

Private Treaty Sale

# (10) High Quality Paper Straw Production Lines

## YoM: 2020/2021



Phenomenal Opportunity from Global  
Provider of Innovative Packaging Solutions

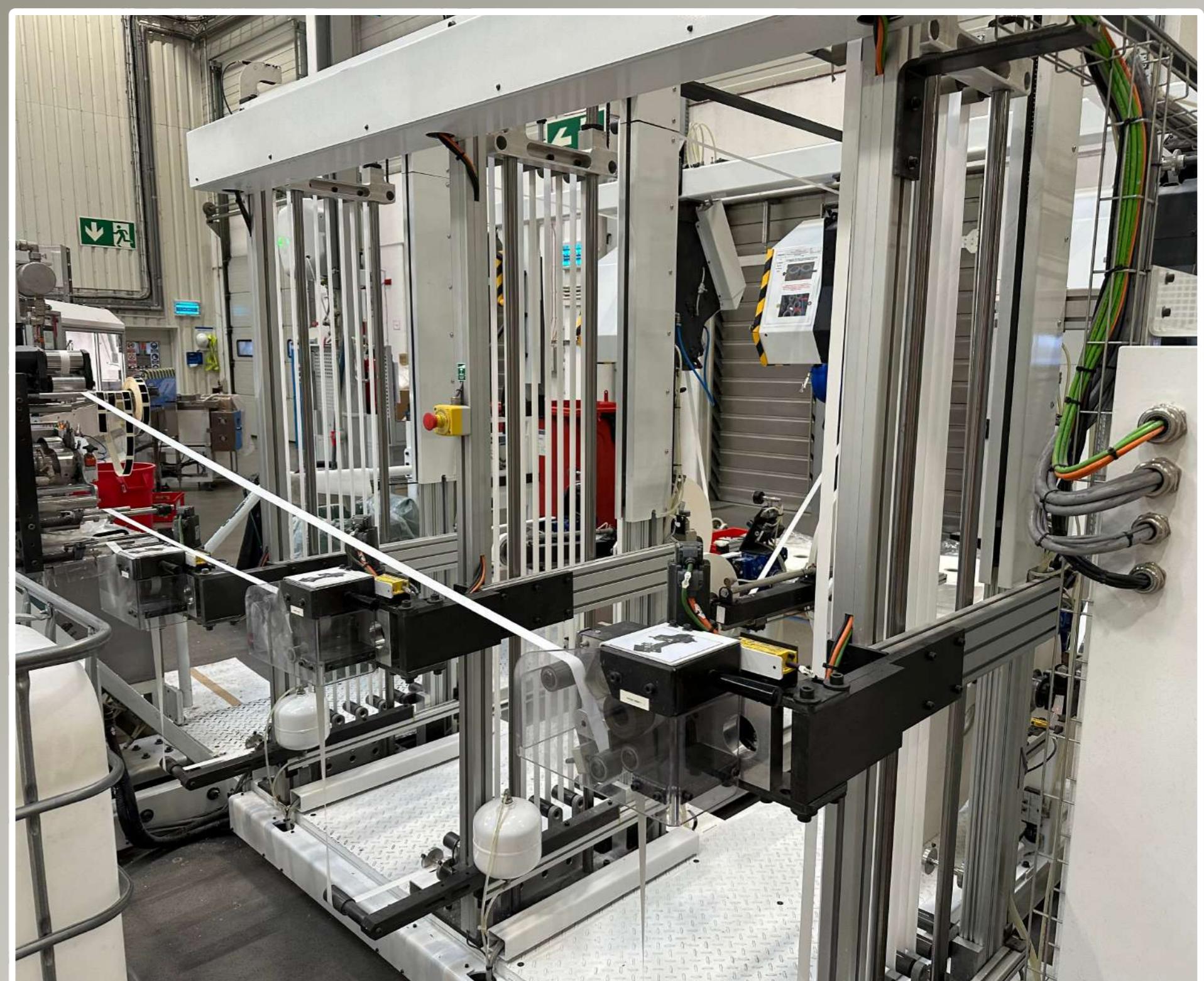
**Location:** Poland (6 Lines)  
N. Ireland (4 Lines)  
**Make:** Eberle  
**Model:** 3/30/S SPCO OLYMPE  
**YOM:** 2020/2021  
**Capacity:** 227,485,440 pcs per annum

For more information, please visit  
[www.vbdindustrial.com](http://www.vbdindustrial.com)  
[www.krudoind.com](http://www.krudoind.com)

# 1. Reel Stand, Make: EBERLE, Model: DEEN 3/30/S, YOM: 2020

## Technical Specifications:

- 3 Plies of paper [19mm 19.4mm 21mm left to right] used to make a 7.3mm straw
- 2 reels [bobbins] fitted on each station
- Full speed splicing of one bobbin into the next using automatic butt splice device meaning continuous production and low waste
- Automatic splice detection & rejection
- Automatic paper tension control inbuilt



## 2. Glue Unit, Make: EBERLE, Model: DEEN 3/30/S, YOM: 2020

### Technical Specifications:

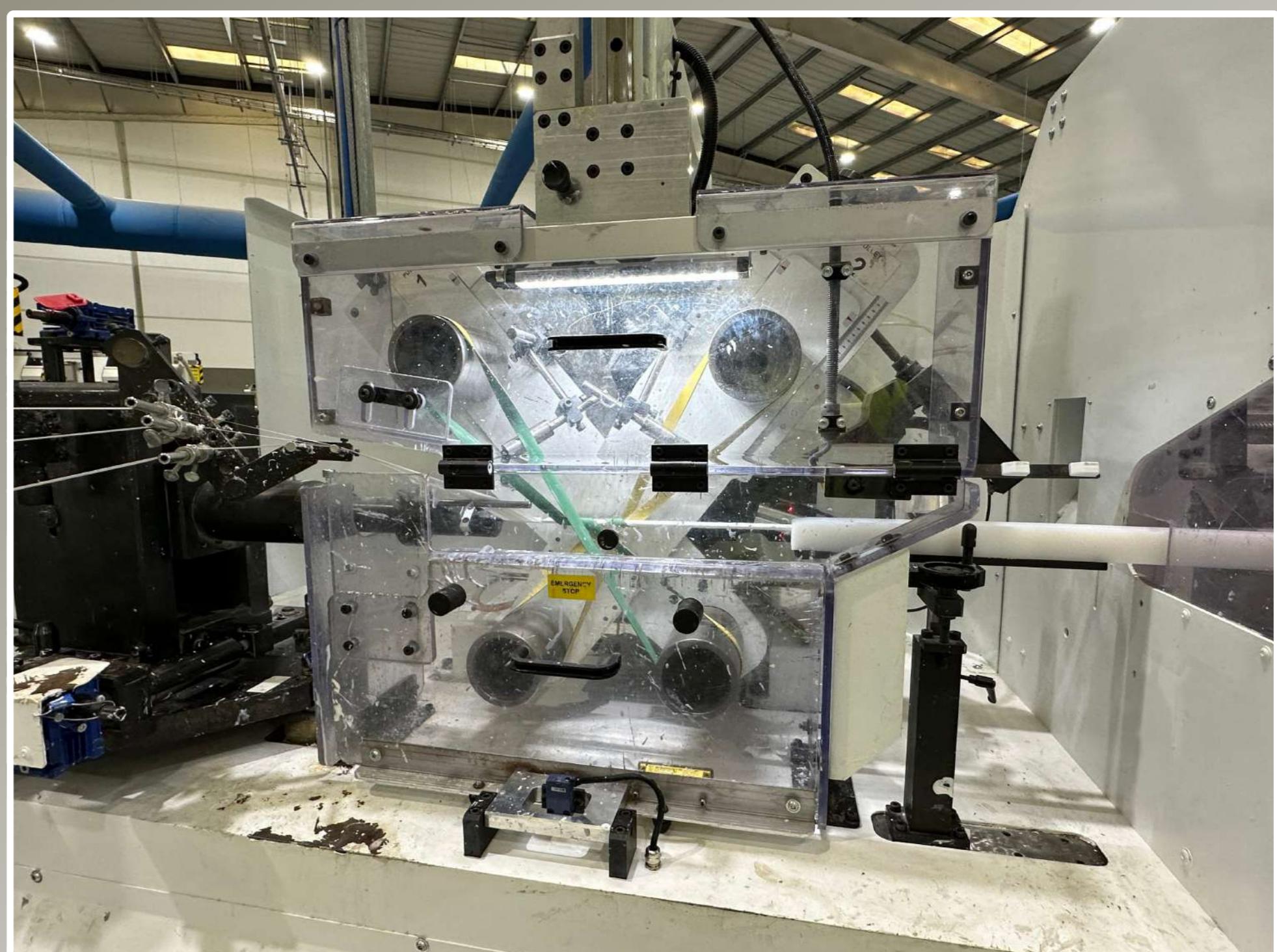
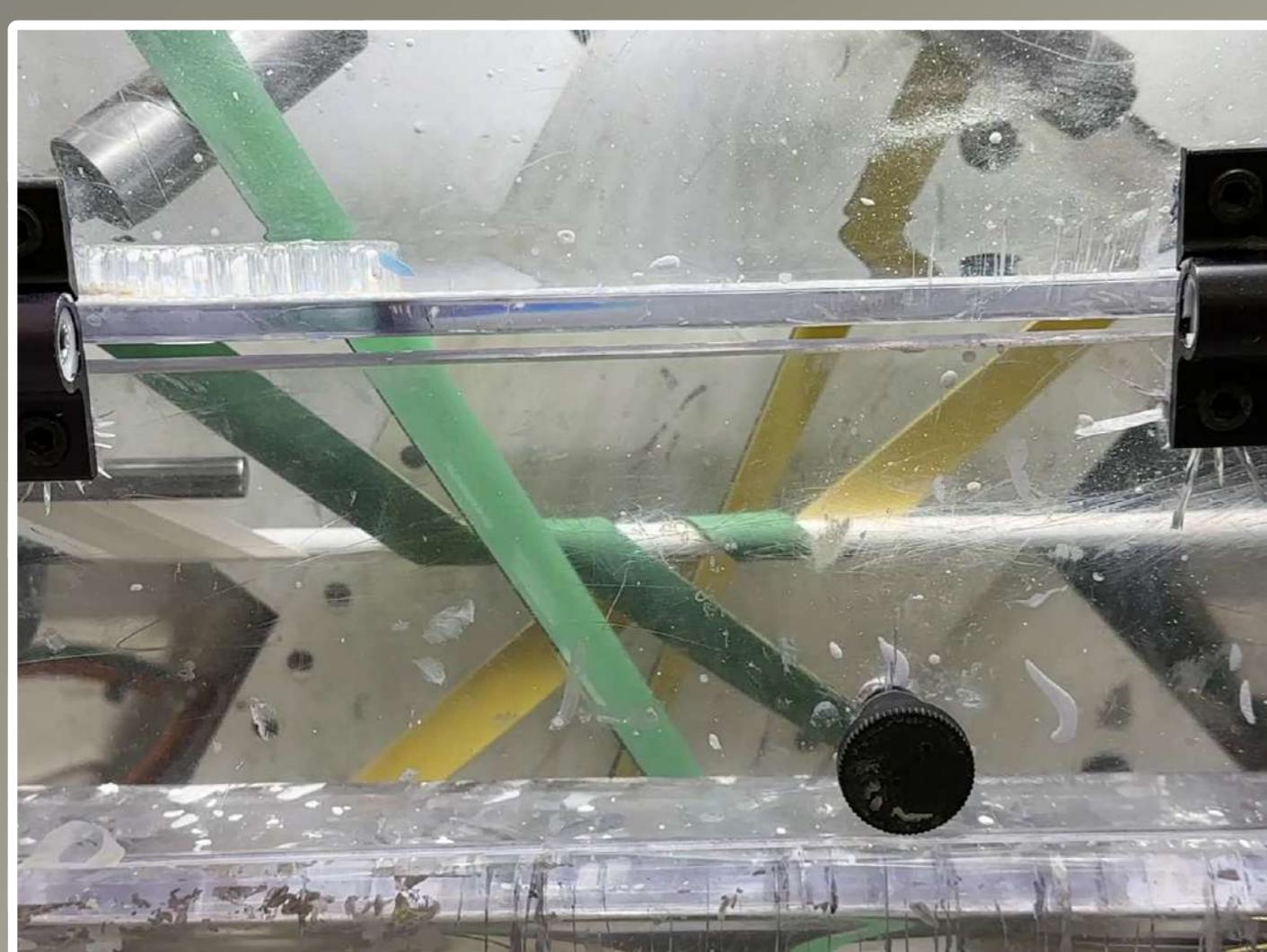
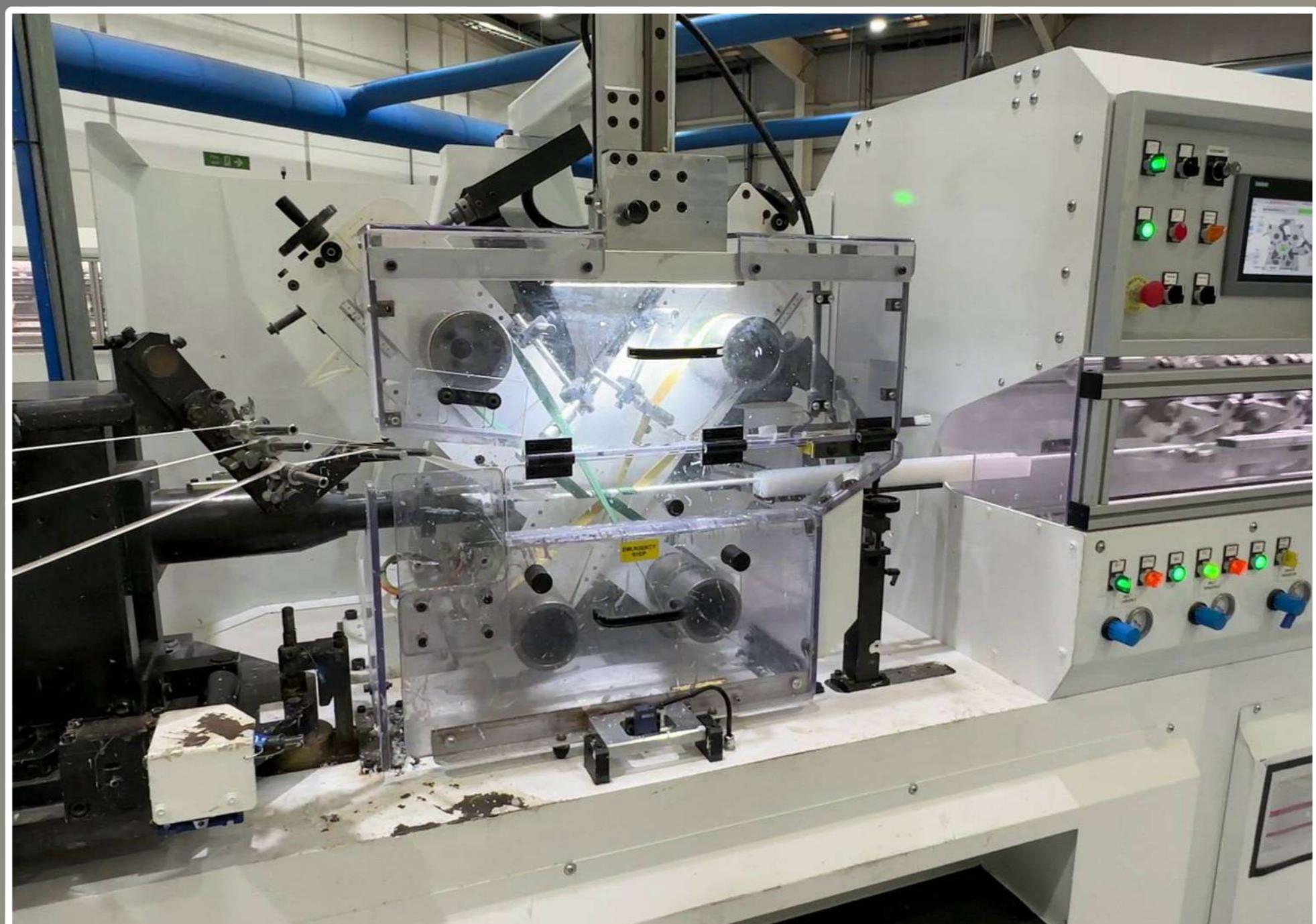
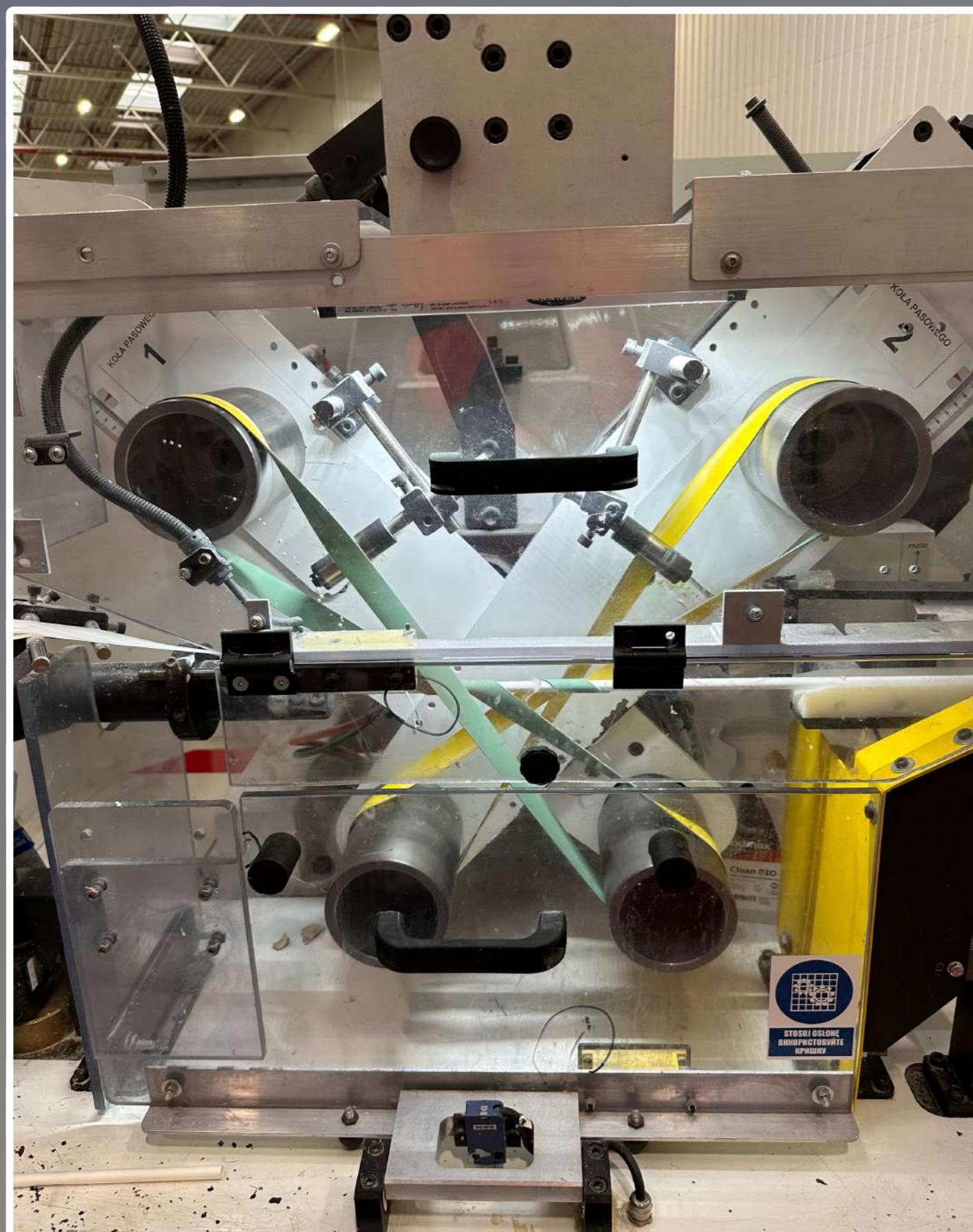
- Only middle and outer plies have glue applied
- Inner ply is lubricated with food safe product
- Glue is temperature controlled @20°C using thermostat on heated water jacket for glue tank.
- Glue film weight adjusted via graduated orange adjustors on each glue unit



### 3. Winding Section, Make: EBERLE, Model: SPC0.7.20.2.1225.0L, YOM: 2021

#### Technical Specifications:

- 3 Plies introduced under tension
- Equal paper overlap set for mechanical strength of straw
- 2 x 18mm drive belts instead of 1 meaning better adhesion and higher speed
- Adjustable paper winding pressure meaning accurate finished diameter of straw



## 4. Cutting Section, Make: EBERLE, Model: SPC0.7.20.2.1225.OL, YOM: 2021

### Technical Specifications:

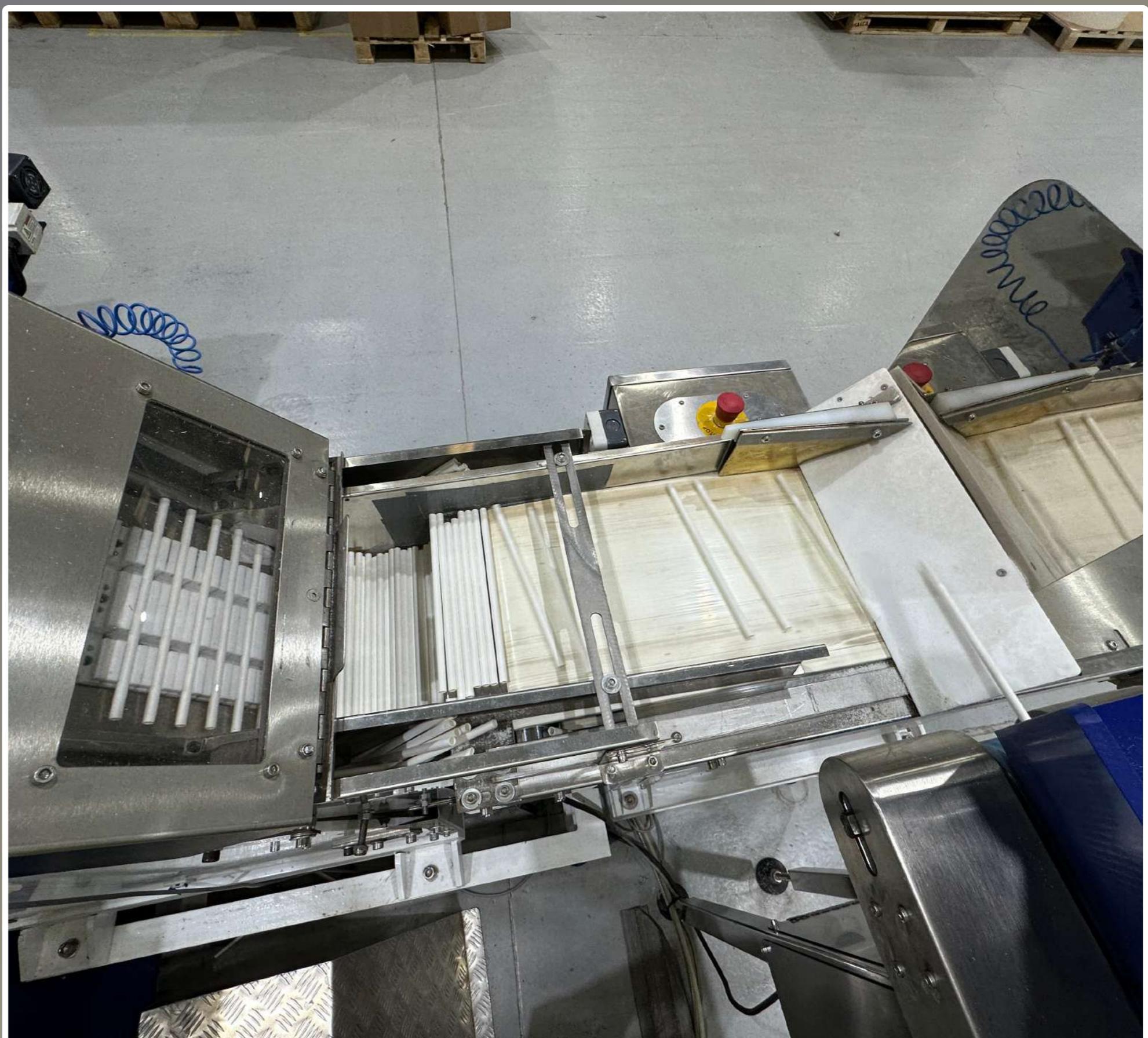
- Adjustable knife cutting pressure
- 7 straws per cut instead of 6 meaning higher output
- No offcut on 7th straw
- Continually measured straw cutting length
- Automatic rejection of straws under or over specified length tolerance
- Parameter adjustable by Operator through touch screen interface
- 60 cuts per minute max =  $60 \times 7$  straws = 420 straws per minute
- HMI Interface
- Control over all parameters for process control
- Special alarm when knife change is due to prevent poor cutting
- Dual laser sensors set to desired straw length allow precision measurement of individual straws to 0.1mm
- Automatic rejection of straws at full speed



## 5. Automatic Straw Feeding Conveyer, Make: Sunrise Machinery, Model: LG-30L / LG-51Z-3 / LG-51Z-2, YOM: 2021

### Technical Specifications:

- Capacity: 1200 pcs/min
- Power: 0.37 kw, 220 V, 50 hz, Single phase
- Net weight: 65 kgs



## 6. Overwrapper, Make: DaeTong Co. Ltd, Model: DT-IW-21, YOM: 2021

### Technical Specifications:

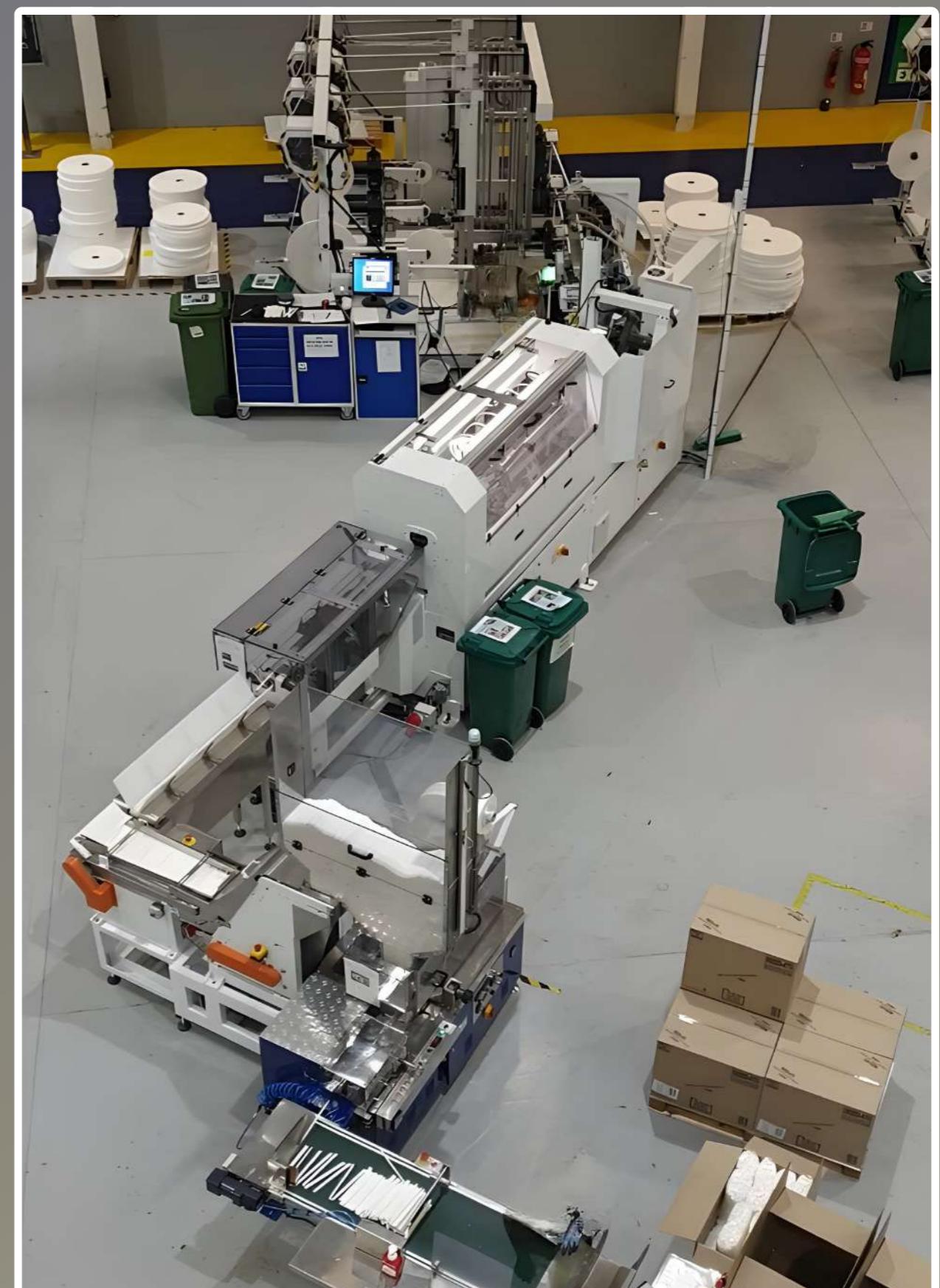
- 900 straws per minute wrapping capacity
- Light weight 23gsm wrapping paper
- Adjustable digital counting and batching of straws
- Straws wrapped and sealed without glue by crimping technique on 3 sides
- Potential 2 colour printing available
- In-line ink drying
- Low migration food safe inks available



## How does this technology work?

The market leading European straw manufacturing equipment is loaded with very special features to control all of the process variables. Fundamentally our machines are PLC controlled and have servo motors throughout but ultimately the precision in process control comes from the software on the user interface which gives the Operator very fine control over each parameter in the process. For example, one has full control over speed, paper tension, glue temperature, paper winding pressure, cutting depth and cutting duration.

Although the manufacture of wound paper straws has only 2 main materials which are high quality sustainable virgin paper and food safe adhesive there are several very specific manufacturing variables to control to produce a high-quality paper straw. The critical variables are paper tension, control of glue viscosity, glue temperature, paper winding pressure and cutting length control. So, a high degree of control over the paper tension for example generates a very uniform finished outer diameter and creates consistent compression strength throughout the straw, at the same time, controlling glue viscosity creates a uniform film weight on the paper plies meaning good adhesion of the 3 layers that make up the straw, the paper winding pressure controls the wall thickness of the straw and the overall adhesion of the paper layers and finally the cutting and length control ensures the straw length is very consistent.



## Additional Services

**Dismantling:** Will be offered separately

**Logistics:** Can be offered up to your target port

**Reassembly:** Can be offered upon request

## Your Contacts

### SALES

#### **Darko Pepovski**

+31 6 55292900

pepovski@vbdindustrial.com

### SALES

#### **Martin Kolodziejczyk**

+31 6 54115413

mkolo@krudoind.com

### ENGINEERING

#### **Milad Barghidarian**

+31 6 18516165

mdarian@krudoind.com

\* Inspections: By prior appointment by us.