



# ***Meeting Documents***

***Gehl's Guernsey  
Farms Inc.,  
USA***

***Quotation No. 11-0306-00***

***Hassia Form, Fill and Seal Machine***

***TAS 16/80, 24-up***

Ranstadt, 05.02.2002

Gehl's Guernsey Farms Inc.  
P. O. Box 1004  
Germantown, WI 53022  
U.S.A.

Our Ref : vh / vf  
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Quotation-No. : 11-0306-00

025P050MP030MA059

Based upon our general terms of delivery attached hereto we quote you without engagement as under:

## 1 Hassia Form, Fill and Seal Machine Type TAS 16/80

### Product:

Pudding  
filling temperature: approx. 68 - 90° C  
density : - still to be determined -  
viscosity : - still to be determined -

### Filling Quantity:

3.5 oz (approx. 100 ml)

### Format:

24-up, (2 x 12), cup size: approx. 67,5 x 67,5 mm  
- final cup dimensions still to be determined -  
Punching in units of 2, 3 and 12 (3 x 4)

### Wrapping Material Quality Recommendation:

Bottom web: PS/K-Resin/EVOH/PE, approx. 1.000 - 1.600 µm  
suitable for steam sterilization

Lid material: PET/Alu/PE, approx. 40 µm - unregistered  
heatsealable and peelable against bottom web and  
suitable for steam sterilization

### Approx. Nominal Output Qn according to DIN 8743:

approx. 26 - 28 strokes/minute - 24 cups/stroke,  
depending on product characteristics, pack geometry, filling level  
and wrapping material quality.

672 cups/min

18.375 gal/min

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## Machine specification

01/3203	Basic Machine		
100150/3206	TAS 16/80	EUR	1.964.560

### Format Range:

- Draw-off length maximum 160 mm
- Material width maximum 800 mm
- Thermoform depth maximum 90 mm

### Basic Machine, consists of:

- Base frame with thermoforming, sealing and punching stations. Lift movement for tool tables of thermoforming and sealing stations by means of elbow lever and eccentric in punch station. Upper table of sealing station movable
- Drives: Individual drives for each station, with precise positioning servo-drives
- Station for contact pre-heating
- Hammer shears for chopping punch waste, with waste discharge
- Base material feed with pre-draw-off for two (2) reels and with two (2) reel shafts  
1st reel max. 1600 mm Ø  
2nd reel max. 500 mm Ø
- Lid material feed with pre-draw-off for one (1) reel, Reel-Ø 400 mm
- Material is advanced by transporting and holding grippers, to an integrated cooling plate located in front of punching station

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- Thermoforming by mechanically driven plug assists and compressed air into a water-cooled mould
- Central lubrication with automatically operated grease pump. Control via the SPS-control program
- Automatic adjustment for sealing and punching stations with base material scanner. According to the base material shrinkage the stations re-adjust to precise position, ensuring centered sealing and punching
- Jam control in front of punching station
- Monitoring of base and lid material reels. Reel-end indications by audible or visible signal; after pre-set time machine stop
- Complete pneumatic installation with compressed air-maintenance unit with 2" connection, cooling water installation with 1" connection
- Separately placed air-conditioned switch cabinet with all control elements and the HASSIA stored, programmable control system HASSIA PROMECON. The control indicator board with Industrial-PC is centrally located
- Modem connection as preparation for separate diagnosis and teleservice
- HMI - Human Machine Interface
- Cable duct between machine and switch cabinet, 10 m are included in price of basic machine
- Printer for printing machine parameters integrated into machine switch cabinet

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- Sterile filter combination, consists of:  
Preliminary filter, sterile filter, charcoal filter  
completely installed with 1" connection. By-pass  
with reversing valves -manual- for steam  
sterilization of sterile filter

Protection Systems to EN 60529

- switch cabinet IP 54
- machine IP 65

AS - Aseptic Equipment, consists of:

- Base material degermination with automatic  
temperature control
- Steam-heated lid material degermination chamber
- Sterile tunnel between base material degermi-  
nation station and sealing station
- Sprayer for tunnel degermination with preparation  
of a steam-sterilizing mixture with sterile air  
generation by pre-filter
- High-efficiency sterile filter and ventilator to  
activate a constant sterile overpressure
- Steam-heated heatexchanger to heat the sterile  
air for the subsequent drying of the sterile tunnel
- Sprayer for sterilizing media for filter degermination
- Pre-sealing station for lid material, integrated into  
tunnel
- Automatic dosing supervision for sterilizing media
- Central hot steam feeding with automatic  
condensation discharge
- Steam sterilization with aligned sterile filter unit
- Integrated data printer for all machine settings  
and production documentation
- Multi-channel recorder for supervising the process

Aseptic operation is only possible, if sterile product  
is supplied to the filling system. Valid are the guide  
lines for installation and take-into operation of  
aseptic equipment - HASSIA WN 12555 -

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For aseptic machines a sterile test will be carried out by an independent institution at HASSIA. The sterile test will be documented and is binding. The purpose of the test is to prove that the machine operates under sterile conditions

100188/4409

ODA - Batch Operating Data Acquisition:

EUR

4.320

The data acquisition starts with the input of parameters by the operator, such as batch number, date of minimum shelf life and optionally article number. - The data input will not be checked for reasonableness -.

Collected information:

- Recipe name which was selected as last one within this batch
- Production start time of the batch
- Production stand-by of machine during the batch
- Production time of the batch
- Machine down-time during the batch
- Cleaning time within the batch
- Sterilization time within the batch
- Absolute counter for material strokes (not re-settable)
- Counter for all material strokes of the batch
- Counter for filled production strokes of the batch
- Counter for delivered production strokes of the batch
- Article number (if pre-set)
- Minimum time of shelf life of the batch as pre-set
- Batch number

The charge data acquisition ends with input of "end of batch" by the operator. The batch data can be displayed on the operator's unit and printed out, (if the machine control unit is equipped with a printer).

100190/3203

Modem connection for HASSIA PROMECON control; already included in basic machine.

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With this unit the technical requirements are given for a separate diagnosis and teleservice. The services for separate diagnosis and tele-service are NOT included and must be agreed upon separately.

Country specific regulations and technical environments could make it necessary to exchange the connection delivered by HASSIA. All costs will be charged to the customer.

100192/3203

HMI -Human Machine Interface  
Standard Industrial-PC, Protection IP65  
- Windows operation system  
- Resistive touch screen for graphical operator guiding  
- Ethernet 10/100 interface

Additional buttons and switches for start, stop, fault acknowledge, activation of separate functions etc.

Emergency stop button

Graphical operator guiding:  
- Selection of operation mode  
- Recipe handling  
- Password protected parameter modification (16 levels)  
- Display of the actual operational data  
  - Machine status  
  - Faults  
  - Cause of fault  
  - Start conditions  
- Logbook for  
  - Recipe selection  
  - Password used  
  - Parameter modification  
- Selectable control display  
  - Signal exchange  
  - Input/output status of control unit  
  - Internal flags  
  - Communication link of control unit  
  - Actual servo axis data

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- Onscreen operation manual
- Onscreen electrical drawings
- Language can be alternated between one pre-selected EU language and German, (other languages upon request)

#### Machine - Statistics

- Summary of duration and occurrence of machine down-times, separated according to reasons of down-time
- Summary of production, CIP, SIP and stop times
- Display pre-settable within the past 12 months for one (1) day, one (1) week, one (1) months or three (3) months

02/3203	Accessories Basic Machine		
1033/4405	Blow-hole detector located at thermoforming station	EUR	3.260
126001/3203	Machine extension for installation of a further working station	EUR	19.160
1283/3203	* Special voltage - additional price - +/- variations in voltage from standard wiring 230/400 V, 50 Hz, of which we must be notified when order is placed or for voltage without neutral conductor to be loaded	EUR	32.170

#### 03/3203 Format

- \*2.1a-25**
- \* Complete set format tools, aseptic design, for thermoforming, sterilizing and sealing 24-up, consisting of:
    - Contact heating plates for plastifying bottom web
    - Thermoforming tool incl. plug assists and thermoforming mould
    - Sterilization tool

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	- 1 Set guide rails - 1 Sealing tool, consisting of sealing plate and sealing mold		
235024/3203	24-up	EUR	340.860
2420/3203	Further thermoforming mould, same pack surface, different height		
242024/3203	24-up	EUR	42.220
2539/3202	Discharge for punched-out stars located underneath the punching station	EUR	4.230
2540/3203	Multi-punching tool - notch punch - for low-waste punching of - Multipacks of 2 - Multipacks of 3 - Multipacks of 12 (3 x 4) The punching tool consists of: - Water-cooled upper table, - Die for star punching, - Connection for rinsing with water, - Water-cooled lift table with die-plate pack support. 4 support columns for the guidance of lift table form the complete upper station.		
254024/3203	24-up	EUR	263.980
2571/4406	Rinsing appliance in punching tool with spray nozzles, drying out by pressure air. Sprayer for Paraffin oil, with hand valves, splash oiler and pressure air regulator	EUR	1.750
*2560/4402	Pack support in punching tool for better cleaning	EUR	19.190

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04/8503	Filler 1
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3040/8503	Membrane Valve Filling Pump type TLM-AS suitable for liquid to pasty products with fruit particulates up to 8 mm diameter consists of: - Pump construction placed above the base material - Membrane intake valves
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	<ul style="list-style-type: none"> <li>- Dosing pistons</li> <li>- Filling hoses with temperature control</li> <li>- Sterile hood with steam closure</li> <li>- Servo-electronic drive system</li> <li>- AS-valves and tubing for CIP/SIP cleaning according to drawing no. 86 110 19 98</li> <li>- CIP/SIP computer program via PLC</li> <li>- Tool kit for filling pump</li> <li>- Immersion system for filling nozzles</li> </ul>		
304044/8503	Not inclusive: product feed system 24-up 25-160 cm³	EUR	240.750
4105/8503 410524/8502	Product distribution tube for one (1) product 24-up	EUR	17.410
4439/8503	Filling nozzle system with single-tube nozzles inclusive membrane outlet valves in aseptic design consists of: <ul style="list-style-type: none"> <li>- Filling nozzle plate</li> <li>- Membrane outlet valves</li> <li>- Round-shaped tube nozzles</li> </ul>		
443924/8503	24-up	EUR	53.230
4844/8503	CIP return container underneath base material, mechanically lift-able, consisting of: <ul style="list-style-type: none"> <li>- CIP return container</li> <li>- Displacement device, pneumatic</li> <li>- Draining device</li> </ul>		
484424/8503	24-up	EUR	19.260
****	Without product container		
*4.1bb-40	Sterile air feed incl. sterile filter and close-off valve	EUR	9.360
042/8503	Second Filler		
3040/8503	Membrane Valve Filling Pump type TLM-AS suitable for liquid to pasty products with fruit particulates up to 8 mm diameter consists of: <ul style="list-style-type: none"> <li>- Pump construction placed above the base material</li> </ul>		

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	<ul style="list-style-type: none"> <li>- Membrane intake valves</li> <li>- Dosing pistons</li> <li>- Filling hoses with temperature control</li> <li>- Sterile hood with steam closure</li> <li>- Servo-electronic drive system</li> <li>- AS-valves and tubing for CIP/SIP cleaning according to drawing no. 86 110 19 98</li> <li>- CIP/SIP computer program via PLC</li> <li>- Tool kit for filling pump</li> <li>- Immersion system for filling nozzles</li> </ul>		
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484424/8503	24-up	EUR	19.260
****	Without product container		
*4.1bb-40	Sterile air feed incl. sterile filter and close-off valve	EUR	9.360
477201/8502	Lifting unit, manually operated, for easy filling nozzle system exchange	EUR	6.230

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## Quotation does not include the following:

- Sterile valve cluster for product feed
- Cleaning unit and treatment
- Initial water pump, return-pump as well as the

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<b>*5.2a-33</b>	necessary software. 12-lane walking beam for orderly pack discharge and transfer to customers 4-lane conveyor, incl. empty and faulty pack discharge	<b>EUR 180.450</b>
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<b>Machine Price :</b>	<b>EUR 3.562.400</b>
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<b>0900</b>	<b>Packaging Costs:</b> One-way packing on pallets with film cover	<b>EUR 21.000</b>
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<b>Total :</b>	<b>EUR 3.583.400</b>
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## Optional Positions

<b>100444</b>	<i>* Basic machine in left hand version</i>	<b>EUR 24.720</b>
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*- additional price -*

<b>114601/3203</b>	<i>Lateral feed of lid material to machine, designed for fast reel change</i>	<b>EUR 24.680</b>
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<b>115101/3203</b>	<i>Registration unit for registering pack message with sensor head, amplifier with lid material stretching unit for ALUMINIUM foil. Heating bar for stretching mechanism for plastic lid material</i>	<b>EUR 21.340</b>
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<b>437199</b>	<i>* Heating system for product pipes incl. thermal housing</i>	<b>EUR 11.760</b>
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*gelatin*

<b>437196</b>	<i>* Temperature control for product pipes</i>	<b>EUR 13.760</b>
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<b>438244</b>	<i>* Heated filling nozzle system for GEL filling, 24-up</i>	<b>EUR 110.300</b>
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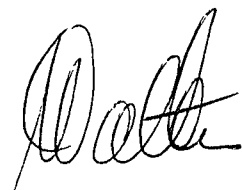
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## General Items

- 0910                      **Validity:**  
3 months beginning with date of quotation
- 0911                      **Delivery time:**  
approx. 12 – 14 months "Ex works Ranstadt"  
after receipt of your written order and  
clarification of all technical and commercial  
details.  
  
"Delivery time for incoming orders will  
be examined and determined and is  
subject to our backlog of orders and  
our utilization of capacity."
- 0927                      **Terms of delivery FOB:**  
FOB German Seaport  
"Free on board" according to INCOTERMS 2000  
  
- excl. value added tax (VAT)  
- excl. installation and commissioning
- 0947                      **Payment terms:**  
35 % Down-payment upon placing order  
  
55 % Upon information of readiness for delivery  
  
10 % After successful installation, not to exceed  
60 days after shipment of the machine

Hassia Verpackungsmaschinen GmbH



07.02.2002

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## Appendix

### Machine Colour:

VA - silver 7955

### Electrical Equipment:

Nominal Voltage acc. to DIN IEC 38  
230 / 400 V (+6% / -10%)  
50 Hz  
3 Phase  
Neutral and ground available

### Air Pressure, if necessary:

Dust: Particle size below 68 µm  
Temperature: 10 - 35 °C  
Working Pressure: Min. 7 bar - at machine inlet stud  
Specification: Clean, dry and oil free

how many?  
CFM?  
101,5 psi

### Cooling Water, if necessary:

Inlet temperature: 12 - 16 °C  
Working pressure: maximum 3,0 bar  
Specification: pH-neutral, water hardness 11 DHG

— 43.5 psi max

### Steam, if necessary:

Working pressure: maximum 8,0 bar  
Specification: saturated steam in food quality

— 116 psi

1 bar = 14.51 psi

### Ambient Conditions:

Temperature: 20 - 35 °C  
Humidity: relative humidity maximum 70%  
Air flow: direct draft to the machine to be avoided.

### Product / Packing Material:

For a final specification of the offered packaging machine,  
an evaluation of the original product(s) / packaging material(s)  
is required.

As no original product(s) / packaging material(s) were on hand,  
this quotation is subject to change after the original materials  
are received and evaluated.

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**Conditions for the mentioned output are as follows:**

- Continuous product in-feed
- Suitable wrapping material quality
- Constant density of the products
- Constant product specifications
- Constant viscosity without air in products in case of liquids and pastes
- No foam formation in case of liquids and pastes

**Content of Documentation:**

- Instruction manual
- Maintenance manual
- Mechanic parts list
- Electric parts list and wiring diagrams with
- Documentation of sub-supplier aggregates included in the appendix to maintenance manual - language according to available manuals of the sub-supplier

All documents will be supplied in 2-fold.

The standard type is available in GERMAN / ENGLISH language.

Further languages are possible against additional price.

**General:**

- The safety and protection equipment of the machine meet the EU machinery regulations.
- For all parts, which are not Hassia-standard parts, a stock keeping cannot be guaranteed.
- Delivery subject to agreement with possible export restrictions of Germany and EU.
- The purchaser releases the contractor from all taxes prevailing in the purchaser's country.
- For series trades within the EU, taxation has to be made by the buyer.
- A regular maintenance is to be ensured by the buyer

**Warranty:**

Wear parts including cutting and punching tools are not covered by any warranty. The same applies for parts, aggregates etc. which have been provided by the buyer.

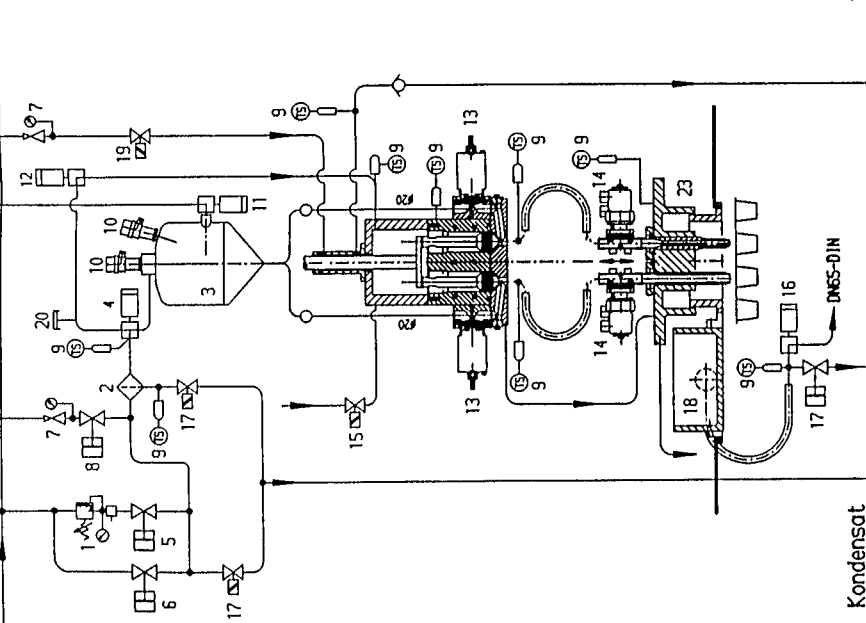
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# ILM-AS mit Einrohrdüsen ILM with single tube nozzles

Produkt CIP/SIP  
(product CIP/SIP)

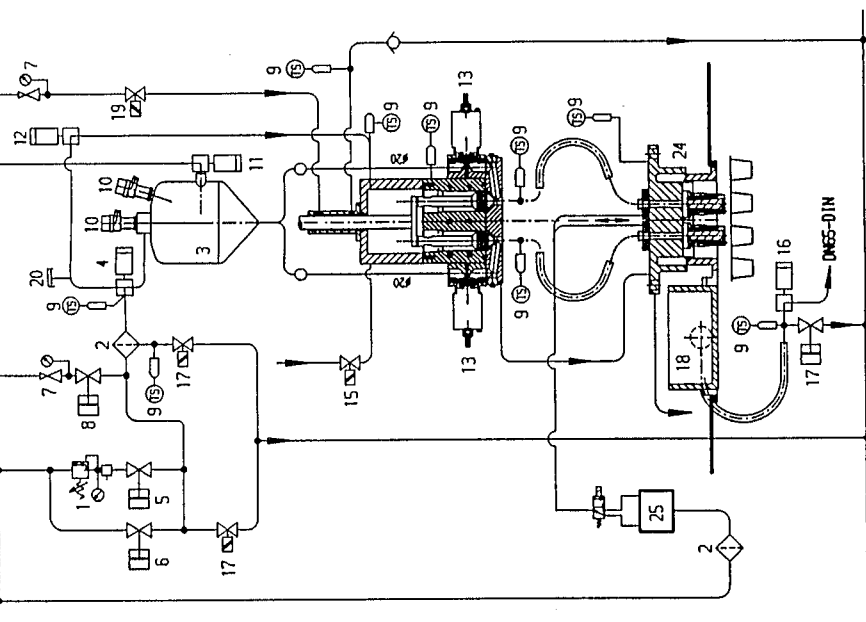
Dampf  
(steam)

Druckluft  
(compressed air)



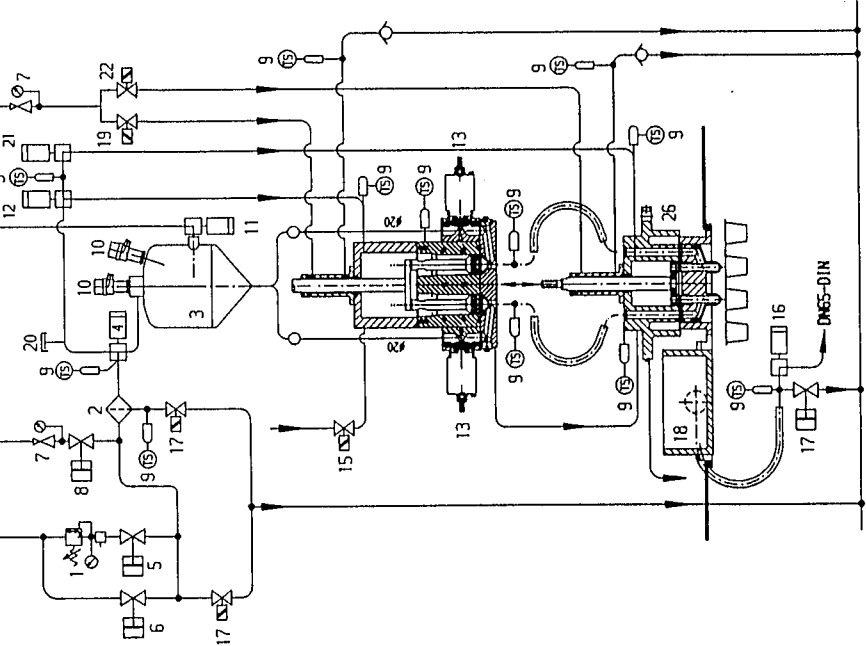
- 1 = Druckbeaufschlagung für Produktbehälter
- 2 = Sterilluftfilter
- 3 = Produktbehälter
- 4 = Sterilluft auf Produktbehälter
- 5 = Sterillufteinlassventil
- 6 = Trocknen des Sterilluftfilter
- 7 = Dampfdruckventil Sterilkannen
- 8 = Dampfentlassventil
- 9 = Temperaturmess-Stellen
- 10 = Niveausonde
- 11 = Produktentlassventil f. Produktbehälter
- 12 = Sterilluft auf Kolbenrückraum
- 13 = Einlassventile am Doseur
- 14 = Ausstoßventile am Doseur
- 15 = Kühlwasser für Doseurrückkühlung
- 16 = CIP Auslass
- 17 = Kondensatablassventil

# ILM-AS mit Membrandüsen System ILM with membrane nozzle system



- Pressure air charge for product container
- Sterile air filter
- Product container
- Sterile air product container
- Sterile air inlet valve
- Drying out of sterile air filter
- Steam regulating valve
- Steam inlet valve
- Temperature measuring point
- Level sensor
- Product inlet valve at product container
- Sterile air for piston backroom
- Suction valves at filler
- Discharge valve on pump
- Cooling water for recooling filler
- CIP outlet
- Condensate drain valve during SIP phase

# ILM-AS mit Kolbenabschließvorrichtung ILM with piston cut-off device



- CIP return container
- Steam onto sterile barriers -pump
- Rupture disk
- Sterile air on piston shut-off device
- Steam onto sterile barriers -nozzle plate
- Single tube nozzle system
- Membrane nozzle system
- Compressed air and vacuum for membrane nozzle
- Piston cut-off device

Auftraggeber:		Ende	Rechnung	Bezeichnung	
1:1	1:1	31.03.2001	31.03.2001	ILM-AS	
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Geprüft:		31.03.2001	31.03.2001	861101998	
Name:		31.03.2001	31.03.2001	Zahl	
Titel:		31.03.2001	31.03.2001	2	
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