



**INNOVATIVE SOLUTIONS
FOR THE GLASS INDUSTRY**



AUTOMATIC VIAL MAKING MACHINE FLA-35



The FLA-35 is a continuous rotary motion machine with 35 spindles for the production of vials from glass tube with diameter from 8 mm to 33 mm. The machine is composed of:

Main base

The lower wall of the base houses the main motor, the chuck motor and the oil pump. The upper part of the base is designed as an oil tank with a filter sistem for continuous oil circulation.

Main Body

Has a planetary gear movement actuated by two independent pinions in a carburized, hardened, ground steel alloy, against the rotor wheel gear and the chuck wheel gear, in a steel alloy. All the gears and the bearings are automatically lubricated by the oil pump.

Chuck Sections

The machine is equipped with the 35 upper chuck sections and 35 lower chuck sections in cast iron

sections. The upper sections hold a double chuck permitting a perfect grip of the glass tube during operations.

The chucks, with a 35 mm bore, run on ball bearings and the lower spindles, in a carburized steel alloy, slide on pre-loaded ball bushes. The chuck section are independent of each other and can be easily realigned or replaced in case of accident.

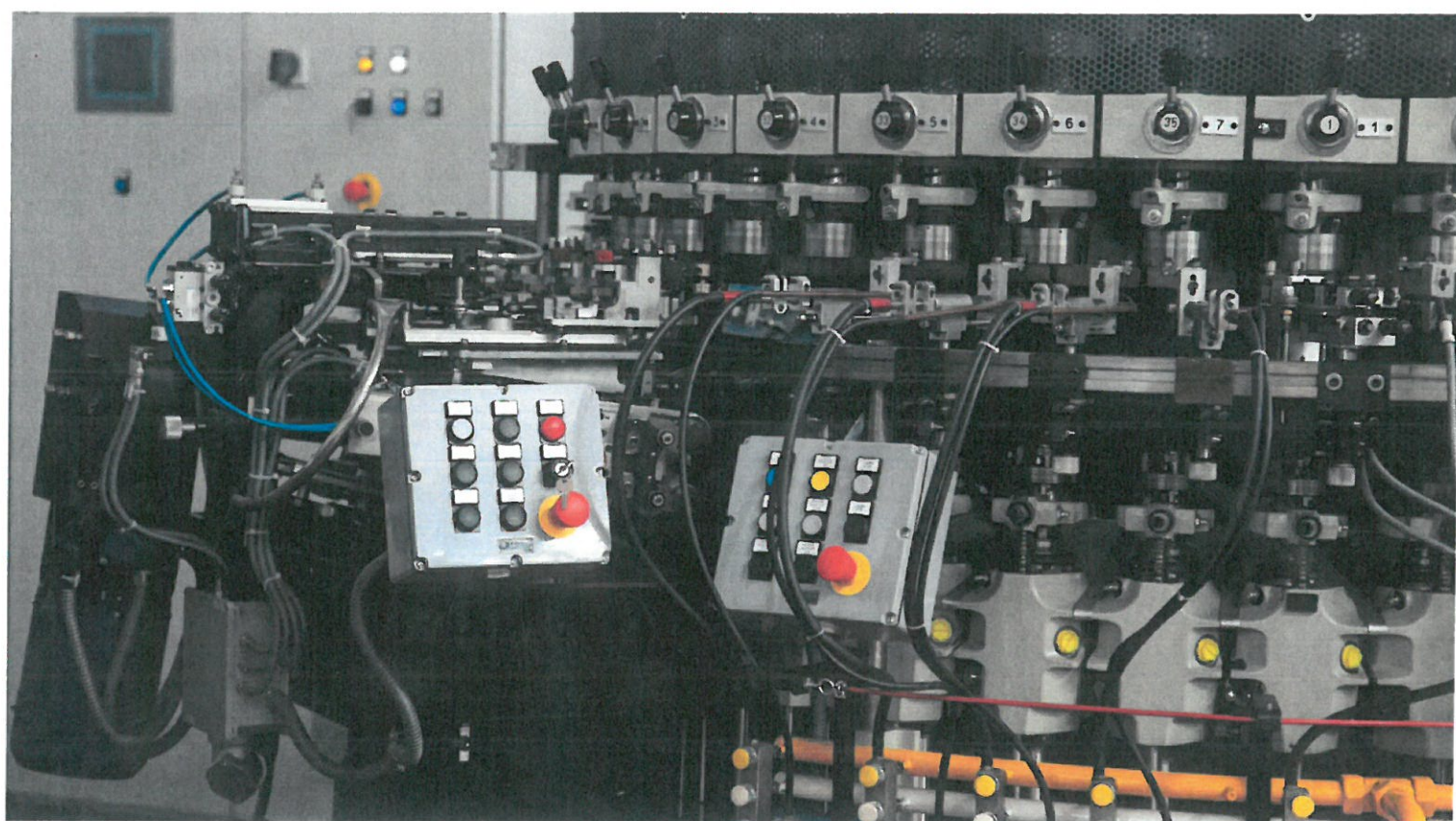
Burner sections

The machine is equipped with special burners actuated by a chuck movement with easy height and radial distance adjustment.

The burners are equipped with different nozzles, depending on their function with a spring and shock-absorber for the back movement.

Forming section

For the forming of the vial's mouth, the machine is equipped with four tool parts wich work with continuous and synchronised movement with the main machine.



Main Control

The machine is controlled through a panel supplied with a 6 mt-long cable for easier installation. The control panel consists of three inverters for the AC motors, a synchronisation chart, an electronic cam programmer for the automatic set-up of all the machine's phases.

One PLC for the elaboration of the following functions:

Motion of the first cutting burner, actuated for every new glass tube, so as to increase the heating power and prepare for better thermal conditions.

Economizing platform, actuated every new glasstube

to reduce the length of the first rejected piece.

Temporary stop-cycle in process with automatic keeping of tube inside the upper chuck and automatic start cycle.

Ejection of the first piece of glass tube in a separate position.

Control of the lubrication system for rollers and plugs with the possibility of adjusting the lubrication time.

The FLA-35 is equipped with a remote control panel installed in the machine, close to the vial forming section, for easier function control.

MACHINE TECHNICAL CHARACTERISTICS

Overall \varnothing	2.450 mm
Height (without hood)	1.850 mm
Gross production	84 pcs/minute

VIAL CHARACTERISTICS

Glass tube \varnothing	8 - 32 mm
Vial length	35 - 150 mm
Type of vial	penicillin neck, insuline neck, screw neck, tapered neck, blow-back neck

AVERAGE CONSUMPTIONS - FLUIDS PRESSURES

	Consumptions	Pressure
Gas	6 m ³ /h	0,6 bar
Oxygen	6 m ³ /h	0,6 bar
Combustion air	9 m ³ /h	1,2 bar
Compressed air	10 m ³ /h	6-10 bar
Installed power	11 kW	



OCMI-OTG S.P.A.

Via Venezia Giulia, 7
20157 Milano (Italy)
Phone +39.02.39.09.18.1
Fax +39.02.35.70.944
e-mail: info@ocmigroup.com
<http://www.ocmigroup.com>