



## Heat Sealers

HS 500 / HS 1000 / HS 1200

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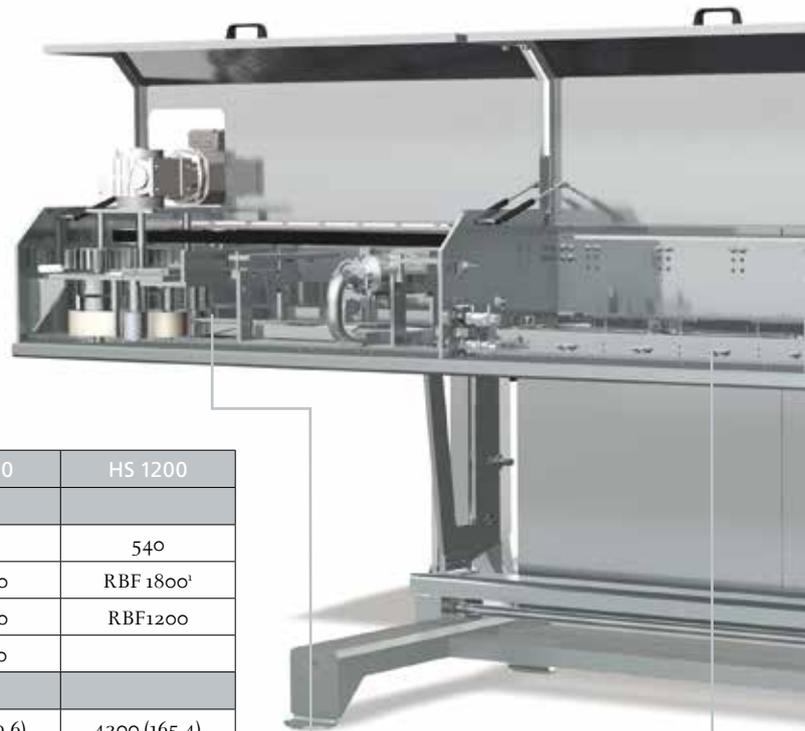
## Overview

GEA Avapac continuous heat sealers are designed to close a wide range of bags used in dairy and food ingredient plants.

The bag is levelled as it enters the sealer which eliminates the need for cutting and resulting wastage. Auto-levelling (available on HS 1200 and HS 1000) allows for a fully automated bag handling process from bag filling through to palletising.

The internal liner is sealed by application of heat, and is then scored without damage to the outer paper to form a free floating internal pouch within the bag. This pouch can be easily removed and passed into a hygienic environment avoiding exposure of the product to contaminants or unfiltered air.

The outer paper bag is then folded and closed by re-activation of the pre-glued strip. Options for alternative bag closure methods including sewing and taping are available.



## Specifications

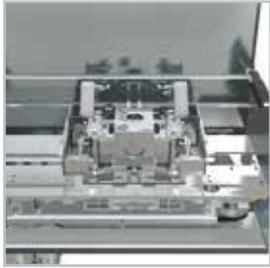
	HS 500	HS 1000	HS 1200
<b>Capacity:</b>			
Bags/hour	200	360	540
Suitable for AVAPAC Bag Fillers	IBF 450	IBF 800	RBF 1800 <sup>1</sup>
	IBF 300	IBF 600	RBF1200
		IBF 450	
<b>Dimensions:</b>			
Length mm (in)	2800 (110.2)	3800 (149.6)	4200 (165.4)
Width mm (in)	1000 (39.4)	1000 (39.4)	1000 (39.4)
Height mm (in)	1450 (57)	1450 (57)	1450 (57)
Weight Kg (lbs)	800 (1764)	1040 (2293)	1400 (3086)
<b>Automation:</b>			
	Rockwell™ / Siemens™		
<b>Heat Sealing/Closing Functions:</b>			
Bag top leveling	No	Yes	Yes
Bag cleaner	Option	Yes	Yes
Sealing & scoring	Yes	Yes	Yes
Folding & compression	Yes	Yes	Yes
<b>Service Requirements:</b>			
Electrical power, 3 phase (kW)	9	12	12
Free Air - m <sup>3</sup> /hr (ft <sup>3</sup> /min) @ 600 kPa (87 psi)	70 (42)		
Dust Extraction - m <sup>3</sup> /hr (ft <sup>3</sup> /hr) @ -2 kPa (-0.3 psi)	320 (11300) (with Bag Cleaner)	320 (11300)	855 (30195)

<sup>1</sup> Based on standard FIBC of 1.4m<sup>3</sup> (49.5ft<sup>3</sup>)

All performance data achieved under test conditions with standard packaging materials.  
All specifications and dimensions subject to revision without notice.



**Fold-Over System**  
Reactivates the pre-applied glue strip and closes the outer paper liner of the bag.



**Automatic Levelling**  
Ensuring that the top fold closure is parallel to the top of the bag.



**Integrated Controls**  
Optional stand-alone control or fully integrated to an automated packing system.



## Design Objectives

- To be integrated in fully automated bag packing lines or, alternatively to work as a stand-alone unit using an operator interface
- Avoid bag trimming
- Handle a wide range of bag sizes and types
- Provide a robust and reliable inner liner seal and high quality closing function
- Compliance with hygiene standards
- Provide integrated and extensible control for other equipment in a bag handling plant
- Ease of operation and maintenance

## Features

- Manual or powered height adjustment for a wide range of bag lengths
- Automatic bag top levelling (HS 1000 & HS 1200)
- Bag mouth cleaning and dust extraction prior to sealing
- Heat sealing and Scoring of the inner liner
- Automatic closing of step-top bags
- Quick-release systems for heating and scoring parts
- Extensible PLC control for additional line components

## Standards

- (a) EU Directives and their harmonized standards:
- Machinery 2006/42/EC;
  - "ATEX" 94/9/EC;
  - Electromagnetic compatibility 2004/108/EC;
  - Pressure equipment 97/23/EC;
  - Hygiene EHEDG Guidelines; and compliance with 1935/2004/EC
- (b) US standards covering:
- Hygiene USDA Guidelines; FDA Codes of Federal Regulations - (CFR series 21)
  - Machine Safety OSHA 1910 Subparts O&S; ANSI B11.19; ANSI/PMMA B155.1; NFPA 70 & 79; ANSI/ISA 12.10.05

## Bag requirements

- Length = 750-950mm, width = 500-600mm
- Multi-wall Kraft paper bags with PE internal liner and pre-applied glue strip
- Bag over powder = 250-300mm (bag width dependent)



**Heat Sealing**  
Multiple stage sealing and scoring to provide hermetic closure of inner plastic liner.



**Height Adjustable**  
Manual handwheel or motor driven system to adjust sealer height for variable bag lengths.



**Seal Cleaning**  
Eliminates powder from the seal area to ensure reliable hermetic sealing.

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