MODEL 50

Thermoformer and Trim Press

IRWIN
Research & Development, Inc
THE ORIGINAL TECHNOLOGY

MODEL 50

Thermoformer and Trim Press

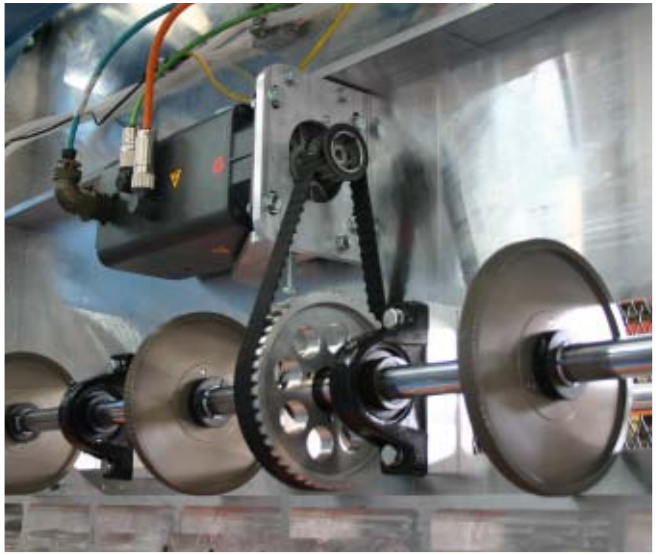
If you are looking for a thermoforming machine that delivers high volume, PS foam production, with around the clock reliability, the Irwin Research and Development Model 50 is the proven leader.

In excess of 500 Model 50 machines are employed in this capacity throughout the world.

Since 1978 the Model 50 has provided its users with reliable, high-volume production of polystyrene foam containers for the food service industry. During its tenure the Model 50 has evolved into an elite performer that has benefited from customer input, allowing our engineers to equip the Model 50 with every feature required by our customers of today and tomorrow.

The Model 50 forming station can accommodate a 52" sheet width and up to a 2.5" deep container with an option for a 3.5" product. Customers may choose between a single motor drive for both platens or independent motor drives for each platen, depending on the process requirements. The sheet is carried through the heat tunnel via a set of water cooled, aluminum-extruded chain tracks with internal steel wear components assuring life-long, performance and reliability.

The Model 50 offers a choice heat tunnels in lengths of



160", 200", or 220". The tunnels utilize tubular heating elements arranged in transverse and/or longitudinal orientations or panel heaters on top and or bottom. Since 1986 the 200" long tunnel has been providing our customers with higher production rates and better quality containers, so much so that today the 200" length has become the rule rather than the exception. The PID system allows you to "soft zone" your heat tunnel giving you the option as to which heaters are attached to which thermocouples.

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Trim Press

The Irwin Research and Development Model 50 Trim Press was the first to the market with high speed trimming for a wide range of foam products. Hundreds of Model 50 Trim Press Machines are in use and have an outstanding record of reliable service. Add Servo Pick and benefit from fast and accurate product indexing into the trimming position via servo driven wheels and fiber optic sensors for product registration. The Servo Pick adds to your production rates while reducing the change over time between tools by relegating stroke and timing changes to a few parameters in the Ballerina Control.

Platen motion, chain indexing, and Servo Pick axes are all driven by AC brushless motors and multi-axis servo drives. Brushless servo motors provide powerful and consistent execution of the motion profiles for every axis, guaranteeing full command over the process, giving you a distinct advantage over pneumatic or hydraulic systems.

All machine functions are implemented and synchronized by our "Ballerina" control. Either system gives microprocessor-based control enhanced by machine specific software resulting in flexible, efficient, and operator friendly control. "Ballerina's" Windows®-based operating system and unique motion profile control give this PC-based operating system and unique motion profile control give the PC-based system a commanding position today and tomorrow.

Once the product is trimmed the Irwin Model 50 under-press "Chesaw" can densify you web scrap in a high in a high capacity, quiet and low maintenance fashion. The "Chesaw" fits easily underneath the Model 50 Trim Press for space efficient operation.

The Irwin Research and Development Field Service, the fastest, most responsive support team in the industry, back the Model 50. In the event of any system failure, Irwin Research and Development will work with you to provide fast, effective solutions, minimizing down time and returning you machine to production.

Count on Irwin Research and Development to continue our long history of using leading edge technologies to engineer and manufacture reliable and innovative Thermoformers from our home in Yakima, Washington (USA). Serving our Customer IS our Business.

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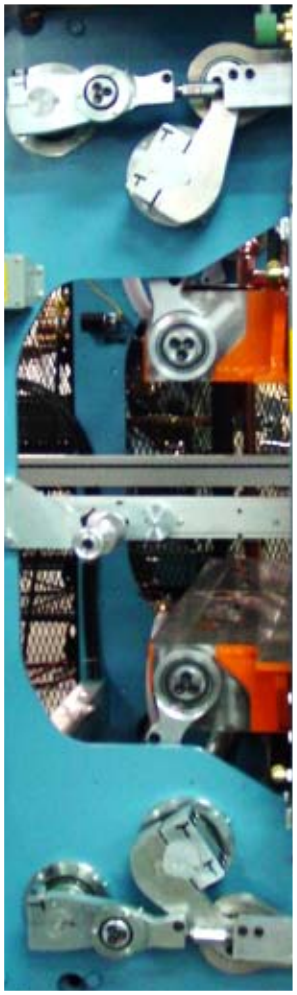
Specifications



Thermoformer Specifications

Material Index	**Max. Chain Speed**	200"/sec.(5080mm)
	Sheet Width	Max 52.5" (1334mm) Min 30" (762mm)
Heat Tunnel	**Length**	160"-220" (4064-5334mm)
	Heating Element	Standard: Cal Rod Optional: Quartz
	Temperature Control	Standard dual control with slaved zones Option PID Control: +2 at 600°F +1 at 316° C
Former	**Sheet Width**	Maximum 52" Wide (1321mm), Minimum 30" (762mm)
	Max. Mold Size	50" Wide (1270mm), 50" Long (1270mm)
	Depth of Draw	Standard: 2.50" (64mm) Optional: 3.5" (83mm)
	Press Rating	60 Tons
	Shut Height	Standard: 10" (254mm) Optional: Up to 14" (356mm)
	Platen Travel	3.78" (96mm) Standard 5.5" (140mm) Optional

Trim Press Specifications

Sheet Width	Maximum 52." Wide (1321mm), Minimum 30" (762mm)
Product Depth	Standard: 2.50" (64mm) Optional: 3.5"
Treadle Adjust	Vertical: 5" (127mm), Horizontal: 7" (178mm)
Stroke	Min: 5" (127mm), Max: 8" (283mm)
Standard Platen Opening	Index Direction: 14" (356mm), Across Sheet: 56" (1422mm)
Maximum Cutting Force	20 Tons
Dry Cycle Speed	1-145 cpm (160 cpm with counterbalances)
Servo Ejector	Optional

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