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STAMPEX

"FLASHSTAMPING"

SOAP PRESSES



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FLASHSTAMPING SOAP PRESSES

In 2000 we discontinued the production of the Condor soap presses and introduced the first model of the new most advanced *Stampex* Family of Flashstamping Soap Presses.

Due to the very positive response of our Customers, we have developed several models to satisfy stamping needs from low to high speeds.

The current *Stampex* models offered are:

- ❑ The Stampex/1 and Stampex/2 designed for low speed production and hotel soap requirements.
- ❑ The Stampex/3 and Stampex/3+ (with double stroke option), Stampex/4 and Stampex/4+ (with double stroke option) for 1,000 to 2,000 kg/h capacity finishing lines.
- ❑ The Stampex/6+ (with double stroke option) and Stampex/8+ (with double stroke option) for high capacity, high speed lines.

MAIN FEATURES

- ❑ The main vertical stamping movement of all Stampex presses is obtained without cams to assure maximum sturdiness and simplicity. The “+” versions take advantage of a toggle-joint mechanism which allows the “Double Stroke” stamping mode for high quality stamped bar finish at any speed.
- ❑ Spring-loaded positive vertical or horizontal pick and place suction cup slug (billet) infeed handling system.
- ❑ Sixty degrees instead of the usual ninety degrees rotation of the bottom die-holder.
- ❑ Special rotation of the bottom die-holder to provide firm, fall free hold for standard and complex shaped stamped bars.
- ❑ Welded carbon steel body.
- ❑ Variable frequency drive motors for the stamping movement, infeed and discharge conveyors.
- ❑ PLC based controls and Electronic Cam Positioner.
- ❑ Venturi vacuum system (conventional vacuum pump upon request).
- ❑ Centralized lubrication system.
- ❑ Quick and easy die set changeover.
- ❑ Automatic stamped bars recycle mode controlled by the down-stream packaging machine.
- ❑ Efficient minimum heat loss die coolant distribution system.

STAMPING SYSTEM

- ❑ A vertical reciprocating motion die slide carries the upper dies.
- ❑ The lower dies are positioned on a 60 degrees alternating motion rotating die-holder (mandril).
- ❑ The “flashstamping” stamping method is used for stamping all banded and bandless shaped bars. The slug (billet) is transformed into stamped bars (tablets) when the upper and rotating dies meet together and excess of product (flashing) is formed around the periphery of the dies. The shape and final weight of the stamped bars is determined by the fully closed upper and lower dies. If “Double-Stroke” action is selected (“+” versions) the upper die reaches the lowest position (first stroke) to meet the rotating die then raises a little and repeats the stamping action (second stroke) in order to stabilize the soap shape. Double stroke operation assures excellent finished stamped bar quality for all type of soap products.

SLUG (BILLET) INFEED OPTIONS

There are two infeed options depending on applications. Horizontal infeed is recommended specifically for production of hotel size bars.

- ❑ VERTICAL SLUG INFEED
The slugs arrive vertically on edge on the infeed belt conveyor. A vacuum suction-cup group brings the slug(s) between the upper and the lower dies.
- ❑ HORIZONTAL SLUG INFEED
The slugs arrive horizontally face down on the infeed belt conveyor. A vacuum suction-cup group places the slug(s) between the upper and the lower dies.

STAMPED BAR DISCHARGE

- ❑ A vacuum suction cup group removes the stamped bars with the flashing from the dies. The bars are pulled through a “deflashing plate” which frees them from the flashing which falls onto a flashing belt conveyor or onto a stainless steel chute for recycle.
- ❑ The suction cups rotate the stamped bars of 60 degrees and place them accurately in line on the discharge conveyor.

DIE SETS

A complete die set for a Stampex press consists of:

- ❑ Up and down reciprocating motion upper die(s) group.
- ❑ One 60 degrees alternating motion lower die(s) group.
- ❑ Deflashing plate

Depending on the Stampex model from one to eight dies can be installed according to bar size, weight and stamping speed.



THE STAMPEX FAMILY



***STAMPEX/1 with Die Chiller Group
in the background***



1 Cavity Die Set



2 Cavity Die Set



***STAMPEX/2 with side
flashing discharge chute***



Specialty Soaps 2 Cavity Die Set



***STAMPEX/3 with front
flashing discharge chute***



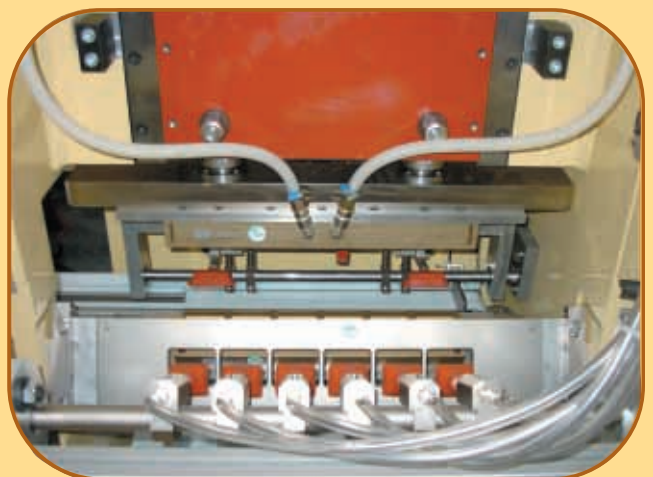
***STAMPEX/4 with front
flashing discharge chute***



4 Cavity Die Set



***STAMPEX/6+ with side
flashing discharge conveyor***



6 Cavity Die Set

| NUMBER OF DIE CAVITIES | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | DIE HOLDER LENGTH |
|------------------------|---|---|---|---|---|---|---|---|-------------------|
|------------------------|---|---|---|---|---|---|---|---|-------------------|

| STAMPEX/1 | PRODUCTION RATE (bars/minute) | 75 | 150 | <div style="border: 1px solid black; padding: 5px; display: inline-block;"> Typical ideal application for each model stamping regular size soap bars </div> | | | | | 220 mm |
|-----------|-------------------------------|--------|-------|---|--|--|--|--|--------|
| | BAR WEIGHT RANGE (grams) | 10-150 | 10-30 | | | | | | |
| | MAXIMUM BAR LENGTH (mm) | 100 | 60 | | | | | | |

| STAMPEX/2 | PRODUCTION RATE (bars/minute) | 75 | 150 | 225 | 300 | | | | 300 mm |
|-----------|-------------------------------|--------|--------|-------|-------|--|--|--|--------|
| | BAR WEIGHT RANGE (grams) | 10-250 | 10-150 | 10-70 | 10-40 | | | | |
| | MAXIMUM BAR LENGTH (mm) | 200 | 100 | 64 | 60 | | | | |

| STAMPEX/3 & 3+ | PRODUCTION RATE (bars/minute) | 75 | 150 | 225 | 300 | 350 | 420 | | | 380 mm |
|----------------|-------------------------------|--------|--------|--------|-------|-------|-------|--|--|--------|
| | BAR WEIGHT RANGE (grams) | 10-250 | 10-200 | 10-150 | 10-70 | 10-40 | 10-30 | | | |
| | MAXIMUM BAR LENGTH (mm) | 200 | 150 | 100 | 72 | 60 | 55 | | | |

| STAMPEX/4 & 4+ | PRODUCTION RATE (bars/minute) | 70 | 140 | 210 | 280 | 350 | 420 | | | | 480 mm |
|----------------|-------------------------------|--------|--------|--------|--------|-------|-------|--|--|--|--------|
| | BAR WEIGHT RANGE (grams) | 20-350 | 20-300 | 20-200 | 10-150 | 10-75 | 10-30 | | | | |
| | MAXIMUM BAR LENGTH (mm) | 250 | 200 | 130 | 100 | 75 | 60 | | | | |

| STAMPEX/6+ | PRODUCTION RATE (bars/minute) | | | 210 | 280 | 350 | 420 | 490 | 560 | 700 mm |
|------------|-------------------------------|--|--|--------|--------|--------|--------|--------|-------|--------|
| | BAR WEIGHT RANGE (grams) | | | 20-300 | 20-250 | 20-200 | 20-150 | 20-100 | 20-70 | |
| | MAXIMUM BAR LENGTH (mm) | | | 210 | 155 | 120 | 100 | 85 | 70 | |

| STAMPEX/8+ | PRODUCTION RATE (bars/minute) | | | | 280 | 350 | 420 | 490 | 560 | 920 mm |
|------------|-------------------------------|--|--|--|--------|--------|--------|--------|--------|--------|
| | BAR WEIGHT RANGE (grams) | | | | 20-300 | 20-250 | 20-200 | 20-150 | 20-150 | |
| | MAXIMUM BAR LENGTH (mm) | | | | 200 | 160 | 135 | 115 | 100 | |

Maximum Stamped Bar Width for all Models: 70 mm - Maximum Bar Thickness for all Models: 50 mm

| STAMPEX MODEL | | 1 | 2 | 3 | 3+ | 4 | 4+ | 6+ | 8+ |
|--|--------|-------|-------|-------|-------|-------|-------|-------|-------|
| Installed power (kW) | | 1,5 | 3 | 4 | 4 | 5 | 6 | 8 | 10 |
| Air consumption with Venturi vacuum system (liters/min. at 6 bars) | | 500 | 900 | 1,000 | 1,000 | 1,100 | 1,100 | 1,300 | 1,600 |
| Die Chiller Capacity (Kcal at -30°C) | | 1,000 | 1,500 | 2,500 | 2,500 | 3,000 | 3,000 | 4,000 | 6,000 |
| Machine Weight (Kg) | | 1,800 | 1,800 | 2,300 | 2,800 | 2,500 | 3,200 | 5,200 | 5,800 |
| Body Dimensions without infeed and discharge conveyors (mm) | Length | 1,750 | 1,750 | 1,750 | 1,750 | 1,750 | 1,900 | 2,140 | 2,200 |
| | Width | 700 | 700 | 800 | 900 | 950 | 1,040 | 1,200 | 1,450 |
| | Height | 1,500 | 1,650 | 1,800 | 2,150 | 1,800 | 2,150 | 2,150 | 2,250 |