



GAMMA III

modular cap former



GEBRÜDER LEONHARDT
BLEMA KIRCHEIS



ALL IMAGINABLE IS PRACTICABLE

GAMMA series



OVERVIEW

The machine system GAMMA III is suited for manufacturing drawn parts for

- TO-caps
- PT-caps
- and other closures

The modular design enables for

- flexible machine concepts
- individual arrangements and number of modules
- easy and fast exchange of complete devices in all modules
- very short changeover times due to preset tools and transfer devices



GAMMA modular cap former

DESIGN AND FUNCTION

- modular design
- four or eight working stations per turret
- drawn parts are separated and accelerated by an infeed worm and fed to the first module

1. MODULE – PRE-FORMING

- edges of the shells are prepared for the following operation

Principle: die-forming



2. MODULE – PRE-CURLING

- curling the edges with profiled tools to the inner side

Principle: roll- or die-forming



3. MODULE - CURLING + LUG-FORMING

- inner roll is finished and the lugs are formed

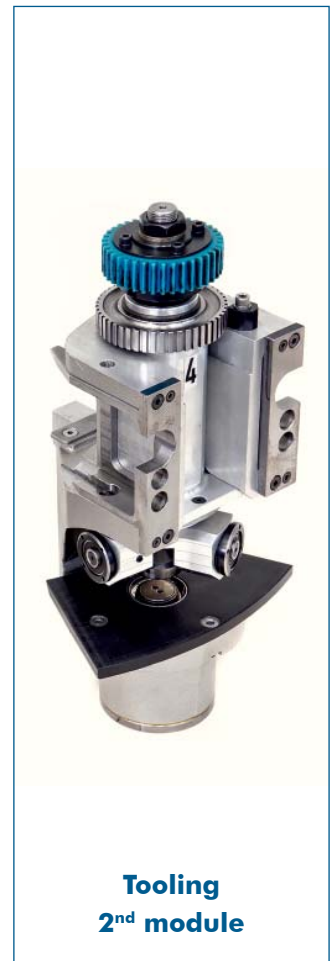
Principle: die-forming



4. MODULE – FORMING THE SAFETY BUTTON

- safety button is formed in the last step to eliminate deformation during the preceding processes

Principle: embossing



COMBINATIONS

MODULE	1	2	3	4	
	•	•	•	•	for TO-Caps <43 mm
		•	•	•	
		•	•		for TO-Caps >43 mm
	•	•	•		

ADVANTAGES

New technological order:

- forming the safety button in the last module recommended for TO-caps with DIA ≤ 43 mm
- easy shell parts without safety button geometry coming out of the press
- elimination of unwanted deformations impacting the function of the safety button
- easy and fast adjustments guarantee the same Flip-In- / Flip-Out-values for all stations



In-line correction during production process, i.e. changing parameters of tooling for

- height per working unit in all modules
- number of contact turns

short changeover time of tools for new diameter or new cap height

- all tools in compact c-frame design, i.e. active tool in the upper part and clamping device in the lower section
- quick clamping device for all tool sets
- easy and fast adjustments outside of the machine



quick clamping device for the transfer units due to preset devices for

- infeed unit – base part with drive / coupling, infeed worm / stopper, infeed star and outer guide



- transfer unit - base part with drive / coupling, transfer star und outer guide



- discharge unit - base part with drive / coupling, discharge star and outer guide

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PRODUCT SAMPLES

MODULAR HIGH-SPEED MACHINE GAMMA III		
TO-CAPS	PT-CAPS	OTHER CLOSURES
PRE-FORMING	PRE-FORMING	PROFILING
PRE-CURLING	PRE-CURLING	BEADING
CURLING LUG FORMING	CURLING	DIE-NECKING
FORMING SAFETY BUTTON		THREAD FORMING
		LINING

GAMMA III SERIES

Machinery directive 2006/42/EG

SAFETY STANDARDS

GAMMA modular cap former

TECHNICAL DATA

	KEAN 100/4	KEAN 100/8
Performance	800 cpm*	1600 cpm*
Stations per module	4 stations	8 stations
Number of modules	2 - 4**	
Products	TO-/ PT-caps, other closures	
Cap DIA	max. 100 mm**	
Cap height	max. 40 mm**	
Material specification	tinplate, aluminum	
Air supply	G1/2", 0.6 MPa = 6 bar = 87 psi	
Mass	1600 kg per module	
Machine dimensions	3850 x 1200 x 1910 mm for 4 modules width per module 580 mm	

* depending on product size and material

** other formats on request

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