



ROTARY MOULDER RM 15



POLIN
INDUSTRIAL LINE



□ ROTARY MOULDER





Starting from a dough batch, the machine moulds biscuits by compressing the dough into moulds, which are machined on the surface of a moulding roll.

The rotary moulder is basically made by a dough hopper with a Grooved feed roll and a bronze Moulding roll.



Biscuit weight is modified by varying the position and the working angle of a stainless steel knife and the gap between grooved and moulding roller.

Combined action of the extraction web and dual durometer rubber roll detach the moulded product delivered on the down-line conveyor.



The machine structure is made of two 50 mm thick steel plate side-frames contributing to the great rigidity of the assembly and providing machined housing for the rolls and the various components.

The hopper is automatically tilted over to permit quick replacement of the moulding roller.

The machine is provided with three independent variable speed drives by inverter: one for the grooved roller, one for the moulding roller and the third for web driving, by means of a fourth rubber roller. All motor-gears are outboard of frames for easy access, directly coupled to the shafts, chain free.

The conveyor web is equipped with pneumatic tensioning and tracking systems, a cleaning scraper and an orthogonal scrap conveyor.

PLC control with on board 12" touch screen" Operator panel as HMI, with enhanced graphics, recipe management and advanced alarm checking, with possibility of up-graded SCADA

Automatic control via servomotors of grooved and moulding roll gap, rubber roll pressure, position of knife, angle of knife.

Automatic blocking of moulding roll, without tools.

Stainless steel covers with plastic windows.

Features

Easy to use

Rapid easy changeover of moulding roll with pneumatic control; intuitive controls for rapid start-ups.

Easy to clean

Special design for easy access and fast cleaning and maintenance; no horizontal surface and niches for allowing debris to fall to the floor.

Great outputs

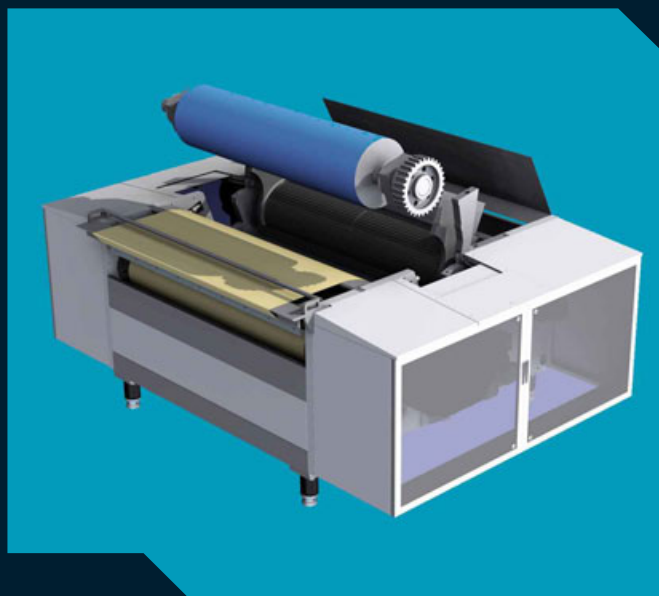
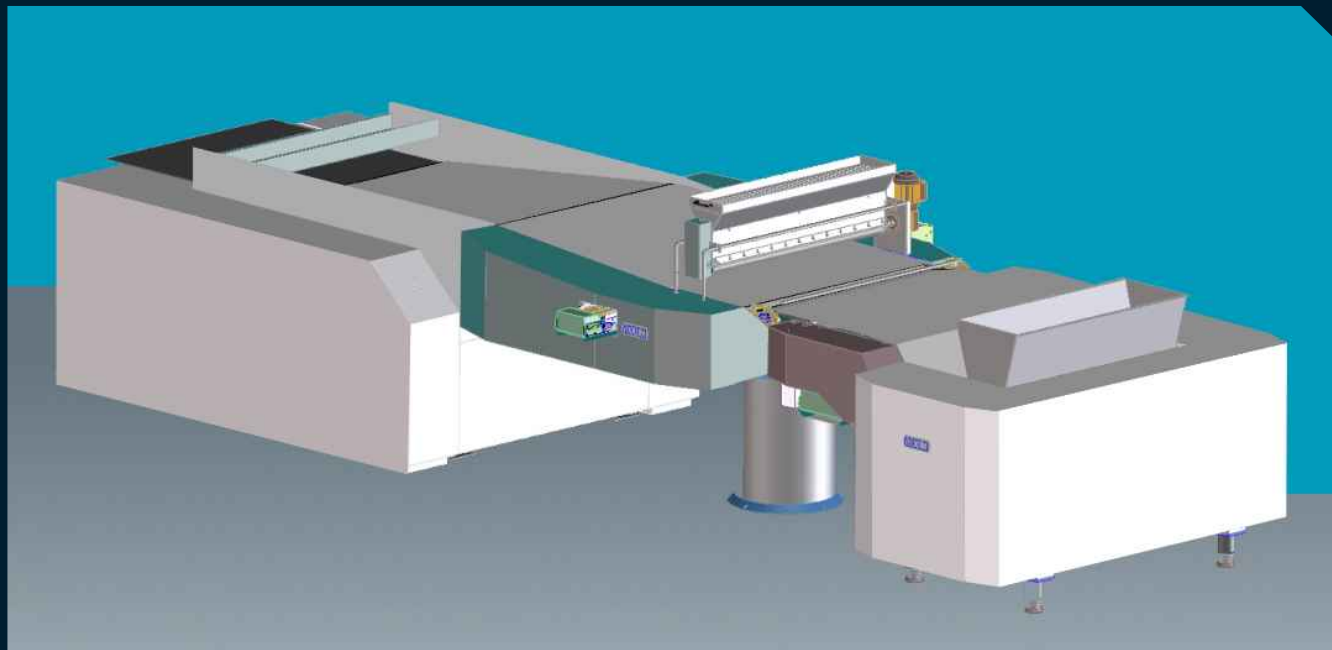
Large diameter grooved and moulding rollers allow great capacities with oven up to 120 m.

Oven feeding assembly

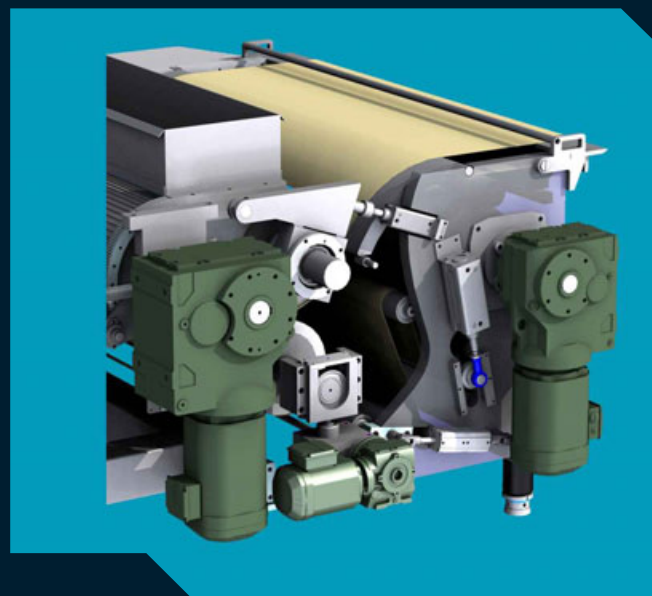
A swivel panner is installed to provide the final transfer of dough from the Rotary moulder accurately onto the oven band. Activated by band follower rollers, the unit follows the tracking of the oven band, ensuring accurate centralized positioning of the product before baking.

Aluminium side frames with provision for the mounting of a Sugar sprinkler over an independent drive wire-mesh or plastic web with excess recovery system by cross conveyor.

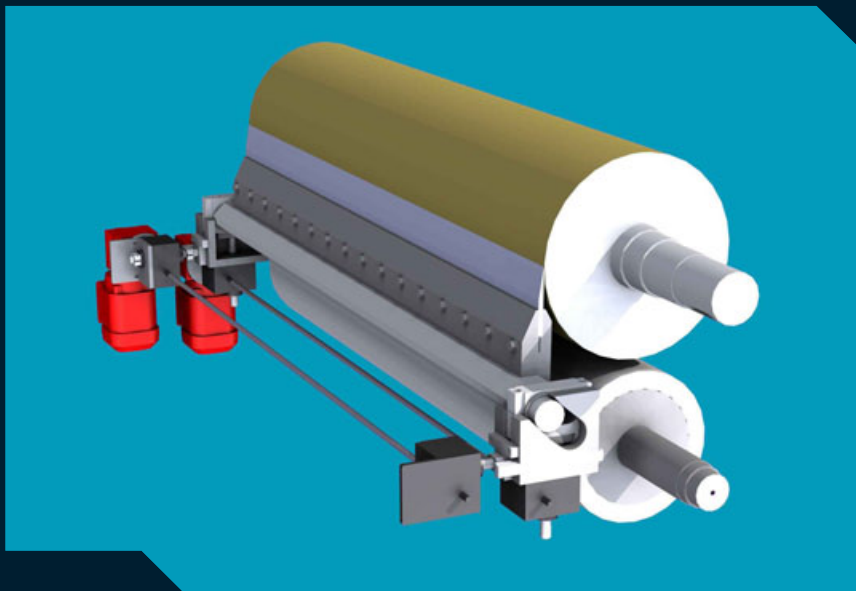
Provided with pneumatic controlled web tensioning and tracking.



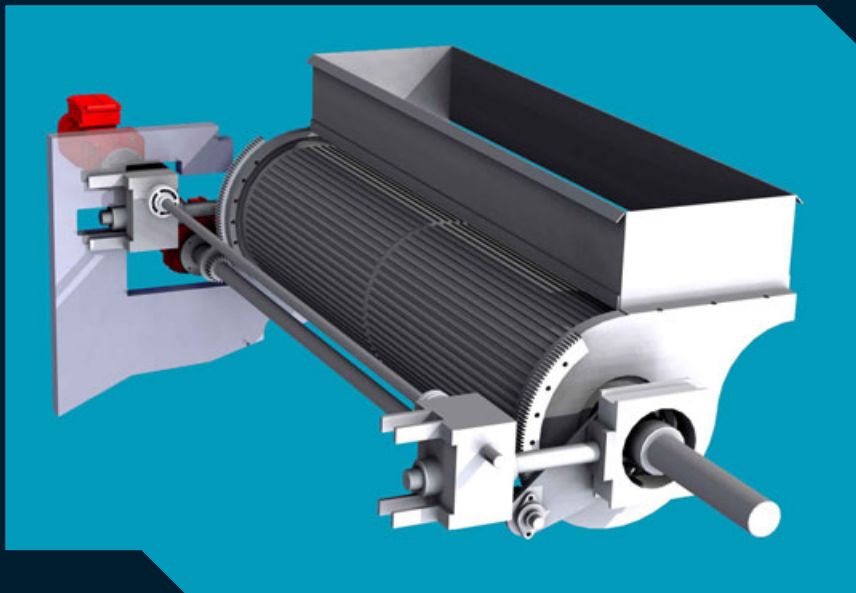
☐ ☐ Moulding roll automatic move



☐ ☐ Servocontrol system



☐ ☐ Knife positioning double automatic control



☐ ☐ Grooved feed roll automatic gap control

☐ Fully automatic adjustable machine

Independent feeding and moulding roll drives enable to vary relative speeds to suit product characteristic such as thickness and dough texture.

The independent web drive ensure that web tension is reduced thus improving extraction and dough texture

Sharp and hardened knife, fitted on a rigid holder for long term lasting and optimum weigh accuracy.

A fast web change reduce maintenance costs and downtime

No chain drives and external drives allow easy cleaning and maintenance

Built-in "Touch screen" Operator panel for rapid, easy control and response to problems

Automatic controls

Grooved feed roll speed

Moulding roll speed

Web speed

Knife position (angle and height separately)

Grooved roll gap (side to side on demand)

Extraction roll pressure (side to side on demand)

Web tensioning

Web tracking

Hopper tilting

Easy access to moulding roll (with quick changeover without tools)

Benefits

Better weigh control

Better shape control

Wider range of products (including low fat biscuits)

Faster start.up

Quicker product change over

Less scraps / fewer tailings

Easy product management by recipe control on Operator Panel





□ Sugar sprinkler

The unit sprinkles uniformly granulated sugar, castor sugar and other products, small pieces of nuts, almond flakes, sesame seeds, poppy seeds and various spices, changing the sprinkling roller.

It consists of a stainless steel hopper containing the product. A variable speed knurled roller at its bottom performs product dosing through a

slit opening, the height of which is infinitely adjustable, controlling the exact sprinkling amount.

It is placed over a continuous running conveyor of wire-mesh or plastic web normally built-in on the swivel panner.



□ Washover attachment

The washover attachment is used for the application of egg-wash sugar/water or other liquids on the biscuits before baking, to obtain the characteristic golden colour of the baked product.

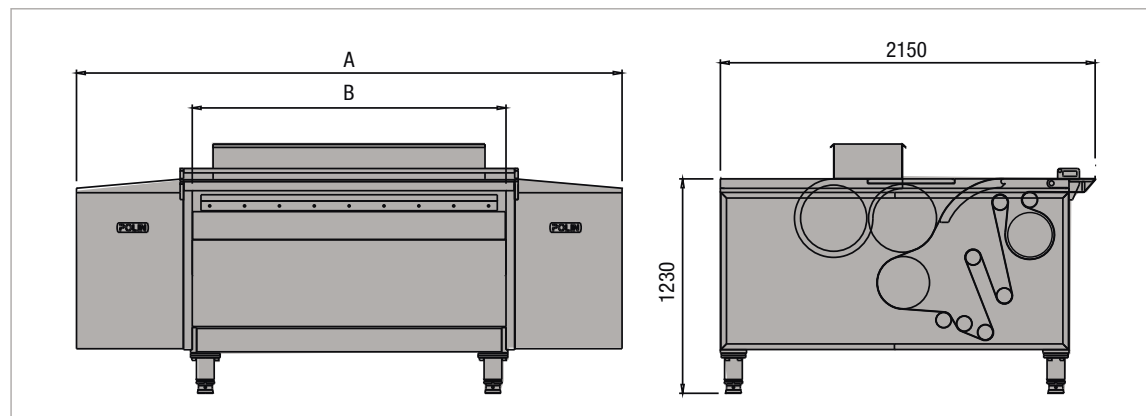
The unit consists of two stainless steel rolls driven by a single variable speed drive. The first roll is partially dipped in the emulsion to be spread, the second roll is for transferring the

emulsion, which is distributed on the product by a third stainless steel roll or a washing nylon brush.

The washover attachment is equipped with a top container to be fed manually or automatically by means of a built-in level control.

□ Technical features

Working width	1.500, 1.600 and 1.800 mm
Grooved feed roll	390 mm diameter
Moulding roll	390 mm diameter
Anvil pressure roll	300 mm diameter
Drive roll	280 mm diameter
Roll gap adjustment	from 4 to 12 mm
Diameter of web nose bar	6 mm
Web	resin-coated cotton
Surface treatment of feed roll	chemical nickel coating



Ancillary equipment to be coupled

- Product detachment roller
- Web humidifier
- Hopper extension with kibbler unit
- Washover attachment
- Biscuit decorator (ink printer)
- Jam topper
- Swivel panner

MODEL	A	B	total power
	mm	mm	mm
1.500	3.140	1.800	20
1.600	3.240	1.900	20
1.800	3.440	2.100	24





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