

CFM *Foldmaster Compact*
Folding Technology

Kannegiesser[®]

PARTNER IN LAUNDRY TECHNOLOGY



FoldMaster Series COMPACT

Principle

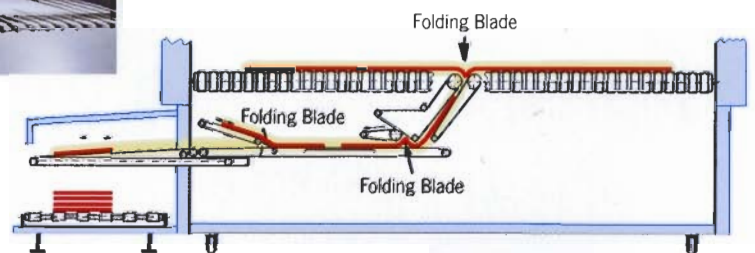
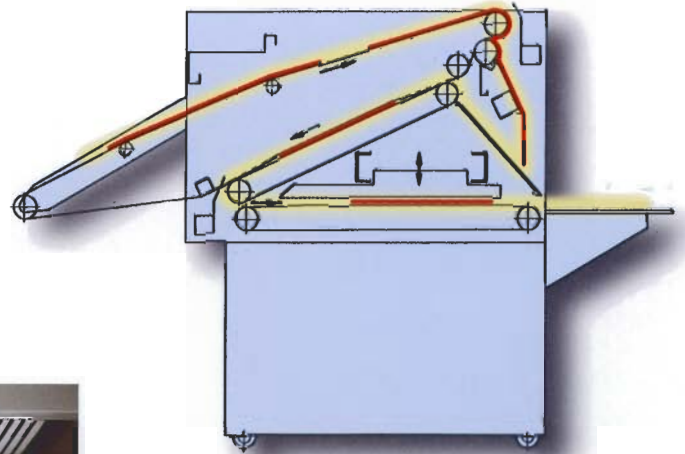
Folding by means of an air blast for length folds, by means of a blade for the cross folds.

Standard version



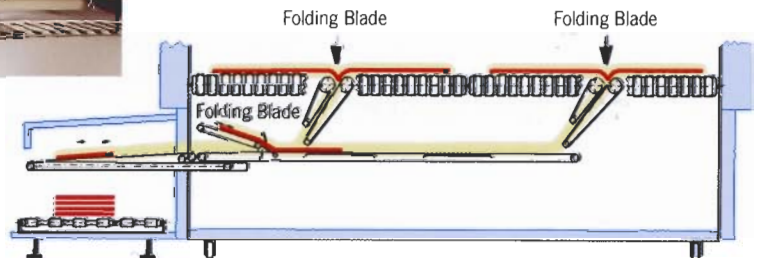
1. Cross fold section KR1

Large articles cross folded in 1 lane operation. Small articles in multi-lane operation without cross fold, discharged onto the take off table.



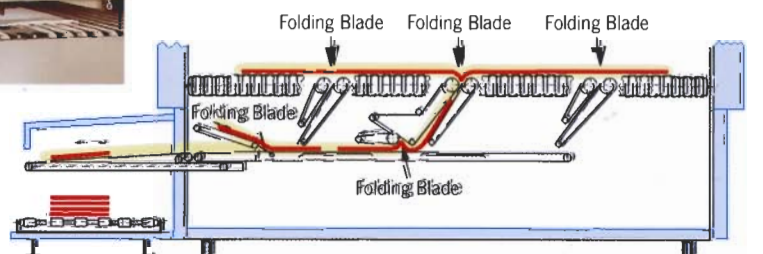
2. Cross fold section KR2

Large articles cross folded in 2 lane operation. Small articles in multi-lane operation without cross fold, discharged onto the take off table.



3. Cross fold section KR3

Large articles cross folded in 1 or 2 lane operation. Small articles in multi-lane operation without cross fold, discharged onto the take off table.



Special Construction Features

The special strength of the FoldMaster COMPACT is its reliable high performance of folding up to 1400 sheets per hour (ironing speed of up to 50 m/min. [165 fpm]).

Therefore, high performance large piece ironing lines are the typical application for this machine. In addition, small articles can also be folded lengthwise in multiple lanes.

Modern textiles and washing techniques can cause static charges which can disrupt the operation of the ironing line.

In order to eliminate such problems as much as possible appropriate precautions

have been taken, for example special conductive coatings on all rollers and support plates with an antistatic device.

For individual programming and operation, the FoldMaster COMPACT is equipped with KANNEGIESSER's standard, user-friendly Control Panel type IBT-Basic. This system automatically diagnoses any malfunctions and can give a fault message in the form of a text on the display.

The IBT-Net which is available as an option also enables you to expand the system with the KANNEGIESSER Management Information System (MIS).



FoldMaster COMPACT

CFM 30

Length Folds

Before each folding process the articles hang freely – this is a prerequisite for an exact, crease-free folding process.

The articles are continually guided between a pair of belts. Because the upper and lower belts are driven, both inevitably run at the same speed, therefore quality is assured.

The articles are measured in front of the folding stations – a measuring wheel is used in front of the first folding station, and a photo cell in front of the next station. The photo cells do not need to be serviced and/or cleaned.

The electronic sensors measure each piece accurately with a fine measurement device – there are 5 measurement impulses per centimeter. According to this data the computer calculates the exact point of time for folding, including the desired amount of overlap.

The advantages of the air blast folding process (using the latest technical generation and equipment) used for length folding are the fast reaction speed, the precise precision, the omission of numerous wearing parts, and the simplicity of the multiple lane process because tearing interlocking mechanisms are not needed.



Open by-pass for combined operation



Cross Folds

Because the items to be folded during the cross fold processes are naturally thicker than in the length folding section, mechanical blades are always used for cross folding.

In the first and second cross fold, a blade pushes the item to be folded between the folding rollers, or between the folding rollers and the belt which adjusts to the various material thickness.

The optional third cross fold, utilises a combined reverse belt/blade fold.

The folding stations in the cross fold section all work like a pinch device in order to ensure the exact fixing and smoothing of the fold edges and the fold format.



Programme Control

In addition, the Kannegiesser MIS-System is built in modules, which means that the individual modules complement each other and can be retrofitted as required.

Module 1:
registration, recording, and sorting of numbers per article and customer.

Module 2:
registration, recording of technical as well as organization disruptions of the machine.

Module 3:
Allocation of the number of items to each operator, and thereby the registration of personal performance.

(see the special brochure "KANNEGIESSER Management Information Systems")

Thanks to the automatic programme, different articles can be processed in a mixed batch, without the operator at the feeding machine having to make a decision or give a single command.

Thanks to the measurement of the pieces before the length fold stations, together with a corresponding match in the computer, a constant, complete tracking of the pieces is guaranteed. As a result it is not necessary to run the ironing line empty when a programme change is required, for example from small to large pieces: the large pieces can be processed after small pieces, or vice versa.

To change a batch (or a customer change) a button is pressed after feeding the last piece in the batch. This article is then tracked through the ironing line. As soon as this last piece is stacked, an acoustic signal notifies the operator at the folding machine of the batch change.

Thanks to the central programme control for the complete ironing line, the operator only needs to retrieve the required

programme for the type of linen to be processed and the complete line switches to the optimum programme stored in the computer.

Just like all other KANNEGIESSER machines, the control of the FoldMaster COMPACT has been designed so that you can expand it with the MIS (Management Information System) at any time.

The MIS system automatically registers, protocols and sorts all occurring data in the folding process and prepares them for evaluation.

A speciality of the Kannegiesser Management Information System is that it is integrated into the machine control: With the retrieval of the stored article or customer specific programme all the corresponding parameters of the machine functions for the complete ironing line, as well as for the data registration, are automatically activated.



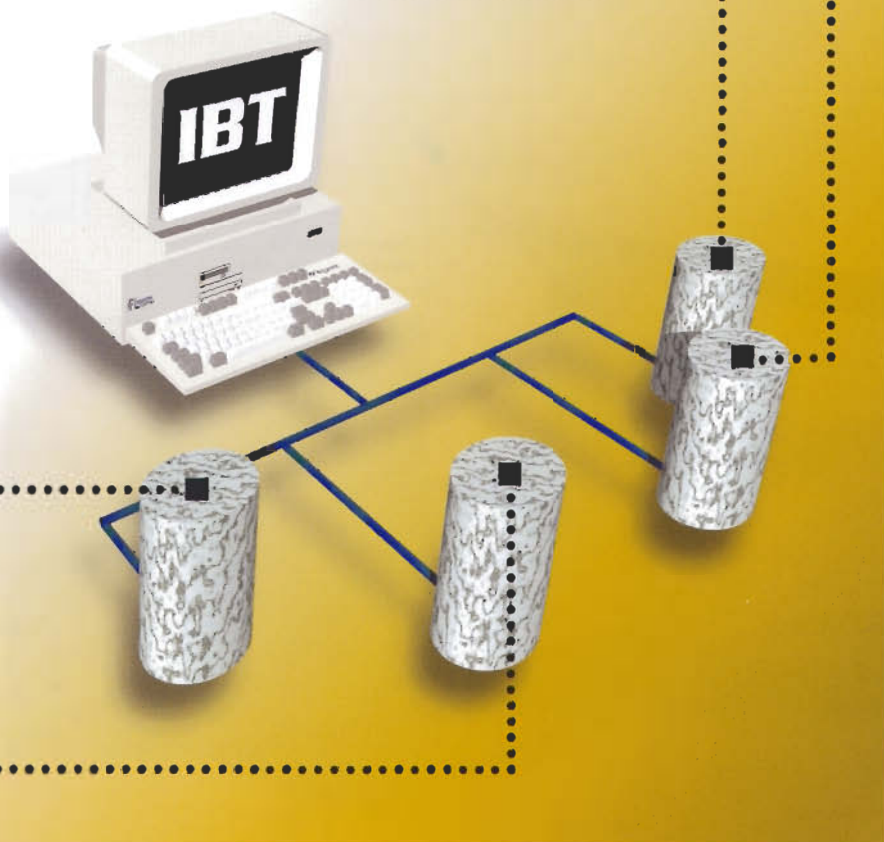
Folding
technique
functions

Ironing
functions

Central control of the ironing line (option)

Large article feeding
system functions

Feeding machine
functions



Transporting/Stacking/Sorting

Transporting

The folded pieces are discharged onto the table located on the side.

Stacking (option)

The item is placed onto the stack by retracting the delivery trolley according to the roll-off principle.

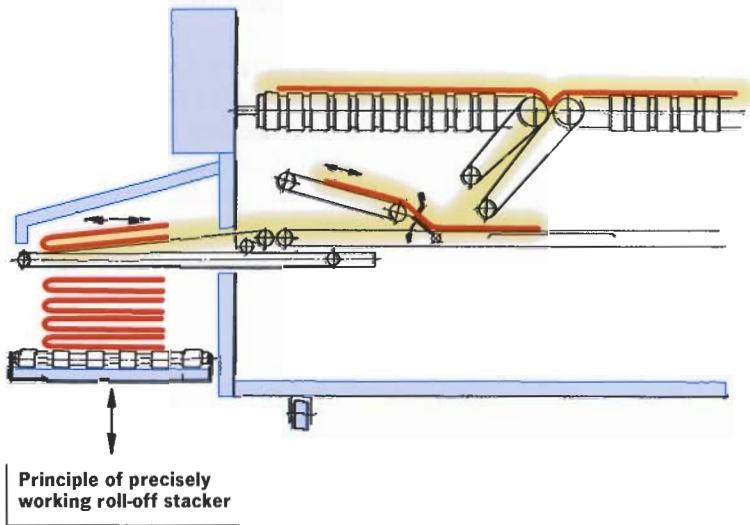
Sorting (option)

According to the signals which can be given to a single item at the feeding section, the folding machine can reject up to two criteria, rewash or repairs.



When two stacking devices are placed next to each other, an automatic sorting according to article size can be performed. This eliminates pre-sorting.

A lifting stacker allows to lower the stacking table according to the thickness of the folded items controlled by photo cell and air cylinder.



Technical Data

Model	Working width mm (inch)	Number of length folds ¹⁾	Number of lanes in length fold section ²⁾	Number of cross folds ²⁾	Measurements			Working air pressure (Pe) bar [psi]	Air consumption at Pe l/min ²⁾	Input power kW	Weight kg
					Length mm (inch)	Width mm (inch)	Height mm (inch)				
CFM 30	3000 (118")	1-3	1,2,3,4	1-3	3050 (120")	3870 (152.4")	1760 (69.3")	6,5 [97.5]	52	2,5	3050
CFM 33	3300 (130")	1-3	1,2,3,4	1-3	3050 (120")	3870 (152.4")	1760 (69.3")	6,5 [97.5]	54	2,5	3080
CFM 35	3500 (138")	1-3	1,2,3,4,6	1-3	3050 (120")	4070 (160.2")	1760 (69.3")	6,5 [97.5]	55	2,5	3290

1) according to equipment

2) depending on the number of pieces per minute

Subject to alterations in detail