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We have available the following **COMPLETE DRINK BOTTLE MANUFACTURING FACILITY**; subject to prior sale:

**PROPOSAL – 16541**

**ONE COMPLETE BOTTLE MANUFACTURING AND PACKAGING LINE FOR 20,000 BOTTLES PER HOUR X 500 ML HOT-FILL ENERGY DRINKS AND JUICES**

Manufactured by SIPA, Italy  
2005 Year of Manufacture  
2006 Installed and commissioned  
2008 Ceased Production Due to Family Unrest

**Containers**

0.5 Liter round PET Bottles  
1.0 Liter round PET Bottles  
1.5 Liter round PET Bottles

**Capacities**

20,000 bph on 0.5-liter bottles  
10,000 bph on 1.0-liter bottles  
6,600 bph on 1.5-liter bottles

**Products**

Energy drinks like Gatorade & Powerade  
Orange and fruit juices with small pulps

**Closures**

Plastic pre-threaded screw caps  
Flat and sport 30/25 (same number of threads)

**Labels**

OPP Wrap around by roll-fed

**Packaging**

3 x 4 shrink wrapped packs without flat cardboard

**The Process:**

1. The PET Granules, previously dehumidified for about 4 hours in a drying hopper dropped at about 170 deg C into a special screw called the extruder. The extruder rotates continuously and is kept at a settled temperature by means of heat resistance, plasticizes the PET, and transfers it into a central distributor. The distributor will lead the melted material through hot channels into the shooting pads
2. The shooting pads (injectors) will inject at a pressure and speed which can be adjusted, the melted material at about 280 deg C into the hot runner and the preformed cavities of the injection molds. Once the cycle time is expired; the molds open up and the preforms can be extracted from them by means of the transfer device. The cycle time is the time needed for the melted PET to cool down inside the injection mold and form the performance. The preform neck is cooled down to low temperatures and the body

temperature to about 105 deg C. Cycle time is related to the preform thickness which depends on the weight and specifications of the final container.

3. The preforms are handled by means of neck carriers and lead to heaters to heat up the under-neck part permitting to maintain or complete the ideal thermal profile of the preforms for the following stretch-blowing treatment. The heaters can be either heating resistances or hot air exhausted by special devices called air knives.
4. The heated preforms are introduced into the blowing cavities of the blow mold. In the first stage, a mechanical and pneumatical device stretches the performance by means of stretch rods and low-pressure air, at the second stage the same device blows high-pressure air to give the performance the final bottle shape.
5. An eject system discharges in bulk the blown containers through a slide. The PET drying hopper, as well as all the functions of the machine, the production parameters, and the cycle time, are controlled by a PLC, complete with a monitor and an alphanumeric keyboard. The Temperatures, pressures, and speed of rotation of the extruder are controlled and regulated by a special feedback system that guarantees the consistency of the process. The machine is equipped with a self-diagnostic program complete with synoptic tables and precise indications of any faulty components or incorrect process parameters.

### **Machinery Technical Data:**

#### **Injection Molds**

Number of Injection cavities	10
Number of Injection Molds	4
Total number of injection cavities	40
Injection Mold pitch	76 mm

#### **Blowing Molds**

Number of blowing cavities	10
Number of blowing molds	2
Blow mold pitch	107 mm

#### **General Characteristics**

Dimensions LxWxH	14.2m x 4.0m x 3.7m
Machine weight	45,000 Kg
Oil Capacity for hydraulic system	2200 cubic dm
Total weight of operating machine	47,200 kg
Standard Color	RAL BLU 5012

#### **Electrical Power**

Power System	3F + N + T
Plant Voltage	100/440 V + or - 10%
Plant Frequency	50 & 60 Hz
Total Installed Power	350 KW
Average Power Factor	0.875
Average absorbed power	150 KW

#### **Compressed Air**

Air Pressure	8 Bar
Machine Air Consumption:	35 Nm <sup>3</sup> / Hour