



***Machine Specification
RAMAC 525 Workstation***



**The RAMAC 525 Workstation
shown with various options and 2-cavity Forming & Sealing tooling**

At a glance:

- **Two-station semiautomatic rotary machine for combined blister forming and sealing**
- **Also capable of respectively forming or sealing**
- **Designed for low to medium blister production volumes incl. quick production setup**
- **Innovative safe industrial design. Operator and service friendly construction**
- **All production parameters stored in easy accessible programs**
- **Large format 325 mm (12,8") x 525 mm (20,6") forming and sealing area**
- **Options for mould cooling and different forming / sealing temperatures**
- **Cleanroom and validation options**
- **Flexible ergonomic options for operator protection**

Standard Features:

- Programmable logic control (Parker)
 - Built-in intelligent system for all production data to be saved in programs
- **Color** touch screen operator interface (Proface) includes:
 - Manual / Auto mode
 - Auto page showing program number, temperatures, counter, current and next operation
 - Counter displays number of performed forming and sealing cycles,
 - Full forming and sealing production data storage with memory for up to 50 different programs
 - Digital temperature controller on screen display in degrees Fahrenheit or Celsius with alarms
 - Programmable Forming and Sealing temperatures, air pressures and timers
 - Complete manual control of all individual functions for set up
 - Turntable jog
 - Low air pressure sensor with alarms
 - System start-up activates machinery in sequences during initial start
 - On-screen system errors machine diagnostics for troubleshooting
 - On-screen alarms. Alarm icon launches and flashes. Alarm data may be accessed from the touch screen.
- Main power switch
- Two-hand START/STOP system for Manual and Auto Mode
- Emergency STOP push buttons (2)
- Servo driven semi-automatic 180° reversing turntable
- Proportional valves installed for controlling vacuum and blowing pressures
- Filter, Regulator & Pressure gauge installed on airline
- Heated forming / sealing plate
 - Quick-change mounting of forming / sealing plate
 - Programmable proportional valve to adjust heated plate pressure
- Rotary table perimeter soft protection
- Easy access through front of machine for tooling changeover or maintenance
- CE certified

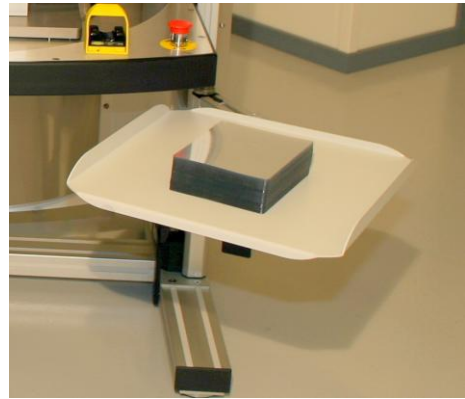
Optional highlights:

- Optional connection for mould cooling
 - Fluid cooled mould platen
 - Quick-change mounting

- Optional ergonomic lift system
 - Operator protection
 - Variable adjustment of working height
 - Stand up or sit down during working



- Optional shelves
 - Operator protection
 - For placing materials during operation
 - Multi adjustable

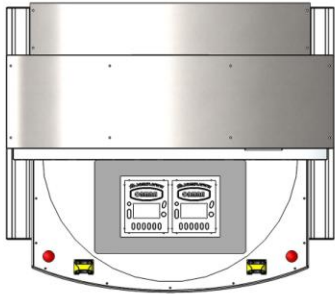
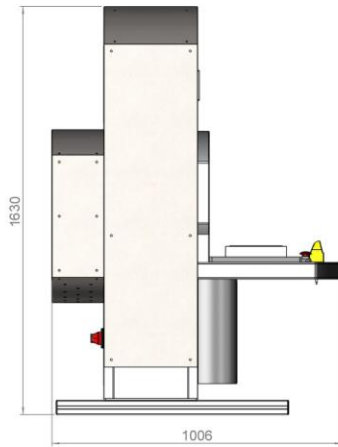


- Other options.....
 - A second heating plane for different forming and sealing temperatures
 - Validation package for validating timers, temperatures, pressures
 - External chiller and temperature controller
 - Cleanroom option with ventilation connection including pneumatic exhaust
 - Pneumatic puncher for hole punching in sealed blister
 - Casters with locking wheels
 - Custom features quoted on request....

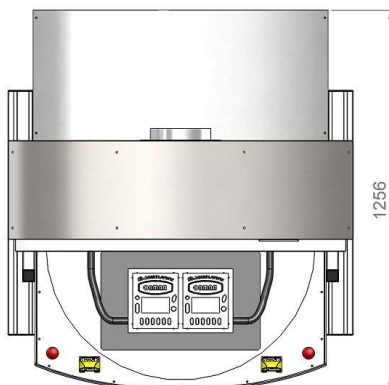
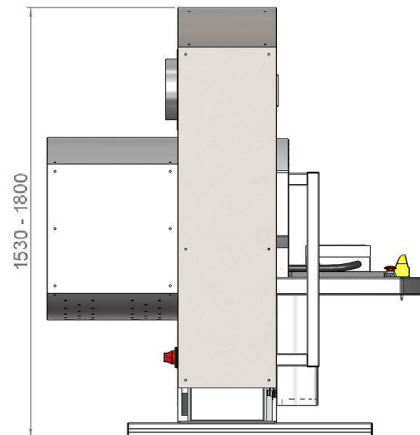
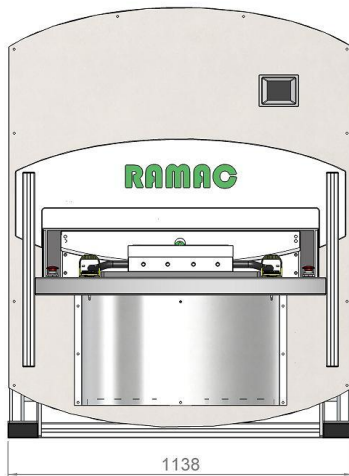
Specifications:	
Electrical (<i>Standard machine</i>): (<i>Options available</i>)	230 Volts / 1 PH / 50 Amps
Electrical (<i>w. optional extra heating plane</i>):	400 Volts / 3 PH / 50 Amps
Control	24 Volts AC
Heating system:	Cartridges 4 x 500 W
Heating system (<i>w. optional extra heating plane</i>):	Cartridges 8 x 500 W
Pneumatic main cylinder bore size: (<i>option 2 pcs.</i>)	1 pcs Ø 200 mm
Temperature range for forming and sealing (std.)	50-180°C
Maximum mould size:	325 mm (12,8") x 525 mm (20,6") x 140 mm (5,5")
Maximum forming and sealing area:	325 mm (12,8") x 525 mm (20,6")
Max blister depth :	135 mm (5,3")
Cycle speed (Forming and Sealing):	400 – 600 blisters/hour
Machine dimensions standard:	W:114cm (45") D:100cm (40") H:163cm(64")
Max. machine dimensions with options:	W:114cm (45") D:126cm (50") H:153-180cm(60"-71")
Working height standard: (+ tooling height)	75cm (30")
Working height with lift option: (+ tooling height)	65 cm (26") to 92cm (36")
Weight: (depending on options)	385 – 480 kg

Machine dimensions:

➤ Standard machine



➤ Machine with all options



Description:

RAMAC A/S leads the market in developing unique efficient and cost effective solutions for a wide range of packaging applications. All solutions supplied by RAMAC A/S are based on the benefit of our fundamental packaging and production expertise, personalized consultation and our worldwide net of professional sales- and service partners.

For production of small to medium sized volumes RAMAC A/S presents the RAMAC 525 Workstation for semiautomatic combined blister forming and sealing. The RAMAC 525 Workstation produces optimal and efficient blister packs at very low start-up costs. As the machine is capable of both forming and sealing blisters, stocks of preformed blisters are no longer necessary. Besides the possibility of just-in-time blister production the RAMAC 525 Workstation makes our customers benefit from an innovative stainless design, maximum reliability and the flexibility to add options that meet individual needs in terms of both productivity and operator friendly ergonomics. The compact machine has a very small footprint and incorporates industry leading design, innovative technology, invariable quality, and CE-documented safety.

RAMAC A/S is continuously working with various leading packaging material manufacturers all over the world to create solutions covering our customer's needs and wishes. We have the capability to produce blister prototypes in our own shop at the lowest possible cost. Our ability to design, build and test functionality and produceability gives our customers real value for money solutions.

All projects are viewed from the standpoints of overall cost, functionality and aesthetics, in close cooperation with our customers. We believe a commercially successful and inexpensive design is more than just a good idea. The design should meet customer requirements by both minimizing manufacturing costs, be functional and eye catching.

RAMAC A/S understands the connection between product design and production costs, and how they work together to create success.

Operation:

Easy production setup and programming secures quick production readiness.

The informative touch-screen shows the operator when the machine has reached the programmed temperatures.

As the machine is a two-station semiautomatic rotary machine, the operator first places a pre-cut plastic sheet on mould nb. 1

The operator activates a two-hand safety contact for the table to rotate 180°. An accurate servo drive, used for repeated precision table positioning, rotates the table.

Inside the machine the blister is formed while on the outside the operator places a pre-cut plastic sheet on mould nb. 2

The operator again activates the two-hand safety contact for the table to rotate 180°

The second blister is then formed inside the machine while on the outside the operator places the items to be packed in the formed blister - which is still sitting in mould nb.1 - and also places the pre-cut lid material on top.

As the operator activates the table, the second formed blister rotates out. Items are placed in- and lids on blister nb. 2 while sealing of the first blister in mould nb.1 is carried out inside the machine. The sealing operation can as an option be made at a different temperature.

The operator again activates the table and a finished sealed blister pack in mould nb.1 rotates out. While the machine is sealing the second blister the operator removes the first finished blister and places a new pre-cut sheet for forming – and the cycle starts all over again.

System specifications are subject to change without notice. Neither RAMAC A/S nor our distributor is responsible for typographical errors. If you are interested in this equipment, please contact our sales department through www.ramac.dk or send your detailed request for a quotation via e-mail to info@ramac.dk. You will then be contacted by our distributor covering your area.