

# Solution of Linear Filling Line for Filling Bottles

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## Solution of Linear Filling Line for Filling Bottles with Shampoo, Liquid soap, Rinse, Dye hair

As an experienced filling machine provider, we are glad to share with you the following solution of a linear filling line for filling bottles with shampoo, liquid soap, rinse, and dye hair.

The solution consists of three main parts: Automatic 12 Nozzles Servo Piston Filling Machine, Automatic Servo 4 Wheels Capping Machine, as well an Automatic Sleeve Labeling Machine HY200 + Bottom wrapping machine + 2m steam shrinkage tunnel + 2m blow dryer.

### Part 1. Automatic 12 Nozzles Servo Piston Filling Machine HY-VF12



### Parameters

<b>Filling Nozzles</b>	12 Nozzles
<b>Production Capacity</b>	70BPM
<b>Filling Volume</b>	100-1200ML
<b>Power</b>	4000W, 220VAC
<b>Accuracy</b>	±2-4ML
<b>Driven</b>	Servo Motor
<b>Interface</b>	Touch Screen

### Servo Drive System

The HY-VF series volumetric filling system utilizes the delicate servo drive system to control the main filling structure, achieving high stability and precise positioning. With the vertical movement of the filling piston provides long term energy saving and also

effectively reduces machine load rate.

### **Tool-Free Adjustment**

Adjustments can be made through the PLC, completely tools-free, giving users a fast and efficient result. The delicate servo control system design provides options for surface layer liquid filling, bottom layer liquid filling, and bottle neck (opening) filling accordingly with different types of liquids.

### **High Accuracy**

The delicate servo system controls the filling amount through precise piston strokes, providing high filling accuracy. The piston is intelligently designed with an adjusting mechanism to enable users to obtain ultimate higher accuracy.

### **High Adaptability**

The Automatic Servo Filling Machine can be used in food, pharmaceuticals, chemicals, cosmetics, and other industries.

### **Other Features**

1. Controlled by Schneider servo system.
2. Adjustable filling speed.
3. Accurate to  $\pm 2-4$ ML (with drinking water).
4. Integrated digital control with Schneider PLC and high tech touch screen controls for easy operation.
5. Designed for easy changeover and cleaning.
6. Professional manufacturing techniques using the ISO-9001 system.
7. GMP standard stainless steel.
8. Bottom-up filling for option.
9. Bottle neck location.
10. No bottle-no fill system.
11. Filling zone protected by stainless steel frame.
12. Volume is easily adjusted through touch screen. Filling pistons are controlled by servo system.
13. Individual piston adjustment.
14. Digital control system to enable multiple filling actions on the same bottle for double, triple and more.
15. Nozzles can set to be above bottle mouth or bottom up, synchronizing with liquid level (beneath or above) to eliminate bubbling of foamy liquids.
16. Three-step-filling, it can fill slowly at the beginning and then accelerate to faster speed, finally slow down once again to finish up. This can prevent foamy liquids from bubbling and avoid spillage.



### Advantages of servo system

1. Volume Setting by touch screen, digital display
2. Further Accuracy Adjustment by touch screen
3. TBI screw lead adapted, higher accuracy
4. 3-step filling, low speed for bottom layer and mouth layer, high speed for middle layer, this can prevent foamy liquids from bubbling and avoid spillage and get more filling efficiency.

### Tool Free and no-blind-corner piston

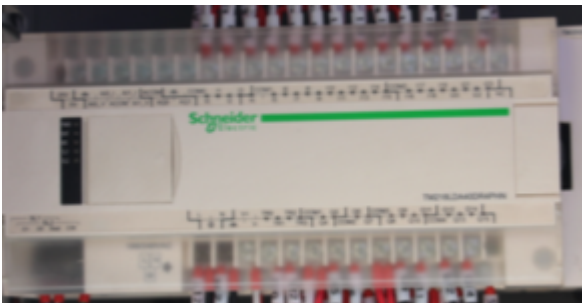


### Anti-Drop Filling Nozzles

The filling nozzles adapt pneumatic valve to prevent drop and leakages.



Siemens PLC



Schneider Relay



Touch Screen Operation

**Menu** 24:00:00

**Bottle In Light** ● **Bottle Out Light** ●

**Feeding Light** ●

Auto Manual Setting

Alarm List Power Off Language

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**Setting 2** 24:00:00

Servo Delay **12.12** S Servo Return Delay **12.12** S

Filling volume **1234.1** ML Frontpart Speed **12.1** R/S

Forepart Filling volume **1234** ML Midpart Speed **12.1** R/S

Lastpart Filling volume **1234** ML Lastpart Speed **12.1** R/S

Return Speed **12.1** R/S

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Components List

Automatic Servo Filling Machine				
No.	Descriptions	BRAND	ITEM	Remark
1	Servo Motor	INOVANCE	3KW	/
2	Reducer	Taifu	ATF1205-15	/
3	Conveyor Motor	ZhenYu	YZ2-8024	/

4	servo drivers	Panasonic	LXM 23DU15M3X	/
5	PLC	Siemens	TM218LDALCODR4PHN	/
6	Touch Screen	Siemens	HMZGXU3500	/
7	Frequency Converter	Schneider	ATV12H075M2	/
8	Photo electricity of Inspect bottle	Keyence	BRF-N	/
9	Pneumatic Element	Airtac	/	/
10	Rotary Valve	/	F07/F05	/
11	Pneumatic actuator	/	F07/F05	/
12	Low-Voltage Apparatus	Schneider	/	/
13	proximity switch	ROKO	SC1204-N	/
14	Bearing	NSK	/	/
15	Lead Screw	TBI	/	/
16	butterfly valve	CHZNA	/	/
17	Screw Lead Bearing	NSK	/	/
18	Straight Bearing	NSK	/	/
19	Sliding Bear	IGUS	/	/

## Part 2. Automatic Servo 4 Wheels Capping Machine



### Parameters

<b>Capping Head</b>	1 Head
<b>Production Capacity</b>	30-80bpm
<b>Bottle Height</b>	Up to 460MM
<b>Cap Diameter</b>	Up to 70MM
<b>Voltage/Power</b>	220VAC 50/60Hz 450W
<b>Driven way</b>	Motor with 4 wheels
<b>Interface</b>	Touch Screen
<b>Spare Parts</b>	Capping Wheels

## Introduction

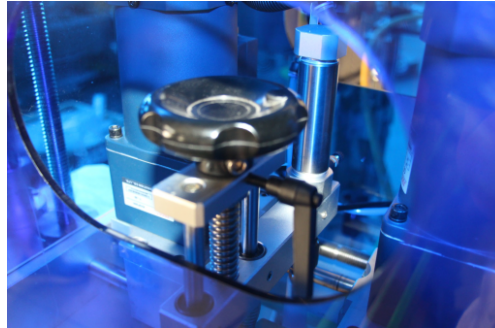
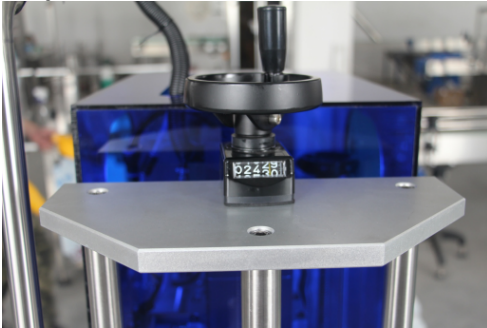
The main structure is made of durable 304 stainless steel. The machine is control by touch screen, parameter can be set on touch screen very easily. It is very flexible for different sizes of round bottles, square bottles and flat bottles by adjustment. Capping time can be set to fit different caps and different levels of tightness. It is very easy for exist line upgrade.

## Main Features

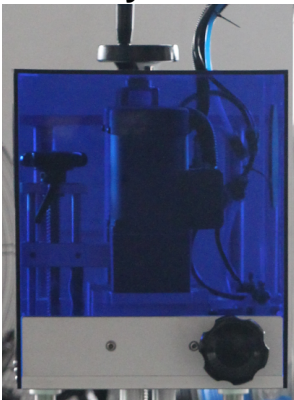
1. Controlled by touch screen.
2. Adjustable for different sizes and shapes of caps and bottles.
3. Bottle Clamp belt bottle in system is optional for upgrade capping speed.
4. Integrated digital control with PLC and high tech touch screen controls.
5. GMP standard stainless steel.
6. Suitable for pump caps, trigger caps, normal screw caps.

## Height Adjustment Adjustment

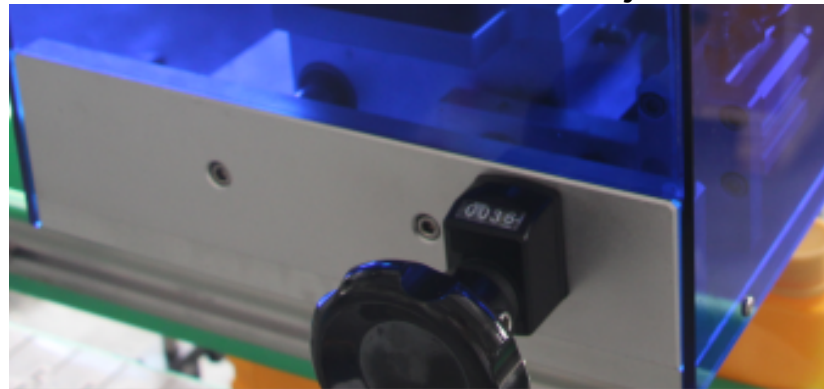
Press



## Security Cover



## Diameter Adjustment



## Main Component List

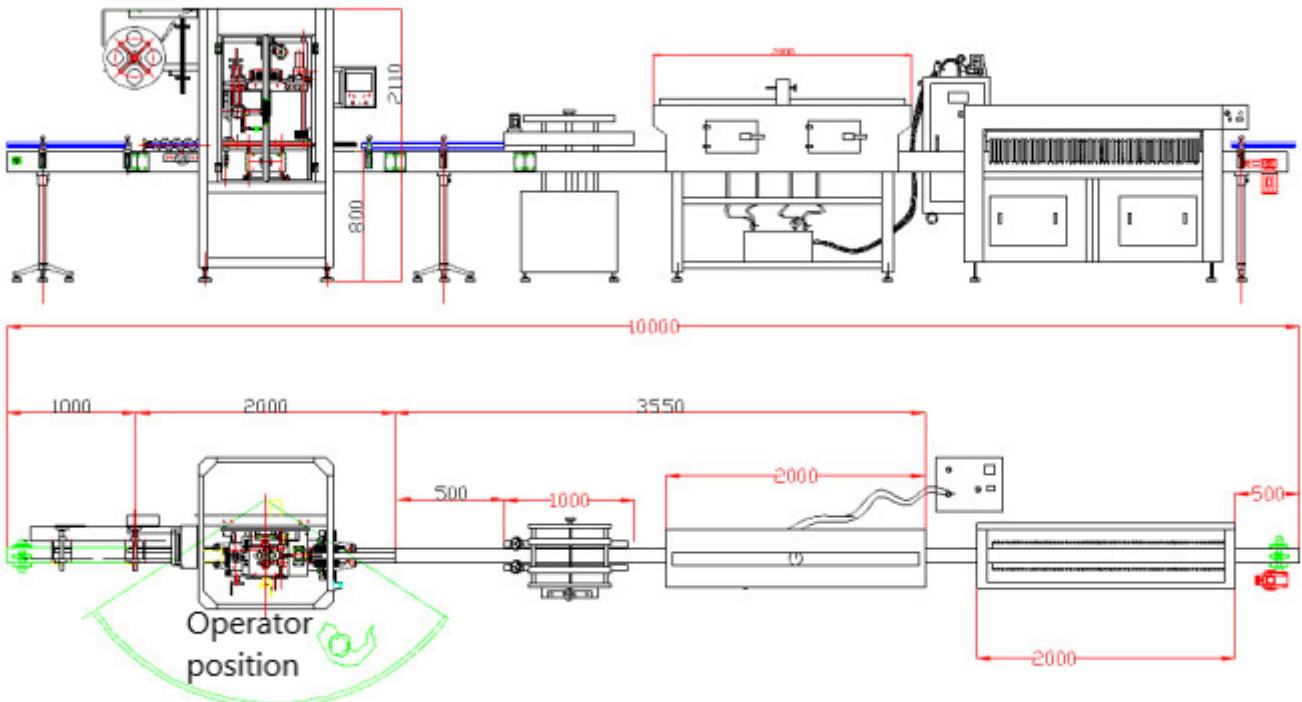
Servo 4 Wheel Capping Machine				
No.	Descriptions	BRAND	QTY	Remark
1	Capping Motor	INOVNACE	4 SETS	Servo Motor
2	Gear Box	/	4SETS	Planet type
3	Touch Screen	SIEMENS	1SET	/
4	PLC	SIEMENS	1SET	/
5	Pneumatic Cylinder	AIRTAC	3SETS	TAIWAN
6	Air Filter	AIRTAC	/	TAIWAN
7	Solenoid Valve	AIRTAC	2SET	TAIWAN

8	Main Structure	/	/	304SS
9	Bottle Fiber Sensor	Keyence	1SET	JP

### Cap Sorting Elevator



### Part 3. Automatic Sleeve Labeling Machine HY200 + Bottom wrapping machine + 2m steam shrinkage tunnel + 2m blow dryer



**Note:** the above layout shows the configuration of Automatic Sleeve Labeling Machine HY200 + Bottom wrapping machine + 2m steam shrinkage tunnel + 2m blow dryer. When connecting the above equipment, double row parallel connecting conveyor belts shall be equipped at the front and rear. The drawing above is the standard layout of the



equipment, and the actual connection shall be subject to the customer site requirements. Among them, the labeling machine, bottom wrapping machine and steam shrinkage tunnel must be configured. The steam generator can be replaced by boiler, but the sufficient and stable gas source shall be ensured. The blow dryer is used to blow off the water droplets on the surface of the bottle after the steam shrinks.

#### Automatic Sleeve Labeling Machine HY200



#### Technical Parameters

Model	HY-200P
power(kw)	3.0
Voltage(v).	220V AC
Production Speed(b/min)	100-200
Applicable Product Diameter(mm)	φ38—φ120 (Subject to the actual product)
Applicable Label Length(mm)	30~220
Applicable Label Thickness(mm)	0.03~0.13
Paper tube diameter(mm)	5”~10” Free adjustment
Equipment dimensions (mm)	2100L*900W*2000H
Equipment weight(kg)	280kg

description

The labeling machine adopts photoelectric signal

sensing, and the PLC processor converts the photoelectric signal to give mechanical

instructions to each servo motor and driver assembly of the equipment, so as to cooperate to complete the actions such as feeding the label of the material tray, moving the label up and down on the guide column, brushing the next wheel and brushing the label after the cutter head is cut off.

(2). After the bottle sensor of the labeling machine senses that the material is transmitted on the conveyor belt, the PLC starts to process the signal and issue the work order within 1 second. The components such as bottle system, material tray system, material rack system, drive system, bottle system, brush down system and brush system cooperate to complete the action of covering the label or transparent film to the material.

(3). The main body of the whole machine is made of 304# stainless steel, which is corrosion-resistant and does not rust. It strictly meets the food safety standards. The parts in contact with the materials are non-toxic and free of harmful substance pollution.

(4). The sleeve labeling machine adopts a complete set of imported electrical equipment configuration, which is processed by Siemens PLC and screen. It is equipped with Japanese Panasonic Optoelectronics, French Schneider servo motors, and French Schneider servo drives. The equipment has excellent electrical quality and stable and reliable quality.

(5). Within the scope of the standard machine, the sleeve labeling machine makes the corresponding central guide column according to different material sizes or bottle and tank sizes. After replacing the guide column and label film for labeling, one machine can be compatible with material labeling packaging of multiple sizes. When the size difference of materials is too large, in addition to replacing the corresponding central guide post and label film, it is also necessary to replace the cutter head for cutting labels.

(6). According to the design of the label film, the sleeve labeling machine is divided into ordinary photoelectric recognition and transparency segment cutting, color code photoelectric fixed-point recognition and cutting, and fully transparent unprinted film fixed-length cutting.

Note: The standard machine is equipped with ordinary photoelectric, which cannot identify the label film with positioning points, but the full transparent film fixed-length mode can be used.

(7). When the labeling machine uses materials within the compatible range for production, in addition to replacing the central guide column and label film, it is also necessary to adjust the height of the machine and the front and rear positions of photo bottles in combination with the size of materials. There is special equipment operation training during equipment installation and commissioning. Please pay attention to learning to achieve the purpose of skilled use of equipment.

(8). The technology of the labeling machine is mature, but attention should be paid to the voltage fluctuation of the power grid during use. In case of frequent voltage instability in the local area, a voltage regulator should be installed on the equipment use site to prevent precise damage to the electrical appliances of the labeling machine caused by voltage fluctuation. When the labeling machine equipment is exported abroad, the local voltage used by the equipment shall be known in advance, and the transformer shall be configured in front of the labeling machine.

(9). For 500ml standard bottles with label height less than 80mm, the fastest labeling speed can reach 500 bottles per minute; If the label height is within 170mm, the fastest labeling speed can reach 300 bottles per minute.

## Application scope

Automatic Sleeve Labeling Machine is applicable to multi-functional automatic labeling machine for round bottles, flat bottles, square bottles, curved bottles, cup-shaped products in food and beverage, medical treatment, daily chemical and other light industries.

## Main features

- (1) The sleeve labeling machine adopts German Siemens electrical configuration, PLC processing is more accurate and stable, the error of standard setting is small, and the accuracy is high. After debugging, there is no standard leakage and no set leakage.
- (2) Adopting 304# stainless steel frame structure, high-quality aluminum parts, NSK Bearings from Japan and gates drive belt from the United States.
- (3) Adopting a dual language operating system and an interactive interface in Chinese and English. The machine appearance and operating system language can be customized according to customer needs. Our equipment is exported to Southeast Asia, Myanmar, Vietnam, Cambodia, Thailand and other countries, as well as Japan, South Korea, Russia, Nepal, Ethiopia and other countries.
- (4) Applicable to the industries of water, beverage, cosmetics, condiments and daily chemical products. It is applicable to the labeling and packaging of bottles, cups, boxes, round, square and conical products.

## Bottom wrapping machine



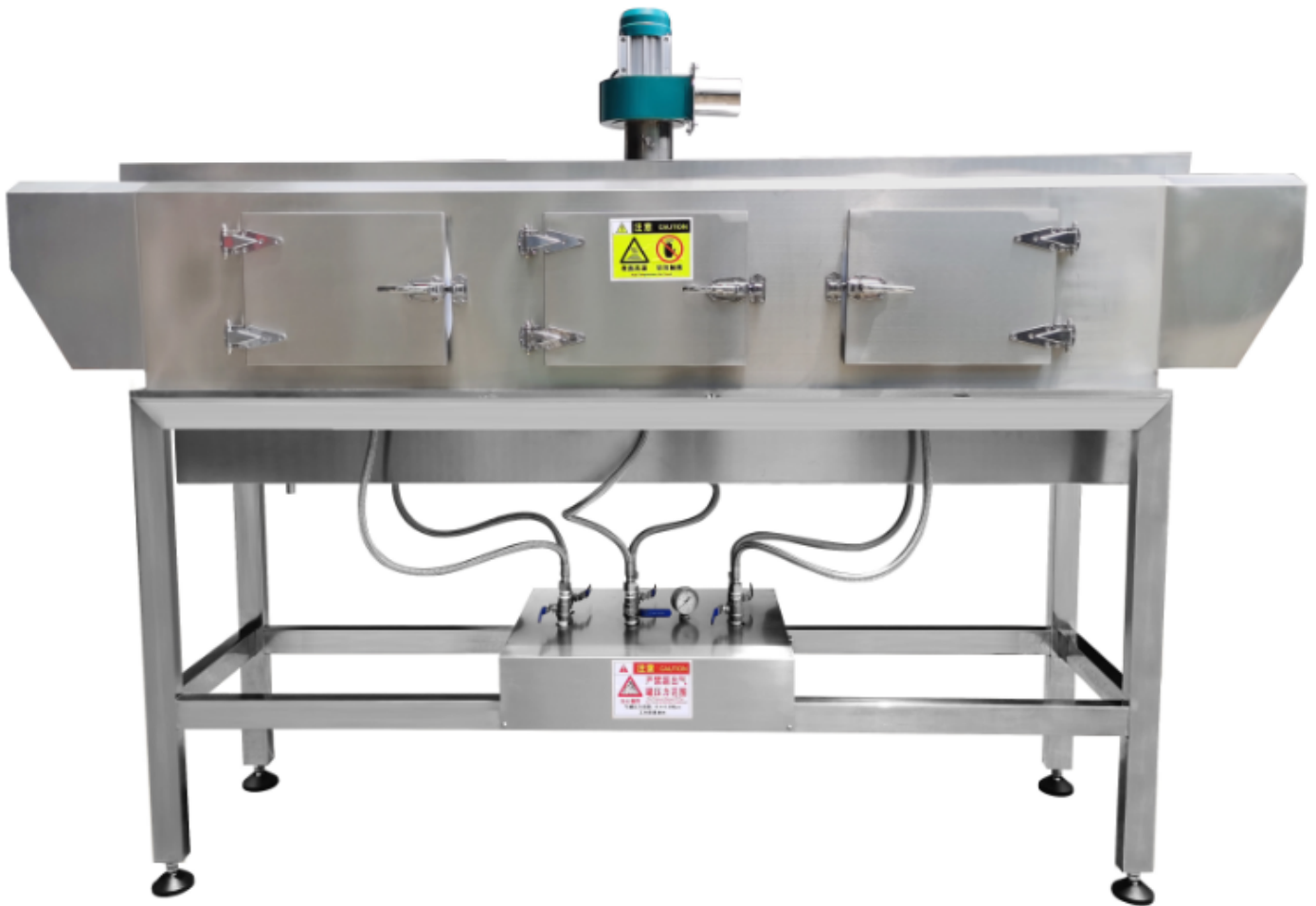
Overall dimension: 1000x550x1250mm

Drive motor	2pcs
Bottle clamping system	1 set
Hot air gun	Industrial grade, 2 sets (of which the hot core is consumables, and the hot core needs to be replaced in half a year or one year according to the use condition)

## Function Description

The bottom wrapping machine is used to hold up the bottle on the conveyor belt after the special-shaped bottle is covered with pvc sleeve label, and wrap the bottom of the bottle

through preheating shrinkage after the label falls 3-5mm, so that the shrinkage effect will not be affected due to the lack of adhesion at the bottom. (Remark: The samples of the customer's bottles are required, if it is confirmed that the normal sleeve label shrinkage can wrap the bottle bottom, the bottom wrapping machine may not be configured.)  
 Steam shrinkage furnace HY-RSL2.0



### Technical Parameters

Name	Steam shrinkage furnace
Model	HY-RSL2.0
Input power (kw)	0.35
Input voltage (v)	220V/50HZ
Working Pressure (Mpa)	≤0.1Mpa
Steam consumption (kg/h)	10~20
Conveying speed (m/min)	0-35
Outward Size (mm)	L2000*W400*H1500
Weight (kg)	100

### Description

The new type of steam shrinkage furnace is designed with seamless steel tube and has three adjustable nozzles for different and irregular cylinder shapes, such as round, square and flat cylinders.

The adjustment and maintenance are convenient, the shrinkage is flat, the distribution of low pressure sub-drum of steam ejection mode is uniform, and the ejection nozzle is divided into three sections. The height of each section, the front and back and the out gassing volume can be adjusted separately to reach the maximum. Perfect contraction

effect realm.

The shell of the whole machine is made of stainless steel and insulated. It not only saves energy, but also meets the international safety standards. The stainless steel water receiving pan at the bottom concentrates condensation water. The whole machine adopts waterproof design, easy operation and maintenance.

High pressure blow dryer



### Technical Parameters

Machine name	Type	Volume
HY-2000 blow dryer	2M	2000x700x1600
Motor model: RAETTS-85 Speed: 21500 rpm		

### Description

The blow dryer is made of 304# stainless steel, with 32 air nozzles on the left and right sides. The blow dryer uses a high-pressure blower and strong airflow to quickly dry the water on the outer surface of the bottle/can.

### Main features

1. High-speed wind blowing into the wind channel causes a wind tunnel effect, which enhances and maintains high wind speed, making it easier for water to be blown away.
2. The air trough can be equipped with top blowing/neck blowing and bottom blowing functions to make the drying complete at one time and solve the problem of bottle caps that are difficult to dry.
3. The air trough can be easily adjusted according to the diameter and height of the bottle/can, so that the efficiency is better and the adjustment is easier.
4. The air trough and a variety of other accessories are made of 304 stainless steel

(materials that meet food hygiene requirements)

5. With drainage and exhaust (wet) air ports, it is convenient for water diversion and exhaust.

6. The air duct is made of sound-absorbing materials and can be covered with a transparent sound-absorbing cover (optional accessory), which is convenient for monitoring and can reduce noise.

7. Suitable for drying round bottles, round cans, square bottles, square cans, large bottles, small bottles and condensate bottles.

