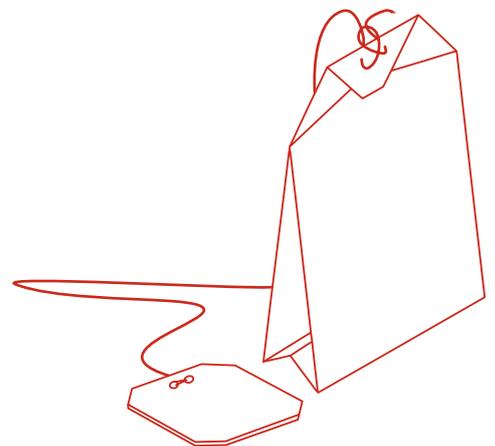# NEW GENERATION
PERFECTA

THE MODULAR TEA BAG PACKAGING MACHINE

TEEPACK
wrap your brand in quality

NEW GENERATION
PERFECTA

BETTER THAN EVER BEFORE

Our goal in the upgrade of one of the world's most successful tea packaging machines: more flexibility, shorter changeover times and better usability for even more production efficiency - see for yourself!

- Interchangeability of assemblies now possible

- Reduction of maintenance time

- Reduction of downtime due to PIT STOP maintenance strategies

- Improved hygenic design

- Faster changeover time for dosing

- Newest and highest standard of electronic and pneumatic components

- New user interface HMI

- Central position of the fibre optic sensors, easy handling

- Digital maintenance support via remote control

- Digital networking possible through a defined interface

- Integrated box erecting device type ISA and lid closing device type IDS available for the first time

OPTIMIZED FOR EVEN MORE PRODUCTION EFFICIENCY:

Mounting system
Interchangeability of assemblies now possible. Reduction of maintenance time. Reduction of downtime due to PIT STOP maintenance strategies.

Pin connections
Taper pin connections have been removed as far as possible. This makes maintenance easier.

Hygienic design
Optimization of flanges and machine wall with regard to hygenic design. Machine is quicker to clean.

Dosing station
Faster changing of the dosing parts.

Automatic tracking of tea volume by weighing optionally possible.

Dosing station
Dosing adjustment in the main drive housing. This gives better access to the dosing station.

Perfect tea volume dosing with servo technology.

Pneumatic components
Newest and highest standard of pneumatic components.

Electronic components
New, fast fieldbus delivers precise sensor signals and advanced diagnostic information.

Latest operating system versions.

Human Machine Interface
Optimized ergonomic HMI user interface. Latest operating system versions.

NEW GENERATION
PERFECTA

THE MODULAR MACHINE SYSTEM WITH SUPERIOR FORM & FUNCTION

With the PERFECTA NEW GENERATION, we offer you a wide range of tea packaging alternatives. It combines all advantages of innovative and modular technology with an outstanding design. Constructed and produced according to the high technical standards expected of a reputable German manufacturer, the new PERFECTA modular machine system is a real productivity factor for your production.

The PERFECTA NEW GENERATION is notable for its captivating design in a cool steel and aluminium look with an accentuated red frame. The new PERFECTA also incorporates completely new engineering features and therefore offers improved usability and easier maintenance.

Fibre optic sensors
Central position of the fibre optic sensors, easy handling.
New intelligent and fast fiber optic sensor generation.

Digital networking of the machine
Digital networking of the PERFECTA machine possible through a defined interface.

Remote maintenance via modem
Digital maintenance support via remote control.

**Integrated box erecting device type ISA and integrated lid closing device type IDS**

Integrated box erecting device type ISA
The integrated box erecting device pushes the plain box via a stamp into the finished form ready for filling with bags.

The finished box is transported directly into the PERFECTA machine.

Integrated lid closing device type IDS
The integrated lid closing device folds the dust flaps of the filled box and closes the lid.
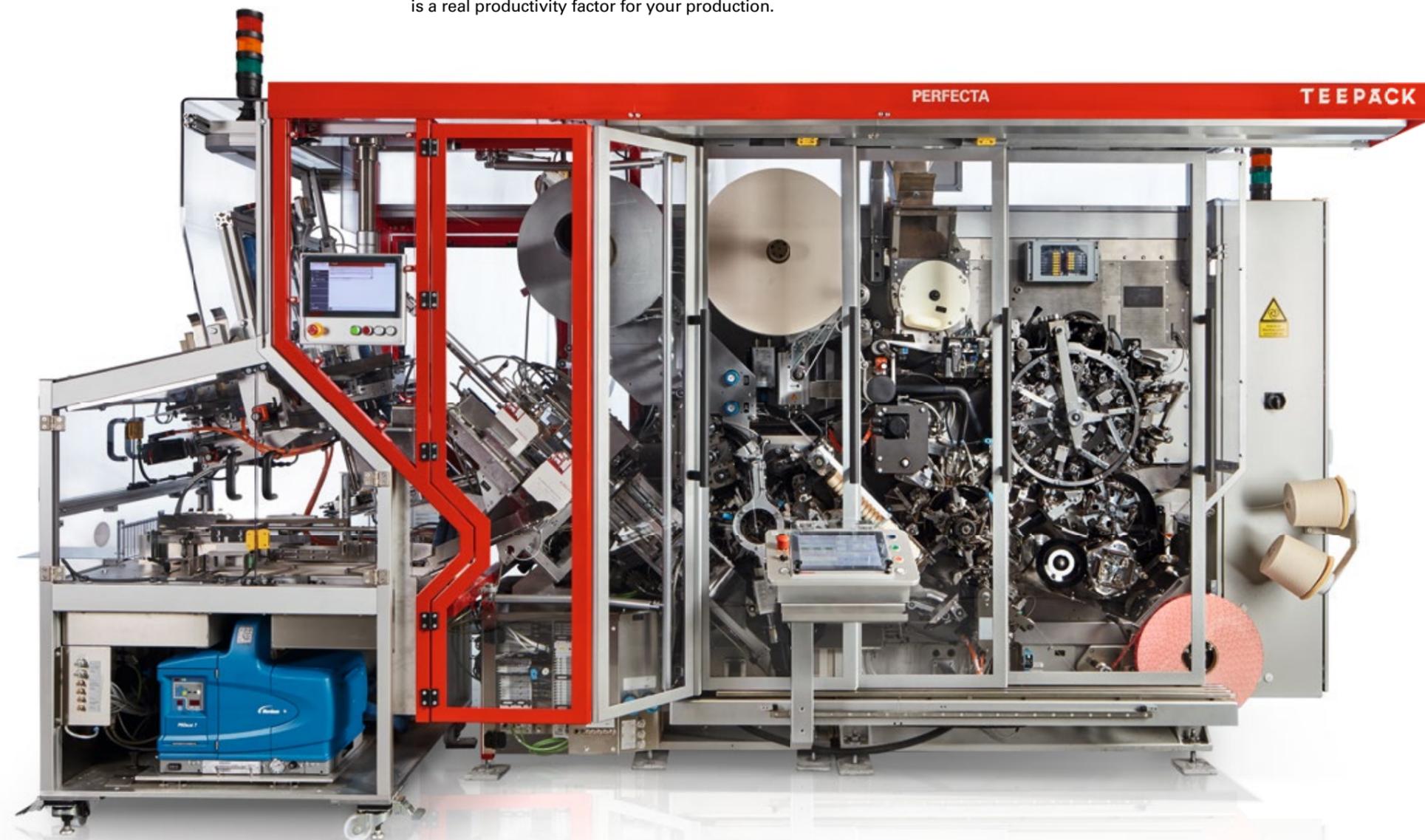
HIGH PERFORMANCE MEETS FLEXIBILITY
PERFECTA

THE MODULAR SYSTEM SECURES YOUR INVESTMENT IN A HIGH PERFORMING TEA-PACKAGING SYSTEM

The PERFECTA NEW GENERATION is more than the upgrade of one of the most successful tea packaging machines on the market. The new PERFECTA constitutes a further step towards the world of modular systems, giving you maximum flexibility for the growth and expansion of your production. Expand the range of packaging for your brand with additive components, without the need to replace the entire machine.

The base of the PERFECTA system consists of the main module and the end group module of the PERFECTA TAG machine. This allows for an endless variety of packaging styles. You can also use the main module of the PERFECTA TAG machine to upgrade the PERFECTA TAG into a PERFECTA UNIVERSAL. All you would need in
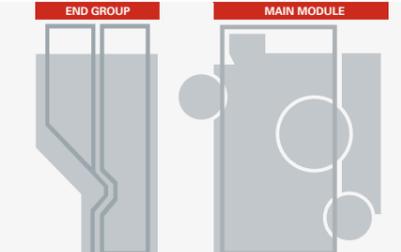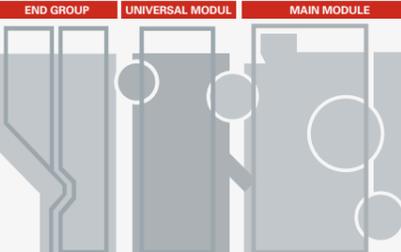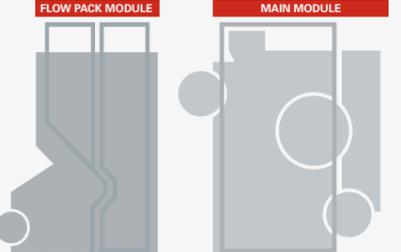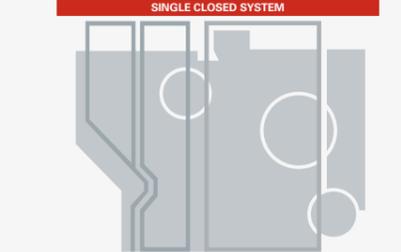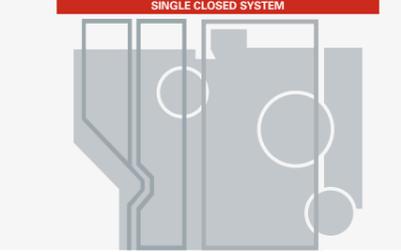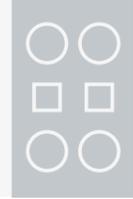
addition is the UNIVERSAL module. Then you would not only be able to produce filter bags (naked bags) but also crimped paper envelope bags and heat sealed envelope bags. Cold sealed envelope bags can also be manufactured on the PERFECTA UNIVERSAL machine. Used in combination the FLOW PACK module you would be able to produce flow packs with your PERFECTA TAG entry-level machine. We will support you with our technical team if you want to convert your PERFECTA TAG so as to have enhanced packaging possibilities. The PERFECTA module system is completed by other module splicers, an integrated box erecting device type ISA and a lid closing device type IDS. So, whatever you decide to do, you will have a future-proof, high quality solution for your tea production.

Rely on our innovative technology for premium quality products

- Modular construction
- Quick format changes
- Fewer staff required
- Longer maintenance intervals
- Shorter maintenance times
- Low spare parts consumption

Increase your efficiency while reducing costs

- Lower production costs
- High production efficiency
- Time saving exchange of packaging materials
- Reliability
- Flexibility
- Superior safety standards
- German premium quality and perfection

	PACKAGING			DEVICE	PERFECTA MODULES			SPLICER	TEA BAGS
	Filter bag	Paper envelope bag	Heat sealed envelope bag	Integrated box erecting & lid closing device				Up to 3 splicer devices (□) with up to 6 pickup stations (○)	
PERFECTA TAG				Integrated box erecting & lid closing device	END GROUP	MAIN MODULE			
PERFECTA UNIVERSAL				Integrated box erecting & lid closing device	END GROUP	UNIVERSAL MODUL	MAIN MODULE		
PERFECTA FLOW PACK				FLOW PACK	FLOW PACK MODULE	MAIN MODULE			
PERFECTA FAMILY SIZE				Integrated box erecting & lid closing device	SINGLE CLOSED SYSTEM				
PERFECTA ENVELOPE				Integrated box erecting & lid closing device	SINGLE CLOSED SYSTEM				

PERFECTA TAG

THE BENEFITS

ENHANCED EFFICIENCY AND PRODUCTIVITY

The PERFECTA TAG machine produces double-chamber tea bags (naked bags) with a thread and tag. As is the case with all PERFECTA machines, the filter bags are formed and then crimped so that no heat sealing filter paper is needed. This ensures a more efficient infusion performance, enabling the natural tea aroma to flow out, eliminating the need for chemical additives and enhancing the taste of your tea. The tag features a unique "thread safety" design which fixes the thread into a slot at the lower edge of the tag, This ensures that the threads and tags do not get tangled inside the tea bag box during transit. Depending on customer requirements, the integrated punching unit can use tag reels with print marks and also punch out the corners of the tag material directly in the PERFECTA machine.
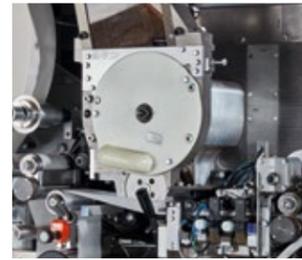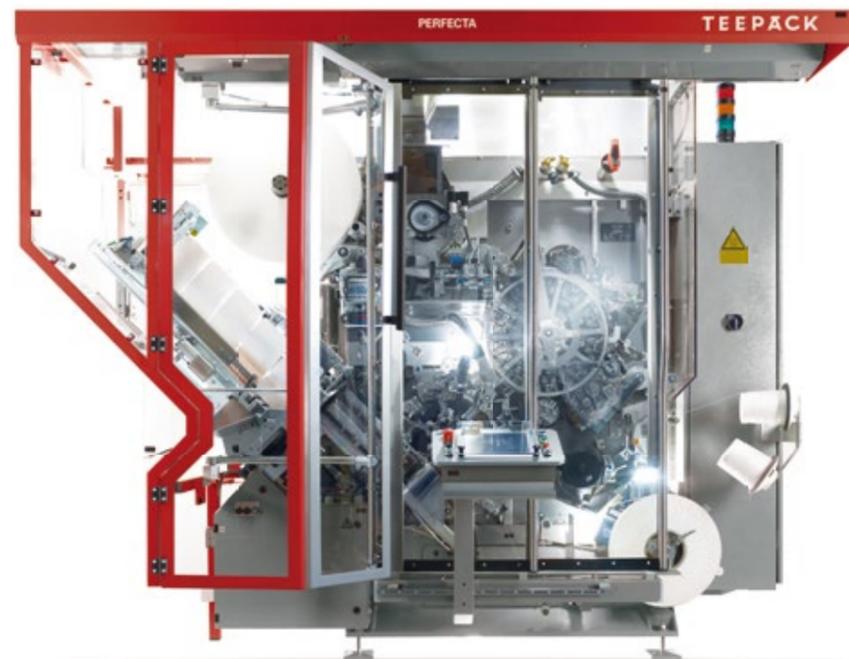
Dosing station with dust exhaust device and filter paper tube forming station*

The "heart" of the PERFECTA machine. Continuous working transport wheel with the stations forming the filter paper bag*

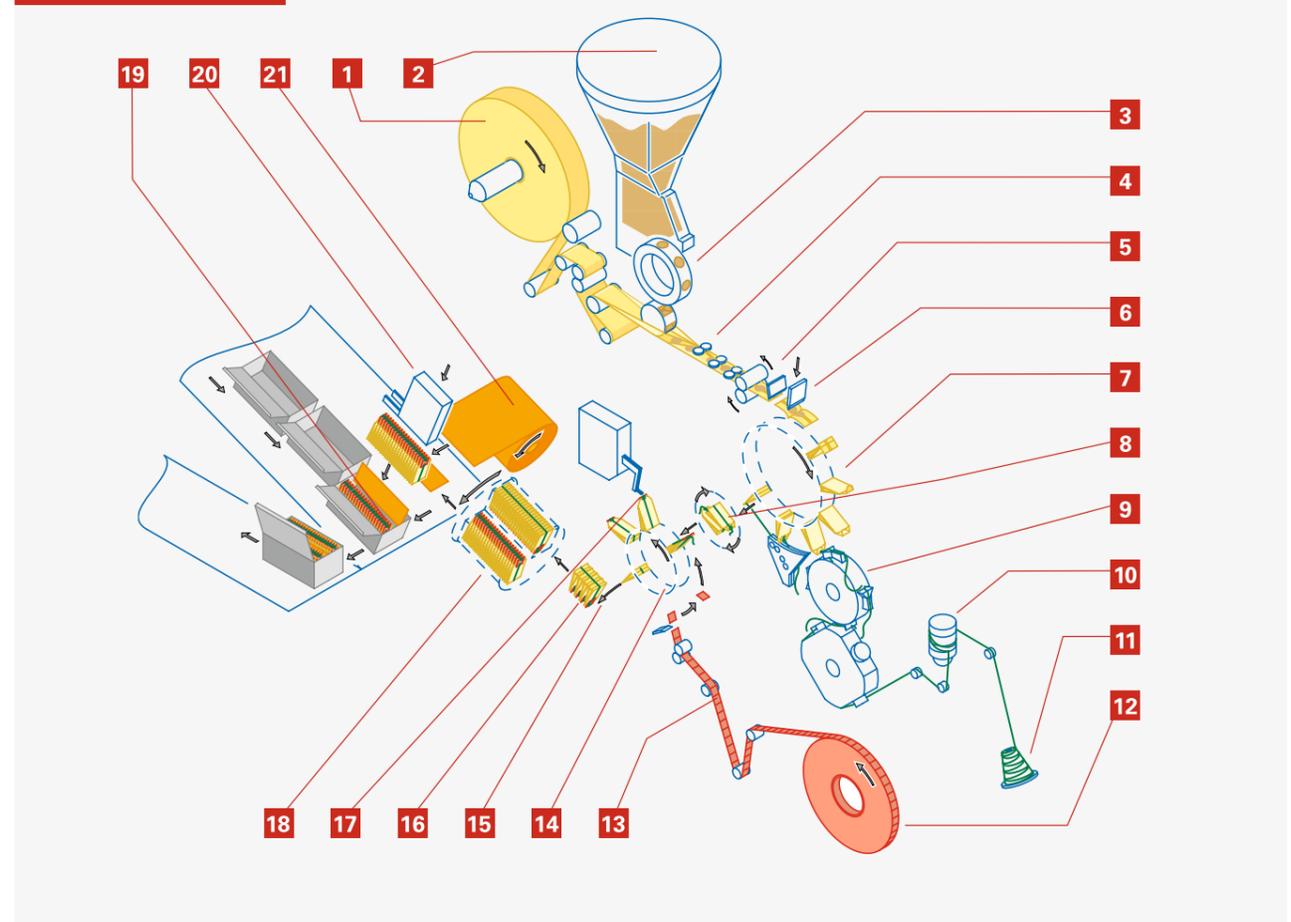Filter paper tea bag forming – bottom and head folding

Final station of tea bag manufacture. Attachment of thread and cardboard tag.

Cardboard tag knotted

Cardboard tag stapled (optional)

Filter bag tag knotted

Filter bag tag stapled (optional)

* Standard for all PERFECTA models

- Production speed of up to 420 bags/min.
- Quicker and easier exchange of the dosing device
- Faulty bag ejection
- Motor operated bag weight adjusting mechanism
- Computer controlled weight checker for full boxes (optional)
- Cardboard divider strip from reel (optional)
- Flavour dosing device (optional)
- Servo-controlled tag corner punching station (optional)
- Automatic splicer (optional)

PERFECTA TAG – DETAILS

No.	Description
1	Filter paper reel
2	Tea feed
3	Dosing
4	Tube forming
5	Tube knife
6	Bottom folding
7	Head folding
8	Reversing wheel
9	Bag head knotting or head stapling station
10	Thread regulating wheel (Fournisseur)
11	Cotton thread cone
12	Cardboard tag reel
13	Cardboard tag unwinding and cutting
14	Lower transport wheel (Tag Type)
15	Faulty bag ejection
16	Bag stacking and counting
17	Tag knotting or tag stapling station
18	Turning magazine
19	Stacking and inserting of carboard divider strip into the box
20	Box filling
21	Cardboard divider strip reel

PERFECTA UNIVERSAL

THE BENEFITS
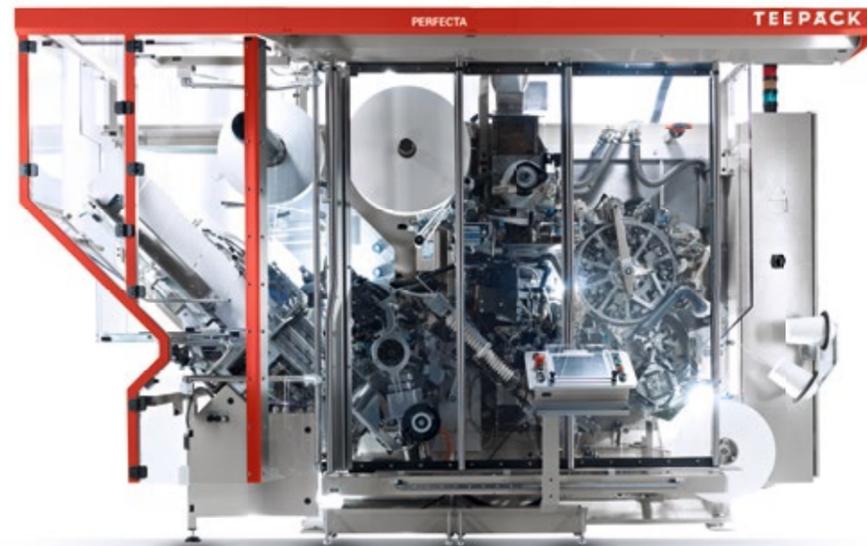
MODULAR DESIGN FOR MAXIMUM FLEXIBILITY AND CAPACITY – UP TO 380 BAGS PER MINUTE

The PERFECTA UNIVERSAL produces three types of double-chamber tea bag with a cardboard tag. The filter bag (naked bag) can be wrapped with either envelope paper or a heat seal envelope. A cold seal envelope is also possible. Retrofitting the machine for the various enveloping options is easy. Simply activate or deactivate the envelope feeder and exchange a few easy-to-handle formatting parts and assemblies. The basic machine is the PERFECTA TAG machine for filter bags.

Functions

After finishing the filter bag with a cardboard tag, the bag is fed into a universal transport wheel where the filter bag is wrapped in an envelope paper or a heat seal envelope. The finished tea bag is then transported to an automatic universal box filling station capable of handling all three types of bags. The envelope aggregate, as well as the box filling device are fitted on the left side of the PERFECTA main module.

Cardboard tag knotted

Cardboard tag stapled (optional)

Filter bag tag knotted

Filter bag tag stapled (optional)

Spiral conveyor

Transport wheel (Universal)

Sealing jaws (heat seal envelope)

Sealing jaws (heat seal envelope)

Bag stacking and cartoning

- Production speed: up to 380 bags/min. (up to 350 bags/min. with heat seal envelope)
- Manufacturing options for 3 bag types:
  - filter bag with tag (naked bag)
  - filter bag with tag in crimped envelope paper
  - filter bag with tag in heat sealed envelope
- Flexible production, can be quickly converted from filter bag to outer envelope production and vice versa
- Hard tag in the envelope (smallest tag size available: 20x24 mm)
- Flavour dosing device (optional)
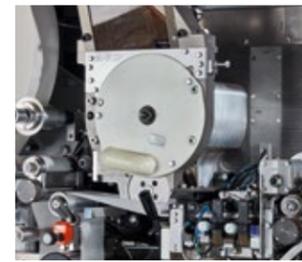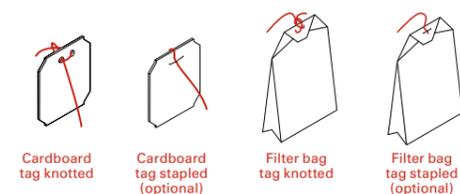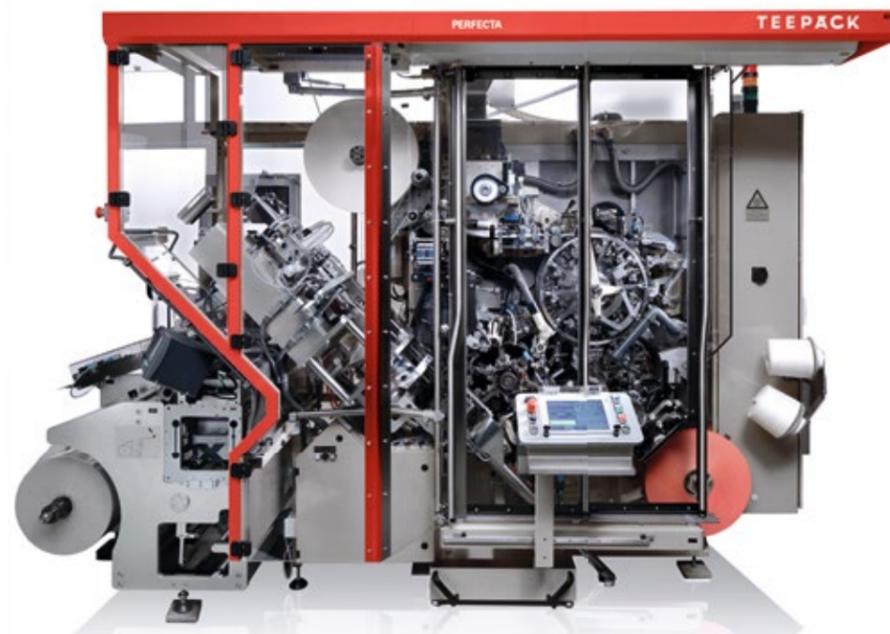- Automatic splicer (optional)

PERFECTA UNIVERSAL – DETAILS
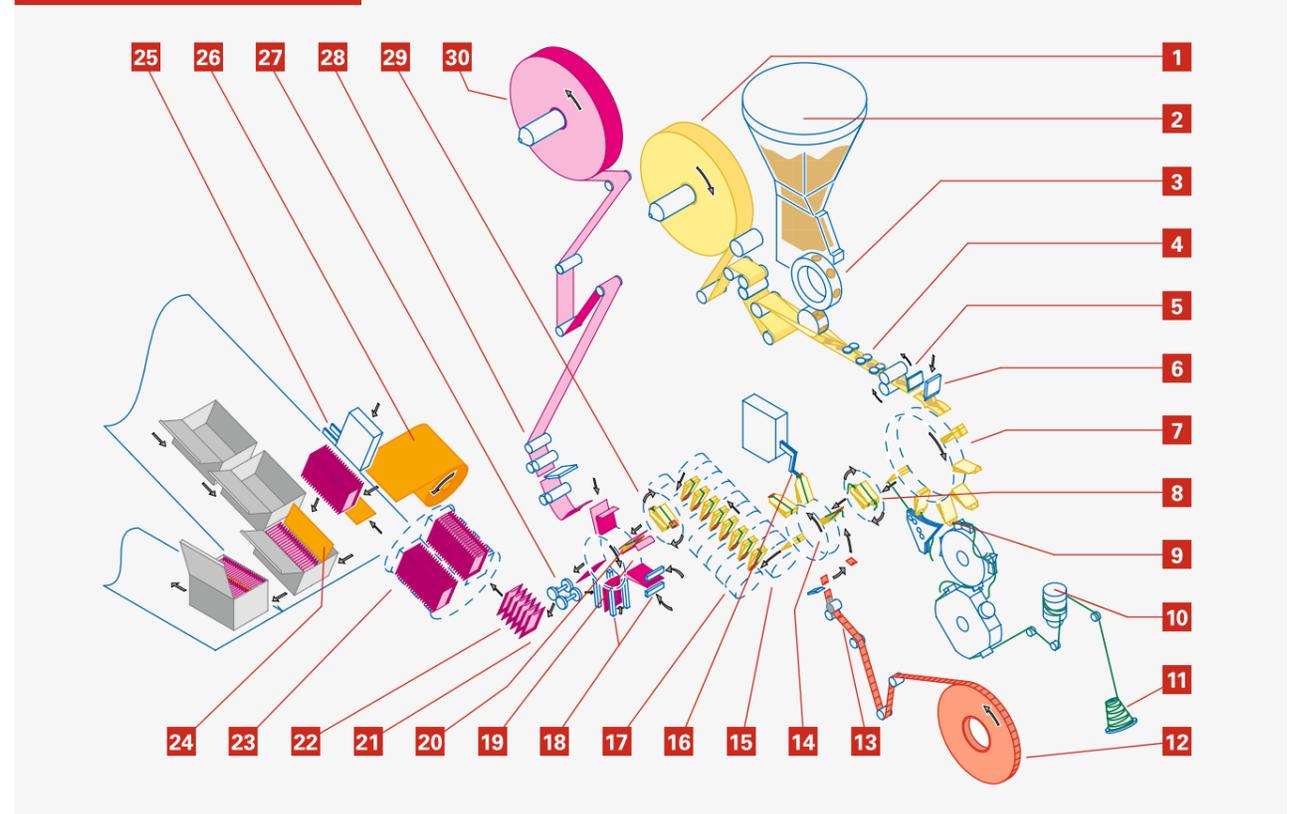
No.	Description	No.	Description	No.	Description
1	Filter paper reel	13	Cardboard tag unwinding and cutting	24	Stacking and inserting of card board divider strip into the box
2	Tea feed	14	Lower transport wheel (Tag Type)	25	Box filling
3	Dosing	15	Faulty bag ejection	26	Cardboard divider strip reel
4	Tube forming	16	Tag knotting or tag stapling station	27	Bag take off and crimping station
5	Tube knife	17	Bag feed (spiral conveyor)	28	Feed station and cutting of paper envelope or aroma protection envelope foil
6	Bottom folding	18	Sealing jaws with tear-off knife	29	Reversing wheel
7	Head folding	19	Transport wheel (Universal)	30	Paper envelope reel or aroma protection envelope foil reel
8	Reversing wheel	20	Pushing of filter bag into outer envelope paper or aroma protection envelope foil		
9	Bag head knotting or head stapling station	21	Faulty bag ejection		
10	Thread regulating wheel (Fournisseur)	22	Bag stacking and counting		
11	Cotton thread cone	23	Turning magazine		
12	Cardboard tag reel				

PERFECTA
FLOWPACK

THE BENEFITS

FROM FILLING TO WRAPPING IN ONE STEP. FLEXIBLE, EFFICIENT AND ECONOMICAL.

In addition to the tried and tested PERFECTA, the PERFECTA FLOW PACK offers a fully integrated wrapping unit for high-quality tea bag repackaging. The PERFECTA FLOW PACK is the complete all-in-one solution: filling and packaging in a single step. Ten or more high-quality double-chamber bags are repackaged with utmost efficiency in flow pack bags. Heat sealing ensures that the aroma is hermetically locked in until the product is ready to be consumed. The PERFECTA FLOW PACK not only saves space, it is also extremely economical: unlike the standard method, no additional packaging machine is required!

Cardboard tag knotted   Cardboard tag stapled (optional)   Filter bag tag knotted   Filter bag tag stapled (optional)

Dosing station

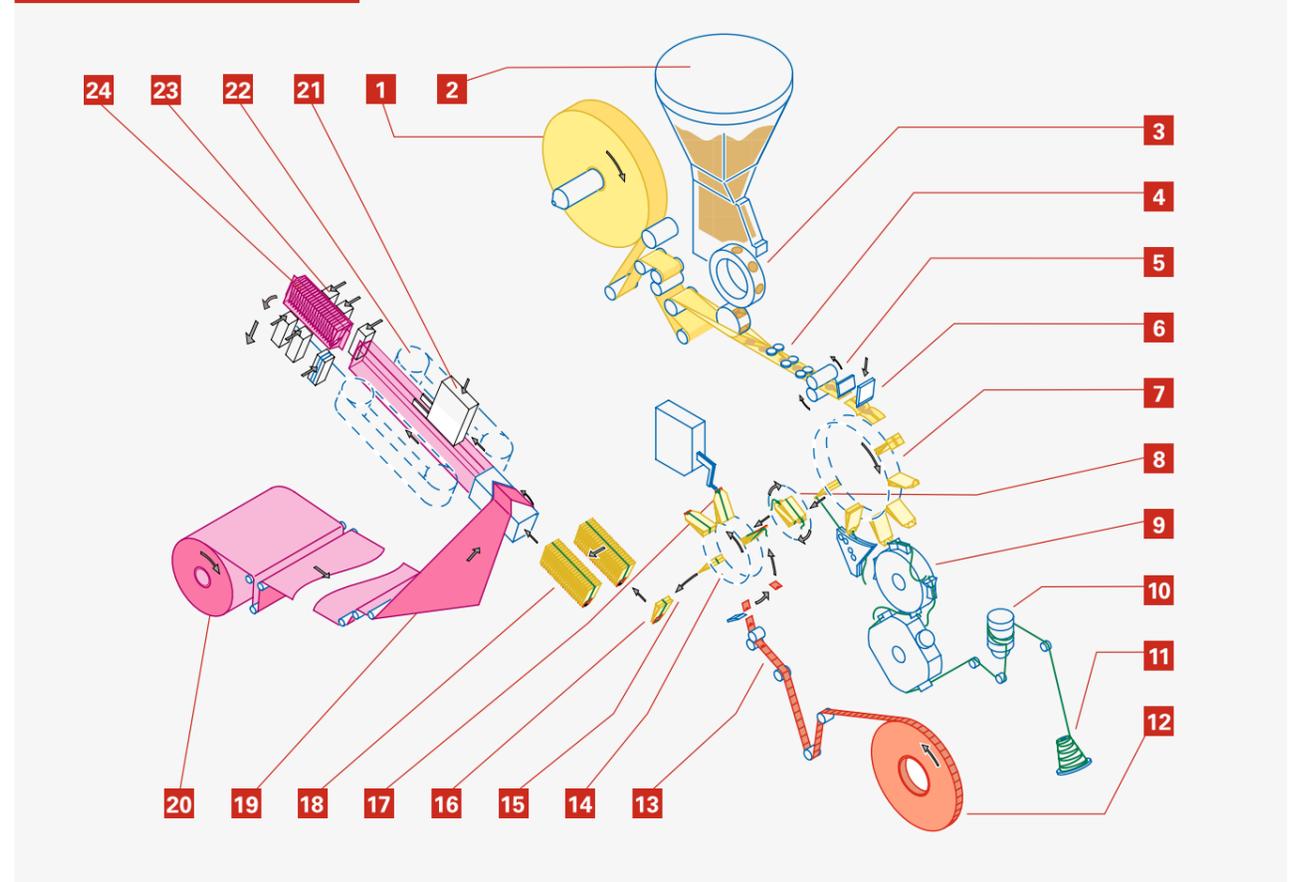
Transport wheel

Filter paper tea bag forming

Sealing jaws

Optional scale for weighing flow pack bags

- Production speed:
  10 bags: on request
  15 bags: up to 350 bags/min.
  20 bags + more: 400 bags/min.
  25 bags: up to 420 bags/min.
- Tea bag producing and wrapping in one step – no additional machine and no transfer required
- Simple foil replacement
- Quick change of bag quantity per flow pack thanks to simple panel operation
- Easy maintenance thanks to modular design
- Motor-operated bag weight adjusting mechanism
- Faulty bag ejection and faulty flow pack ejection
- Small space requirement
- Optional scale for weighing flow pack bags

PERFECTA FLOW PACK – DETAILS

1	Filter paper reel	11	Cotton thread cone
2	Tea feed	12	Cardboard tag reel
3	Dosing	13	Cardboard tag unwinding and cutting
4	Tube forming	14	Lower transport wheel (Tag Type)
5	Tube knife	15	Faulty bag ejection
6	Bottom folding	16	Bag stacking and counting
7	Head folding	17	Tag knotting or tag stapling station
8	Reversing wheel	18	Linear magazine
9	Bag head knotting or head stapling station	19	Forming shoulder
10	Thread regulating wheel (Fournisseur)	20	Foil reel
21	Longitudinal sealing		
22	Draw-off belts		
23	Cross sealing		
24	Flow pack bag removal		

PERFECTA FAMILY SIZE

THE BENEFITS

ADVANCED DESIGN FOR MAXIMUM QUALITY FAMILY SIZE PACKAGING

The PERFECTA FAMILY SIZE machine has been designed to deliver maximum quality XL double-chamber tea bags with a thread and cardboard tag. It features all the advantages of the PERFECTA TAG machine, allowing for the manufacture of bags with natural non-heat seal filter paper using a variety of tag sizes. However, with the FAMILY SIZE model you can fill double-chamber tea bags with up to seven grams of black tea with a production speed of up to 250 bags per minute for the latest trends in ice tea, and cold or hot brew tea specialties.
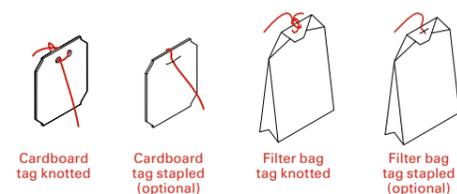
Dosing station with dust exhaust device and filter paper tube forming station

The "heart" of the PERFECTA machine. Continuously working transport wheel with the stations forming the filter paper bag

Filter paper tea bag forming – bottom and head folding

Final station of tea bag manufacture. Attachment of thread and cardboard tag


Drive, drive for filter paper and dosing. Motor operated bag weight adjusting mechanism

Cardboard tag knotted Cardboard tag stapled (optional) Filter bag tag knotted Filter bag tag stapled (optional)

- Production speed: up to 250 bags/min.
- Filling volume of up to 22 cm^3
- Faulty bag ejection
- Low filter paper consumption
- Motor operated bag weight adjusting mechanism
- Quicker and easier exchange of the dosing device
- Computer controlled weight checker for full boxes (optional)
- Servo-controlled tag corner punching station (optional)

PERFECTA FAMILY SIZE – DETAILS
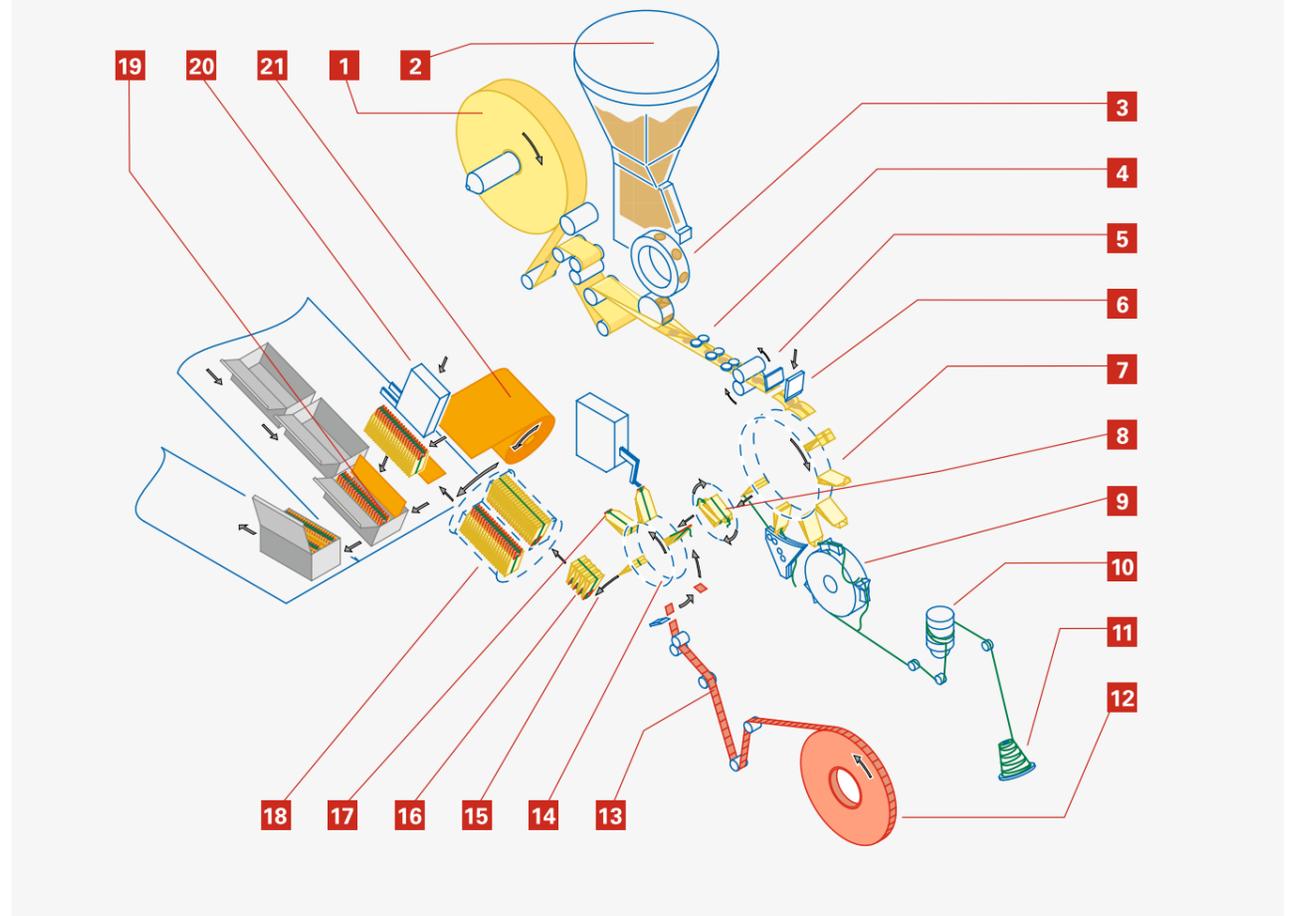
1	Filter paper reel	9	Bag head knotting or head stapling station	17	Tag knotting or tag stapling station
2	Tea feed	10	Thread regulating wheel (Fournisseur)	18	Turning magazine
3	Dosing	11	Cotton thread cone	19	Stacking and inserting into the box
4	Tube forming	12	Cardboard tag reel	20	Box filling
5	Tube knife	13	Cardboard tag unwinding and cutting		
6	Bottom folding	14	Lower transport wheel (Tag Type)		
7	Head folding	15	Faulty bag ejection		
8	Reversing wheel	16	Bag stacking and counting		

PERFECTA ENVELOPE

THE BENEFITS

HIGHLY ECONOMICAL DUE TO A UNIQUE TAG CUTTING DESIGN

The PERFECTA ENVELOPE manufactures double-chamber tea bags in a protective paper envelope. Its unique envelope bag is the only one which does not require the production of an additional tag, as the tag is cut from the paper envelope itself. Over the entire lifespan of the machine, this results in substantial long-term cost savings.
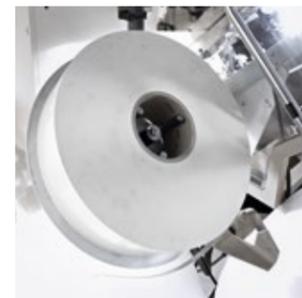

Paper envelope feed
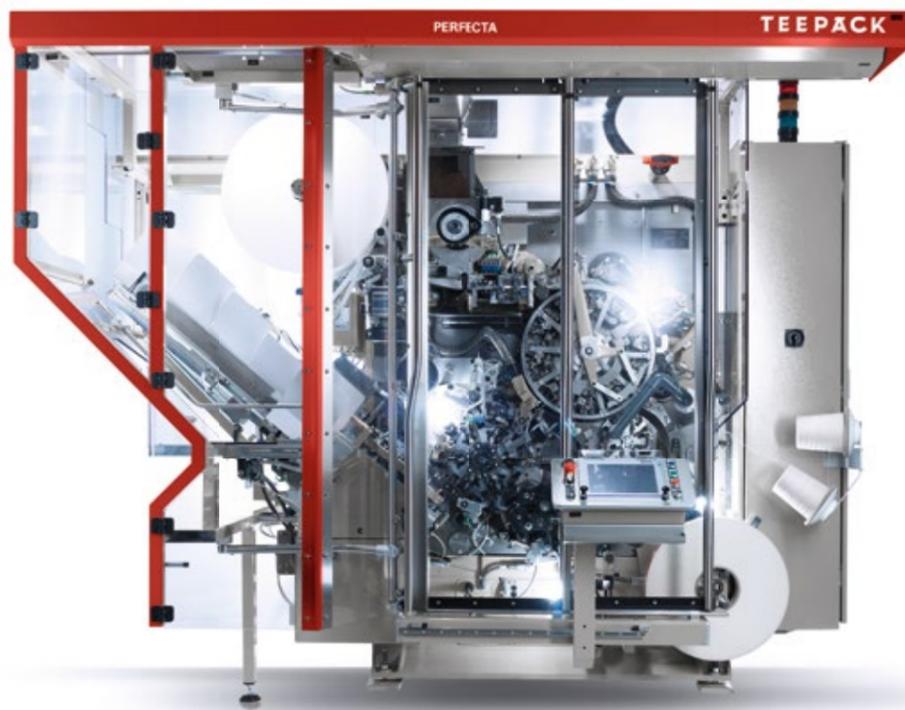

Lower transport wheel (envelope)

Bag stacking and box filling

Cardboard divider strip reel and cardboard divider inserter

- Production speed: up to 380 bags/min.
- Cost savings (paper tag cut from the paper envelope)
- Available as a knotting or stapling machine (tea bag head with knot, paper tag with staple)

- Faulty bag ejection
- Motor operated bag weight adjusting mechanism
- Computer controlled weight checker for full boxes (optional)

- Cardboard divider strip from reel (optional)
- Flavour dosing device (optional)
- Automatic splicer (optional)

PERFECTA ENVELOPE – DETAILS
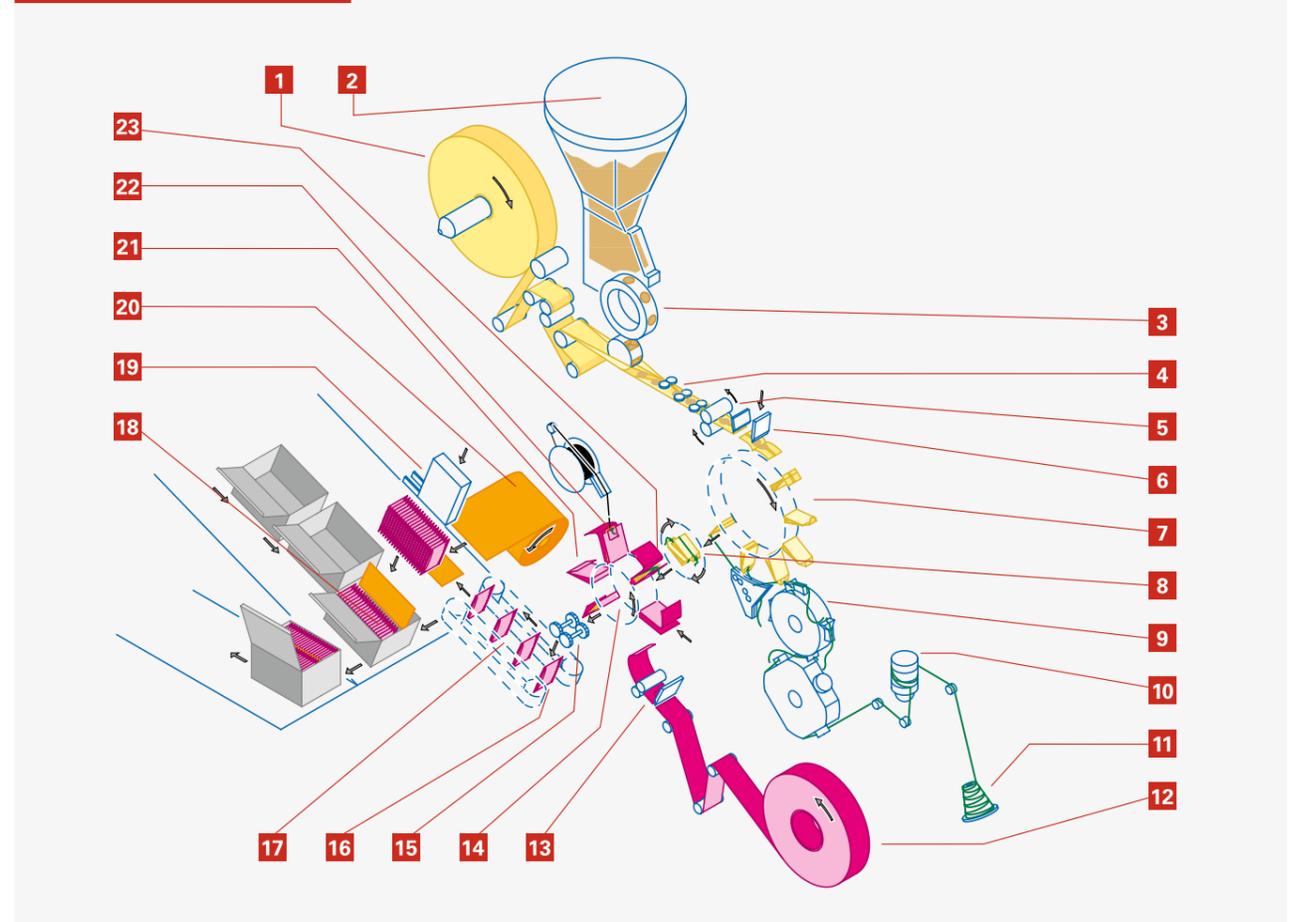

1	Filter paper reel	9	Bag head knotting or head stapling station	18	Stacking and inserting of card board divider strip into the box
2	Tea feed	10	Thread regulating wheel (Fournisseur)	19	Box filling
3	Dosing	11	Cotton thread cone	20	Cardboard divider strip reel
4	Tube forming	12	Envelope paper reel	21	Reversing of the closing flap
5	Tube knife	13	Envelope unwinding and cutting	22	Tag stapling
6	Bottom folding	14	Lower transport wheel (envelope type)	23	Pushing of filter bag into the outer envelope
7	Head folding	15	Bag take off and crimping station		
8	Reversing wheel	16	Faulty bag ejection		
		17	Envelope bag stacking and counting		

Cardboard tag stapled

Filter bag tag knotted

Filter bag tag stapled (optional)

A PATENTED LINK

KNOT ON THE BAG

The thread is knotted securely to the top of the bag by two needle stitches to the left and right of the longitudinal seam in a patented procedure. The knot replaces the function of the staple by fixing the inner folds with two stitches and reliably closing the top of the tea bag.

The knot is self-tightening and therefore cannot become loose. The station works in a continuous process. The movements run slowly and the needles are protected against wear. The knotted thread is tightened at the end of the process by a thread brake. A 100% knot check is performed at this stage. Faulty bags are ejected.

This device produces the same double chamber bag as any other PERFECTA machine – the two knotting stations simply replace the two stapling stations.

KNOT ON THE TAG

The knot is formed between two holes punched before-hand in the cardboard tags in a patented procedure. The holes are cleanly punched out by an apparatus installed in the tag feed. As well as giving a neat optical impression, the holes serve to relieve wear on the needles which do not need to pierce the hard tag. The knot is formed between both holes which results in a perfect appearance. The knot is self-tightening. A sensor monitors the position of the bag and the tag before it reaches the knotting station. If the positions are incorrect, the knotting device swings out of its operating position for one cycle and then back in again, allowing the faulty bag to pass through without knotting, and thus protecting the extremely precise components. A thread monitor checks whether the knots have been formed. A bag detected as being faulty is blown out by the faulty bag ejection station.
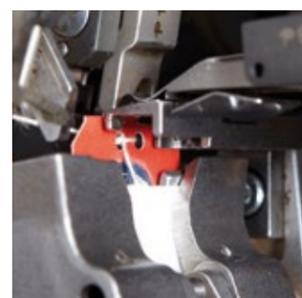
KNOT ON THE BAG

KNOT ON THE TAG
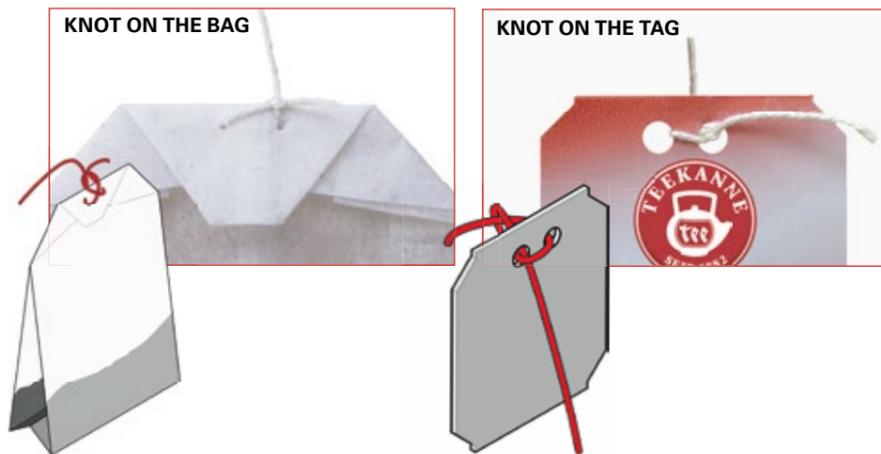

Sectional view of the knotting station(bag) BG-D60

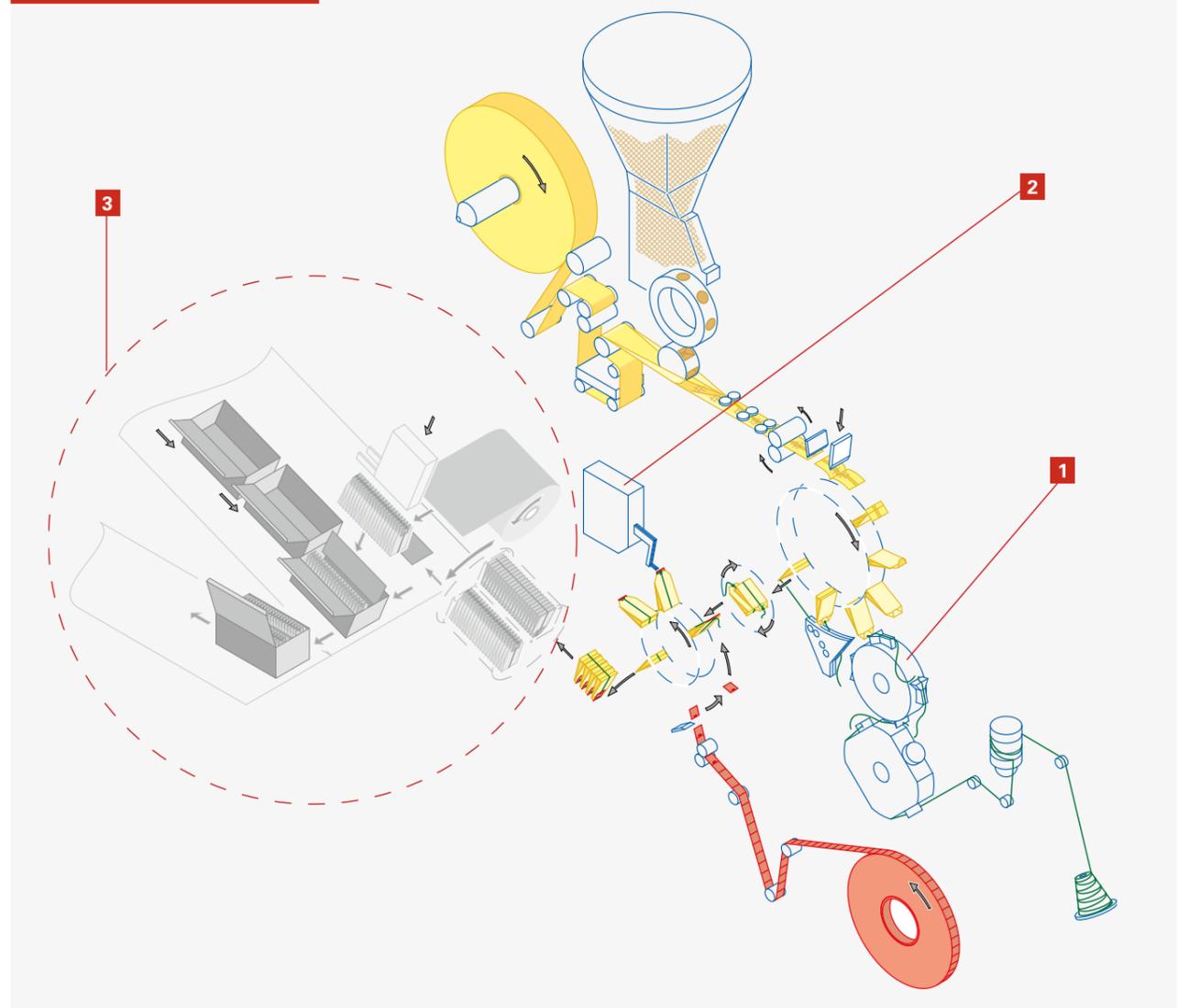Sectional view of the knotting station(bag) BG-D60

Sectional view of the knotting station (tag) BG-D62

Sectional view of the knotting station (tag) BG-D62

KNOTTING STATION – DETAILS

| 1 | Knotting station filter bag | 2 | Knotting station cardboard tag | 3 | ■ TAG ■ UNIVERSAL |

OPTIONAL

SIMPLY ACHIEVE MORE.

Tag punch

A tag feed system enables greater flexibility and more design options for the tags. The feed system is driven by a servo motor making it possible to process a tag reel without punched-out corners. The integrated punching unit can also punch out the corners or other geometric shapes from the tag material. The station can quickly be set to any tag size by exchanging a few format parts.
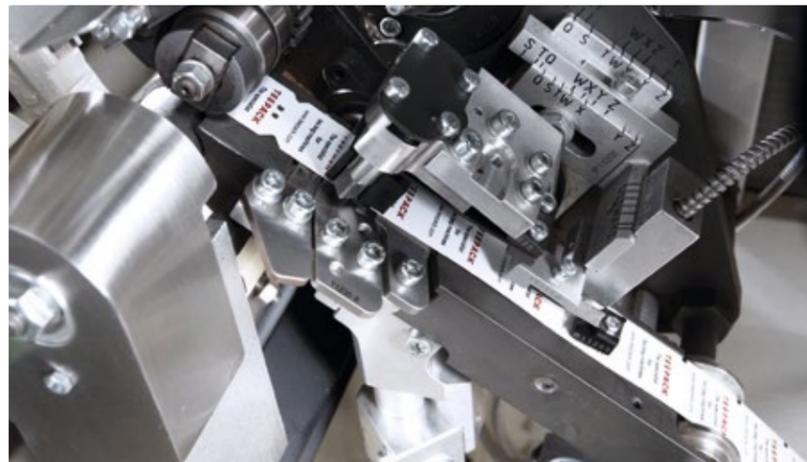
Weight checking system

The weight checking system can be optionally integrated into the PERFECTA controls. It consists of a control scale, an interface for data exchange and a faulty box ejector. This system conducts an automatic weight check of every box and adjusts the motorized weight regulation system when necessary. The faulty box ejection device removes the boxes from production which do not conform to the exact weight specifications.

Integrated box erecting device type ISA and integrated lid closing device type IDS

The integrated box erecting device pushes the plain box by means of a stamp into the finished form ready for filling with bags. The finished box is then transported directly into the PERFECTA machine. The integrated lid closing device folds the dust flaps of the filled box and closes the lid.
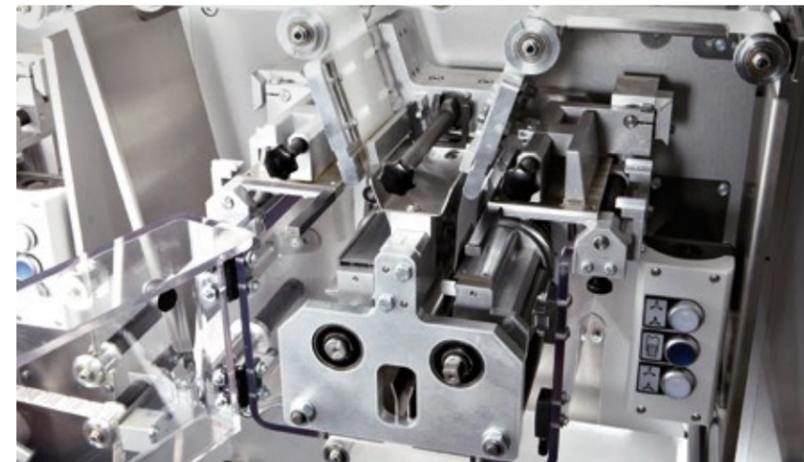
Splicer

Once the end of a reel is reached, the PERFECTA Splicer automatically splices the next roll of material while the machine remains operational. This useful option reduces machine down-time and allows for significantly more material feed flexibility. The modular concept is such that two roller holders and one splicer unit form one module, splicers are available for one, two or even three material types. The machine can process roll diameters of up to Ø 600 mm of filter paper and paper or foil envelope material.

The machine's universal structure allows for quick and easy format changes without the need for additional parts. Parts can be exchanged by hand and the handling of all materials is the same. The result is an accurate alignment of materials edges – the output of the bag with an adhesive point is similarly automated.

Up to six reel pickup stations

Manufacturers who respond quickly to market changes will always be a step ahead of the competition. That is why the PERFECTA can easily be expanded to meet any requirement. It offers great flexibility in terms of tag design, allows for flavour dosing with up to two flavours and is available with an optional weight check system.

The machine can also accommodate up to three optional splicer devices for filter paper, enveloping foil and tags, as well as up to six reel pickup stations.
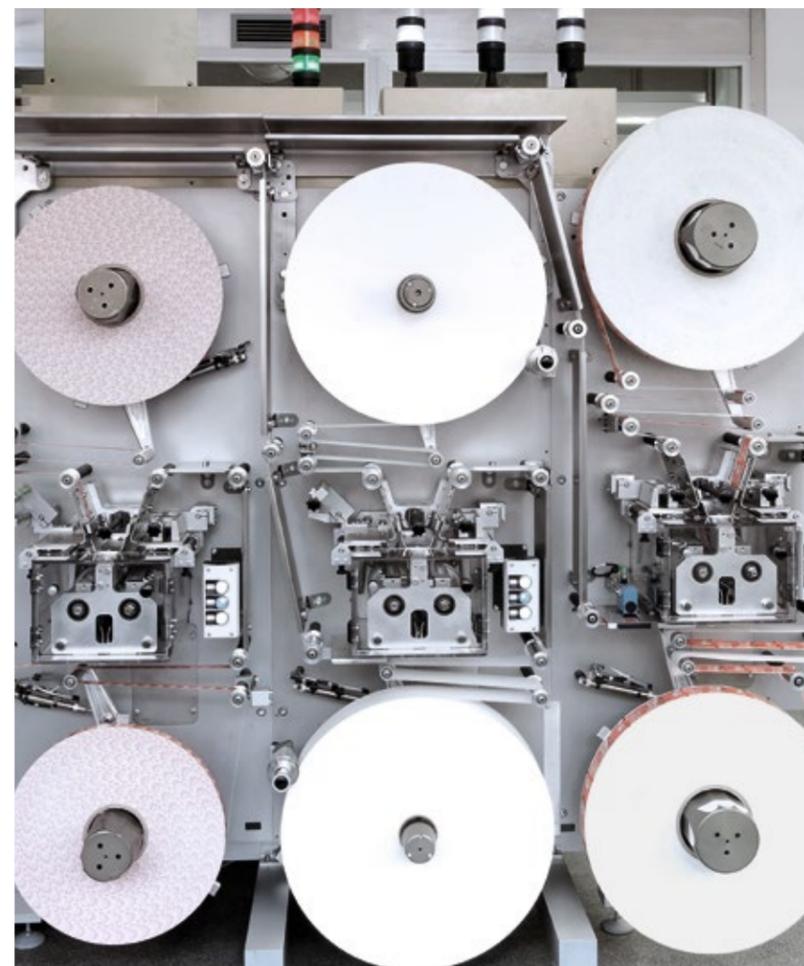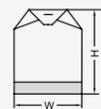
PERFECTA TAG

MATERIAL DATA

PERFECTA UNIVERSAL

MATERIAL DATA

PERFECTA TAG

BAGS

Tea bag sizes

Size	W	H	Max. bag volume
02	40	61	9.5 cm³*
03	44	61	12.5 cm³

* Size 02 max. 7.0 cm³ at 420 bags/minute

CARDBOARD

Cardboard dividers

Size	D	W	d^{+1}	L envelope & tag type	Paper thickness approx.
02	550	110-215	152	43	0.3
03	550	110-215	152	43	0.3

Cardboard tag

Standard size "Z"

Size	W	L	d	D_{max}
Z	28	32	120 or 152	500
X	26	28	120 or 152	500
Y	20	24	120 or 152	500
T	25.4	31.75	120 or 152	500
Ω	23	28	120 or 152	500

Cardboard material
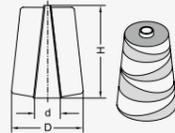
1 row up to 160 mm length:
280-320 g/m²

Multi-row boxes:
360-400 g/m²

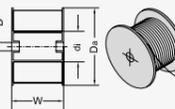Flat blank for cartoning attachment for 15 to 160 bags per box

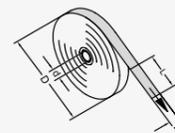Folding box for cartoning attachment for max. two rows per box

SPOOLS

Thread spool

Size	D_{max}	$d^{+/-0.3}$	H_{max}
02	180	47	180
03	180	47	180

Aluminium wire spool

Da	$D^{+/-0.3}$	di	W
min Ø138	18.3	min Ø56	min Ø 49
max Ø152	18.3	min Ø56	max Ø102

REELS

Filter paper reel

Size	D_{max}	d^{+2}	L	$W^{+0.5}$	g/m²
02	600	75	150	94	12
03	600	75	150	103	12

BOX

Box sizes for cartoning attachment for

15 to 160 filter bags with tag (10 filter bags on request)
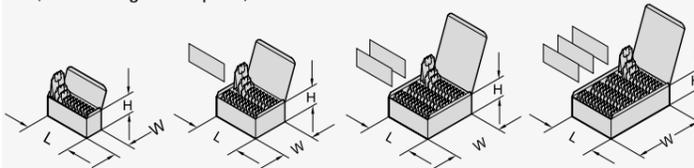
Format 02

	min	max
W	42	165
H	60	60
L	115	220

PERFECTA UNIVERSAL

BAGS

Tea bag sizes

Size	W	H	Max. bag volume
02	40	61	9.5 cm³
03	44	61	12.5 cm³

Filter bag with tag in crimped envelope paper

Size	W	H	Max. bag volume
02	56	67	9.5 cm³
03	60	67	12.5 cm³

Filter bag with tag in heat sealed envelope

Size	W	H	Max. bag volume
02	66	77	7.0 cm³
03	66	77	9.5 cm³

CARDBOARD

Cardboard dividers

Size	D	W	d^{+1}	L envelope & tag type	Paper thickness approx.
02	550	110-215	152	43	0.3
03	550	110-215	152	43	0.3

Cardboard tag

Standard size "Z"

Size	W	L	d	D_{max}
Z	28	32	120 or 152	500
X	26	28	120 or 152	500
Y	20	24	120 or 152	500
T	25.4	31.75	120 or 152	500
Ω	23	28	120 or 152	500

Cardboard material
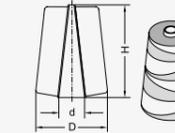
1 row up to 160 mm length:
280-320 g/m²

Multi-row boxes:
360-400 g/m²

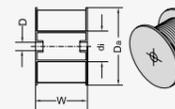Flat blank for cartoning attachment for 15 to 160 bags per box

Folding box for cartoning attachment for max. two rows per box

SPOOLS

Thread spool

Size	D_{max}	$d^{+/-0.3}$	H_{max}
02	180	47	180
03	180	47	180

Aluminium wire spool

Da	$D^{+/-0.3}$	di	W
min Ø138	18.3	min Ø56	min Ø 49
max Ø152	18.3	min Ø56	max Ø102

REELS

Filter paper reel

Size	D_{max}	d^{+2}	L	$W^{+0.5}$	g/m²
02	600	75	150	94	12
03	600	75	150	103	12

Envelope paper reel sizes

Size	D_{max}	d^{+1}	$L1^{+/-0.5}$	$W^{+/-0.2}$	g/m²
02	600	75 or 152	144.5	56	60-70
03	600	75 or 152	144.5	60	60-70

Envelope foil reel sizes

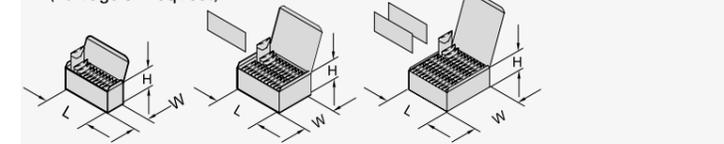| Size	D_{max}	d^{+1}	$L1^{+/-0.2}$	$W^{+/-0.15}$
02	600	75 or 152	154	66
03	600	75 or 152	154	66

BOX

Box sizes for cartoning attachment for

15 to 160 filter bags with tag (10 filter bags on request)
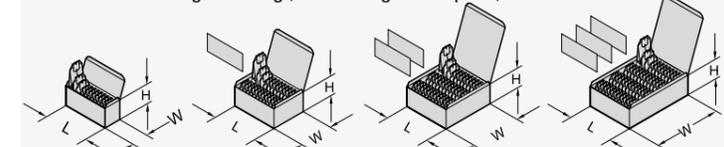
15 to 120 filter bags in crimped envelope paper (10 bags on request)

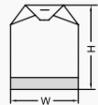15 to 120 filter bags in heat sealed envelope (10 bags on request)

Format 02

	min	max
W	42	229
H	60	79
L	115	220

PERFECTA FLOWPACK

MATERIAL DATA

PERFECTA FAMILY SIZE

MATERIAL DATA

BAGS

Tea bag sizes

Size	W	H	Max. bag volume
02	40	61	9.5 cm³*
03	44	61	12.5 cm³

* Size 02 max. 7.0 cm³ at 420 bags/minute

Flow pack bag

Size	W	H
02	40	63.5
03	44	63.5
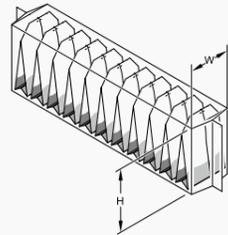
CARDBOARD

Cardboard tag

Standard size "Z"

Size	W	L	d	Dmax
Z	28	32	120 or 152	500
X	26	28	120 or 152	500
Y	20	24	120 or 152	500
T	25.4	31.75	120 or 152	500
Ω	23	28	120 or 152	500

SPOOLS

Thread spool

Size	Dmax	d+/-0.3	Hmax
02	180	47	180
03	180	47	180

Aluminium wire spool

Da	D+/-0.3	di	W
min. Ø138	18.3	min. Ø56	min. Ø49
max. Ø152	18.3	min. Ø56	max. Ø102
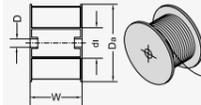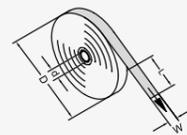
REELS

Filter paper reel

Size	Dmax	d+2	L	W+0.5	g/m²
02	600	75	150	94	12
03	600	75	150	103	12

FOILS

Heat-sealable on both sides

Size	W	Dmax	d+2
02	217	550	75
03	223	550	75

BAGS

Tea bag sizes

Size	W	H	Max. bag volume
06	58	76	22.0 cm³

CARDBOARD

Cardboard tag

Standard size "Z"

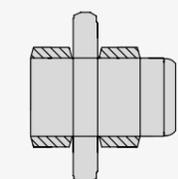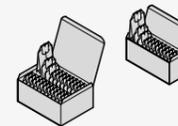| Size	W	L	d	Dmax
Z	28	32	120 or 152	500
X	26	28	120 or 152	500
Y	20	24	120 or 152	500
T	25.4	31.75	120 or 152	500
Ω	23	28	120 or 152	500
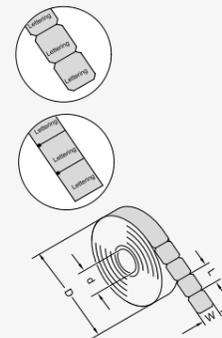
Cardboard material
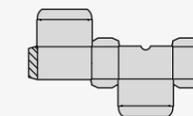
1 row up to 160 mm length:
280-320 g/m²

Multi-row boxes:
360-400 g/m²

Flat blank for cartoning attachment for 10 to 75 bags per box

Folding box for cartoning attachment for max. one row per box

---

SPOOLS
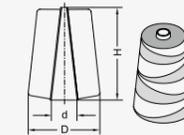
Thread spool

Size	Dmax	d+/-0.3	Hmax
06	180	47	180

Aluminium wire spool

Da	D+/-0.3	di	W
min. Ø138	18.3	min. Ø56	min. Ø 49
max. Ø152	18.3	min. Ø56	max. Ø102
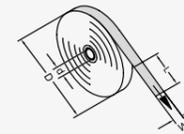
REELS

Filter paper reel

Size	Dmax	d+2	L	W+0.5	g/m²
06	550	75	190	129	14

BOX

Box sizes for cartoning attachment for

15 to 75 filter bags with tag (10 filter bags on request)

Format 06

	min	max
W	60	180
H	76	76
L	110	240*

* max. row length 220mm

PERFECTA ENVELOPE

MATERIAL DATA

TECHNICAL DATA

BAGS

Tea bag sizes

Size	W	H	Max. bag volume
02	40	61	9.5 cm³
03	44	61	12.5 cm³

Filter bag in crimped envelope paper

Size	W	H	Max. bag volume
02	56	67	9.5 cm³
03	60	67	12.5 cm³

CARDBOARD

Cardboard dividers

Size	D	W	d^{+1}	L envelope & tag type	Paper thickness approx.
02	550	110-215	152	33	0.3
03	550	110-215	152	33	0.3

Cardboard material

1 row up to 160 mm length:
280-320 g/m²

Multi-row boxes:
360-400 g/m²

Flat blank for cartoning attachment for 15 to 160 bags per box

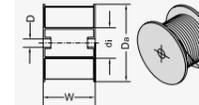Folding box for cartoning attachment for max. two rows per box

SPOOLS

Thread spool

Size	D$_{max}$	d$^{+/-0.3}$	Hmax
02	180	47	180
03	180	47	180

Aluminium wire spool

Da	D$^{+/-0.3}$	di	W
min Ø138	18.3	min Ø56	min Ø 49
max Ø152	18.3	min Ø56	max Ø102

REELS

Filter paper reel

Size	D$_{max}$	d^{+2}	L	W$^{+0.5}$	g/m²
02	600	75	150	94	12
03	600	75	150	103	12

Envelope paper reel sizes

Size	D$_{max}$	d^{+1}	L1$^{+/-0.5}$	W$^{+/-0.2}$	g/m²
02	650*	152	164	56	60-70
03	650*	152	164	60	60-70

* with splicing unit 500

BOX

Box sizes for cartoning attachment for

15 to 120 filter bags in crimped envelope paper (10 bags on request)
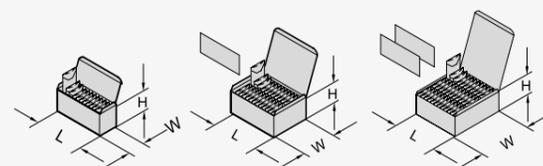
Format 02

	min	max
W	58	229
H	68	68
L	115	220

PERFECTA TAG

Technical data

Production speed:	up to 420 bags/minute
Length x width:	approx. 2780 x 1700 mm
Height with hopper:	approx. 2460 mm
Height without hopper:	approx. 2270 mm
Net weight:	approx. 2500 kg
Electric power connection:	4.0 kW / 6.0 kW*
Consumption:	up to 3.6 kWh
Operating pressure:	6 bar
Consumption:	up to 200 NL/minute up to 600 NL/minute**
Compressed air connection:	1/2"

*electrical power connection for knotting machine.
**compressed air pressure consumption for knotting machine.

2780
(1350)
271
2460
1600-1613 setting range
928-941 setting range
45°
894-905
1350
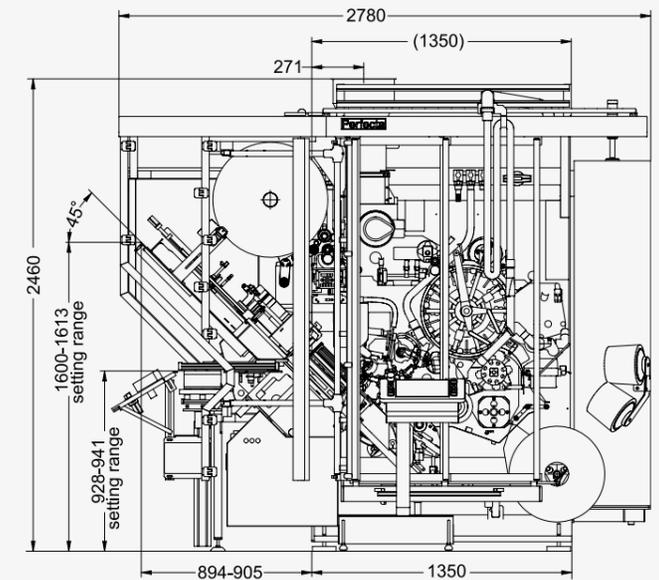
PERFECTA UNIVERSAL

Technical data

Production speed:	up to 380 bags/minute
Length x width:	approx. 3510 x 1700 mm
Height with hopper:	approx. 2460 mm
Height without hopper:	approx. 2270 mm
Net weight:	approx. 3600 kg
Electric power connection:	10.0 kW / 10.0 kW*
Consumption:	up to 5.0 kWh
Operating pressure:	6 bar
Consumption:	200 up to 800 NL/minute 600 up to 1200 NL/minute**
Compressed air connection:	1/2"

*electrical power connection for knotting machine.
**compressed air pressure consumption for knotting machine.
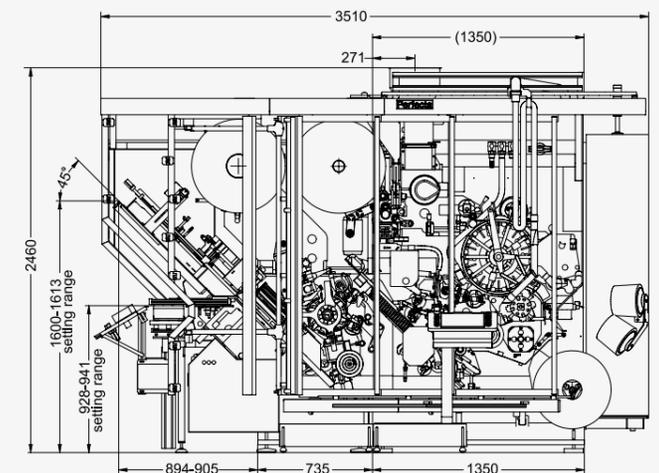
3510
(1350)
271
2460
1600-1613 setting range
928-941 setting range
45°
894-905
735
1350

PERFECTA FLOWPACK

Technical data

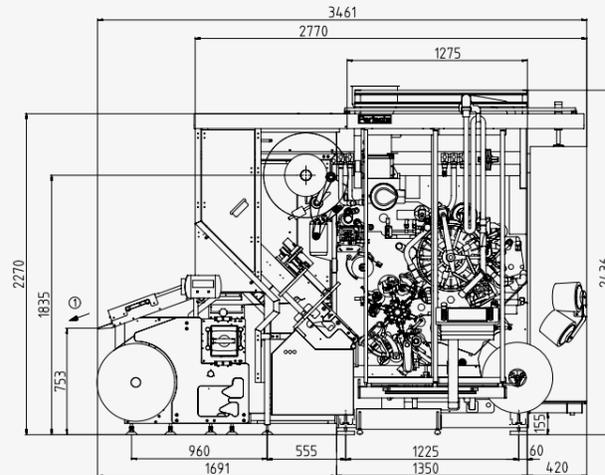|	
Production speed:	up to 420 bags/minute
Length x width:	approx. 3460 x 1700 mm
Height with hopper:	approx. 2460 mm
Height without hopper:	approx. 2270 mm
Net weight:	approx. 3000 kg
Electric power connection:	6.0 kW/8.0 kW*
Consumption:	up to 4.2 kWh
Operating pressure:	6 bars
Consumption:	up to 450 NL/minute
	up to 850 NL/minute**
Compressed air connection:	1/2"

*electrical power connection for knotting machine.
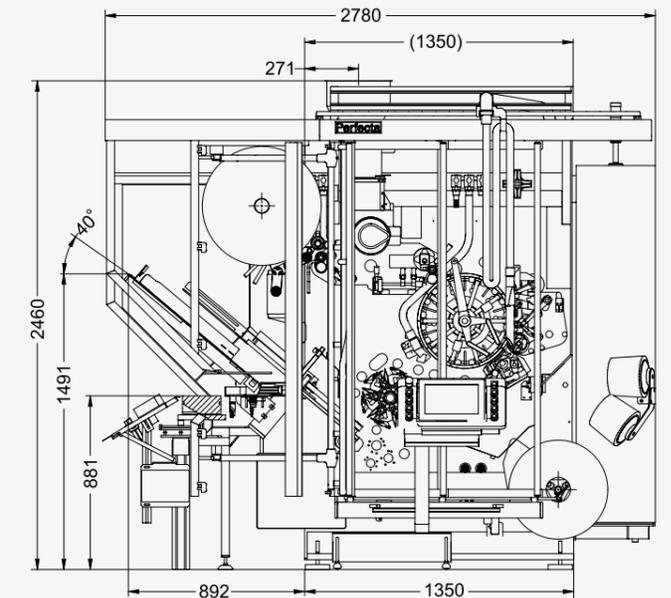**compressed air pressure consumption for knotting machine.

PERFECTA ENVELOPE

Technical data

Production speed:	up to 380 bags/minute
Length x width:	approx. 2780 x 1700 mm
Height with hopper:	approx. 2460 mm
Height without hopper:	approx. 2270 mm
Net weight:	approx. 2500 kg
Electric power connection:	4.0 kW / 4.0 kW*
Consumption:	3.6 kWh
Operating pressure:	6 bar
Consumption:	up to 700 NL/minute
Compressed air connection:	1/2"

* Electrical power connection for knotting machine
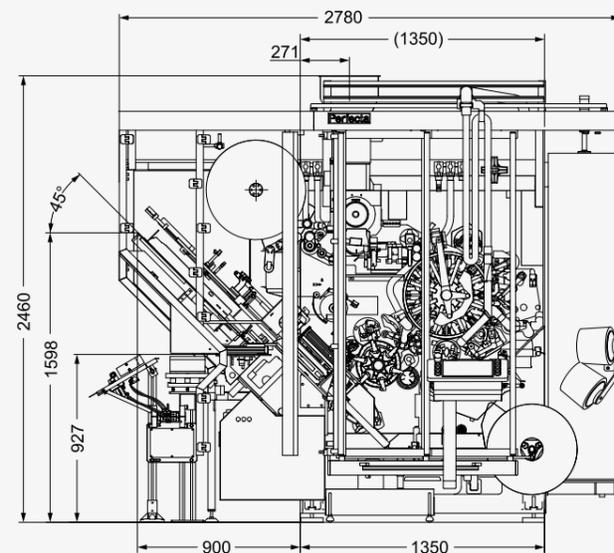** Compressed air pressure consumption for knotting machine

PERFECTA FAMILY SIZE

Technical data

Production speed:	up to 250 bags/minute
Length x width:	approx. 2780 x 1700 mm
Height with hopper:	approx. 2460 mm
Height without hopper:	approx. 2270 mm
Net weight:	approx. 2700 kg
Electric power connection:	6.0 kW
Consumption:	up to 2.4 kWh
Operating pressure:	6 bar
Consumption:	up to 200 NL/minute
	up to 600 NL/minute**
Compressed air connection:	1/2"

**compressed air pressure consumption for knotting machine.

Production speed overview
(bags per minute)

	PERFECTA TAG	PERFECTA UNIVERSAL	PERFECTA FLOW PACK	PERFECTA FAMILY SIZE	PERFECTA ENVELOPE
	filter bag	filter bag	filter bag	filter bag	
Stapling machine	up to 420*	up to 380	up to 420*	up to 250**	
Knotting machine (two knots)	up to 400*	up to 380	up to 400*	up to 250**	
Knotting machine (knot on bag only)	up to 400*	up to 380	up to 400*	up to 250**	
* with up to 7.0 cm³ black tea					
** with up to 22 cm³ black tea					
		crimped envelope bag			crimped envelope bag
Stapling machine		up to 380			up to 380
Knotting machine (two knots)		up to 380			not available
Knotting machine (knot on bag only)		up to 380			up to 380
		cold sealed envelope bag			
Stapling machine		up to 380			
Knotting machine (two knots)		up to 380			
Knotting machine (knot on bag only)		up to 380			
		heat sealed envelope bag			
Stapling machine		up to 350			
Knotting machine (two knots)		up to 350			
Knotting machine (knot on bag only)		up to 350			

TEEPACK

wrap your brand in quality

10/2018

TEEPACK

wrap your brand in quality