

## Data Sheet for RoRo StretchPack® – High Speed Duplex

Machine Information	ID	Large Duplex		XL Duplex / XL Power Duplex	
		D2	D4	D2	D4
Number of Film Units / film roll sizes		2 / 1	4 / 2	2 / 1	4 / 1
Max. stretching forces		600 kg		1.000 kg / 2.000 kg	
<b>Capacity examples @</b> transport speed 600 mm/s, product height 400 mm, product width 600 mm, 15% stretch					
Capacity (@L:6000 mm) 100% sealed		< 100 packs / hour			
Capacity (@L:2400 mm) 100% sealed		<140 packs / hour			
Capacity (@L:1200 mm) 100% sealed		<165 packs / hour			
Capacity (@L:600 mm) 100% sealed <sup>1)</sup>		<180 packs / hour			
Capacity (@L:1200 mm) open ends		<165 packs / hour			
Higher packaging capacity		Optional: multiple packaging per movement by adding Semi Flow, Ropex and high-speed equipment			
Capacity (@L:2400 mm) 100% sealed		<250 packs / hour			
Capacity (@L:1200 mm) 100% sealed		<500 packs / hour			
Capacity (@L:600 mm) 100% sealed <sup>1)</sup>		<500 packs / hour			
		On request more packaging capacity examples can be supplied <sup>1)</sup> products L: 450 - 1250 must have extra conveyor and/or pusher support to secure safe passage through the packaging machine			

### Specifications

Power connection	3 x 400 Volt + N + PE 63 Amp fuses
Power consumption (standby)	~300W
Power consumption per packaging cycle (incl. standby consumption)	~0,03kWh
Air consumption per packaging cycle	250 – 300 litres
Operating temperature	Min. 0°C – Max 35°C Forced and filtered air flow in electrical cabinet Optional: Above 35°C with Air Con in electrical cabinet
Tentoma's scope of supply	RoRo machine, safety fencing, and packaging options. Optional: Transport solution with in-feed and out-feed belt, V-shape, roller, or chain conveyors and pusher for short products.
Configuration & layout support	Yes
Drawings available in DWG	Yes
Transport / conveyor height standard	650mm
Transport / conveyor height above 650mm	Optional with extra height extensions
Machine components in general	Globally available and acclaimed brands like Festo, Sick, SEW, Siemens
PLC	Siemens Serie 1500 with safety module. Programmed in TIA Portal

### Ergonomics

Operation	Fully automatic (excl. film roll exchange)
Noise level	Low (product & stretch level dependant)
MMI / HMI	Intuitive software and 12" Siemens colour touch display

Product dimensions for product to be packaged	Large Duplex		XL Duplex / XL Power Duplex	
	D2	D4	D2	D4
Product width	300 – 880mm		300 – 1.350mm	
Product height	10 – 800mm		10 – 1.385mm	
Product circumference (L+H) x 2 with stretched film <sup>3)</sup>	750 - 3.360mm		750 – 5.200mm	
Product length, @ W: 600mm, H: 500mm and applying 40µ PE-film	300 <sup>2)</sup> - 9.000mm		XL Duplex XL	Power Duplex
			300 <sup>2)</sup> - 10.000mm	300 <sup>2)</sup> – 19.000mm
Product length, @ W: 600mm, H: 500mm and applying 80µ PE-film	300 <sup>2)</sup> - 4.200mm		300 <sup>2)</sup> - 8.000mm	300 <sup>2)</sup> – 16.000mm
Product length, @ W: 1.200mm, H: 800mm and applying 100 µ PE-film	N/A		300 <sup>2)</sup> – 6.700mm	300 <sup>2)</sup> – 13.500mm
Other lengths	On request more length examples can be supplied			
<sup>2)</sup> Length constrains	Packaging of products L: 300 – 425mm requires moving out-feed conveyor to prevent short products from tilting at outfeed.			
	Packaging of products L: 425 – 1.200mm requires a pusher or built-in conveyor in the packaging machine to secure safe passage through the machine			
<sup>3)</sup> Products with tight packaging	Minimum handleable film circumference is 750mm. It is possible to package products with smaller circumference ((H + W) x 2), but it will be with a loose film.			

### Sealing Options

100 % sealed	Six-sided enclosure. 100 % Water resistant and protected against contamination
< 100 % sealed	Four- or five-sided enclosure (1 or 2 open ends),
Including pallet, underlayer, beams	Possible – the gap between in- and out-feed conveyor must be closed
Including wood / metal frame	Possible

### Stretch Film Info

Film type	Standard Tubular Stretch Hood Low-Density Polyethylene (LD-PE)	
Thickness (flat film without gusset)	30 - 80µ	30 - 120µ
Stretchability	20 – 120%	
Film Roll width max. mm	1.900mm	2.200mm
Film circumference	750 – 4200mm	750 – 4.200mm
Load stability	Higher PE-film thickness results in higher load stability	
Puncture way and resistance	Excellent	
Tear resistance	Excellent	
Product surface temperature	Max 60 °C (when applying film on product)	
COF (friction coefficient)	< 0,25	
Blow up ratio (during production)	Recommended blow up ratio between 2,5 and 4 during film production	
Anti-slippery function	Optional (glue or friction film)	
UV-blocking	Optional: Product Protection against UV deterioration	
UV-protection	Optional: Film Protection against UV deterioration	
Logo and branding options	Integrated in film or/and as add-on process.	
Film supplier	Locally or regionally available	
Film supplier qualification	According to Tentoma test and validation procedures. List available <a href="#">here</a>	
Recycled content	PE-Film can contain 0-50% recycled PE-film	
Recyclable	100%	

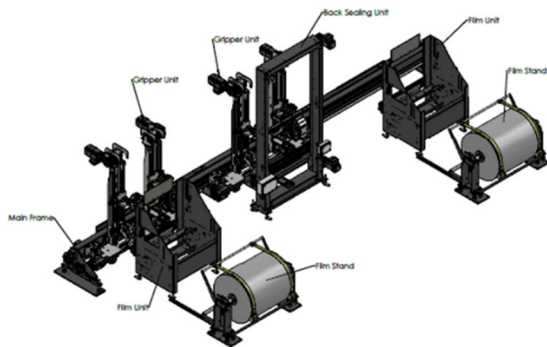
**Film Roll Data**

Roll diameter	Max. Ø: 800mm (optional active film stand allowing Ø: 1000mm)
Roll core diameter, mm	Standard Ø: 76mm. Optional: Ø: 152mm
Roll exchange time	3 - 5 minutes

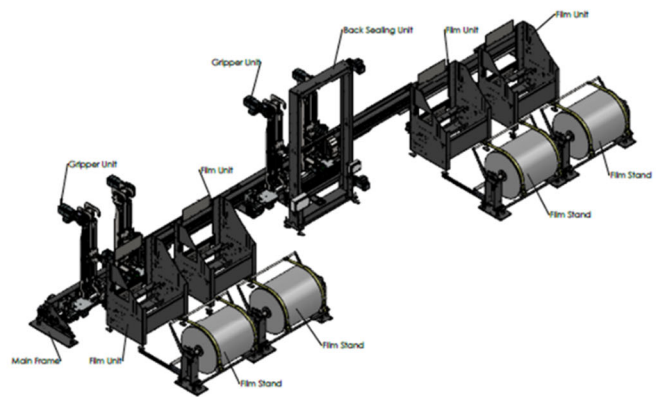
**Certification**

EU Declaration of Conformity	In accordance with EC Machine Directive 2006/42/EC Encl. II, Annex A
IPR (Intellectual Property Rights)	Patents on key technical solutions

**Large Duplex high-speed machines**

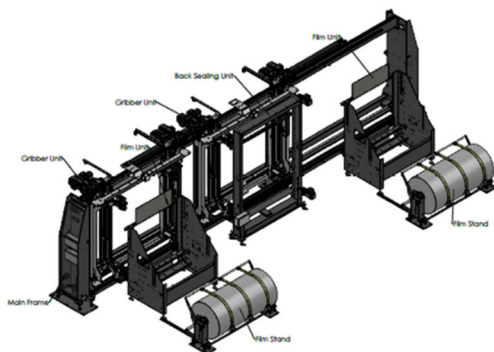


Large D2

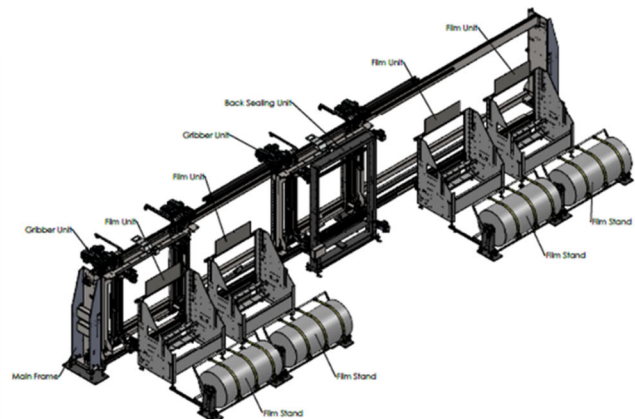


Large D4

**XL Duplex high-speed machines**



XL D2



XL D4