Plastic Extrusion and Thermoforming Lines

plastic extrusion and thermoforming lines and equipment for the production of lids, cups, containers and trays surplus to the ongoing operations of Huhtamaki - production lines from manufacturers Illig, Gabler, Bellaplast and Kiefel including moulds for each line.

Featuring:

- **Inline-Production line GABLER**, type D600, *for lids or flat products (PET, PLA, PS)*, with extruder KUHNE, composed of: extruder, calender, heating, former, stacking, mill (ca. 2003)
- **Inline-Production line GABLER**, type D600, *for caps or flat products (PET, PLA, PS)*, with extruder HENSCHEL, composed of: extruder, calender, heating, former, stacking, mill (ca. 1999)
- **Inline-Production line BELAPLAST** type MPS, *for lids/bowls (PS)*, with extruder KUHNE, composed of: extruder, calender, former, mill
- **Inline-Production line KIEFEL**, type KMD 100 BFS (S), *for plates, salad bowls, trays (PP, PET, PLA, PS)*, with extruder KUHNE, composed of: extruder, dryer, calender, former, stacking, down stream unit (2004)
- and more items such as frequency converters, sealing machines, plastic mills, forklifts and moulds
GABLER D600 Inline-Production line

Manufacturer and model: GABLER D600

Description:
Inline-Production line GABLER, type D600, Line 102, for lids or flat products (PET, PLA, PS), with dryer MOTAN LA/4-400 PET incl. conveying units: 2x HLX6, 1x HLX15, 1x HLX30, dosing unit VOLMIX M9 (volumetric and gravimetric), dryer tank 1200 l, control SIEMENS S5/OP5, vacuum pump Nash Elmo, extruder line: KUHNE KS60-30D, power: 22,7 kW, heating-/cooling unit: Kelviplast W400 / retrofit in 2000, 10 kW, rollers: 260x800 mm 58 +/-2 HRC, speed: 8 -15 m/min., capacity: APET 140 kg/h, PS 120 kg/h, PLA 130 kg/h, extrusion die: EDI Ultraflex R-75, sheet width max. 700 mm, control SIEMENS S7/OP27/Gossen R2600, thermoformer GABLER D 600, power: 80 kW, forming area: 600 x 320 mm, max. 45 cycles/min, heating length: 1800 mm, pneumatic stacking unit - engineered by Huhtamaki, mill ILLIG RS 75B, power: 15 kW with noise protection, floor space required ca. 70 m², line composed of: extruder, calender, heating, former, stacking, mill, year of manufacture ca. 2003
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GABLER D600 Inline-Production line

Manufacturer and model: GABLER D600

Description:
Inline-Production line GABLER, type D600, Line 103, for lids or flat products (PET, PLA, PS), extruder line: HENSCHEL HE 60, power: ca. 41 kW, heating/cooling unit: KELViplast W400 / retrofit, 10 kW, rollers: 280x800 mm 58 +/-2 HRC, speed: 8 - 15 m/min, capacity: APET 140 kg/h, PS 120 kg/h, PLA 130 kg/h, extrusion die: EDI Ultraflex HR-75, sheet width max. 700 mm, electromechanical control, thermoformer GABLER D 600, power: 80 kW, thermoforming area: 600 x 320 mm, max. 45 cycles/min, heating length: 1800 mm, pneumatic stacking unit GABLER, mill ILLIG RS 75B, power: 15 kW with noise protection, floor space required ca. 70 m², line composed of: extruder, calender, heating, former, stacking, mill, year of manufacture ca. - Please note: PET drying system NOT included!
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ILLIG RDM 70K Inline-Production line

Manufacturer and model: ILLIG RDM 70K

Description:
Inline-Production line ILLIG, type RDM 70K, Line 133, material PS and PP, ca. 170 kW,
dosing unit: MOTAN (volumetric) with conveying units 2x HLX30, HLX6, 2x HLX10, control:
SIEMENS S7/OP17, vacuum pump: NASH ELMO, extruder line: KUHNE K 90 / 30D, 126 kW,
heating: 30 kW, capacity: PP 320 kg/h, extrusion die: EDI Ultralaxx HR 75, max. sheet width:
750 mm, feedblock for 2-ply film, pump: MAAG Extrex EX 56-5, control system: KUHNE, Co-
extruder: engineered by Huhtamaki type BH 45, power: 15 kW, heating: 10 kW, capacity ca.
PP 35 kg/h, calender: KUHNE GA 2/900, power: ca. 15 kW, rollers: 200x900 mm 54 +/- 2
HRC, speed: ca. 11m/min, heating/cooling: KELVIPLAST W300, thermoformer ILLIG RDM
70K, power: ca. 90 kW, thermoforming area: 700x280 mm, max. sheet width: 730 mm, max.
35 cycles/min, heating length: 1800 mm, control: SIEMENS S7/OP 37, mill ILLIG RS 75B,
17.8 kW, incl. thermoforming tools: 27 cavity mould Ø 68 mm for PP, 24 cavity mould Ø 75
mm for PP, 12 cavity mould Ø 106 mm for PP, 24 cavity mould Ø 71 mm for PS, 6 cavity
mould rectangular ice container 177 x 162 mm for PS, line composed of: extruder, calender,
former, stacking, mill, year of manufacture 2000
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ILLIG R650 Offline-Production line

Manufacturer and model: ILLIG R650

Description:
Offline-Production line ILLIG, type R650, Line 203, for PS-lids, connected load: ca. 12 kW, forming area ca. 610 x 700 mm, sheet width max. 650 mm, max. 10 cycles/min, control SIEMENS S7/OP7, punch ILLIG STA 85, The line has has been overhauled in 2011, incl. thermoforming tool for PS-lids with clip Ø ca. 90 mm, floor space required ca. 40 m², line composed of: unwinder, former, punching station
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ILLIG RDM 63/10B Offline-Production line

**Manufacturer and model:** ILLIG RDM 63/10B

**Description:**
Offline-Production line ILLIG, type RDM 63/10B, Line 204, for PS-lids, connected load: ca. 43 kW, forming area ca. 665 x 305 mm, sheet width max. 685 mm, max. 40 cycles/min, electromechanical control, punch ILLIG STA 95B, The line has has been overhauled in 2011, incl. thermoforming tool for PS-lids Ø 83 mm (21 cavities), for PS-lids Ø 100 mm (8 cavities), floor space required ca. 40 m², Line composed of: unwinder, former, punching station,
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ILLIG RDM 50/3 Offline-Production line

Manufacturer and model: ILLIG RDM 50/3

Description:
Offline-Production line ILLIG, type RDM 50/3, Line 117, for round PS-lids Ø ca. 104 mm and rectangular PS-lids 118x118mm, ca. 50 kW, thermoforming area 500 x 285 mm, sheet width max. 520 mm, max. 50 cycles/min, control SCHLEICHER, handling system MK (year of manufacture ca. 2007), packaging machine: KALLFASS Packjet 1000, 7,5 kW with control: SIEMENS S7/OP17, mill ILLIG RS 75B (year of manufacture 2007), incl. thermforming tools for 2 different PS-lids, floor space required ca. 60 m², Line composed of: sheet unwinder, former, stacking, shrink-wrap machine, mill, year of manufacture 2007
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MPS Inline-Production line

Manufacturer and model: MPS

Description:
Inline-Production line BELLAPLAST type MPS, for lids/bowls (material PS), Line 139, ca. 160 kW, dosing unit: MOTAN with conveying units 2x HLX15, HLX6, HLX10, Mann + Hummel-unit VOLMIX M9 gravimetric, Plasticolor unit volumetric, control SIEMENS S7, vacuum pump: Nash Elmo, extruder line: KUHNE K 90 / 30D, 125 kW, heating: 30 kW, capacity: PS ca. 450 kg/h, extrusion die: EDI Ultraflex 75, max. sheet width: 800 mm, feed block for 2-ply film, pump: MAAG Extrex EX 56-5, control system: KUHNE Digipac, Co-extruder: engineered by Huhtamaki type BH 45, power: 15 kW, heating: 10 kW, capacity ca. PS ca. 45 kg/h, calender: engineered by Huhtamaki, rollers: 250x820 mm 54 +/- 2 HRC, speed: 5-15 m/min, heating/cooling: 2x Kelviplast/engineered by Huhtamaki W400, thermoformer BELLAPLAST MPS, power: ca. 65 kW, forming area: 680x660 mm, max. sheet width: 740 mm, max. 30 cycles/min, control: SIEMENS S7 (machine has been modified in 2002), mill CONDUX CS 300/800, 9 kW, incl. thermoforming tools for PS lids and 975 ml salat bowls (twister), floor space required ca. 85 m², line composed of: extruder, calender, former, mill,
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KIEFEL KMD 100 BFS (S) Inline-Production line

Manufacturer and model: KIEFEL KMD 100 BFS (S)

Description:
Inline-Production line KIEFEL, type KMD 100 BFS (S), Line 141, for plates, salad bowls, trays (material PP, PET, PLA, PS), ca. 260 kW, dryer: Mann + Hummel Somos D1400 RLK with conveying units AZV 316/65, AZV 450/65, AZV 250/50, dosing unit: Mann + Hummel VOLMIX M9 (volumetric + gravimetric), 2 drying tanks Somos 4000 l + 1600 l, control SIEMENS S7/MP370Touch, vacuum pump: Busch Mink MM1322, extruder: KUHNE KF105E/60 E-5V/1300, power: 200 kW, heating: 35 kW, capacity: APET 600 kg/h, PS 500 kg/h, PLA 600 kg/h, extrusion die: BD117F, max. sheet width: 1170 mm, feed block: for 3-ply film, control: SIEMENS S7/MP370Touch, Co-extruder: KUHNE PET KF105E/60 E-5V/1300, Power: 75 kW, heating: 10 kW, capacity: APET 200 kg/h, PS 200 kg/h, PP 150 kg/h, PLA 200 kg/h, pump: Eprotec Melt X2, calender: KUHNE BA1/200/1300, rollers 300x1300 mm 56 +/- 2 HRC, speed: 10-35 m/min, power: ca. 18 kW, heating/cooling Kelviplast W600, thermo former KIEFEL KMD 100 BFS (S), power: 200 kW, forming area ca. 1000 x 1000 mm (500 x 500 mm), sheet width max. 1050 mm, max. 40 cycles/min, heating length: 3000 mm, mill RAPID 2690-KURF, power: 15 kW, packaging machine: BVM Compacta 7022, control SIEMENS S7, incl. various 12 cavity thermoforming tools for PP-lids, PP-plates, PP-trays, PET-trays, PET-lids, floor space required ca. 270 m², Line composed of: extruder, dryer, calender, former, stacking, down stream unit, year of manufacture 2004
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ILLIG RS 107B Plastic mill

**Manufacturer and model:** ILLIG RS 107B

**Description:**
Plastic mill ILLIG, type RS 107B, entrance width: 1080 mm,
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ILLIG RS 107B Plastic mill

Manufacturer and model: ILLIG RS 107B

Description:
Plastic mill ILLIG, type RS 107B, entrance width: 1080 mm,
ILLIG RS 107B Plastic mill

Manufacturer and model: ILLIG RS 107B

Description:
Plastic mill ILLIG, type RS 107B, entrance width: 1080 mm,
KELVIPLAST W 300/120+9/30 MS Heating/Cooling unit

Manufacturer and model: KELVIPLAST W 300/120+9/30 MS

Description:
Heating/Cooling unit KELVIPLAST, type W 300/120+9/30 MS, heating power: 9 kW, cooling power: 35/40 kW/°C,
KELVIPLAST W 300/120-15/60 Heating/Cooling unit

Manufacturer and model: KELVIPLAST W 300/120-15/60

Description:
Heating/Cooling unit KELVIPLAST, type W 300/120-15/60, heating power: 15 kW, cooling power: 69.7/40 kW/°C,
CASCADE 25F-RC-06A Forklift attachment

Manufacturer and model: CASCADE 25F-RC-06A

Description:
ENGLISH:
Forklift attachment CASCADE, type 25F-RC-06A, (attachment for TOYOTA forklift), lifting capacity: 1200 kg, (hydraulic unit MEYER 5/1502N, year of manufacture 2004),
NORMPACK NCG036001 Sealing machine

Manufacturer and model: NORMPACK NCG036001

Description:
Automatic Sealing machine for folded boxes NORMPACK, type NCG036001, glue head: T23, with roller conveyor 0,5 x 1,5 m,
NORMPACK Sealing machine

Manufacturer and model: NORMPACK

Description:
Automatic Sealing machine for folded boxes NORMPACK, glue head: T23
NORMPACK Sealing machine

Manufacturer and model: NORMPACK

Description:
ENGLISH:
Automatic Sealing machine for folded boxes NORMPACK, glue head: T23
NORMPACK Sealing machine

**Manufacturer and model:** NORMPACK

**Description:**
ENGLISH:
Automatic Sealing machine for folded boxes NORMPACK, glue head: T23
GETECHA RS 3009-E1.39 Plastic mill

Manufacturer and model: GETECHA RS 3009-E1.39

Description:
Plastic mill GETECHA, type RS 3009-E1.39, 400V/63A, film entrance: 850 mm, year of manufacture 2006
CONDUX Plastic mill

Manufacturer and model: CONDUX

Description:
Plastic mill CONDUX, with star roller, without flange motor, sheet width max. 740 mm, power: 15 kW, mobile
EBS 6000 Ink jet printer

Manufacturer and model: EBS 6000

Description:
Ink jet printer EBS, type 6000, for markings, year of manufacture 2000
EBS 6000 Ink jet printer

Manufacturer and model: EBS 6000

Description:
Ink jet printer EBS, type 6000, for markings, year of manufacture 2000
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EBS 6000 Ink jet printer

Manufacturer and model: EBS 6000

Description:
Ink jet printer EBS, type 6000, for markings, year of manufacture 2000
EBS 6000 Ink jet printer

Manufacturer and model: EBS 6000

Description:
ENGLISH:
Ink jet printer EBS, type 6000, for markings, year of manufacture 2000
SIEMENS 6RA7091-6DS22-0 DC-Converter

Manufacturer and model: SIEMENS 6RA7091-6DS22-0

Description:
DC-Converter SIEMENS, type 6RA7091-6DS22-0, DC-Output: 485V/1200A, year of manufacture ca. 2005
SEW MOVITRAC 31C008-503-4-00 Frequency converter

Manufacturer and model: SEW MOVITRAC 31C008-503-4-00

Description:
Frequency converter SEW, type MOVITRAC 31C008-503-4-00
SEW MOVITRAC 31C008-503-4-00 Frequency converter

Manufacturer and model: SEW MOVITRAC 31C008-503-4-00

Description:
Frequency converter SEW, type MOVITRAC 31C008-503-4-00,
SEW MOVITRAC 31C008-503-4-00 Frequency converter

Manufacturer and model: SEW MOVITRAC 31C008-503-4-00

Description:
Frequency converter SEW, type MOVITRAC 31C008-503-4-00,
SEW MOVITRAC 31C008-503-4-00 Frequency converter

**Manufacturer and model:** SEW MOVITRAC 31C008-503-4-00

**Description:**
Frequency converter SEW, type MOVITRAC 31C008-503-4-00,
SEW MOVITRAC 31C008-503-4-00 Frequency converter

Manufacturer and model: SEW MOVITRAC 31C008-503-4-00

Description:
Frequency converter SEW, type MOVITRAC 31C008-503-4-00,
SEW MOVITRAC 31C008-503-4-00 Frequency converter

Manufacturer and model: SEW MOVITRAC 31C008-503-4-00

Description:
Frequency converter SEW, type MOVITRAC 31C008-503-4-00,
SEW MOVITRAC 31C008-503-4-00 Frequency converter

Manufacturer and model: SEW MOVITRAC 31C008-503-4-00

Description:
Frequency converter SEW, type MOVITRAC 31C008-503-4-00,
SIEMENS MIDIMASTER VECTOR 6SE3223-5DH50 Frequency converter

**Manufacturer and model:** SIEMENS MIDIMASTER VECTOR 6SE3223-5DH50  
**Description:**  
Frequency converter SIEMENS, type MIDIMASTER VECTOR 6SE3223-5DH50,
SIEMENS SIMOVERT VC 6SE7026-0ED61 Frequency converter

Manufacturer and model: SIEMENS SIMOVERT VC 6SE7026-0ED61

Description:
Frequency converter SIEMENS, type SIMOVERT VC 6SE7026-0ED61,
GARBE, LAHMEYER SG 465aFZK 21 2 Power converters

Manufacturer and model: GARBE, LAHMEYER SG 465aFZK 21

Description:
2 Power converters GARBE, LAHMEYER, type SG 465aFZK 21,
SEW MOVITRAC 310A Drive inverter

Manufacturer and model: SEW MOVITRAC 310A

Description:
Drive inverter SEW, type MOVITRAC 310A,
LEUZE lumiflex compact Safety light curtains

Manufacturer and model: LEUZE lumiflex compact

Description:
Safety light curtains LEUZE, type lumiflex compact, 6x 225 mm, 6x 150 mm
ELEKTRA-FAURNDAU DNR 30-6d Three phase motor

Manufacturer and model: ELEKTRA-FAURNDAU DNR 30-6d

Description:
Three phase motor ELEKTRA-FAURNDAU, type DNR 30-6d, 14.4 - 45.0 kW, 440 - 1380 rpm,
ILLIG VHW 72 Pre-heater

Manufacturer and model: ILLIG VHW 72

Description:
Pre-heater ILLIG, type VHW 72, with 2 electrical heated rollers, heating power: 30 kW, max. sheet width 720 mm,

MOTAN LHC-600 -1+1-0-S Crystallizer

Manufacturer and model: MOTAN LHC-600 -1+1-0-S

Description:
Crystallizer MOTAN, type LHC-600 -1+1-0-S, connected load: 47 kW, dry-air capacity: 600m³/h, heating power: 35 kW, drying tank KREYENBORG 1,2 M/3 VA (no. 20697) with stirring unit, year of manufacture 2004, dismantled
RAPID 2690-KURF Mill

**Manufacturer and model:** RAPID 2690-KURF

**Description:**
Mill RAPID, type 2690-KURF, sheet width 1000 mm, year of manufacture 2005
Thermoforming tool

Description:
6 cavity PP-thermoforming tool for rectangular containers, different heights, mould size ca. 182 x 125 mm, for ILLIG 70K
Thermoforming tool

Description:
4 cavity rectangular lid-thermoforming tool, mould size ca. 181 x 122 mm, with stacking unit, for ILLIG RDM 58-3
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**Thermoforming tool**
4 cavity rectangular lid-thermoforming tool, mould size ca. 190 x 130 mm, for ILLIG RDM 58/3
Thermoforming tool

Description:
8 cavity rectangular lid-thermoforming tool, mould size ca. 145 x 95 mm, with stacking unit, for ILLIG RDM 58/3
Mould cutting tool

Description:
Mould cutting tool 21 cavity, for PS-lid, mould size ca. 106 x 80 mm, for Kiefel KMD75
Thermoforming tool

Description:
6 cavity PP-thermoforming tool, bowl-Ø ca. 166 mm, with stacking unit, for Kiefel KMD 75
Thermoforming tool

Description:
16 cavity PS-thermoforming tool, mould size ca. 142 x 130 mm, 3 different heights, with stacking unit, for Kiefel KMD 75, on three pallets
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Thermoforming tool

Description:
6 cavity PP-thermoforming tool, for fresh food trays, mould size ca. 180 x 280 mm, with stacking unit, for Kiefel KMD 75
KUHNE K02-770 mm Sheet-die

**Manufacturer and model:** KUHNE K02-770 mm

**Description:**
Sheet-die KUHNE, type K02-770 mm
Thermoforming tool

Description:
8 cavity PP-lid-thermoforming tool Ø ca. 135 mm, for OMV-machines, on two pallets
HYSTER J3.00XL E-Forklift truck

**Manufacturer and model:** HYSTER J3.00XL

**Description:**
E-Forklift truck HYSTER, type J3.00XL, operating hours read-off 5418, with duplex mast, side shifting device, lifting height 3800 mm, charger DETA, next service 2013