
DAIRY PROCESSING EQUIPMENT

SPECIALISED PRODUCTION LINE FOR CUTTING OF CHEESE AND YELLOW CHEESE WITH PRECISE WEIGHT

This machine is designated for cutting yellow cheese and cheese from a rectangular loaf into blocks with precise weight.

The working principal of the line is as follows:

The rectangular loaf of yellow cheese is set in start position; a spinner-pusher moves it to the section for pre-cutting into three roughly equal pieces, then each piece is fed to the conveyor with a scale which measures their weight. Thus the measured piece is transported to the cutting guillotine. During the movement the shape and dimensions of the piece of cheese are measured by laser sensors. Taking the resulting parameters, the microprocessor calculates the thickness of each slice. After the guillotine each slice falls to a check scale and if there is a deviation from the specified weight, it is removed by a rejecter.

The course for the cheese is the same; the only difference is that the lump of cheese is placed directly on the conveyor with the instrument.

Products - yellow cheese and cheese.

Maximum dimensions of the product - 220 x 320 x 150 mm.

Maximum size of the portions: from 150g to 1000g.

Productivity – up to 60 slices per minute (depending on the product)

This line is a module one and it consists of:

- Cutting module for a yellow cheese loaf
- Cutting machine with precise weight
- Check scale with rejecter
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I. Cutting module for a yellow cheese loaf

It is used for cutting of the yellow cheese loaf into three roughly equal parts which will be cut into equal blocks through the given weight.

The Module consists of:

- Transporter (roll gang) where the loaf has to be placed by the operator. The machine automatically positions the loaf into a position for cutting.
- Cutting tool (knife or string).
- Photocells for presence of another product.
- Pusher.
- Control panel – integrated to the main machine.
- A turner of the first piece.
- Construction – made of stainless steel treated with glass beads.
- Dimensions (l x w x h) 800 x 800 x 1364 mm.
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II. Machine for packaging cutting with precise weight

This machine consists of:

- Input conveyor - special design for easy cleaning. Dimensions (l x w x h) 520 x 400 x 1025 mm.
 - Bar transporter - polyurethane.
Dimensions (l x w) 500 x 254 mm.
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Strip speed 6 m / min.

- Scale with range up to 5000 g and 0.5 g accuracy

Dimensions (l x w) 400 x 400 mm.

Communication - MODBUS.

Strip - polyurethane.

Reset of the scale – manual and automatic.

- Construction – made of stainless steel treated with glass beads.
 - Transporter for portioning of the pieces.

Dimensions (l x w) 700 x 400 mm.

Strip - polyurethane.

3D scanning - laser sensors.

Cutting mechanism - driven by servo motor teflonized guillotine blade.

- Node to adhere the pieces.
- Control- Delta Holland.
- Screen -TFT 7 inches, 65 000 colors.
- Software – specifically programmed for machine operating, illustrating the technological process. There is possibility for launching of programs.
- Power supply 3 x 400 V ,50Hz
- Installed supply 4 Kw
- Compressed air supply Ø8
- Output conveyor

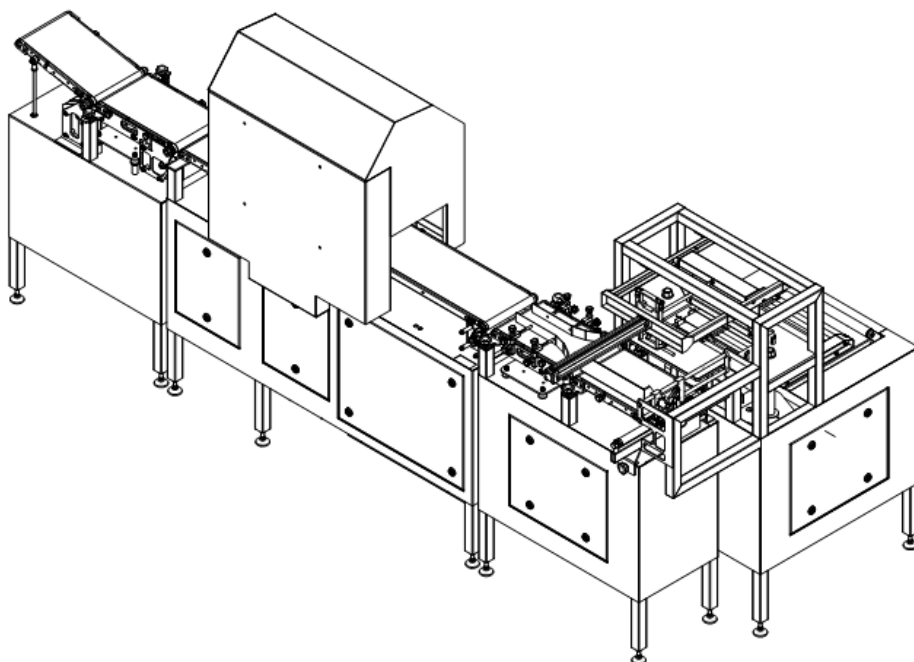
Dimensions (l x w x h) 3100 x 1300 x 1300 mm

III. Check scale with rejecter

It consists of three conveyors serving the dynamic drawing of the slices. The range of the scale is up to 1000 g, with accuracy to 0,2 g.

Check scale reset – manual and automatic.

Construction – made of stainless steel treated with glass beads.



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