

› INCORPORATING RODA

GANDRIA

Perfect Square Cut



FEEDING TABLE AND FEEDING ROLLERS



Product is fed into the machine by hand. The feeding table helps the operator supporting the board while feeding it in the master controlling rollers for forward feeding; a pneumatic system automatically adjusts the infeed roller nips to the caliper of the material being processed.

CREASING AND SCORING AREA



Scoring and creasing area is positioned after feeding rollers. It consists in a bridge where tools can be installed to act on the counter tool, applied on lower motorized shaft. For special applications the bridge can be replaced with a motorized shaft to have motorized tools also on the top.

COLLECTING CONVEYOR



Cut pieces are orderly shingled out onto the collecting table. A roller system, in front on the table, allows a correct forming of the shingle. The pieces can be collected in continuous mode or divided in pre-counted batches by the table.

TOUCH SCREEN / ELECTRICAL CABINET



Machine is controlled and operated from the touch screen panel installed on electrical cabinet. From this HMI the operator processes and save data related to the different products to be recalled for the next production.

SOLEMA GANDRIA is designed for accurate, high volume production of blanks in corrugated board for various type of packaging, reinforcements and inner fitments for cartons and boxes, protection packages, pads, filling and blanks.

The machine allows fast and precise cutting of corrugated board, solid fiber board, padded board/press pan, acetate, foam and plastic materials with different thicknesses.

SOLEMA GANDRIA is a machine integrating RODA technology that offers many advantages and unique points integrated into the same machine. All the processes are possible within an automatic single pass operation reducing labor costs.

Moreover, the ability to process two sheets in a single pass, can double the productivity.

Every piece is cut absolutely square, due to unique combination of slitting and crosscutting in a single pass while the board is always positively held and driven.

The electronic sheet advance controlled via electrical shaft provides absolute crosscut repeatability.

SOLEMA GANDRIA cut technique delivers only clean and sharp edges, without dust, and trim waste is automatically ejected from the delivery table.

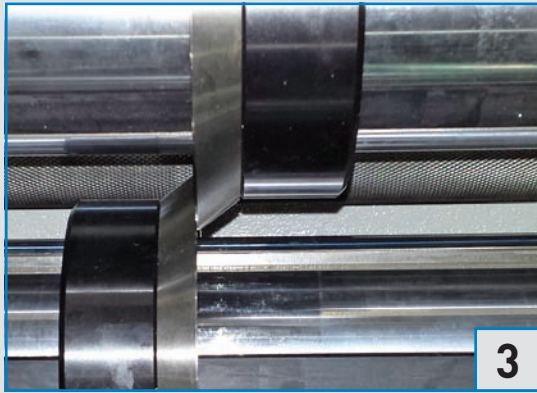
The machine is ideal for long runs but also, thanks to the simple and fast set-up, very versatile for short runs.

Sheet advance is adjusted at the operator display, mounted on the electrical cabinet. Job length changes and fine-tuning can be carried without stopping the machine. Real-time production data is displayed automatically on the screen.

FINISHED PRODUCT

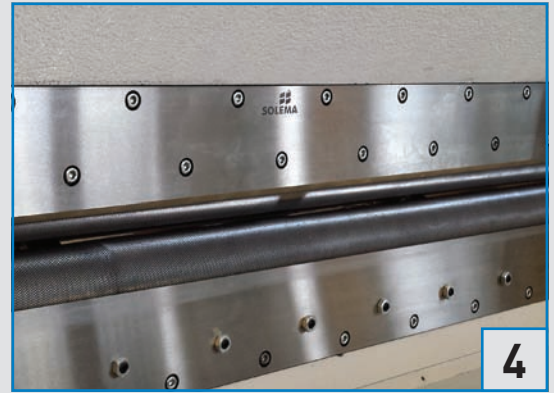
- STRIPES
- PADS / PROTECTIVE PADS
- PADDED BOARD
- FILLERS

ROTARY SLITTING KNIVES



Knives are positioned manually along their respective shaft and locked by means of a screw acting on a longitudinal key. Special perforation knives are available upon request. Perforation (pre-tear) is particularly suited to ease the collection of small pieces.

CROSS CUTTING BLADES



Crosscut is done through two superimposed blades that move upwards (lower blade) and downwards (upper blade), cutting the sheet crosswise. Cutting speed is automatically set. Control of the crosscutting length is secured by a motor integrated resolver.

WASTE CONVEYOR BELT

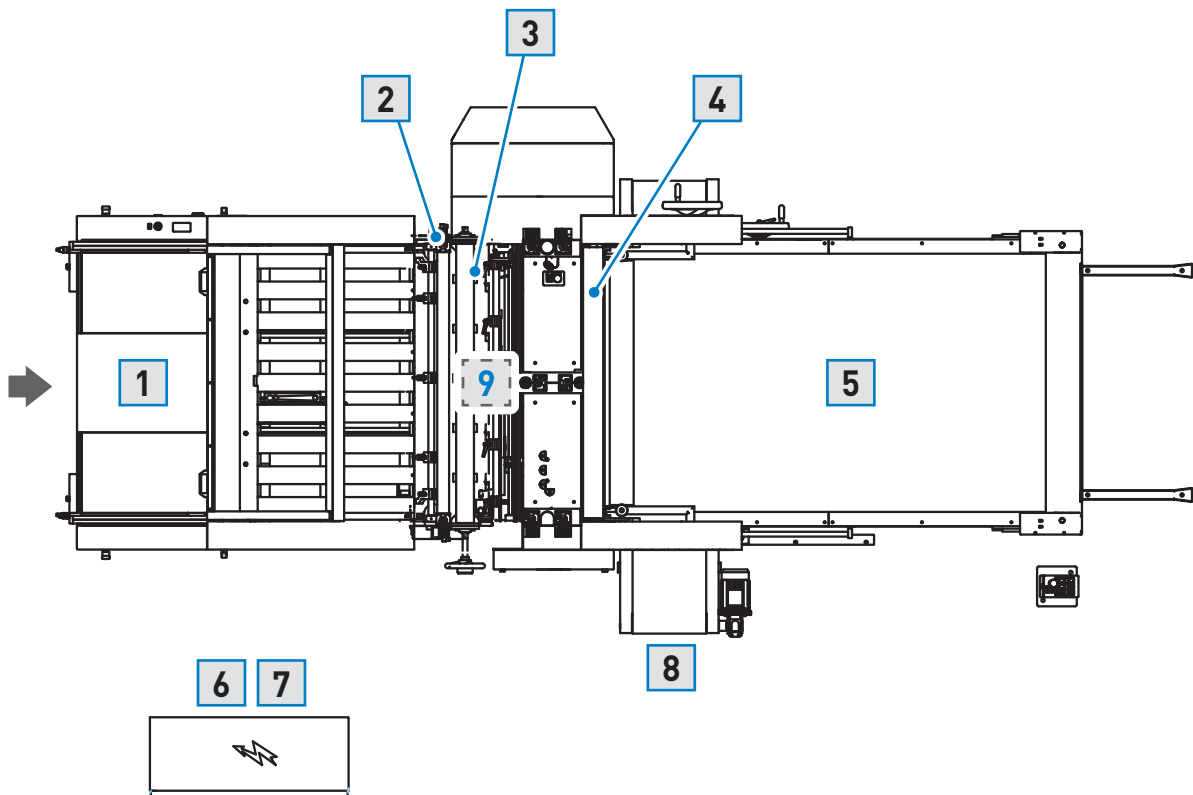
Every cutting operation produces scrap which are removed by a conveyor located under the machine. Lateral scraps are carried with a roller system (waste remover) to the scrap chute and then ejected by the same conveyor belt.

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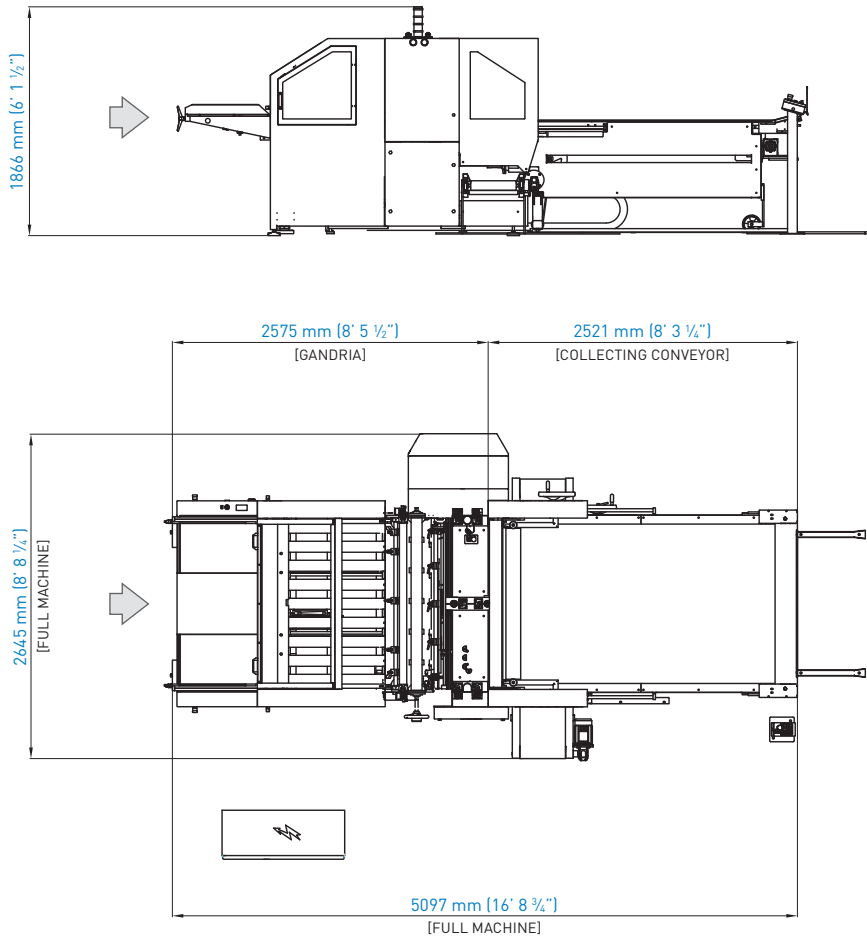
LASER MEASURING (opt.)

Machine can be endowed with an optical measuring device with digital scale to speed up the rotary slitting knives' set up process.

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GANDRIA



■ weight approx. 4400 Kg (9700 lb)

TECHNICAL DETAILS

PASSAGE WIDTH

- max. 1300 mm (51 3/16")

CROSS-CUTTING LENGTH

- min. 20 mm (5/8") — max. 1200 mm (47 1/4")

CROSS-CUTTING PRECISION

- ±0,2 mm (1/128")

BOARD THICKNESS

- solid board: max. 4 mm (5/32")
- corrugated board: max. 10 mm (25/64")

DISTANCE BETWEEN CIRCULAR BLADES

- min. 50 mm (1 31/32")

DISTANCE BETWEEN CREASING / SCORING TOOLS

- min. 25 mm (63/64")

THROUGHPUT

- max. 154 pieces / minute with an advancement length of 5 mm (13/64") speed is related on pieces length

ELECTRICAL REQUIREMENTS

- electrical power supply: 3 x 400 V PE 50 Hz
- controls voltage: 24 V DC

PNEUMATIC SYSTEM

- pressure: 6 bar

OPTIONAL DEVICES AVAILABLE

- Tools for top and bottom creasing and scoring
- Special bridge for tools activation / de-activation
- Air shafts for easier rotary knives set-up
- Laser measuring for tools positioning
- Additional waste conveying
- Unwinding unit for reel's feeding

EXTERNAL DEVICES AVAILABLE

- CB-FEED (automatic feeder from pile)
- B-PAL (palletizer)
- QUADRO (stacker)