



# MS Series Continuous Separate Station Thermoforming Machines



## Continuous Separate Station Thermoforming Machines

Sunwell manufactures MS series continuous separate station thermoforming machine for foam products with high technology and efficiency. Precision controls and process capability allow the users to run a wide range of materials including Polystyrene, Polypropylene and polyethylene. 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.

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# Two-Stations Post Trim Thermoforming Systems



Shell Clam Oven



Servo Driven



Mechanical Linkage



Horizontal Forward Trim Press



Vertical Trim Press

MODEL	MS900L	MS1200L	MS1370L	MS1460L
<b>Configuration</b>	Forming Front, Post Trim with Scrap Granulation Inline	Forming Front, Post Trim with Scrap Granulation Inline	Forming Front, Post Trim with Scrap Granulation Inline	Forming Front, Post Trim with Scrap Granulation Inline
<b>Application</b>	Foam Products or Thin Gauge Shallow Products	Foam Products or Thin Gauge Shallow Products	Foam Products or Thin Gauge Shallow Products	Foam Products or Thin Gauge Shallow Products
<b>Forming Method</b>	Vacuum and Slight Pressure Forming	Vacuum and Slight Pressure Forming	Vacuum and Slight Pressure Forming	Vacuum and Slight Pressure Forming
<b>Forming Direction</b>	Either Above or Below Sheet Forming	Either Above or Below Sheet Forming	Either Above or Below Sheet Forming	Either Above or Below Sheet Forming
<b>Maximum Sheet Width(mm)</b>	900	1,200	1,370	1,460
<b>Mold Size(mm)</b>	Max. 850 x 1,000 Min. 600 x 760	Max.1,150 x 1,200 Min. 850 x 800	Max.1,320 x 1,350 Min. 1,000 x 1,000	Max.1,400 x 1,500 Min. 1,000 x 1,000
<b>Max. Depth of Draw</b>	100 mm	100 mm	100 mm	100 mm
<b>Forming Tonnage(ton)</b>	80 Tons	80Tons	80Tons	80Tons
<b>Shut-height(mm)</b>	Top = 150 mm Bottom = 150 mm	Top = 150 mm Bottom = 150 mm	Top = 150 mm Bottom = 150 mm	Top = 150 mm Bottom = 150 mm
<b>Platen Travel</b>	Top = 180 mm Bottom = 180 mm	Top = 180 mm Bottom = 180 mm	Top = 180 mm Bottom = 180 mm	Top = 180 mm Bottom = 180 mm
<b>Max. Dry Cycle Speed</b>	50 cycles / Min	50 cycles / Min.	50 cycles / Min.	50 cycles / Min.
<b>Platen Drive</b>	AC Servo Driven; Toggle Linkage	AC Servo Driven; Toggle Linkage	AC Servo Driven; Toggle Linkage	AC Servo Driven; Toggle Linkage
<b>Sheet Index</b>	AC Servo Driven Chain Feed	AC Servo Driven Chain Feed	AC Servo Driven Chain Feed	AC Servo Driven Chain Feed
<b>Heat Tunnel Length</b>	4,000mm	5,000mm	5,600 mm	6,000mm
<b>Heating Elements</b>	Ceramic	Ceramic	Ceramic	Ceramic
<b>In Line with Trim Press</b>	Horizontal Trim Press or Alternative	Horizontal Trim Press or Alternative	Horizontal Trim Press or Alternative	Horizontal Trim Press or Alternative
<b>Trim Drive</b>	AC Servo Driven; Crank Reciprocated Run	AC Servo Driven; Crank Reciprocated Run	AC Servo Driven; Crank Reciprocated Run	AC Servo Driven; Crank Reciprocated Run
<b>Trimming Max. Speed(CPM)</b>	160 cpm	160 cpm	160 cpm	160 cpm
<b>Trimming Tonnage</b>	20 Tons	20 Tons	25 Tons	25 Tons
<b>Control System</b>	YASKAWA 2200	YASKAWA 2200	YASKAWA 2200	YASKAWA 2200
<b>Floor Space(M)</b>	20L x 4W x 4H M	22L x 4W x 4H M	23L x 4.5W x 4H M	24L x 5W x 4H M
<b>Machine Weight</b>	12,000 kg	14,000 kg	16,000 kg	18,000 kg

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