corporation Bulk Bin Laminators are custom built to customer specifications, overall size and configuration are relative to maximum box size and plant layout. The following performance specifications are based on a typical machine and may vary due to customer requirements.

**Production:** 5 boxes/minute

**Crew:** 2 persons minimum, 3 recommend

**Score registration:** +/- 0.030 inches

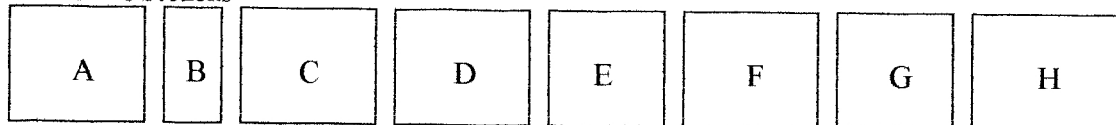
**Score program memory:** 100 programs

**Box path height:** 72 inches for floor

**Liner lift capacity:** 6000 pounds

**Box lift capacity:** 8000 pounds

Machine Sections



**A. Liner Lift:** Hydraulic four post leaf chain lift with hydraulic driven conveyor.

**Operation:** Liners (inner) are conveyed on to lift from end or side. Photo-eye automatically controls level of lift.

**B. Feeder / Gluer:** Hydraulic driven, pneumatic actuated rubber feedroll. Hydraulic driven roll coat gluer (Black Brothers).

**Operation:** Feeder moves liner from top of stack into gluer. Glue is applied to bottom of liner.

**C. Box Lift / Back Stop:** Hydraulic four post leaf chain lift with hydraulic driven conveyor. Hydraulic and pneumatic actuated placement stops with hydraulic driven vertical feed belt. Hydraulic actuated scissor lift for operator.

**Operation:** Boxes (outer) is conveyed onto lift from operator side. Operator locates box in stops, receives liner from gluer, locates liner on box with stops, stops then retract and operator feeds box (belt assessed) into compression section. Photo-eye automatically controls level of lift.

**D. Two Station Compression:** Hydraulic four post leaf chain lift with two stacked compression stations. Stations have hydraulic driven belt conveyors and pneumatically clamped, vinyl covered foam compression pads.

**Operation:** Receives box with liner into station one as laminated box/liner exits, lift moves station two into position to receive next box/liner, then returns to station one.

**E. Score Section:** Electric servo controlled feed conveyor and pinch rolls with hand held control for programming score positions. Hydraulic actuated score bars with changeable score profiles.

**Operation:** Receives laminated box/liner from compression section onto conveyor with straightening guide. Box/liner proceeds through score bars stopping to score at programmed locations. Box/liner exits on conveyor with guide.

**F. Folder:** Hydraulic driven conveyor belts and pneumatically traversed glue extrusion heads. Vacuum box holding system with hydraulic actuated folding arms.

**Operation:** Box/liner enters from score section, glue is applied to lap joint, box/liner is folded and is then conveyed into the compression section.

**G. Four Station Compression:** Hydraulic four post leaf chain lift with four stacked compression stations. Stations have hydraulic driven belt conveyors and pneumatically clamped, vinyl covered foam compression pads.

**Operation:** Receives folded box into station one as joined box exits, lift moves station two into position to receive next folded box, then station three and station four, then returns to station one.

**H. Work Station / Down Stacker:** Hydraulic driven belt conveyor, UHMW work table and hydraulic actuated scissor lift with hydraulic powered conveyor.

**Operation:** Conveyor receives joined box from compression section and transfers it to work table. Operator will rotate box as needed and use corner stop to locate box on down stacker. When stacker has a full load the conveyor will move it off and stacker raises to accept next box.