Sealed Air
CRYOVAC®
Food Packaging Systems

VM26

Equipment Information

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Sealed Air
CRYOVAC®
Food Packaging Systems

1 Description and key features

1.1 Description

The Cryovac® VM26 is an in-line vacuum chamber machine with heat-sealing, specifically designed for packaging of moulded hams in heat treatable Cryovac® bags. It is fully automatic and requires only one operator to feed it with hams, lay the bag necks flat and monitor operation. The vacuum chamber has capacity for two or four moulds per cycle, depending on size.

The machine consists of 3 sections: an infeed conveyor, a vacuum chamber and a discharge conveyor; all of which are controlled by a PLC (programmable logic control) which monitors and sequences each phase of the machine during operation. Operators can choose from 10 programmes, which have parameters that can be customised to suit particular requirements. A typical example is the VCS (vacuum control system) function for use in optimising the vacuum cycle when packaging wet and damp products. Programming is self-explanatory and made via a touch screen control panel.

Construction is simple and robust. All critical parts are treated against the corrosive environment often found in food production and packaging rooms. Designed with ergonomics safety and hygiene in mind it is easy to use and clean, simple to maintain and meets all relevant European legislation for safety and hygiene.

1.2 Key features

- Large chamber automatic belt vacuum packaging machine requiring only 1 operator
- Machine achieves up to 2 cycles/min (dependent on vacuum configuration)
  - That is: from 7 to 8 products/min (in 4 mould mode) and from 3 to 4 products/min (in 2 mould mode)
- Touch screen with self-explanatory programming, incorporating product specific factory settings as well as open channels to easily program your own settings
- Start and stop pump remote control
- Automatic product transfer
- Bi-active sealing system
  - Sealing cycle controlled through temporisation, with water cooling and adjustable seal bar pressure
  - Double seal gives better pack security
- Adjustable seal bar height to optimise presentation and minimise bag length required
- Final cutting system, ON/OFF (99% of bag length cut. Enables trims to be removed manually for better presentation)
- Two steps vacuum, ON/OFF
- Integrated booster pump, minimises the floor space required
- Active safety devices, interlocked guards and a category 2 fail safe control system combined to provide a state of the art safety system
- Hygienic design makes cleaning easy and effective
- Good access for maintenance
- Robust, high quality build standard using food approved materials throughout

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2 Layout

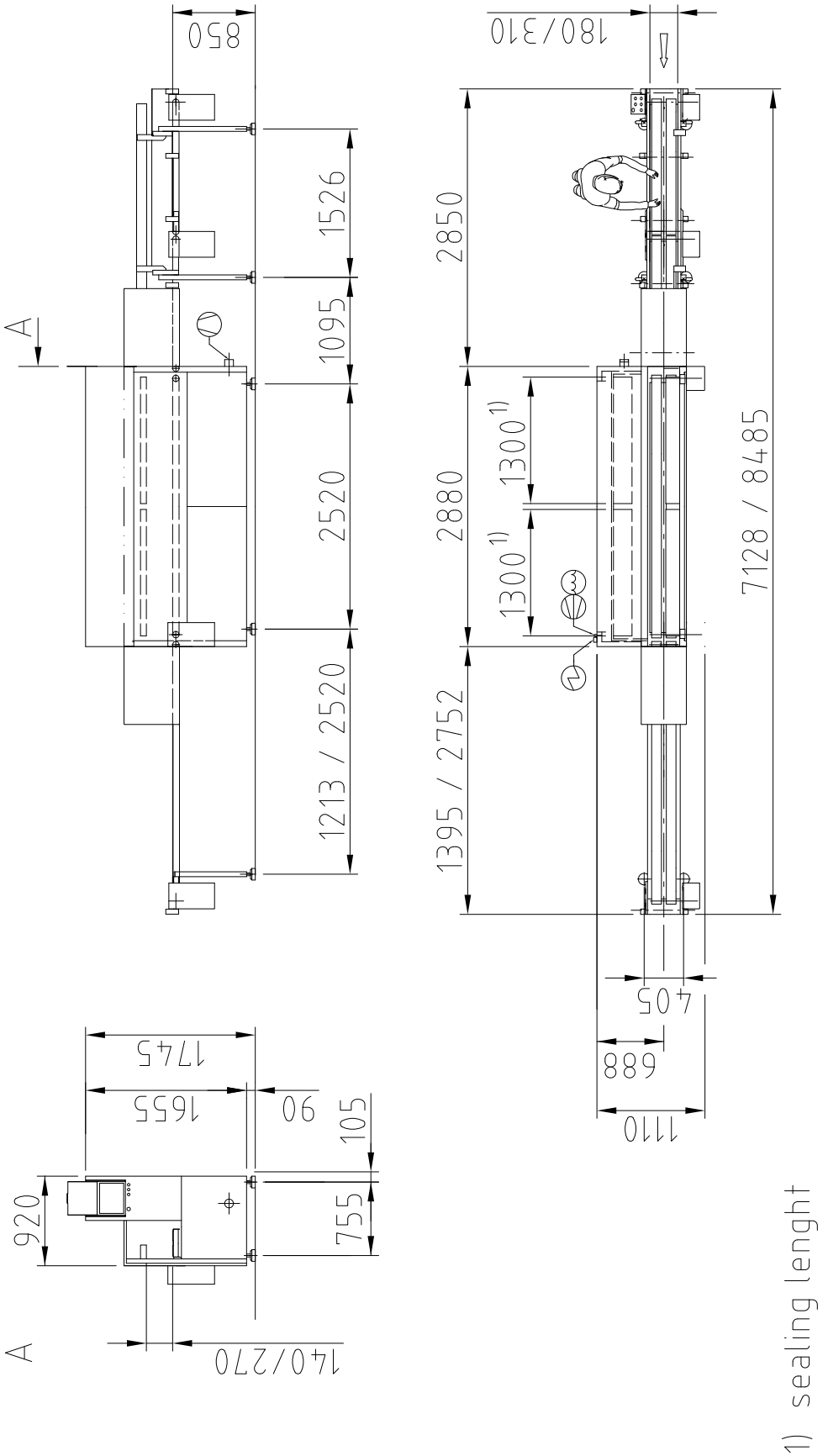

Fig. 2-1, Layout LH (left hand machine)

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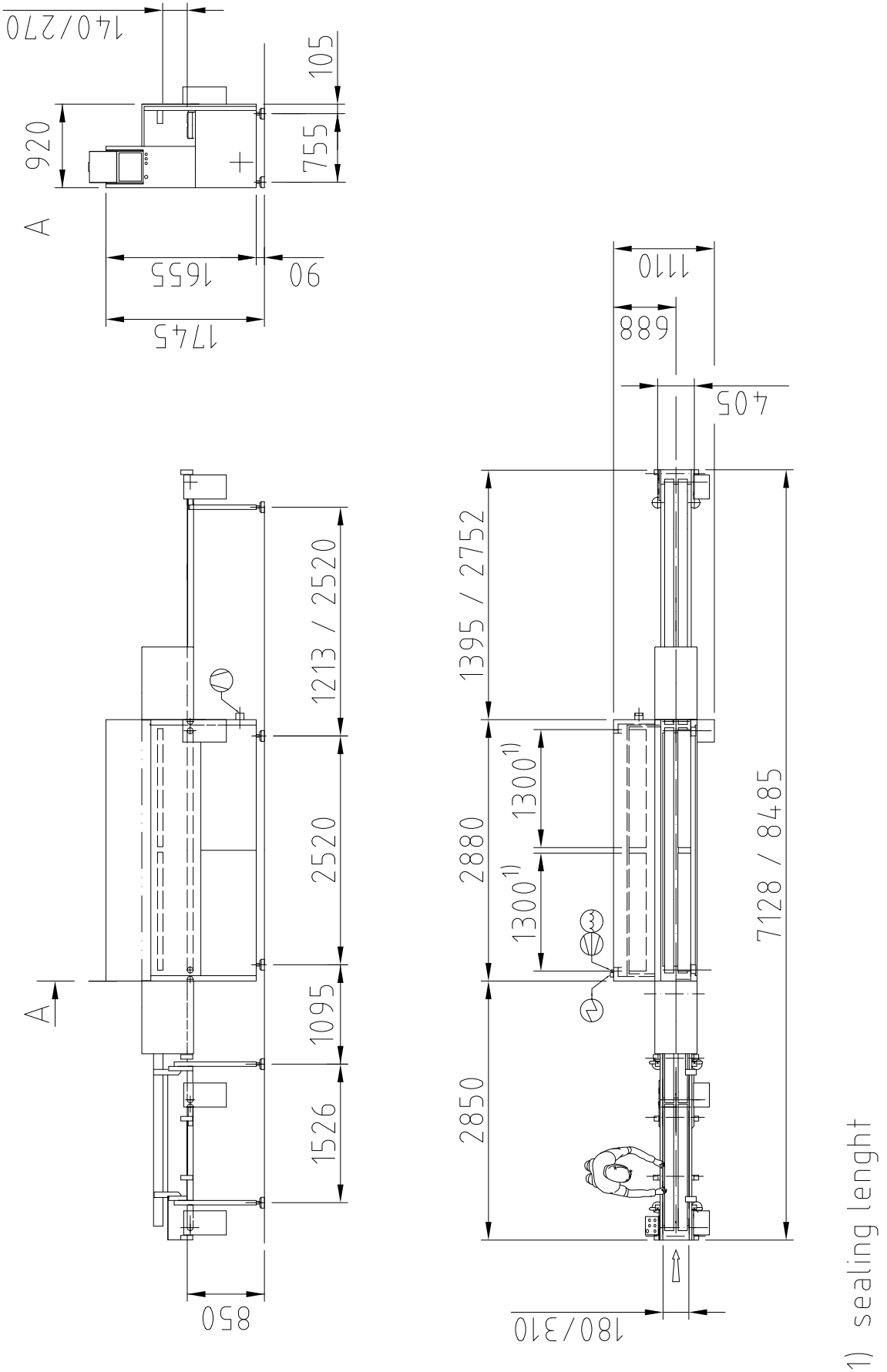

Fig. 2-2, Layout RH (right hand machine)

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3 Nominal technical data

3.1 Machine dimensions

Length, width & height	See machine layout

3.2 Weight

Weight	1500 kg approx.

3.3 Utilities

3.3.1 Compressed air

Quality (ISO8573-1:2001)	Class 5.4.4 Class 3.4.2 when using oils containing esters Class 3.3.2 when equipment is used below 5°C
Pressure	0.6 MPa (6 bar)
Consumption	15 N m^3/h
Connecting fitting	1/2”

3.3.2 Water

Pressure	0.4 MPa (4 bar)
Consumption	250 l/h
Connecting fitting	1/2”
Drain connection	Flexible pipe of 12.5 mm inside

3.3.3 Electrical

Voltage	400 V
No. of phases	3 + earth
Frequency	50 Hz
Energy consumption per hour (average)	2.8 kWh
Installed power	21.4 kW
Current protection	50 A, delayed-action type
Conductor size	4 x 16 mm

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3.3.4 Vacuum data

Main pump	* 630 m^3/h
Booster pump	* Busch Puma 1250 C2
* (Depending on product type and pipe length)	
Connection to external pump	3 inch pipe
Chamber capacity	430 litres

3.4 Working characteristics

3.4.1 Mould dimensions

Width	180 mm - 310 mm
Height	110 mm - 210 mm
Maximum length	2 mould programme 1000 mm 4 mould programme 400 mm
Sealing length each sealing bar	2 mould programme 1200 mm 4 mould programme 550 mm
Weight	60 kg max. total load on the infeed conveyor

3.4.2 Sealing Bars

Length	1300 mm
Height	140 - 270 mm

3.4.3 Bag details

Length	Local Cryovac® representative to advice
Width	1200 mm max. (packaging in 2 moulds) 550 mm max. (packaging in 4 moulds)
Bag type(s)	Cryovac® HT or CN shrinkbag range

3.4.4 Functional details

Working speed	2 cycles/min (with a 630 m^3/h pump and a 1250 m^3/h Busch booster) From 3 to 4 products/min (packaging in 2 moulds) From 7 to 8 products/min (packaging in 4 moulds)
Noise level	75,5 dB (A)
No. of operators	1 to monitor only

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4 Configuration

4.1 Standard

- Siemens PLC S7
- Touch screen panel with self-explanatory programming
- Infeed conveyor
- Discharge conveyor
- Anti-stick profiles on bag supports
- 2 pairs of sealing bars, adjustable in height, incorporating:
  - Bi-active system
  - Final cutting system
  - Anti-stick device
- Vacuum control system
- Booster
- Photo cell for product sensing
- Vacuum valve heating
- Spare parts kit
- Technical manual
- Declaration of Conformity

4.2 Versions

- Left or right hand side
- Short or long discharge conveyor

4.3 Options

- Strip-off

4.4 Recommended line assembly

- Product preparation system which puts product into Cryovac® bags, places bags in moulds and conveys moulds to VM26
- VM26
- System to take packaged product from VM26

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