

DATE: 11/10/95

MACHINE NUMBER: M-3167 CUSTOMER NAME:

SPECIAL INFORMATION SHEET.

FOR DOUGLAS MACHINE INFORMATION ONLY (NOT TO BE INCLUDED WITH THE CUSTOMER'S COPY OF THE MACHINE SPEC).

CUSTOMER REQUESTED SHIP DATE: Five months

COMMENTS AND CONCEPTS OF WHAT WAS SOLD: SR7-1124C with straight through capability for the wrap-around case.

Infeed concept: Direct link to tray former.

This machine is similar to: \_\_\_\_\_

Was A Hard Project Meeting Held:.....Yes \_\_\_ No XX

Hard Project Report Attached.....Yes \_\_\_ No XX

Machine Specifications:

A.1 Mechanical

A.1.1 Douglas standard.....Yes XX No \_\_\_  
A.1.2 Customer specifications.....Yes \_\_\_ No XX  
    A.1.2.1 Customer spec's attached.....Yes \_\_\_ No XX  
    A.1.2.2 Approved exceptions to customer  
            specifications attached.....Yes \_\_\_ No XX

A.2 Electrical

A.2.1 Douglas standard.....Yes XX No \_\_\_  
A.2.2 Customer specifications.....Yes \_\_\_ No XX  
    A.2.2.1 Customer spec's attached.....Yes \_\_\_ No XX  
    A.2.2.2 Approved exceptions to customer  
            specifications attached.....Yes \_\_\_ No XX

FINAL: 11/10/95:JG:jc

Salesperson: Gary Kluver \_\_\_\_\_

Designer: \_\_\_\_\_

Project Mgr: John Gilbertson \_\_\_\_\_

SHRINK WRAP SPEC SHEET

PURCHASE ORDER #: 12994

JOB NO: M-3167

PROPOSED SHIP DATE: Five months

QUOTE NO.: 95-000975

MACHINE NAME: SR7-1124C

CUSTOMER:

MACHINE DESTINATION:

1. SPEED REQUIRED FOR MACHINE: Variable up to 70 tpm per minute. (See Item #5 for maximum machine speed for each individual product size.) Conveyor through for wrap-around, eighty (80) trays per minute.

2. SIZE RANGE FOR MACHINE: Loose    Trayed XX

Dimensions:

	(Direction of Flow)	(Across Machine)	(Vertical)
Minimum:	8.75"	x 11.7"	x 7-1/2"
Maximum:	12.00"	x 18"	x 9-3/16"

3. SHRINK WRAPPER CONFIGURATION:

- 3.1 Stand alone.....Yes    No XX
- 3.2 Integrated.....Yes XX No   
  - 3.2.1 With Tray Loader.....Yes XX No
  - 3.2.2 With Stacker.....Yes    No XX
  - 3.2.3 Other.....Yes    No XX
- 3.3 Other.....Yes    No XX

4. MACHINE ORIENTATION AND CONVEYOR LENGTHS: (See Floor Plan #FP-951171 C)

4.1 Infeed height: 39"

4.2 Discharge height: 39"

4.3 Leg style:

4.3.1 Threaded Rod.....Yes XX No    

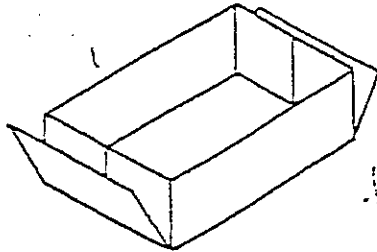
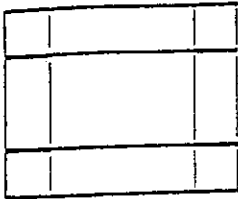
4.3.2 Square tube with threaded adjustment.....Yes     No XX

4.3.3 Stainless steel adjustment screws. Recommended for wet and washdown environments.....Yes     No XX

4.3.4 Other.....Yes     No XX

5. How is product received. Lugged from tray former.

6. SIZES AND SKETCH OF TRAY BLANK OR BUNDLE:



END SLOTTED TRAY

Product Reference From Item 5	Pack Pattern			Dir. Of Trvl (A)	Vert (B)	Across Mach (C)	Tray Depth (D)	Case Tray Speed
	A	B	C					
A. 16 ounce	4	3	1	8.7"	7-1/2"	11.68"	2 to 4-1/2	70 tpm
A. 16 ounce	6	4	1	11.68"	7-1/2"	17.52"	2 to 4-1/2	35 tpm
B. 20 ounce	4	3	1	8.7"	8-11/16"	11.68"	2 to 4-1/2	70 tpm
B. 20 ounce	6	4	1	11.68"	8-11/16"	17.52"	2 to 4-1/2	35 tpm
C. 500 ml	3	4	1	8.7"	7.8"	11.68"	2 to 4-1/2	70 tpm

6.1 Description: End slotted tray

7. SEQUENCE OF OPERATION:

Product is received on the infeed conveyor of the inline machine with the long dimension across the conveyor. The product is then sensed by a photo eye to start the wrapping sequence. Film, which has been automatically cut to the correct length, is conveyed by servo controlled vacuum belts to arrive and be positioned under the product as it arrives at the wrapping mechanism. The wrapping mechanism is a rotating wand which travels in an oval path, wrapping the film around the product and overlapping the opposite end which has been held in position under the tray. Following the wrapping section, each package is conveyed through the shrink tunnel where the bundle is sealed by contact with the heated, open web conveyor and the hot air passing through it. The controlled air flow in the upper tunnel assures a uniform shrink to the upper film and bullseyes.

7.1 Sketch of Operation: SEE FP-951171 C

7.2 Orientation of machine approved by Customer.....Yes XX No   

8. SHIPPING SIZE REQUIREMENTS: Other than Douglas Machine standard of less than 95" wide X 100" high x lengths determined by machine design.

9. FILM STANDS:

9.1 Single Roll, Single Spindle.....Yes    No XX

9.2 Single Roll, Double Spindle.....Yes    No XX

9.3 Side film stands: Location determined by equipment orientation.....Yes XX No   

9.3.1 Splice bar (Standard on SR60 & SR100).....Yes XX No   

10. TYPE OF WRAP:

10.1 Bullseye.....Yes XX No   

10.1.2 Film Width Required: 19", 24", 24" maximum

10.2 Complete Overwrap.....Yes    No XX

10.2.1 Film Width Required:       "

10.2.2 Squeeze Roller Kit.....Yes    No XX

10.3 Film Specification:

10.3.1 Suppliers Name:

10.3.2 Film Thickness:

10.3.3 Clear.....Yes XX No   

11. MACHINE FINISH

11.1 Purchased parts: Manufacturers standard finish.

11.2 Aluminum parts: Clear

11.3 Machine Frame:

11.3.1 Powder Coated. Recommended for wet or washdown environments.....Yes XX No   

11.3.1.1 Color: Powder Coated Steel Gray

Epoxy.....Yes XX No   

Other.....Yes    No XX

11.3.1.2 Brand: Tri-Mite

11.3.1.3 Paint Number: 616 Gray Metallic

11.3.1.4 Supplier:

11.3.1.5 Powder or Paint to be supplied by:  
Customer    Douglas XX

11.3.2 Hot dip galvanized.....Yes    No XX

11.4 Electrical Cabinets:

11.4.1 Powder Coated.....Yes XX No   

11.4.1.1 Color: Powder Coated Steel Gray

Epoxy.....Yes XX No   

Other.....Yes    No XX

11.4.1.2 Brand: Tri-Mite

11.4.1.3 Paint Number: 616 Gray Metallic

11.4.1.4 Supplier:

11.4.1.5 Powder or Paint to be supplied by:  
Customer    Douglas XX

11.4.2 Stainless steel enclosure. See electrical section.

## 11.5 Machine Guards:

11.5.1 Powder Coated posts with lexan upper doors and panels and sheet metal lower doors and panels. Recommended for all environments.

11.5.2 Post Color: Powder Coated Steel Gray

11.5.2.1 Powder Coated.....Yes XX No   

11.5.2.2 Lexan Color:

11.5.2.2.1 Clear.....Yes XX No   

11.5.2.2.2 Tinted.....Yes    No XX

11.5.2.3 Lower sheet metal doors and panels:

11.5.2.3.1 CRS powder coated....Yes XX No   

11.5.2.3.2 Brushed stainless steel.....Yes    No XX

## 11.6 Fabricated Stock Parts:

11.6.1 Nickel plated, standard.....Yes XX No   

11.6.2 Zinc plated.....Yes    No XX

11.6.3 QPQ.....Yes    No XX

## 11.7 Other Fabricated Parts:

11.7.1 Zinc plated.....Yes XX No   

11.7.2 Nickel plated. Recommended for wet and washdown environments.....Yes    No XX

11.7.3 QPQ. Lead screws, mating blocks, spline shafts and spline hubs. Recommended for wet and washdown environments.....Yes    No XX

11.7.4 Lexan or Stainless Steel sheet metal hood for protection against product spillage and clean-up overspray on Torque Limiting Clutches and Disc Brakes. Recommended for washdown or wet environments.....Yes    No XX

## 11.8 Fabricated parts that contact product or tray.

11.8.1 Stainless steel or chrome plated steel....Yes XX No   

11.8.2 Stainless steel only. Recommended for wet and washdown environments.....Yes    No XX

11.9 Stainless steel line shaft. Recommended for wet and washdown environments.....Yes    No XX

11.10 Nickel plated drive and flight chains and stainless steel hand adjustment chains. Recommended for wet and washdown environments.....Yes    No XX

11.11 Stainless steel fasteners. Recommended for washdown environments.....Yes    No XX

12. LANE DIVIDER REQUIRED.....Yes \_\_\_ No XX

12.1 Lane Divider Brand and Model to be used:

13. LUBRICATION SYSTEM REQUIRED.....Yes XX No \_\_\_

13.1 Douglas Grease Banks.....Yes XX No \_\_\_

13.1.1 Aluminum cluster blocks with copper clad carbon steel tubing and 1/8" nylon flexible tubing.....Yes XX No \_\_\_

13.1.2 Other.....Yes \_\_\_ No XX

13.2 Lincoln Central Lubrication.....Yes \_\_\_ No XX

13.2.1 One shot.....Yes \_\_\_ No XX

13.2.2 Auto pump.....Yes \_\_\_ No XX

13.2.3 Plated steel manifolds with copper clad carbon steel tubing and 1/8" nylon flexible tubing.....Yes \_\_\_ No XX

13.2.4 Other.....Yes \_\_\_ No XX

13.3 Other Grease System.....Yes \_\_\_ No XX

13.4 Lubrication points or types of bearings requiring lubrication:

Grease banks and grease lines for lubricating non-sealed bearings and bushings, sealed linear bearings, and sealed bearings which have shafts that rotate 360° or more during each machine cycle. Lubrication would be performed with a manually operated grease gun. The grease fittings would be mounted in clusters on the upper perimeter of the machine's frame for convenient servicing. Each fitting will have a color coded disc to indicate frequency of lubrication required. Rod ends would have their standard grease fittings.

13.5 Type of Grease in System:

13.5.1 Non-Edible.....Yes XX No \_\_\_

13.5.2 Edible.....Yes \_\_\_ No XX

13.6 Chain Oilers: Recommended for washdown environments on driven chains with exception of magazine drive.....Yes \_\_\_ No XX

13.7 Type of oil in system.

13.7.1 Non-Edible.....Yes \_\_\_ No XX

13.7.2 Edible.....Yes \_\_\_ No XX

NOTE: Edible oil not available in sealed gear heads and indexers.

14. BRAND OF MOTORS:

14.1 Douglas Choice (Reliance).....Yes XX No    

14.2 Type: TEFC

14.2.1 Standard.....Yes XX No    

14.2.2 Easy Clean Plus Motors up to 3-hp and Easy Clean Motors  
3-hp and larger. Recommended for wet and washdown  
environments.....Yes     No XX

14.2.3 Dirty Duty. Recommended for washdown  
environments.....Yes     No XX

14.3 Other. (Customer Specification).....Yes     No XX

15. TUNNEL MANUAL ADVANCE HANDWHEEL.....Yes     No XX

16. HARDENED SPROCKETS.....Yes     No XX  
(30 Teeth Or Less, Drive Chain Only.)

17. CONTINUOUS WELD.....Yes     No XX

18. SKIP WELD.....Yes XX No    

19. ADJUSTMENT INDICATORS.....Yes XX No    

19.1 Scales in inches.....Yes XX No    

19.2 Other.....Yes     No XX

20. PLANT VOLTAGE

20.1 480V-3ph-60Hz.....Yes XX No    

20.2 Other.....Yes     No XX

21. CONTROL VOLTAGE

21.1 24V DC (Standard if PLC is used).....Yes XX No    

21.2 120V AC.....Yes     No XX

21.3 Other.....Yes     No XX

22. NEMA RATING (ELECTRICAL COMPONENTS):

- 22.1 NEMA 12.....Yes  No
- 22.2 NEMA 4. Recommended for wet environments.....Yes  No
- 22.3 NEMA 4X. Includes stainless steel cabinets.  
Recommended for washdown environments.....Yes  No
- 22.4 Other.....Yes  No

23. CONDUIT:

- 23.1 Rigid Aluminum (Standard). Can be used for all environmental conditions offered.....Yes  No
- 23.2 Galvanized. Can be used for all environmental conditions offered.....Yes  No
- 23.3 Other.....Yes  No

24. PROGRAMMABLE LOGIC CONTROLLER:

- 24.1 Allen Bradley SLC 5/02.....Yes  No
- 24.2 Other.....Yes  No

25. ELECTRICAL OPTIONS:

- 25.1 Alphanumeric Display / Operator Interface
  - 25.1.1 Vorne (Standard on Continuous Motion).....Yes  No
  - 25.1.2 Allen-Bradley Dataliner.....Yes  No
  - 25.1.3 Other.....Yes  No
- 25.2 Variable Frequency Drive
  - 25.2.1 Allen-Bradley 1333.....Yes  No
  - 25.2.2 Allen-Bradley 1336 (Standard Continuous)...Yes  No
  - 25.2.3 Lugged to tray former (conveyor tunnel drive (Euro) not Reeves).....Yes  No
- 25.3 Programmable Limit Switch
  - 25.3.1 Electro Cam 5004 (Standard Continuous).....Yes  No
  - 25.3.2 Other.....Yes  No

- 25.4 Alternate Control Panel
- 25.4.1 Partial (Start/Stop, No Fault Indication)..Yes \_\_\_ No XX
- 25.4.2 Complete (Start/Stop, w/Fault Indication)..Yes \_\_\_ No XX
- 25.5 Red Strobe for Shutdown Conditions.....Yes \_\_\_ No XX
- 25.6 Amber Strobe for Non-Shutdown Conditions.....Yes \_\_\_ No XX
- 25.7 Stackable Light
- 25.7.1 Red Light for Shutdown Conditions.....Yes \_\_\_ No XX
- 25.7.2 Amber Light for Non-Shutdown Conditions....Yes \_\_\_ No XX
- 25.7.3. Green Light for Machine Running.....Yes \_\_\_ No XX
- 25.7.4. Other.....Yes \_\_\_ No XX
- 25.8 Start-up Delay with Horn.....Yes \_\_\_ No XX
- 25.9 Warning Horn for Shutdown Conditions.....Yes \_\_\_ No XX
- 25.10 Downstream Surge Control.....Yes XX No \_\_\_  
(Dwells machine if surge is detected) Wire and J-box for  
downstream signal.
- 25.11 Separate Conduit Runs for Control and Power
- 25.14.1 24V DC / 90V DC, 120-480V AC.....Yes \_\_\_ No XX
- 25.14.2 120V AC / 90V DC, 240-480V AC.....Yes \_\_\_ No XX
- 25.14.3 Other.....Yes \_\_\_ No XX
- 25.12 Isolation Transformer for PLC
- 25.15.1 Topaz.....Yes \_\_\_ No XX
- 25.15.2 Sola.....Yes \_\_\_ No XX
- 25.13 Additional Emergency Stops/Machine Lockouts.....Yes \_\_\_ No XX  
(Two Standard) \_\_\_\_\_ Additional
- 25.14 Emergency Stop Pull Cords.....Yes \_\_\_ No XX
- 25.15 Additional Disconnects
- 25.18.1 Remote Safety Disconnect \_\_\_ Additional....Yes \_\_\_ No XX
- 25.18.2 Glue System Disconnect.....Yes \_\_\_ No XX
- 25.16 Flange Mounted Main Disconnect.....Yes \_\_\_ No XX
- 25.17 Remote Mounted Electrical Enclosure.....Yes \_\_\_ No XX
- 25.17.1 Wiring harness provided by Douglas.....Yes \_\_\_ No XX

- 25.18 Enclosure Light for Remote Enclosure.....Yes  No
- 25.19 Elevated Main Control Enclosure.....Yes  No
- 25.20 Stainless Steel Electrical Enclosures.....Yes  No

26. WARRANTY:

- 26.1 Warranty other than standard twelve (12) months....Yes  No

27. MISCELLANEOUS:

- 27.1 Spare parts kit.....Yes  No
- 27.2 J-box for downstream surge and input.
- 27.3 Eurodrive conveyor.

SPEC SHEET

JOB NO.: M-3167

SPEC SHEET

PURCHASE ORDER #: 12994

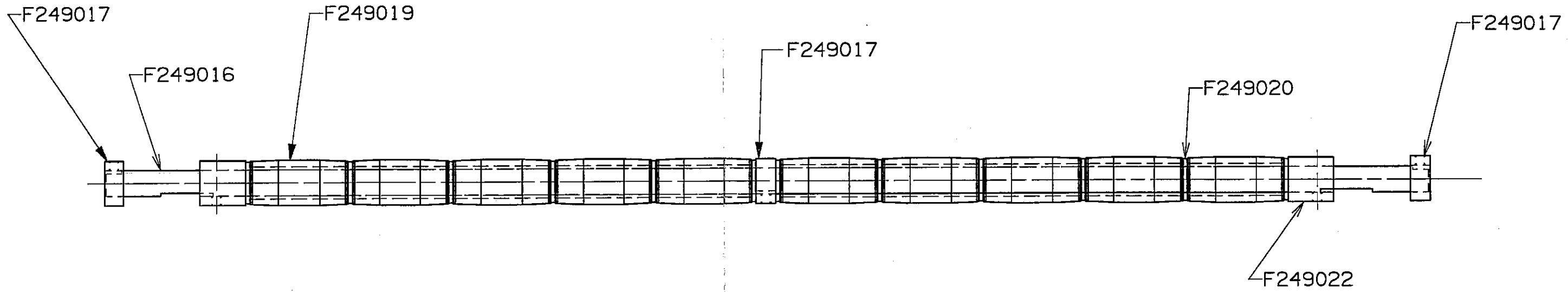
JOB NO.: M-3167

PROPOSED SHIP DATE: Five months

QUOTE NO.: 95-000975

MACHINE NAME: SR7-1124C

*Integrated Tray - former/Loader*



ITEM	F #	QTY/ASSY	DESCRIPTION
1	F249016	1	THOMSON SHAFT
2	F249017	3	ROUND SPACER
3	F249019	10	OILUBE ROLLER
4	F249020	12	WASHER
5	F249022	2	ROUND SPACER
6	N85615	20	OILUBE BUSHING
7			

REV	DESCRIPTION	DATE	BY
A	XXXXX	XXX	XXX

PROJECT #	3									
	2									
	1									
ITEM	PART #	QTY	U/H	ID	DESCRIPTION	LENGTH	CUTT	COMM	XTRA	
BILL OF MATERIAL / PURCHASED										
PR #:	MACH.	WELDER					Q.C.			
<b>DOUGLAS MACHINE</b> ALEXANDRIA, MINNESOTA 56308 <b>CONFIDENTIAL INFORMATION</b>						THIS DRAWING IS THE PROPERTY OF DOUGLAS MACHINE AND IS NOT TO BE USED OR REPRODUCED WITHOUT THEIR PERMISSION.				
QTY:	TOLERANCE UNLESS OTHER- WISE SPECIFIED	NAME: CONVEYER ROD ASSY								
	.00 ±.010	SCALE: 1/2	DRAWN BY: BJZ			DATE: 2/24/97				
	.000 ±.005	DSG	AST	DET	DRAWING NO:					
	FRAC ±1/64	REF#:		SASY	DWG SZ: B	F249023				
	ANGLE ±1/2°									