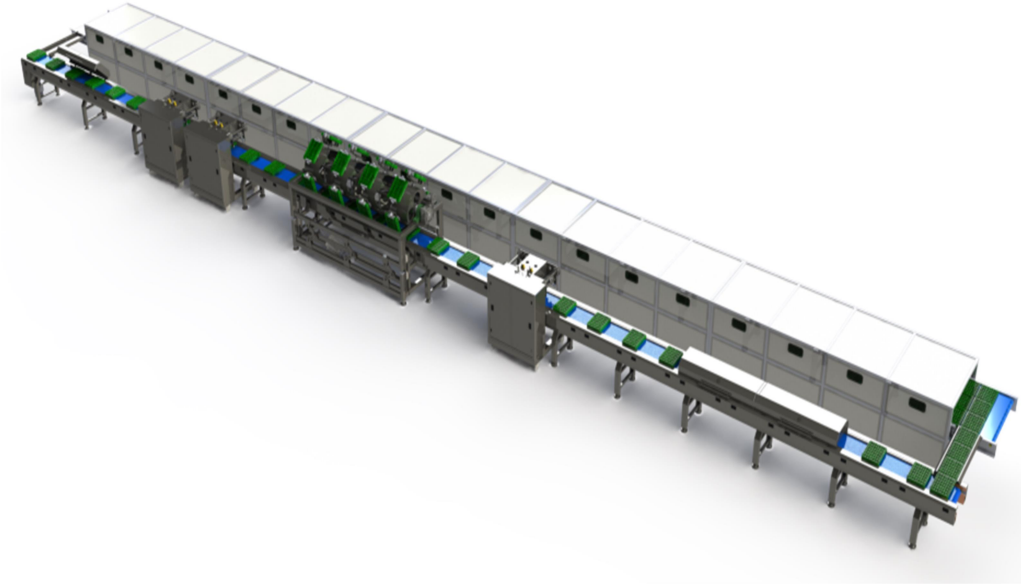


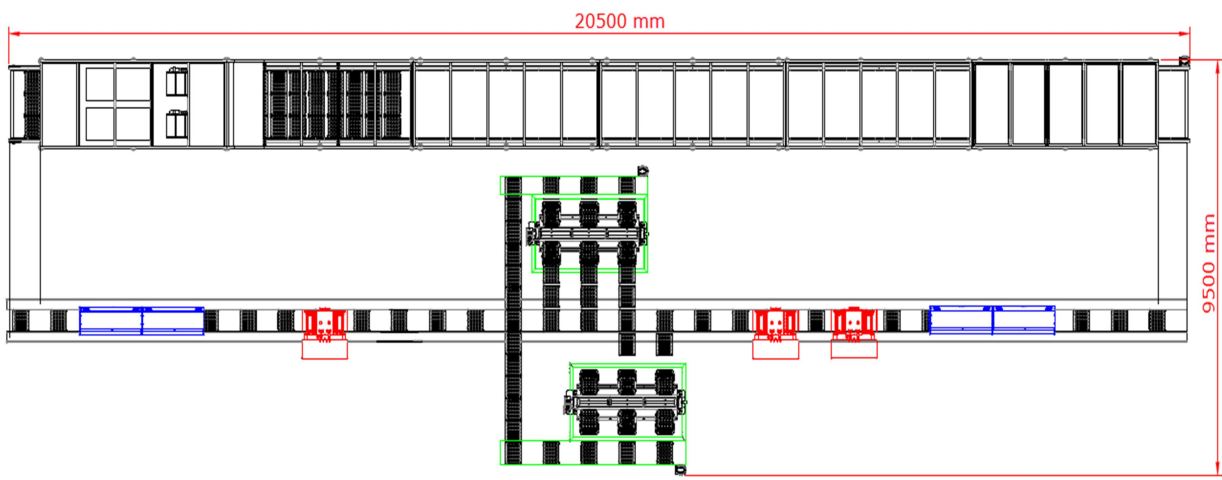


## AUTOMATIC FILLING LINE

AUTOMATIC ONE SHOT AND SHELL FILLING LINE



Producer: : İEM ENDÜSTİRİYEL GIDA MAKİNALARI SAN DİŐ TİC LTD.ŐTİ  
Address : orhan gazi mah. 2.yol sk. Isıso San Slt. B blok No:8 Esenyurt/İSTANBUL  
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### UNIT LIST

1) .Mold heating	6) Mold buckling and rammer	11) Mold heating (lip heating)	16) Tunnel output piston
2) Depositor servo(Comcoline)	7) Mold opening	12) Mold closure	17) Mold buckling and piston
3) Mold closing	8) *Putting or capsule	13) Upper printing apparatus	18) *Product unloading
4) Mold turning	9) 2.Deposter servo (cream)	14) Tunnel Entrance Feeding	
5) Spinner(Creating a shell)	10) 3.DEPOZITOR Servo (Cream)	15) Cooling Tunnel	

\* It is determined by the customer..

- \* The outer chassis of the machine is made of AISI 304 stainless steel.
- \* The machine is provided with a modular band with mold-carrying soldiers.
- \* The reducers used for the motion system in the machine are the Yılmaz Reduktor brand.
- \* The pneumatic system used in the machine is SMC brand.
- \* Total mold capacity is 395 pieces.
- \* Tunnel formwork capacity is 312 pieces. (The tunnel will be double-decker.)
- \* Conveyor mold capacity is 43 pieces.
- \* Spinner mold capacity is 30 pieces.
- \* Tunnel feeding and output 4 pieces each.
- \* The minimum production capacity for the shell is min. 12 pieces, with a maximum of 15 pieces.
- \* The minimum production capacity for Oneshot is min. 14 pieces, with a maximum of 17 pieces.

## AUTOMATIC FILLING LINE

### 1.) MOLD HEATING UNIT



- \* For product printing, it heats the mold surface and brings it to the appropriate temperature for filling.
- \* Each heating tunnel has 8 kW resistance heating.
- \* It is designed for homogeneous heating of the molds on the line.
- \* **For safety purposes, when the line stops, the resistance is automatically turned off and the cover is opened so that it does not burn out.**
- \* To preserve the existing heat in short stops, only the cover is opened, not the resistance is turned off.
- \* There are 2 mold heating units in the machine. Heating 1 for mold conditioning. Heating is for 2-lip heating.

## 2.) 1. SHELL AND ONE-SHOT DEPOSITOR SERVO



\* There is 1 chocolate filling deposit on the machine.

\* 1. The chocolate depositor was used to form the crust.

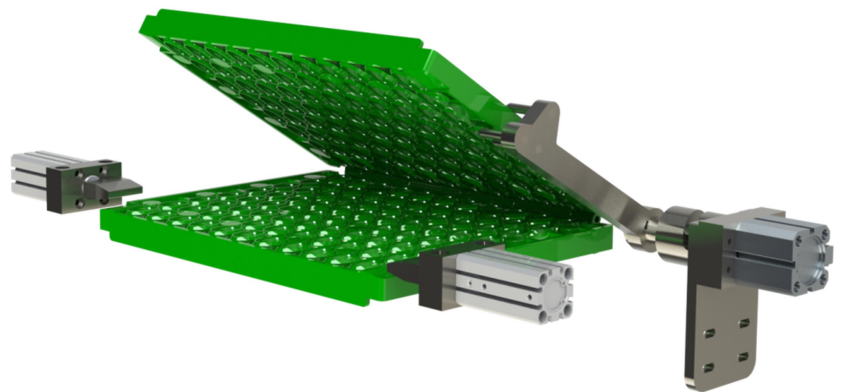
\* Depositors can be custom-made.

\* The temperature of the product; stainless water tank, water transfer motor and resistance, and a walled chamber and a walled Thanks to the block, it can be adjusted to the desired degree with +/-1C deviation.

\* Separate mixing system is available for both chambers.

\*The depositor has a one-shot feature. Different products are produced by making multiple pouring molds. and different weights can be studied.

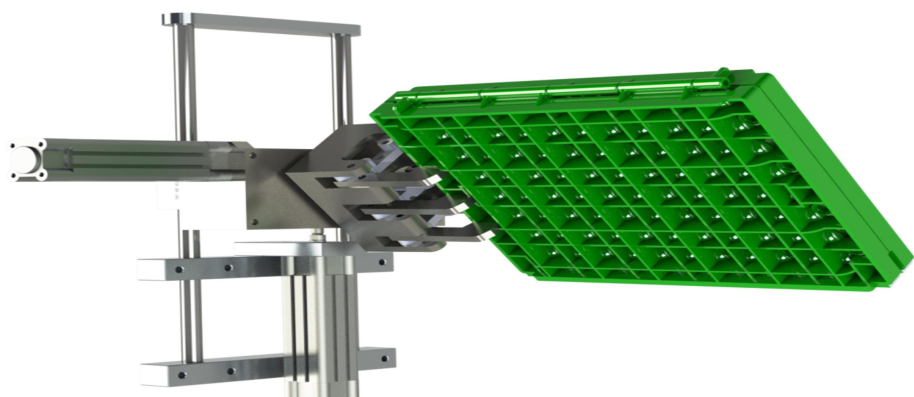
## AUTOMATIC FILLING LINE



## 3.) MOLD OPENING AND CLOSING

\* After the depositor group is filled, the mold is closed and the cream, filling or particles are put into the shell. It is used for mold opening before placing.

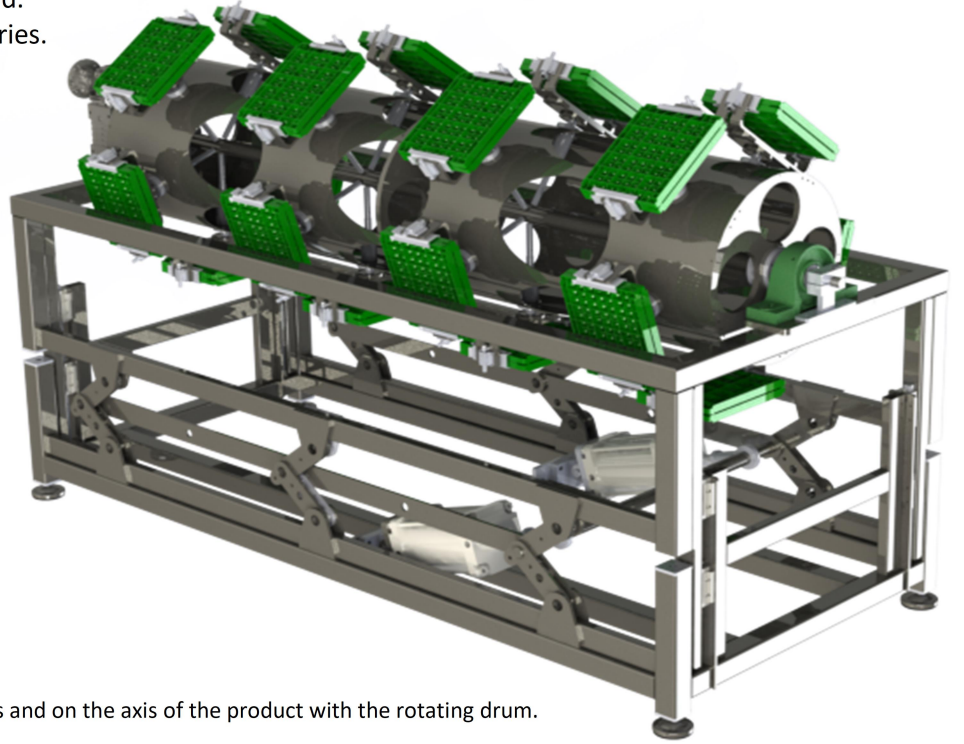
## 4.) MOLD TURNING



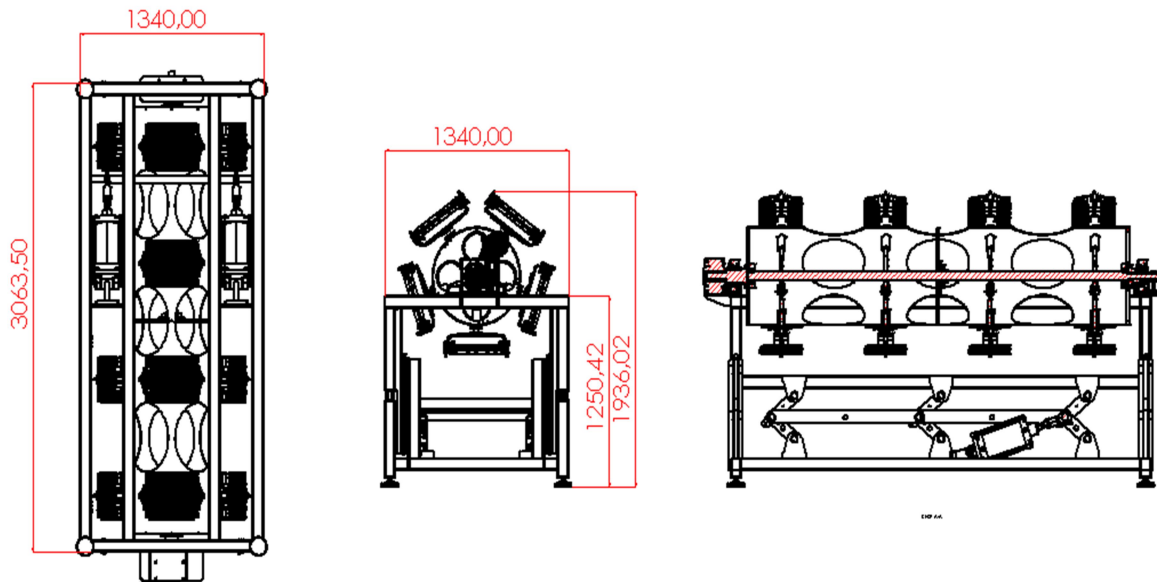
- \* The first preparation for the product to be of equal thickness in both parts of the book mold in shell productions does.
- \* Pneumatic pistons used are SMC brand.
- \* The aluminum quality used is 7000 series.

## AUTOMATIC FILLING LINE

### 5.) SPINNER - CREATING A SHELL

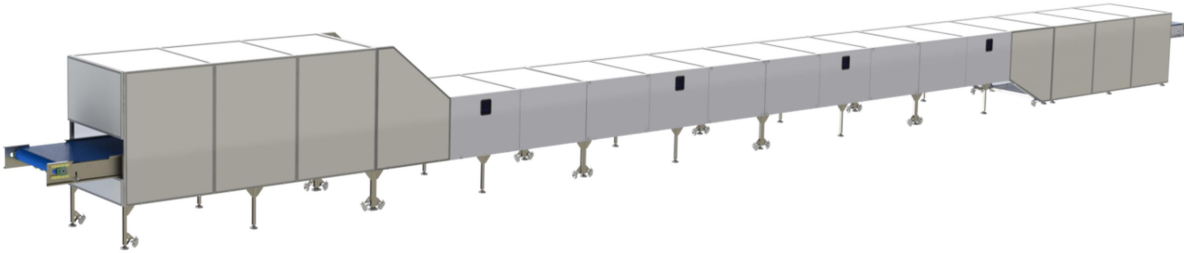


- \* By turning the mold 360 degrees both on its axis and on the axis of the product with the rotating drum. It provides a homogeneous spread.
- \* Yilmaz brand reducer is used with the spinner rotation speed of 1.5 rpm and 0.75kw power.
- \* Spinner linear movement is provided by linear cars with the help of double pistons.
- \* All chassis material quality will be made of AISI 304 steel.
- \* Spinner is disabled during Oneshot operation.



## AUTOMATIC FILLING LINE

### 6.) COOLING TUNNEL



- \* It is designed for homogeneous cooling of the formed crust.
- \*The cooling tunnel will have 2 floors.
- \* Yilmaz Reduktor brand reducers with 2,2 kW motor power were used.
- \*The tunnel band width is 1200 mm and 3 molds can fit.
- \* A modular tape with a pitch of 380 mm and a permeability of 60% is used.
- \* The modular belt is designed for cleaning and its post-production cleanability is simplified.
- \*It has 20 HP x 2 cooling double fan speed adjustment. The total cooling capacity is 100 kW.
- \*The drip holder is designed to prevent perspiration in the mold.
- \* The residence time of the mold in the tunnel is approximately 18~25 minutes.  
The cooling capacity is between 3°~9°C.
- \*The tunnel chassis is made of AISI 304 stainless steel, with heat-insulated covers on the chassis.
- \* is dressed.
- \* Sight glass and 220V - 30W 10 LED lights are available

