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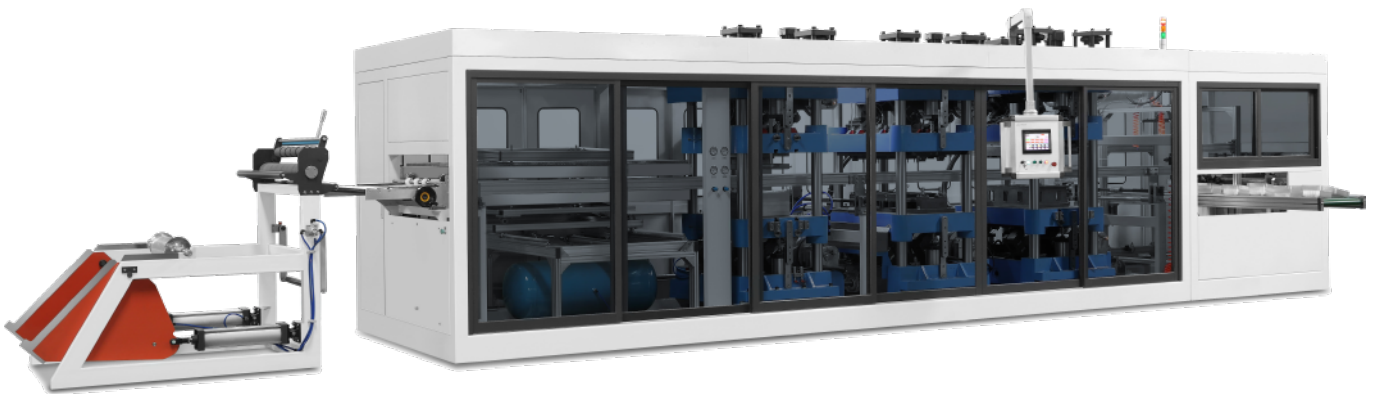
Xinxing Industrial Park, Pingyang County,
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◀ PRODUCT INTRODUCTION ▶

TTF-700AF

FULL-AUTOMATIC FOUR-STATION PLASTIC THERMOFORMING MACHINE



1、APPLICATIONS

TTF series full-automatic thermoforming machine is our latest developed core product. The machine combines forming, cutting, and stacking into process. widely used and suitable for most of the customer requested, it can produce plastic trays, containers, boxes, lids, etc. The machine is completely driven by servo motor. stable operation, low noise, high efficiency, high quality.

2、PRODUCT PARAMETER

Model	TTF-700AF
Forming Area	700mm x 550 mm
Forming Depth (Max.)	120mm
Sheet thickness	0.2-2.0mm
Forming Speed (Max.)	30times/min
Air pressure	0.6-0.8mpa
Air consumption	3.6 m ³ /min
Water consumption	0.7 m ³ /h
Sheet width (Max.)	730mm
Suitable Sheet	PP, PS, HIPS, PET, PVC, PLA etc.
Power supply	AC 380V, 50Hz, Three-phase, Four-wire
Used power	105Kw
Rated power	210Kw
Heating power	118Kw
Procedure	Forming-punching-cutting-stacking
Dimension	L13000*W4700*H2750mm
Weight	About 25.0T

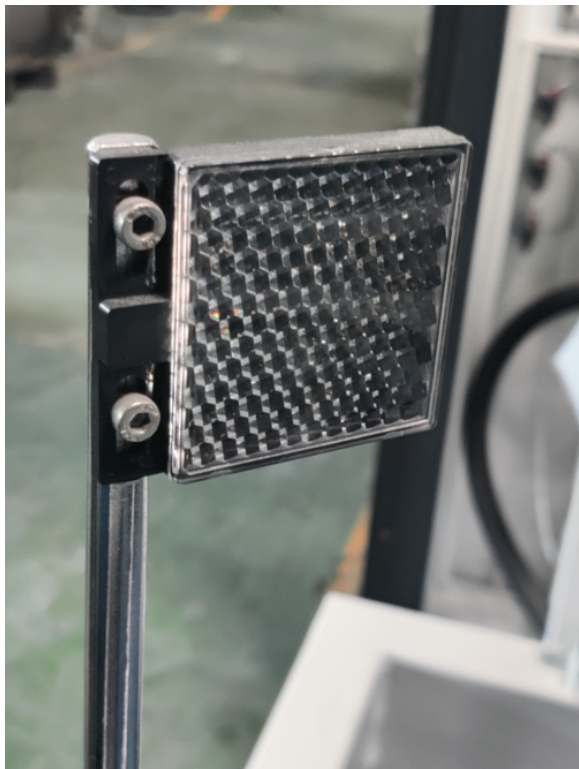
MAIN PARTS	
Filter	CKD (Japan)
Forming valve	MAC (USA)
Temperature control module	WEST (UK)
Proximity switch	ROCKWELL (USA)
AC contactor\Circuit breaker\Button	SCHNEIDER (France)
Intermediate relay	IDEC (Japan)
Intermediate Relay Base	OMRON (Japan)
Vacuum Pump	ELMO RIDTSCHLE (Germany)

3、ELECTRIC FURNACE SYSTEM

1. After heating the starting point, four sections (four times the molding length). More suitable for PP sheet, heating speed faster, higher production efficiency.



2. Sheet overtemperature detection, under the furnace protection device, can make the sheet in excessive heating, prevent the sheet melting in the furnace, so that the furnace quickly moved out, leaving the sheet to protect the furnace.



4、 FORMING STATION

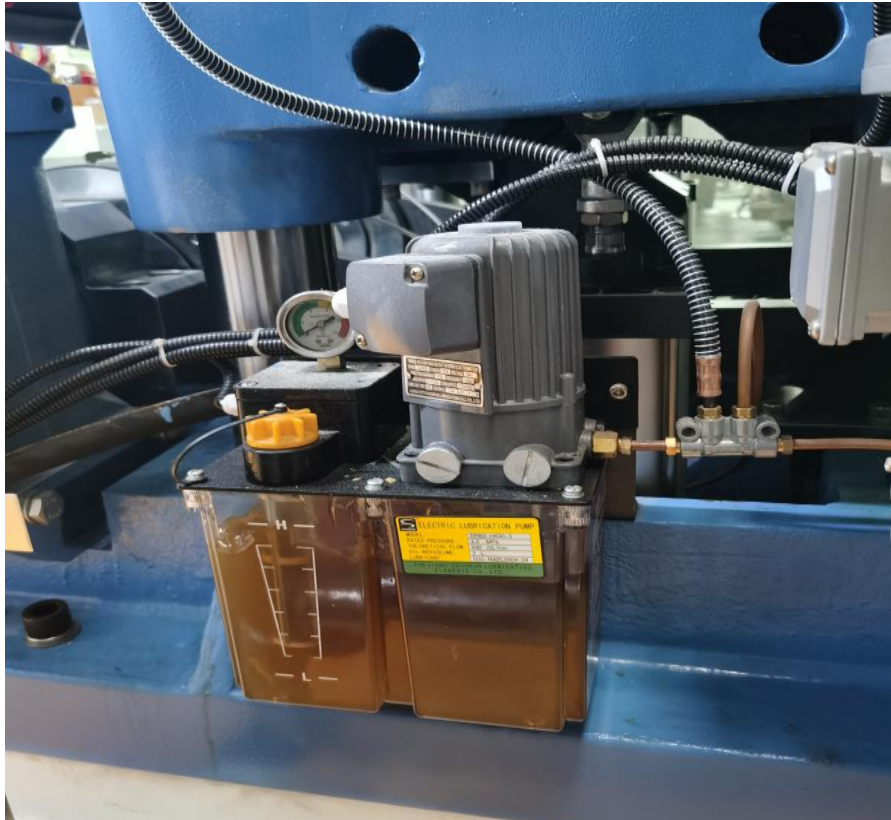
1. Positive and negative pressure molding, positive and negative pressure molding (the maximum 0.7Mpa, approximately equal to 7 times the vacuum suction), the bottom negative pressure suction, so that the molding exhaust more quickly, forming more in place, suitable for PP material, molding difficult product production, depending on the product demand, can choose to use.

2. Can be concave or punch mode, suitable for the use of reverse side, punch products production.

3. Mold quick locking device: when installing the mold, align the T-shaped groove and position it in place quickly, and use the locking device to quickly lock it, effectively shorten the fixed time of the mold. When unloading the mold, the locking device loosens and the mold exits quickly. With the supporting arm of unloading the mold, it is pulled into the loading and unloading truck.



4. Automatic joint lubrication system: joint sliding point, are equipped with pressurized lubricating oil inflow point and oil pipe, oil embellishing system automatic timing and quantitative (adjustable setting) filling, with no oil pressure alarm.



5. Shut down safety device: When shutting down for maintenance and mold change, the operation involving personal safety must use this protection device. It cannot be opened if not in use.

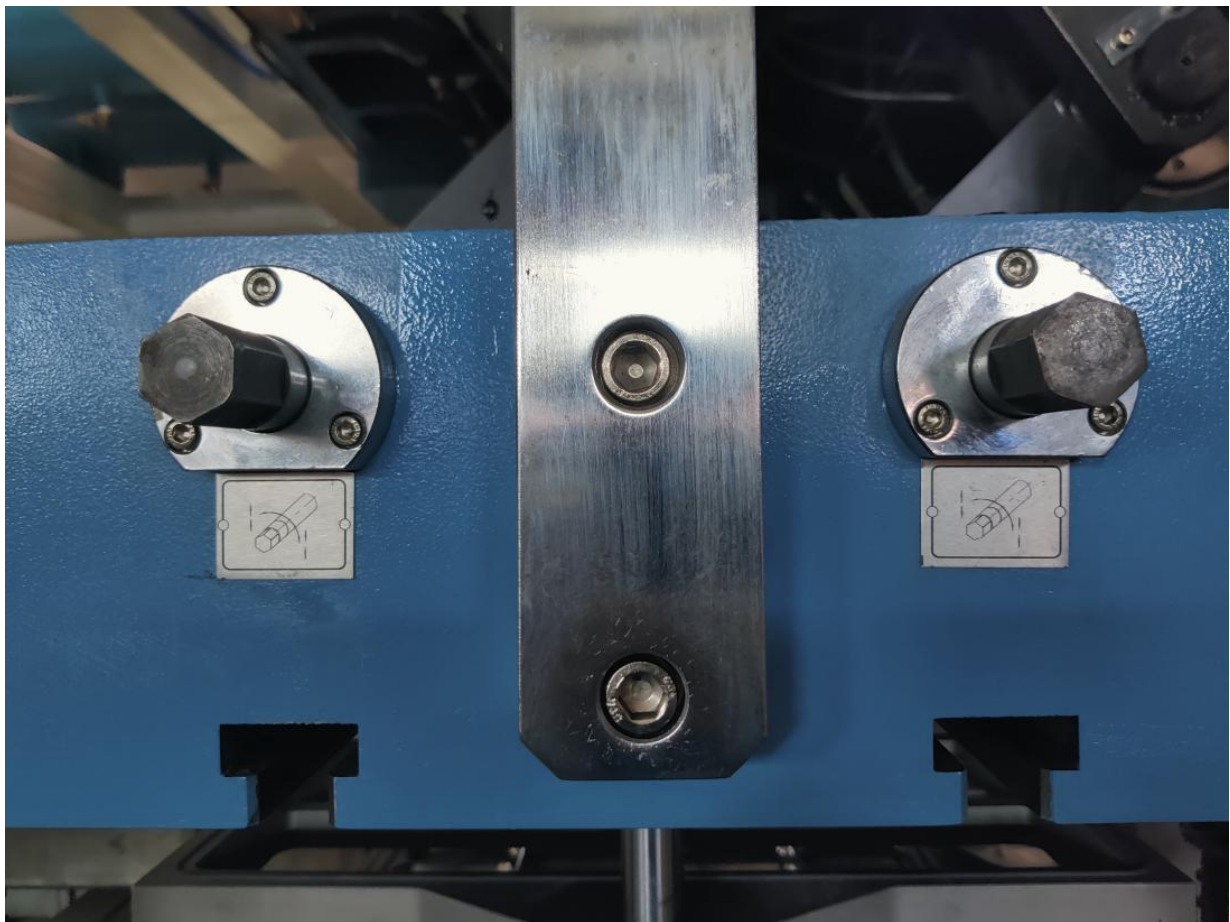
6. Stretch device: this device can be used to make the product more uniform and save materials.

7. Electric adjustment of forming height: when different molds need to adjust the upper part of the position, you can use the adjusting part to automatically adjust, the adjustment is finished, automatic locking.

5、 CUTTING STATION

1. Cutting knife adjustment and heating device: in order to ensure more beautiful cutting products, you can use cutting shear heating, less burr after cutting, cutting position before and after or diagonally adjusted, effectively complete the adjustment of knife.

2. Cutting die quick locking device: when the cutting die is installed, it can be in place quickly, and the locking device is used to fast lock, shorten the time of changing the die. When the die is unloaded, the locking device is loosened, and the cutting die is pushed out quickly.



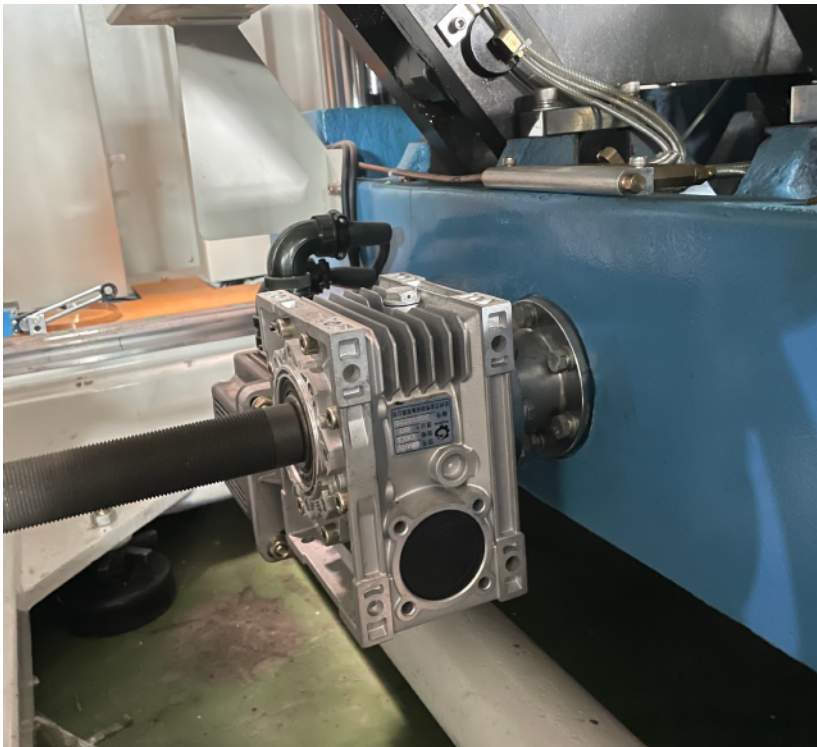
3. High reliability, high precision joint: selection of special alloy materials, finishing, grinding according to the standard process.



6、 SAFETY DOOR ARRANGEMENT

When the protective door is closed, the machine will work normally. When it is working, open the protective door and it will alarm or stop the machine.

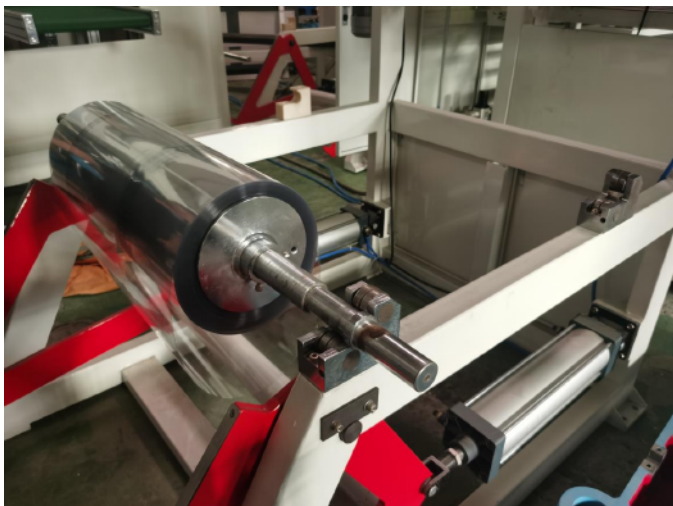
7、 LOCATION ADJUSTMENT



Electric adjustable station distance, fast and convenient.

8、 SHEET FEED

Double station coil material supply device, the maximum diameter of the coil is 900mm.



PHOTOELECTRIC CONTROL FEEDING DEVICE

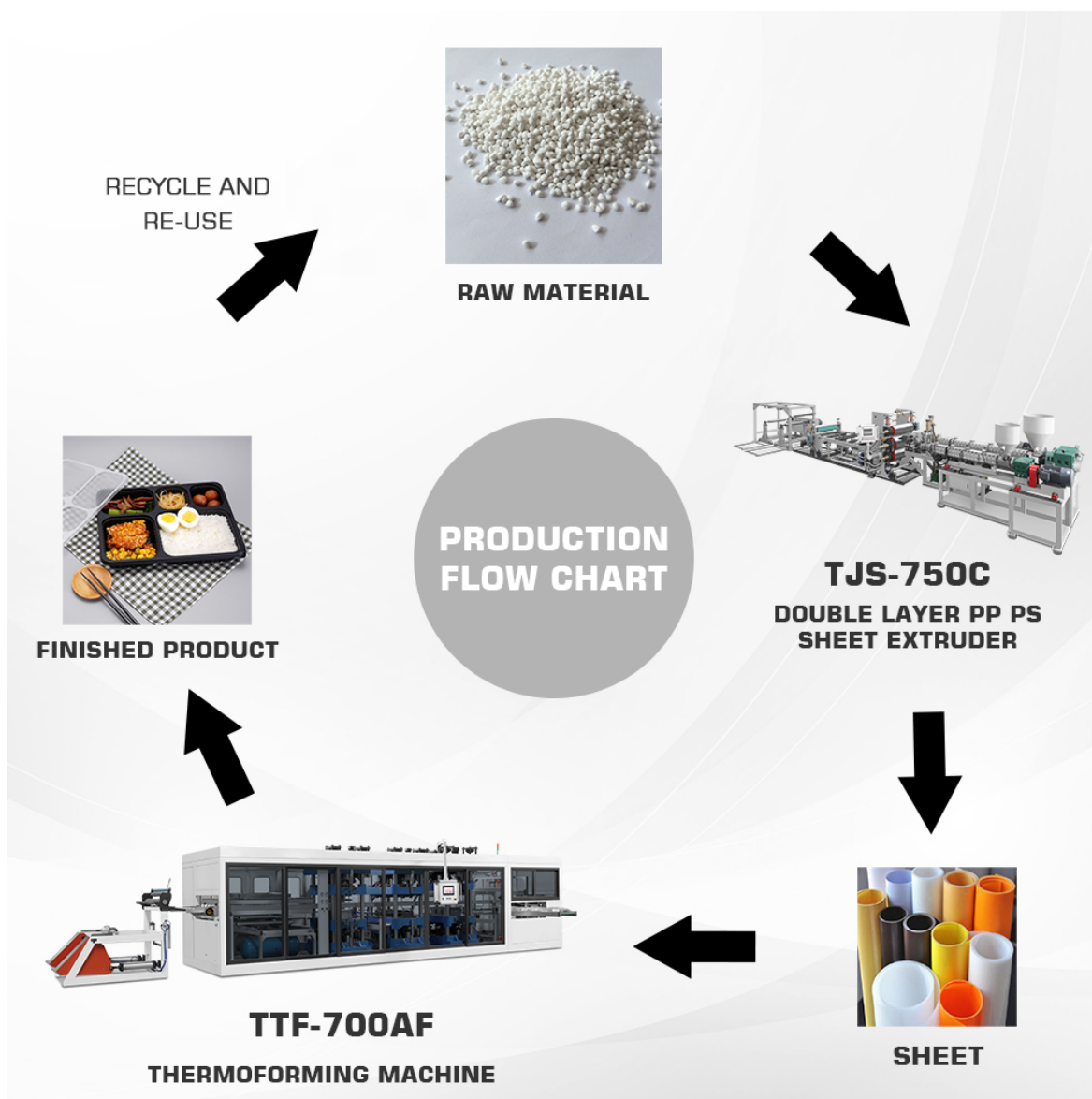
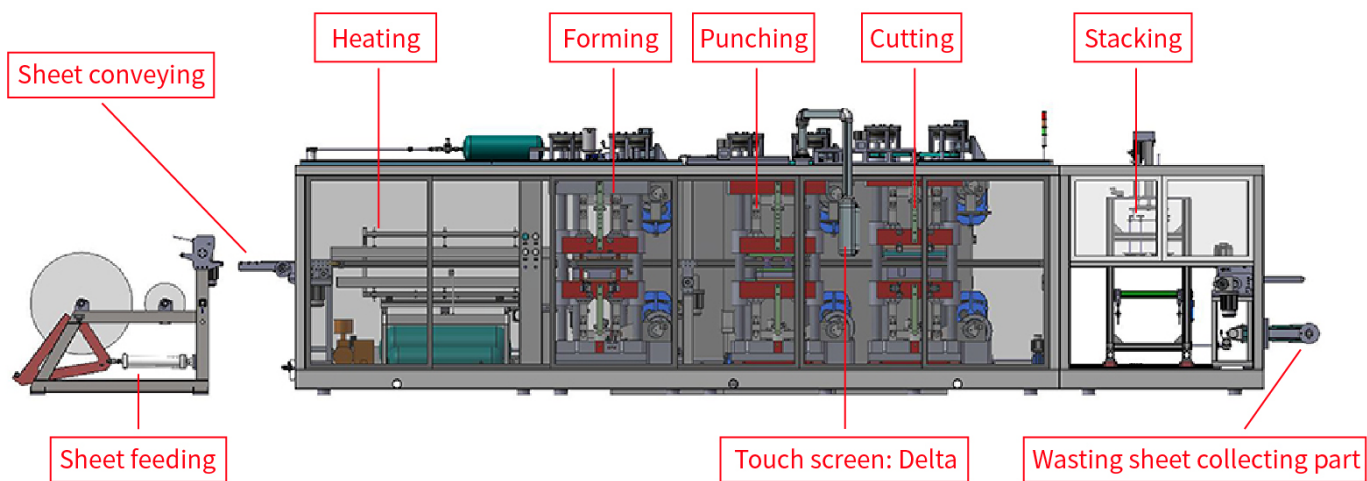
9、 OPERATION INTERFACE

The operation interface is convenient and fast.



10、 PRODUCT DESCRIPTION

1. Every station is driven by the eccentric crank linkage structure.
2. Feeding and heating part have optoelectronic switch in order to prevent error operating from production process.
3. The toothed chain made of 65#Mn, helping convey sheet. Aluminum rails with water cooling, save water.
4. The machine adopts PID temperature system, it shows high precision, and temperature control tolerance $< 1^{\circ}\text{C}$.
5. Each servo motor has overload protection for machine's overworking.
6. Low barycenter and height of finished products as well as steady running ensures easy operation and friendly viewing.
7. There is an alarm function of the sliding doors.



11、AUXILIARY EQUIPMENT



Chiller

Cool down molds, rails and hydraulic systems while the machine is running.

Model	15F	Motor Power	13.6kw
Refrigerant	R22	Power supply	AC 380V, 50Hz, Three-phase, Four-wire
Cooling fan	0.55kw x 2	Dimension	L1500 x W850 x H1450mm
Volume of water tank	150L	Weight	about 750kg



Air Compressor

Get enough air during molding.

Model	TK-3.6	Dimension	L1150 x W900 x H1350mm
Air displacement	3.6m ³ /分	Power supply	AC 380V, 50Hz, Three-phase, Four-wire
Working pressure	0.8Mpa	Weight	about 580kg
Motor power	22kw		



Air Tank

The auxiliary part of the air compression system keeps the air pressure stable.

Volume	1.0m ³	Inner diameter	800mm
Pressure	0.8Mpa	Relief valve interface	Rp11/2
Design temperature	150°C	Drain valve interface	R1/2
Total height	2400mm		