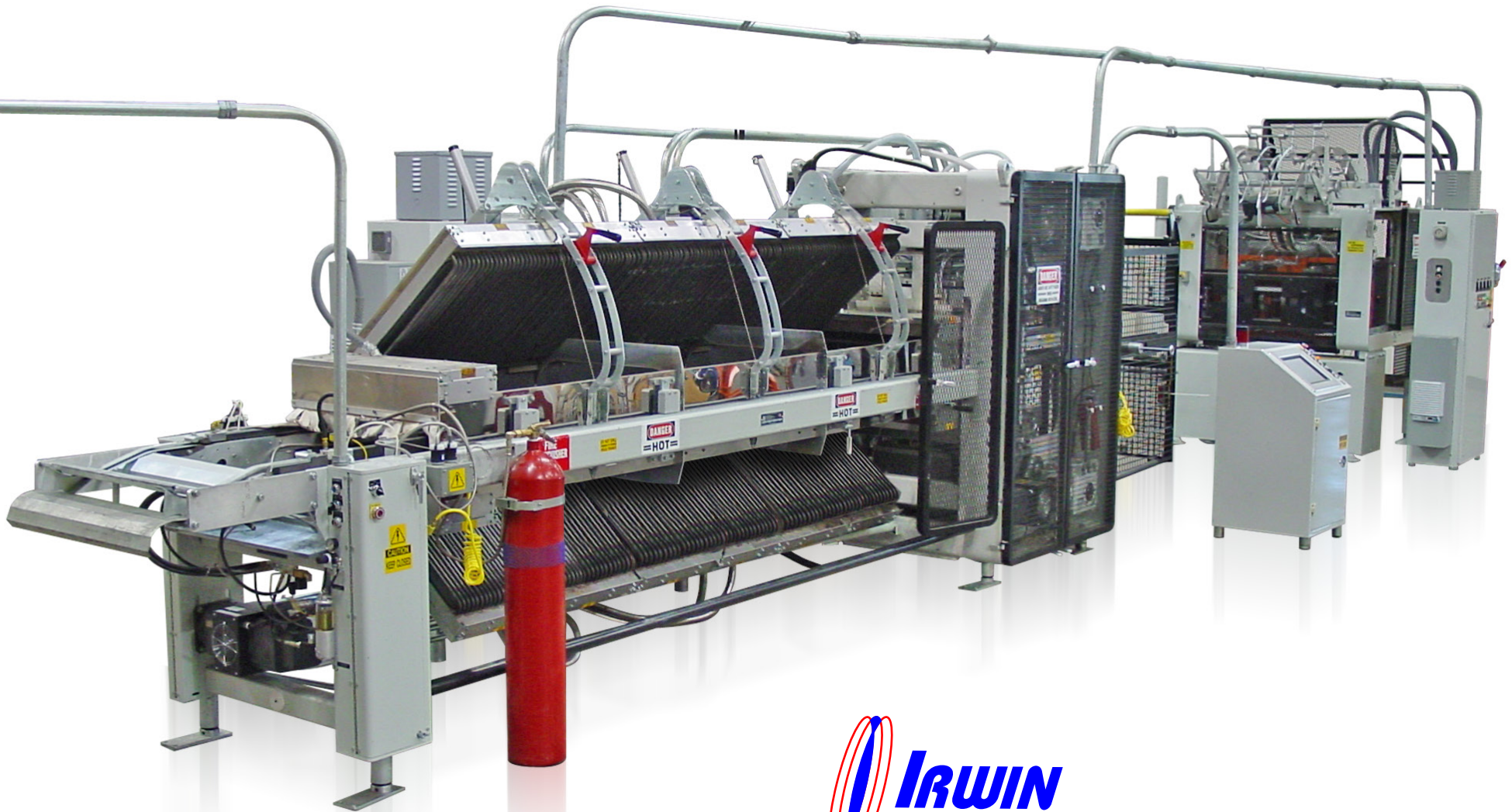


MODEL 28^{NT}

THERMOFORMER AND TRIM PRESS

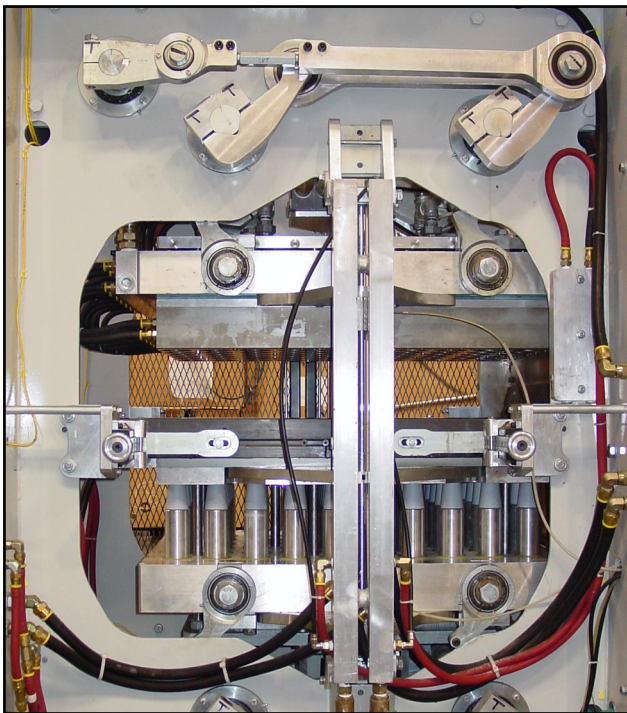


 **Irwin**
Research & Development, Inc.
THE ORIGINAL TECHNOLOGY
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MODEL 28^{NT}

THERMOFORMER AND TRIM PRESS

The Irwin Research and Development NT (New Technology) machines are designed with continually improving technologies, resulting in a higher speed alternative for rigid and PS foam product processing.



Former Side View

Our proprietary process control software, "Ballerina", is a crucial part of the NT's higher production rates. "Ballerina" is configured for maximum control flexibility with a Windows®-based operating system that

The NT is available in a 28" mold width for foam and cup production.

incorporates, in cad-cam fashion, point to point construction of a motor motion profile.

The 28NT Former is available in foam configuration utilizing a conventional platen set for mold mounting. This configuration is intended for shallow draw (2.5") foam or light gauge, solid sheet products. A second 28NT configuration for rigid products eliminates platens in favor of connecting the former rod

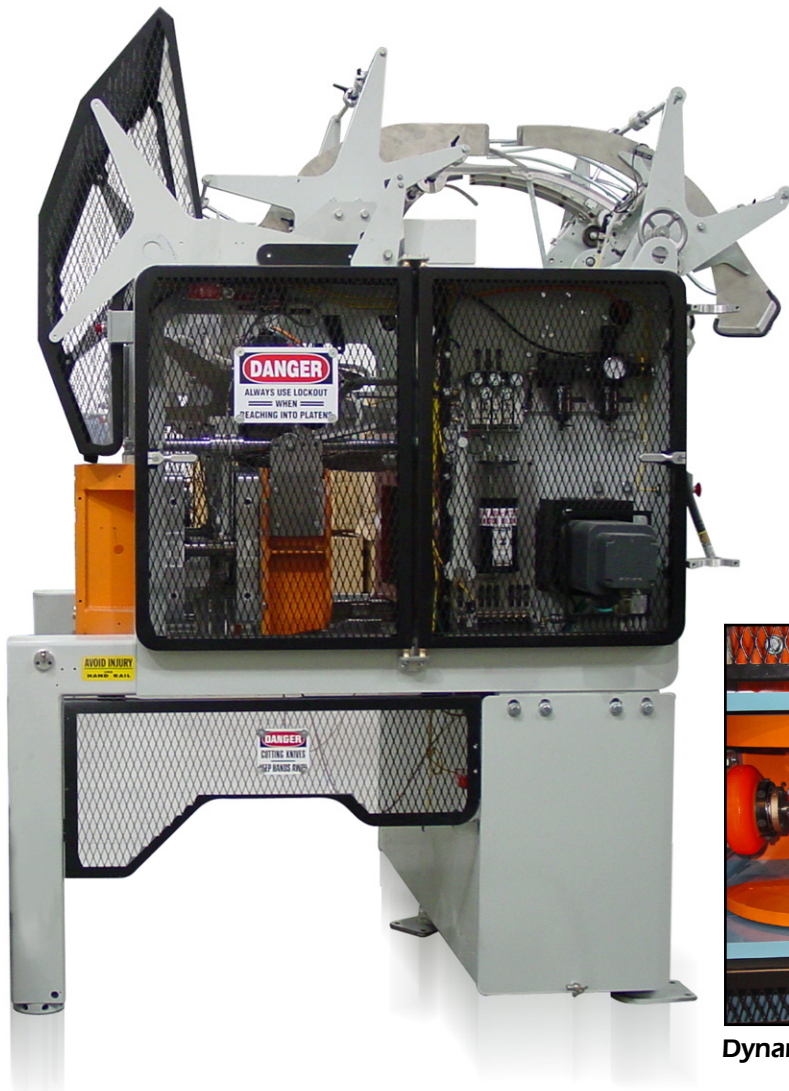
ends directly to the mold. This allows for a deeper draw (5") product in a compact frame. The mold is specifically designed for this application with innovations that provide superior evacuation, clamping, and cooling resulting in unparalleled forming speeds.

We have added a separate water temperature control system to the chainrails, reducing the effects of sheet chilling. For fast and effortless adjustment the chainrails can be moved via an electric motor at the feed drive shaft and via low friction ball bearing ways in the forming station.



MODEL 28^{NT}

THERMOFORMER AND TRIM PRESS



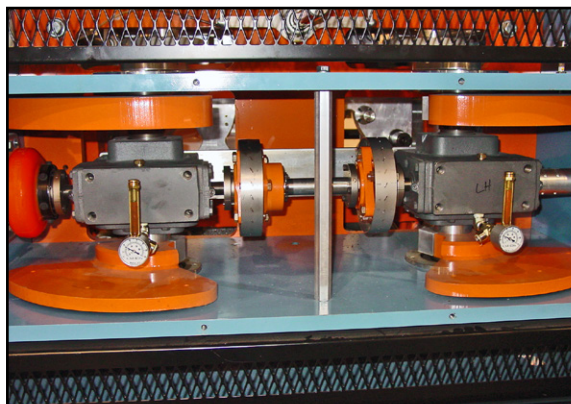
Trim Press

The 28NT Trim Press is a high speed and high tonnage Machine. The lightweight, aluminum-cast platen is driven from four points and drives a linear motion treadle with two connecting rods. The platen, treadle, and tooling are counterbalanced to increase machine performance at higher speeds. It also features automatic sheet adjust at the canopy feed, servo pick and a self-feed, auto start" treadle, which allows operational threading of the sheet into the treadle sheet guides. The result is a trim press that can run at cycle speeds of up to 200 RPM.

Irwin Research and Development Field Service Department, the fastest most responsive support



Patented "Auto Start" Servo Feed



Dynamically Balanced Trim Press Drive

team in the industry, back the NT. In the event of any system failure, Irwin Research and Development will work with you to provide fast, effective solutions, minimizing down time and returning your machine to full production.

The 28NT is just one more example of how Irwin Research and Development is continuing its long history of using leading edge technologies to engineer and manufacture reliable and innovative Thermoformers from our home in Yakima, Washington (USA). Serving our Customers IS our business.

MODEL 28^{NT}

SPECIFICATIONS

Thermoformer Specifications



Material Index	Max. Chain Speed	200"/sec. (5080mm/sec.)
	Sheet Width	Max.: 30" (762mm) Min.: 19" (483mm)
Heat Tunnel	Length	200" - 220" (5080mm - 5588mm) Optimal 183-228 (4648mm-5791mm)
	Heating Element	Standard Cal Rod (Optional Quartz)
	Temperature Control	Standard B&R X20 PID Control System: +2° at 600°F +1 at 316°C
Former	Sheet Width	30" Maximum (762mm), 19" Minimum (483mm)
	Max. Mold Size	28" Wide (711mm), 40" Long (1016mm)
	Depth of Draw	Standard 2.5" (64mm) Cup machine 5" (127mm)
	Press Rating	40 Tons
	Shut Height	Standard: 6" (152mm) Cup Machine: 10.8" (274mm)
	Platen Travel	5.2" (132mm) per platen at 6" (152mm) shut height for foam machine 5.1" (131mm) top - 5.2" (132mm) bottom platen at 10.8" (274mm) shut height for cup machine

Trim Press Specifications

Sheet Width	Maximum 30" (762mm)
Product Depth	Maximum 5" (127mm)
Stroke	6" (152mm) Standard
Maximum Cutting Force	27.5 Tons
Standard Platen Opening	Index Direction 14" (356mm) [20" (5080mm) optional], Across Sheet 34.5" (876mm)
Dry Cycle Speed	1-200 cpm
Servo Pick	Standard
Servo Canopy	Standard
Self Feed Treadle(Auto Start)	Standard
Counter Balance Platen Motion	Standard



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