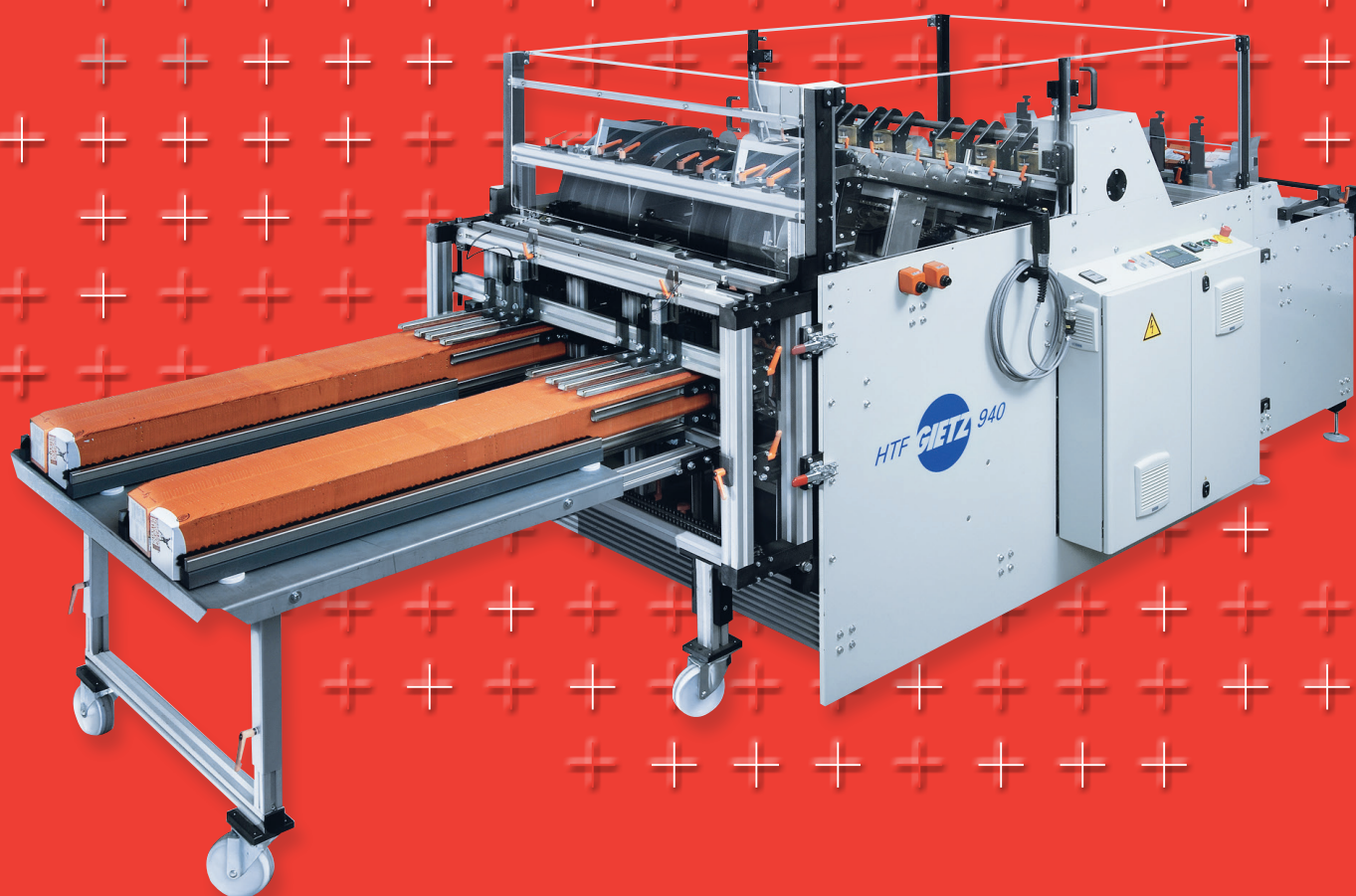


# HTF 940 / HTF 1270

*Tray Forming at its best.*



Gietz since 1892.  
From Professionals for Professionals.



# HTF 940 / HTF 1270

## *At a glance.*

The HTF machine range is designed for the gluing and forming of conical trays. Printed blanks are glued and formed to trays with or without cover lids, take-away boxes or hamburger clamshells. The HTF converts all common types of cardboard / corrugated board. Many decades of experience in the construction of tray forming machines combined with practical knowledge from the customers allow Gietz to offer a range of highly productive and versatile machines that can be upgraded and retrofit at any time. The user benefits from a long-lasting and efficient machine concept.

### The 10 Advantages

#### 1. Up to 12'000 trays per hour and stream

This highly productive machine can convert blanks with up to 12'000 strokes per hour and stream.

#### 2. Modularly machine configuration

Even if the machine is originally equipped for onestream operation only, further streams can be added later at any time. The HTF can be retrofitted with further options such as a flanging station or plasma nozzles for the pre-treatment of coated gluing flaps.

#### 3. Short setup times

For all tray types a fix forming station is available with the corresponding forming dies. In just a few steps, these fix forming stations can be fitted to the machine, which dramatically reduces the make-ready times. All fix forming stations are set, tested and adjusted upfront at supplier site.

#### 4. A selection of gluing systems

Whether a 2-/4-/6- or 8-point gluing is required, the HTF offers users a complete choice of gluing systems to suit different applications. The machine can be equipped with a unit for cold gluing by soft pads, a cold gluing unit with spray nozzles or a hot-melt adhesive unit with spray nozzles.

#### 5. Intelligent movement of forming dies

Various parameters such as the start, end, length and speed of the forming stroke can be selected to guarantee optional production security. For an optimum folding procedure of hamburger clamshells a pair of twin swords is integrated in the movement.

#### 6. User-friendliness

The swing away delivery allows easy access and a quick and comfortable setup of the forming stations. The horizontal delivery of the trays at optimal working height simplifies the removal of the finished cartons during production.

#### 7. High production security at the in-feed units

The pneumatically controlled in-feed of the blanks guarantees highest reliability and production security.

#### 8. Core competence and service life

Since 1968, the Gietz Company manufactures machines for the forming and gluing of conical trays. This know-how combined with the practical experience made by hundreds of machine users is incorporated into the HTF technology. In addition the very solid and robust machine construction guarantees long durability.

#### 9. Price-performance ratio

Best quality of forming and gluing systems, maximum production speed and security, as well as a durable construction: a Gietz machine is well worth its price.

#### 10. Top products for professionals

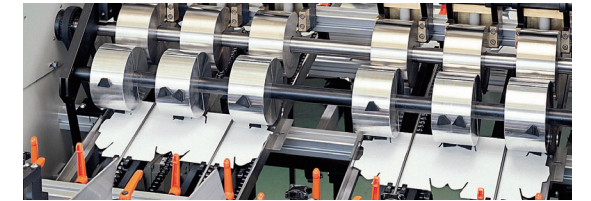
Machines for the forming and gluing of conical trays from Gietz are recognized by the paper converting industry worldwide as leading products from professionals for professionals.

# HTF 940 / HTF 1270

## *Some details.*

### Gluing systems

The standard cold gluing unit applies dispersion glue all over in the required shape on the blanks by means of foam rubber pads on gluing wheels.

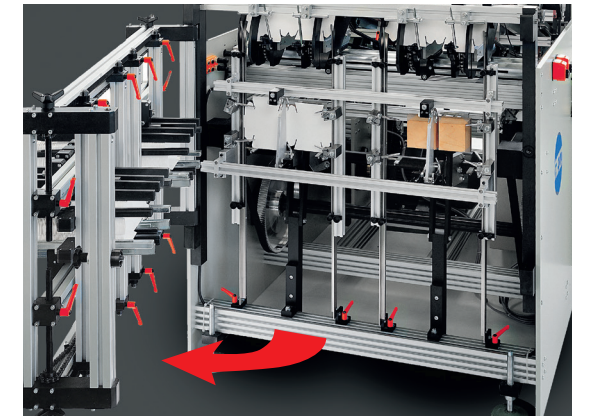


Also available are high pressure hot or cold glue spray systems.



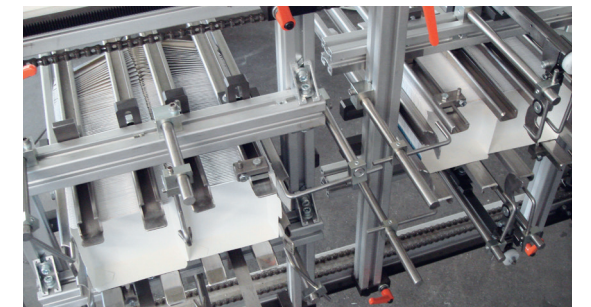
### Swing away delivery stack

The Gietz HTF machines are designed for maximum operating comfort. Swing away delivery stacks allow optimal access to the forming stations which enables a comfortable and quick set-up. The horizontal delivery of the completed trays simplifies the removal of erected trays at optimal height and with a minimum number of operators.



### Fix forming stations

Fix forming stations are suitable for running repeat jobs due to the dramatically reduced setup time. The pre-setting of these is normally made by Gietz AG at their production site in Gossau, Switzerland. It can also be made by the customer on site, with material supplied by Gietz AG.



### Flanging Station

The Gietz HTF 940 can be enlarged at any time very easily and quickly by a tray edge reinforcing station. Fixed by hot glue, single or double folded reinforcement flanges are possible on either the inside or outside of the carton tray to reinforce the trays for stronger resistance and better handiness.

Only available for the Gietz HTF 940.



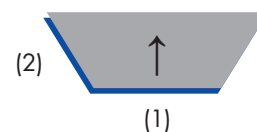
# HTF 940 / HTF 1270

## *The facts.*

	HTF 940	HTF 1270
Speed max.	12'000 strokes/hour	12'000 strokes/hour
Cardboard min.	180 gsm	180 gsm
Cardboard max.	600 gsm	600 gsm
Corrugated board	E/F/N	E/F/N
Size of blanks min.	100 x 100 mm 3.9" x 3.9"	100 x 100 mm 3.9" x 3.9"
Size of blanks max.		
1 stream operation	940 x 500 mm 37.0" x 19.7"	1270 x 500 mm 50.0" x 19.7"
2 stream operation	420 x 500 mm 16.5" x 19.7"	590 x 500 mm 23.2" x 19.7"
3 stream operation	250 x 500 mm 9.8" x 19.7"	360 x 500 mm 14.1" x 19.7"
4 stream operation	- -	250 x 500 mm 9.8" x 19.7"
Tray depth min.	approx. 15 mm approx. 0.6"	approx. 15 mm approx. 0.6"
Tray depth max.	approx. 320 mm approx. 12.6"	approx. 320 mm approx. 12.6"
Tray side angle	5°- 50°	5°- 50°

### Flanging station

- Available for Gietz HTF 940 and 1- or 2-stream operation only
- For single or double inside or outside folded flanges
- Hot gluing of the flangers
- The sum of the tray base width (1) plus the length of one finished tray sidewall (2) must be at least 84 mm / 3.3" (note measurements taken in relation to tray running direction ↑)
- Flange height 8 - 30 mm / 0.3" - 1.2"



### Floor space

HTF 940	approx. 4.20 x 1.50 m	approx. 13.78 x 4.92 ft
HTF 940 with flanging station	approx. 6.03 x 1.50 m	approx. 19.78 x 4.92 ft
HTF 1270	approx. 4.20 x 1.80 m	approx. 13.78 x 5.90 ft

### Height

HTF 940/1270 with gluing unit by soft pads	approx. 1.60 m	approx. 5.92 ft
HTF 940/1270 with gluing unit by spray nozzles	approx. 2.10 m	approx. 6.89 ft

### Weight

HTF 940	approx. 1.9 tons	approx. 2.1 US tons
HTF 940 with flanging station	approx. 3.0 tons	approx. 3.3 US tons
HTF 1270	approx. 2.2 tons	approx. 2.4 US tons

