



STONEPAK

Product line



Force Flow (Air) Packer



Particle size
3/8" diameter and smaller

The **Air Packer** is designed to fill and weigh fine powders, flakes, pellets, and granules with a particle size of 3/8" or smaller. The **Model 787** is a simple, rugged, economic machine. The **Model 720-MP** is a feature-rich machine offering excellent weight accuracy (2 ounces at two sigma for many products) and simple operation.

Features and benefits

- Low Maintenance – no moving parts in the product path
- Easy Changeover – quick drop bottom for cleanout between runs
- Small Profile – multiple machines can be banked together under one bin
- Simple – all pneumatic design, no electricity required (Model 787)
- PLC Style Controls – easy to troubleshoot and replace "cards" (Model 720 MP)

The following features are standard for the 720-MP and options for the 787:

- Bulk and Dribble Product Flow – slow "top-off" improves accuracy
- Swirl Filling Tube Cleanout – product on scale is moved to the bag for best accuracy and cleanest operation
- Inflatable Sealer – closes off the gap between the filling tube and the bag's valve to minimize dusting during fill

Technical data

Typical equipment dimensions:Length: 46" (1194 mm)
(Model 787) Width: 16" (406 mm)
Height: 93" (2362 mm)

Bag capacity:22-110 lb (10-50 kg)

Compressed air:1.5 ft³ @ 80 psig per bag packed required

Low pressure air:Up to 150 scfm @ up to 6 psig required

Shipping weight:1200 lb (550 kg)

Filling tubes:Sized for 3-8" bag valves

Dust collection requirements:400 scfm recommended

Electrical requirements:110 V, 1ph, 60 hz, 5 amps (Model 720-MP or 787-DM)

Applications

Concrete mixes, gypsum, resins, phosphates, flour, etc.



Production rate

Up to **10 BPM** (per spout)

Options

- DM Weight Controller – provides digital display for operator use (Model 787 only)
- Atmospheric configuration for lowest machine cost
- Plug-Stack configuration for handling abrasive products like sand
- Potbelly style chamber for low head applications
- Built for dust explosion environments
- Metal Detector mounted around gum rubber filling tube behind fill spout

Jet Flow (Impeller) Packer



Particle size
200 mesh and finer

The **Impeller Packer** is designed to handle powdered products with a particle size of 200 mesh or finer. Less air is introduced into the product than with an air packer. This results in faster filling rates and smaller bag sizes. Product is consistently and positively fed to the impeller by means of two horizontal side screws. The **Model 801** is a rugged, economic design while the **Model 820-MP** is a feature-rich design providing excellent weight accuracy.

Features and benefits

- Low-Maintenance Design - easy side access for impeller and housing liner
- Effective Product Flow Path – side screws channel product to impeller
- Small Profile – multiple machines can be banked together under one bin
- Full Electrical Controls Package – includes motor starter and disconnect switch (model 820 MP)

Applications

Cement, gypsum, clay, lime, talc, etc.



Production rate

Up to **8 BPM** (per spout)

Options

- DM Weight Controller – provides digital display for operator use (for Model 801 only)
- Variable Frequency Drive – allows tuning of the machine for optimal performance with different products
- Metal Detector mounted around gum rubber filling tube behind fill spout

The following features are standard for the 820-MP and options for the 801:

- Weight Controller – provides digital display for operator use
- Bulk and Dribble Product Flow – slow "top-off" improves accuracy
- Swirl Filling Tube Cleanout – product on scale is moved to the bag for best accuracy and cleanest operation
- Inflatable Sealer – closes off the gap between the filling tube and the bag's valve to minimize dusting during fill

Technical data

Typical equipment dimensions:Length: 28" (711 mm)
(Model 801) Width: 22" (559 mm)
Height: 62" (1575 mm)

Bag capacity:22 - 110 lb (10-50 kg)

Compressed air:1.0 ft³ @ 80 psig per bag packed

Shipping weight:1200 lb (544 kg)

Filling Tubes:Sized for 3 - 8" bag valves

Electrical requirements:230/460 V, 3 ph, 60 Hz, 30/15 amps supply 7.5 hp, 1800 rpm TEFC motor

Auger Flow Packer



The High Speed **987 Series Auger Flow Packer** provides rapid delivery of product into bag, weight control, and easy operation.

Features and benefits

- Manual bag clamp with automatic start switch
- Mild steel product contact surfaces
- 1500 rpm auger
- Bag chair for support of bag bottom
- Enclosed guards at V belt drive
- Sturdy welded steel frame
- High quality control components
- Sealed proximity switch for cut-off weight sensing
- Dust collection hood and duct assembly
- Inspection door with interlock switch

Production rate

Up to **6 BPM**

Technical data

Typical equipment

dimensions:	Length: 64" (1626 mm) Width: 26" (660 mm) Height: 66" (1676 mm)
Bag capacity:	22 to 110 lb (10 to 50 kg)
Bag valve size:	5 1/2" or 6 1/2"
Bag length:	Up to 34" long pasted valve multiwall bag
Shipping weight:	Approximately 1000 lb (454 kg)
Compressed air:	Basic machine - none machine with pneumatic options - 0.1 to 0.5 ft ³ @ 80 psig per bag packed
Auger drive:	5 hp TEFC motor
Electrical controls:	Disconnect switch, fuses, control transformer, reversing starter, timer(s), push buttons and lights in NEMA 12 dust tight enclosures
Electrical requirements:	230/460 V, 3 ph, 60 Hz, 20/10 amps

Applications

Paint pigments, carbon black, chemicals, minerals, bakery mixes, etc.



Options

- Stainless steel product contact surfaces
- Cone type valve sealer on filling tube
- Hopper with ribbon agitator and rotary paddles
- Motors and electrical enclosures for wet or hazardous environments
- Bag settler
- Pneumatic powered bag clamp
- Automatic bag edge start switch

Vacuum Packer



The **DB Series Vacuum Packer** is designed to package extremely light and fine powders into porous valve bags. The vacuum chamber and bulk / trim flow system draw product into the bag at uniform rates, providing excellent fill accuracy. Fast and accurate, the SpeedAc NXT weight controller allows complete control of the filling process with unprecedented efficiency.

Features and benefits

- Aluminum vacuum chamber including fully adjustable interior panels, bag inflation, spout purge, and two dust collection points
- Butterfly type bulk and trim gates with rotary air actuators. Inflatable spout boot comes standard
- Pushbuttons and selector switches are located in a station, which is within easy reach of the operator
- Special safety device: Two "Start" pushbuttons must be activated by the operator to start the filling process, therefore reducing possibility of injury
- Well-positioned connection points for dust collection
- Ruggedly constructed including high quality components that meet the highest standards of heavy industry
- Designed for dusty environments
- C.S.A. / U.L. approved electrical components

Applications

Fluffy carbon black, fumed alumina, fumed silica, graphite powders, pigments, etc.



Production rate

Up to **3 BPM***

* Depending upon product flow, vacuum pressure, product bulk density, bag construction, etc.

Options

- Vacuum pump and filter house
- Valve bag placer and ultrasonic sealer

Technical data

Typical equipment

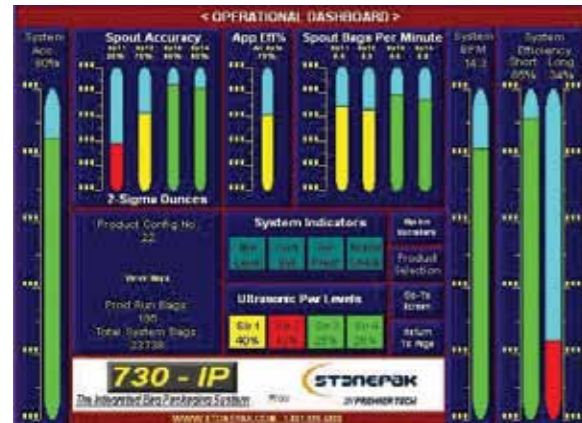
dimensions:	Length: 74" (1880 mm) Width: 49" (1245 mm) Height: 114" (2895 mm)
Valve sizes:	5.25" to 8" (133 to 203 mm)
Filled bag weight:	5 to 50 lb (2 to 22 kg)
Bag dimensions:	Face width: Up to 29" (737 mm) Length: Up to 48" (1220 mm)
Product bulk density:	Gusset: Up to 10" (254 mm)
Accuracy*:	1 to 25 lb/ft ³ (16 to 400 kg/m ³)
Vacuum requirements:	± 2 to 6 oz. (± 55 to 170 g) 14" to 20" Hg
Electrical requirements:	(356 to 508 mm Hg) 120 V / 1 Ph / 60 Hz
Ambient temperature:	(other voltages available) 40°F to 95°F (5°C to 35°C)

* Depending upon product flow, vacuum pressure, product bulk density, etc.

Integrated Packer



VALVE BAG FILLING
SYSTEMS



One single HMI controls scale, packer, sealer, and applicator

A single HMI is used to control and monitor an entire bagging system which may contain several bag fillers, bag placers, and bag sealers. Product changeovers can be handled by simply making a single menu selection. A dashboard style display with scaled green, yellow and red indicators provides at-a-glance and real-time information to operations, maintenance, and management personnel.

Features and benefits

- Automated machine adjustments eliminates the need for an operator to enter the packaging cell
- Ethernet communication to the HMI and a manager's desktop computer or plant control system
- Mechanical technology seamlessly integrates with control technology for ease of use
- Highest level of weight accuracy in the valve bag packaging industry saves money
- Feedback from downstream checkweigher ensures that optimum system accuracy is obtained
- Common measurement and recording of production and utilization data allows inter-company benchmarking
- Insightful utilization log identifies system downtime and cause to eliminate downtime
- Systems available for Class II, Div 1 & 2 dust explosion hazard areas

Multiple machine control



Scale

All weight data is seamlessly interfaced with the system PLC and HMI and can be easily networked to any PC.

Packer

The Integrated Packer incorporates Air Packers, Impeller Packers, or Auger Packers with state-of-the-art control and communication equipment.

Sealer

The Clean-Pak II Ultrasonic Sealer effectively closes the valve of the bag before the bag is moved from its original filling position.

Applicator

The robot applicator is completely integrated into the control system of the Intelligent Packer.



Ultrasonic Sealer



The **Clean-Pak II Ultrasonic Sealer** effectively closes the valve of the bag before the bag is moved from its original filling position. This ensures the cleanest operation while handling dusty products. The once common puff of dust as filled bags are discharged to the conveyor is completely eliminated by the sealed valve.

Features and benefits

- Clean bags – filled bags are sealed prior to handling
- Improves finished bag accuracy – sealed bags do not leak during conveying, stacking, or shipping
- Retrofittable – easily mounted to STONEPAK Air and Impeller packers
- Effective Seals – Even through product contamination
- Durable – IP68 controls and hardware designed for dusty environments

Options

- BOSS – Bag on Spout Sensing – laser detectors ensure that bag is properly on fill spout before machine is started.
- Horizontal (gusset) or vertical (butt) discharge
- Touchscreen Operator Control – provides user friendly interface and diagnostics
- Built for dust explosion environments

How it works



Bag is filled, then fill tube is purged of product and retracted from the spout of the bag.



Bag valve is sealed and bag is discharged to a conveyor.



Fill tube is extended to fill position and ready for next bag.

Production rate

Up to **4 BPM**

Technical data

- Dust collecting requirements:** 400 scfm recommended (typically already planned for packer)
- Approximate weight:** 500 lb (227 kg) above packer weight
- Air consumption:** 10 scfm @ 80 psig (clean & dry)
- Electrical requirements:** .. 230 V, single ph, 50/60 Hz, 20 amp sealer power required

Pinch Bottom Bag Closer



Model 90 Pinch Bottom Bag Closer efficiently closes the open top of filled pinch bottom open-mouth multiwall bags and woven polypropylene bags. It activates the pre-applied hot melt adhesive, folds the top flap against the face of the bag and compresses to set the closure, providing a strong, attractive package. **Model 92-J Pinch Bottom Bag Sealer/Closer** provides an effective double closure of pinch bottom open-mouth bags by sealing the bag's inner poly liner first.

Features and benefits

- Bag material: open-mouth multiwall bags (model 90-J and 92-J) and woven polypropylene bags (model 90-JS)
- Time-tested: model 90 was developed in 1963 and has been redesigned 10 times
- Accessible: machine cover pivots and compression belt assembly rotates up for easy cleaning and maintenance
- Belt breakaway: pushbutton removes belt pressure and enables instant removal of bag
- Variable belt speed: VFD enables easy adjustment of belt speed for optimal operation
- Temperature Control – Digital controllers provide consistent and precise temperatures
- 40 inch long sealer bar assembly allows for lower temperatures and faster speeds (model 92-J)

Options

- Powered height adjustment – by air motor
- 460 V heater and motor
- Interface to high-speed automatic operations
- Bag top cleaner for sticky or dusty products
- Bag top coder
- Bag conveyor VFD controls
- Construction for dust explosion environments
- High speed version, 77 fpm to 150 fpm

Production rate

Up to **30 BPM** with belt speeds up to 100 fpm
Up to **45 BPM** with belt speeds up to 150 fpm

Technical data

- Typical equipment dimensions:** Length: 90" (2286 mm)
Width: 34" (864 mm)
Height: 76" (1944 mm)
- Bag capacity:** Handles the complete pinch bottom bag range
- Shipping weight:** 1,300 lb (590 kg)
- Air requirements:** 7 scfm at 80 psig
- Electrical requirements:** .. 230V/460V, 3 ph, 50/60 Hz, 30/15 amps



The **509/511 Series Valve Bag Applicator** automatically positions valve bags on the filling tubes of one, two, three, or four valve bag packers.

Features and benefits

- Positive Valve Opening – mechanical duckbill enters, opens, and rounds bag’s valve
- Bag Control - Pneumatic claw style bag gripper forcefully replicates the control of a human hand
- Continuous Operation - discards most defective bags and continues without operator assistance
- Simple Bag Magazine – can be reloaded without interrupting production
- Traffic Control – controls the discharge of bags from packers to ensure proper spacing and no pile-ups
- Durable – designed for use in dusty environments

Production rate

Up to **18 BPM**

Technical data

Bag types:Multiwall paper valve bags with or without extended sleeve for ultrasonic sealing

- Plastic film valve bags, block bottom style
- Woven polypropylene valve bags, block bottom style

Bag size range: 16” - 25” (406 - 635 mm) face width

- 18” - 36” (457 - 914 mm) face length
- 3” - 8” (76 - 203 mm) top width

Air requirements:0.7 ft³ (0.02 m³) clean dry free air at 80 psig per cycle

Electrical requirements: ..230/460 V, 3 ph, 60 Hz

Applications

Handles complete range of valve bags.

Options

- Touchscreen Operator Control – provides user friendly interface and diagnostics
- Built for dust explosion environments
- Choice of left or right hand models, and multiple configurations permit adaptation to tight spaces



STONEPAK specializes in integrating FANUC robots in the bag packaging industry. A wide range of end effectors provide reliable operation. Custom design and programming capabilities allow STONEPAK to meet even your most challenging applications.

Features and benefits

- Durable – Industrial robots are renowned for long life and low maintenance – long MTBF and short MTTR
- Flexible Operation – A single robot can often perform multiple tasks that would otherwise be performed by multiple machines.
- Layout Flexibility – small footprint combined with numerous payload and reach configurations allow for adaptation in tight spaces
- Operator friendly teach pendant for robot control from a wide range of positions
- High Performance Motion – fast cycle times and high throughput
- RIA Compliant Safety Fencing with Control Reliable Circuits

How it works



Apply



Apply/Remove/
Palletize



Palletize

Options

- FoundryPro™ Dust/Liquid Protection Package
- Touch Screen Operator Interface Multi-robot configurations

Production rate

Up to **32 BPM**

STONEPAK offers a wide range of equipment to complete your production line. From the raw product to the wrapped pallet we ensure total integration of your

equipment. You will find below additional equipment that we can provide to maximize your production.

Conveyors



- Belt conveyor
- Roller conveyor
- Turn Table

Checkweighers



- Provides extremely precise bag weight
- Unprecedented efficiency

Metal detectors



- Detect metal parts that may not be readily apparent
- Largely used in the chemicals, food, and mineral industries
- Prevent metal contamination during manufacturing process
- Filling tube or conveyor mounted versions

Reject conveyors



- Enable to remove out-of-standard bags
- Reject bags from the normal flow while still moving at the conveyor velocity
- Ensure consistency of output products

Flatteners



- Makes perfect square bags
- 4-sided

Operator seats



- Adjustable
- Ergonomic design
- Padded seat and back cushions
- Safety seat belt included on sea

FIBC Fillers



- Automatic metering
- Heavy-duty knife gate valve or butterfly valve
- 4400 lb (1996 kg) capacity scale deck

Robotic Palletizers



- Flexibility in layout configuration allows installation in tight spaces
- Quick changeover of palletizing patterns through stored recipes
- Up to 40 PBM

Stretch Hooder



- Fully automatic system designed to apply a mechanically pre-stretched film hood to a pallet load
- Entirely designed, engineered, manufactured and supported in North America
- Up to 110 loads per hour

SpeedAC NXT Data Collector



- Gather data from a controller which is used to operate scales, checkweighers and valve bag fillers
- User-friendly graphical interface
- Remote reading of equipment production data

High Level Palletizers



- All electric design for a smooth and quiet operation
- Produces high quality full-pallet loads
- Up to 35 BPM

Stretch Wrappers



- Overhead rotary arm
- Precise control of the film stretch and force
- Up to 70 loads per hour

History

STONEPAK is Premier Tech Chronos Valve Packing line. It is born from the acquisition of the bagging division at Graphic Packaging in May 2009. STONEPAK will continue the tradition that has been passed down through **Bates, St. Regis Bates, Stone Container, Smurfit Stone, Altiivity and Graphic Packaging.**

For more than 108 years, these companies have provided cutting-edge packaging and bagging solutions for their customers. The product selection includes valve bag fillers (air packers, impeller packers, auger packers), robotic and traditional bag placers, bag palletizers, ultrasonic bag sealers and pinch bag closers. Visit stonepak.com for more information.

Leader in valve packing solutions since 1901

1901 Bates Valve Bag Company

1929 St. Regis

1985 Stone Container

1998 Smurfit-Stone

2006 Altiivity Packaging

2008 Graphic Packaging

2009 **STONEPAK A Premier Tech Brand**

You can contact us for parts and service for this legacy equipment.

Service

Customer care at STONEPAK and Premier Tech:

- Customized training and preventive maintenance programs
- Spare parts depots located in 8 different countries
- 24/7 technical support
- Over 90 technicians in our service team worldwide
- Continuous improvements to our equipment
- Remote performance management capabilities
- A complete team dedicated to your satisfaction

Contact us now for parts and service for all STONEPAK's product line.

Service & Parts ☎ 801 536-0435
 Inside Technical Support ☎ 801 536-0426
 Parts / Customer Service ☎ 801 536-0431

stonepak@premiertech.com
STONEPAK.COM

WE CARE



Office & Manufacturing Plant

STONEPAK
1881 West North Temple,
Salt Lake City, UT 84116
United States
☎ +1 801 595-6800
stonepak@premiertech.com



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