



MF Series Continuous Separate Station Thermoforming Machines



Continuous Separate Station Thermoforming Machines

Sunwell manufactures MF series continuous separate station thermoforming machine for plastic products with high technology and efficiency. Precision controls and process capability allow the users to run a wide range of materials that include Polystyrene, Polypropylene, APET, and PLA. There are two stations, which are forming, followed by separate trim with scrap granulation automatically in-line.

Sunwell's thermoformer is driven by two(2) axis of servo action, linked to mechanical toggles which open and close the top and bottom platens independently.

The heat tunnel is mounted with high quality ceramic heating elements and equipped with multi controlled zones to ensure the temperature of the sheet is precisely managed. The chain feed index is controlled by a servo motor as well, for accurate index and synchronous signals for the program interface.

The horizontal (or optional vertical) trim press features the moving platen motion controlled through a servo motor and drive with additional stroke length to pre-punch and trim deep draw containers in a progressive trim application.

Two additional servo actions control the product index and eject functions, in order to precisely trim the finished product on to the packing table for packaging.

The scrap web after trimming is fed into a granulator under trim press in-line to minimize the space requirement and manpower.

**PARTNERS FOR
MAXIMUM PROFITABILITY**

Two-Stations Post Trim Thermoforming Systems



Shell Clam Oven



Servo Driven



Mechanical Linkage



Horizontal Forward Trim Press



Vertical Trim Press

MODEL	MF850	MF1000	MF1200
Configuration	Forming Front, Post Trim with Scrap Granulation Inline	Forming Front, Post Trim with Scrap Granulation Inline	Forming Front, Post Trim with Scrap Granulation Inline
Application	Mass production	Mass Production	Universal Especially for Deep Draw Products
Forming Method	Pressure and Vacuum	Pressure and Vacuum	Pressure Forming
Forming Direction	Either Above or Below Sheet Forming	Either Above or Below Sheet Forming	Either Above or Below Sheet Forming
Maximum Sheet Width(mm)	900	1,050	1200
Mold Size(mm)	Max. 850 x 1,000 Min. 550 x 800	Max. 1,000 x 1,000 Min. 700 x 800	Max. 1,190 x 1,000 Min. 850 x 800
Max. Depth of Draw (mm)	180	180	180
Forming Tonnage (ton)	80	80	80
Shut-height (mm)	Top 380 Bottom 380	Top 380 Bottom 380	Top 380 Bottom 380
Platen Travel (mm)	Top 190 Bottom 190	Top 190 Bottom 190	Top 190 Bottom 190
Heat Tunnel Length (mm)	4,000	5,000	5,600
Heating Elements	Ceramic	Ceramic	Ceramic
In Line with Trim Press	Horizontal, Vertical or Alternative	Horizontal, Vertical or Alternative	Horizontal, Vertical or Alternative
Trim Press Drive	AC Servo; Crank Reciprocated Driven	AC Servo; Crank Reciprocated Driven	AC Servo; Crank Reciprocated Driven
Auto Counter Rotating	Option	Option	Option
Side Linear Guidance	Option	Option	Option
Trimming Max. Speed (CPM)	Standard 120 Option 160	Standard 120 Option 160	Standard 120 Option 160
Trimming Tonnage	35	35	35
Control System	YASKAWA 3000	YASKAWA 3000	YASKAWA 3000
Floor Space (M)	22L x 3.8W x 5H M	22L x 3.8W x 5H	24L x 4W x 5H
Machine Weight (kg)	18,000	20,000	22,000

Short shut-height model MF850S; MF1000S and MF1150S are available for below 80mm draw.

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