

# M U L T I V A C Packaging Machine Model R 085

Fully automatic stainless steel horizontal Form, Fill and Seal rollstock packaging machine; custom designed and constructed for durability and reliability to maximize user efficiency and profitability.

## Products packaged:

Bulk, 5 lbs.  
Bulk, 2-5 lbs.  
Strips, 1 lb.  
Steaks, 1 lb.

## Packaging material:

Bottom web (flexible), Width: 422 mm, Tolerance: +2 mm  
Top web (flexible), Width: 412 mm, Tolerance: ±1 mm

# M U L T I V A C Packaging machine model R 085

## 1. BASIC MACHINE

consisting of:

Stainless steel construction

Hygienic design (IP 65)

Machine chassis

Frame length 2,875 mm,  
Die center distance approx. 1,200 - 1,350 mm,  
Machine frame fixed (non-divisible)

Control cabinet (810 mm x 1335 mm) with integrated operating terminal

Nominal machine width 420 mm

Equipment package "Easy Production Package"

Package includes:

Castors for easy move of the machine in the production room and one foot switch for clocked production

Equipment package "Package Atmosphere"

Evacuation and gas flushing unit for producing vacuum and MAP packages

Control cabinet heating

Holder for integrated vacuum pump

Note: Gas flushing system for future use.

Special tool set 1

Contains hand tools and consumables (round gaskets for forming die, microfuses, etc.)

#### SAFETY

Safety system E, with magnetic switch and sliding guard in loading area

Set of safety covers for first die set, safety slides  
Plates Pos. 1 and 4 perforated, Pos. 2, 3 and 6 unperforated

Interlocked side frame claddings at lifting systems (with magnetic switches)

#### LIFTING SYSTEMS

Lifting mechanism HKE 20, max. opening width 100 mm, 4-post mounting, for forming

Lifting mechanism HKE 20, max. opening width 100 mm, 4-post mounting, for sealing

#### DRIVE SYSTEM

MC-Drive advance system, AC-motor 2 Nm

Transport chain (nickel plated with rectangle spring)

#### FILM UNWINDS

F 26 mechanical film unwind for top web with 3" core, max. reel-Ø 300 mm  
Guide roller for top web, at sealing die infeed additional guide roller for machines with stamp printer

F 26 mechanical film unwind for bottom web with 3" core, max. reel-Ø 350 mm

#### PNEUMATIC EQUIPMENT

Forming of Bottom web (System A)  
Forming system Standard, heating and forming by compressed air via MULTIVAC proportional pressure regulator

Separate ventilation of seal die upper part for skin pack total heat sealing. Provides a secondary sealing area to the product's edge, minimizing wrinkles.

#### ELECTRICAL EQUIPMENT

Machine control IPC 06

operating system Windows Embedded, high temperature-, vibration-and EMC stability

Equipment:  
intelligent bus terminal system with integrated diagnostics

Ethernet-interface

Number of inputs and outputs depending on machine equipment

USB interface integrated in the operating terminal, with cover made of stainless steel

2 temperature control loops, appropriate to PT 100 thermo couples

4 analog inputs (for pressure transducers etc.)

recipe store for 500 recipes, recipe management with alphanumeric

input external data backup of recipes on memory stick possible high

data security by uninterruptible power supply

password protection with 3 access levels for different access authorizations

Rate meter

Cycle counter

Production hour meter

Counter for good packages / bad packages as standard, an exact result can only be assured with further monitoring systems, e.g. end of web detector for top and bottom web

line motion control system for infeed and discharge units as standard program

for partial advance, the advance can be halved, make thirds, quartered in equal

shares film consumption display in meters, resettable, for display of the film

consumption at shift end, can be activated via service menu, only active

together with an end of web detector for top and bottom web

muting for alarm horn for alarm for current error, via button at operating terminal,

can be activated in service menu

Touch screen-terminal 12,1" colored, jet water secured in IP 65 stainless steel enclosure and LED backlight

User interface HMI 2.0

Servicetool

Imagetool on USB-Stick, for a complete backup and recovery of the control software

Circuit breaker in standard execution

Single-phase alternating current heaters (heating- and sealing plate)

Hardware per installed temperature control loop, with PT 100 temperature sensors and solid state relay temperature control loops for

## 7. Die Set

Format no.: 100411

Cutoff length: 300 mm Nominal

machine width: 420 mm edge

trim: 29 mm Seal type:

Standard

Forming depth: 80 mm

## Basic Die

Number of tracks: 1  
Number of rows: 1

## Die Components

Insertion die with centralized connection plate for pneumatical supply of forming and sealing station

Please note:

Due to the number of variables involved in the production of properly gas backfilled packages, it is essential that packages be tested on a regular basis using an appropriate gas analyzer (usually an oxygen analyzer to measure percent of residual oxygen).

Film thickness and exact film composition must be known to determine proper web width tolerances for your packaging materials. Please be certain that your material supplier has discussed this matter with us or that you have provided these specifications and have received web width tolerances from us prior to ordering your materials.

Sample film may be required to be sent to our production facility in Kansas City, Missouri for quality testing purposes. This will be at customer expense.

Forming die upper part  
Standard lid, designed for basic heating plate  
1 track heating  
sanitation design

Seal die upper part designed  
for basic-sealing plate  
sanitation design

## Package Support

Support system for frame length 2.875 mm (2 support rail(s) included)

## Vario 1

Number of tracks: 1  
Number of rows: 1 Drawing no.:  
15000208138

Package specification:  
Package dimension: 391.00 mm x 300.00 mm  
Forming dimension: 376.00 mm x 282.00 mm  
Package depth: 80 mm

Performance:  
Variable depth from 17mm to 80mm, set at 50mm

Product:  
Bulk, 5 lbs.

## Vario 1 Die Components

Forming die lower part

Sealing frame for forming die upper part, nominal machine width 420 mm  
to hold the heating plate for cutoff length 300 mm

Heating plate(s)

Non-stick coating Type 1 single-  
layer Teflon coating, grey

Note: Heating plate to be used with all varios.

Filler plates (draw depth 80mm)  
Forming depth adjustable in 1 mm increments

Radius plates Standard , Bottom radius: 20 mm, Corner radius: 20 mm

Seal die lower part

Sealing frame for sealing die upper part, nominal machine width 420 mm  
to hold the assembly-sealing plate for cutoff length 300 mm

Skin sealing plate (surface seal) for basic sealing plate

Non-stick coating Type 1 single-  
layer Teflon coating, grey

Basic sealing plate for spare

Note: Sealing plate to be used with all varios.

## Vario 1 Parts

- Longitudinal Cutting

Rotary knife shaft

2 x Rotary blade with hub

Cutting register basic unit (incl. 2 partions for cutting)

Vario 2

Number of tracks: 2

Number of rows: 1 Drawing no.:  
15000208139

Package specification:  
Package dimension: 195.50 mm x 300.00 mm  
Forming dimension: 180.50 mm x 282.00 mm  
Package depth: 70 mm

Performance:  
Package depth variable from 17mm to 70mm; set at 50mm

Product:  
Bulk, 2-5 lbs.

## Vario 2 Die Components

Forming Die Accessories:

Divider for Flexible film

Filler plates (draw depth 80mm)  
Forming depth adjustable in 1 mm increments

Radius plates Standard , Bottom radius: 20 mm, Corner radius: 20 mm

Seal die lower part

Filler plates (draw depth 80mm)  
Forming depth adjustable in 5 mm increments

## Vario 2 Parts

- Longitudinal Cutting

Rotary knife shaft

3 x Rotary blade with hub

Cutting register basic unit (incl. 2 partions for cutting)

Vario 3

Number of tracks: 3  
Number of rows: 1 Drawing no.:

15000208140 Package

specification:

Package dimension: 130.33 mm x 300.00 mm  
Forming dimension: 115.33 mm x 282.00 mm  
Package depth: 70 mm

Performance:  
Variable depth from 17mm to 70mm, set at 50mm

Product:  
Strips, 1 lb.

## Vario 3 Die Components

Forming Die Accessories:

Divider for Flexible film

Filler plates (draw depth 80mm)  
Forming depth adjustable in 1 mm increments

Radius plates Standard , Bottom radius: 20 mm, Corner radius: 20 mm

Seal die lower part

Filler plates (draw depth 80mm)  
Forming depth adjustable in 5 mm increments

## Vario 3 Parts

- Longitudinal Cutting

Rotary knife shaft

4 x Rotary blade with hub

Cutting register basic unit (incl. 2 partions for cutting)

with 1 cutting support(s)

Vario 4

Number of tracks: 3  
Number of rows: 2 Drawing no.:  
15000208144

Package specification:  
Package dimension: 130.33 mm x 150.00 mm  
Forming dimension: 115.33 mm x 132.00 mm  
Package depth: 70 mm

Performance:  
Package depth variable from 17mm to 70mm; set at 50mm

Product:  
Steaks, 1 lb.

## Vario 4 Die Components

Forming Die Accessories:

Divider for Flexible film

Filler plates (draw depth 80mm)  
Forming depth adjustable in 5 mm increments

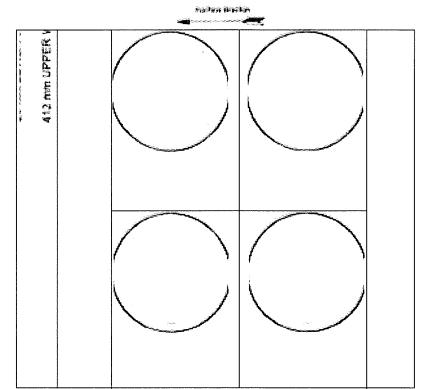
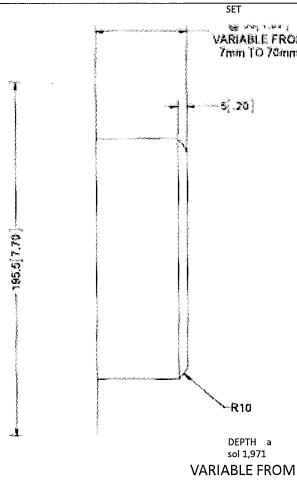
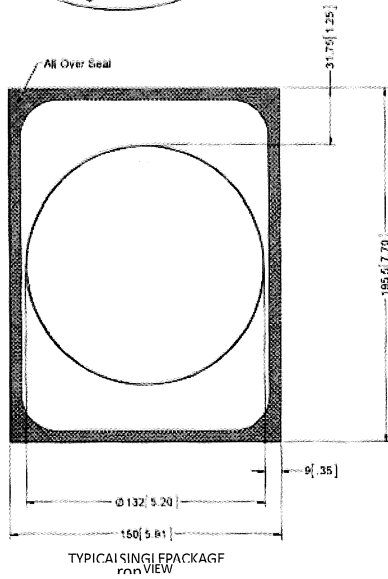
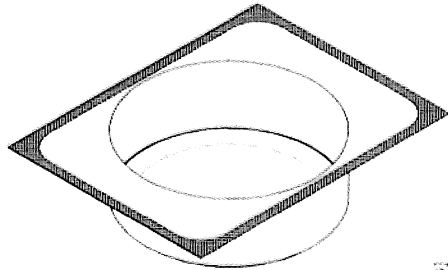
Radius plates Standard , Bottom radius: 20 mm, Corner radius: 20 mm

Seal die lower part

Filler plates (draw depth 80mm)  
Forming depth adjustable in 5 mm increments

## Vario 4 Parts

Note: XMD cutting by divided advance, longitudinal cutting from Vario 3 will be used.



ADVANCE  
TYPICAL PACKAGE ARRAY  
SCALE

W-6-7-1  
known to determine proper web  
compacted  
to determine proper web

FILM NOTE:  
tolerances for your packaging materials. Please be certain that your material supplier has measured the  
matter with us or that you have provided these specifications and have received web width tolerances from  
us prior to ordering your materials.

PRO rect.' NOTICE 16016

PACKAGE DESIGN NOTES

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REAL ZERO DESIGN TO PROVIDE CONTACT SEAL  
AND/ OR PERMEATION OF PACKAGE ONLY. BORN  
FOR MULTIVAC SEALING SYSTEMS.

FORMS AND TOOLING CONSTRUCTION  
ALL OVER SEAL

ALL DIMENSIONS ARE IN MILLIMETERS

ALL DIMENSIONS ARE IN INCHES

KEEPER DATE 1.6.2016

The dimensions of the package blister are the inside dimensions of the  
forming mold. The inside dimensions of the blister are reduced due to  
film thickness and shrinkage properties of the package material.

MULTIVAC HIGHLY RECOMMENDS PLUS  
ASSIST WHEN PACKAGE DEPTHS ARE  
GREATER THAN 4mm

mumvnc

2T2R PACKAGE ARRAY

keeper

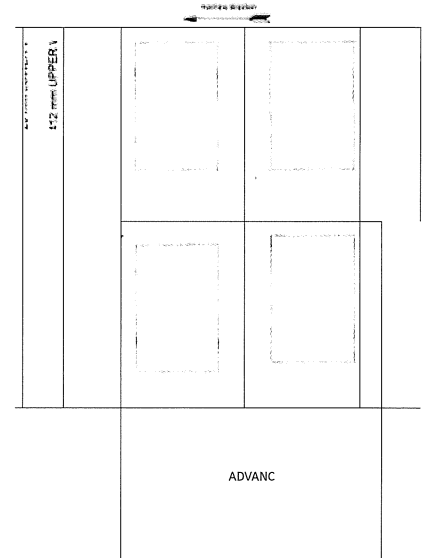
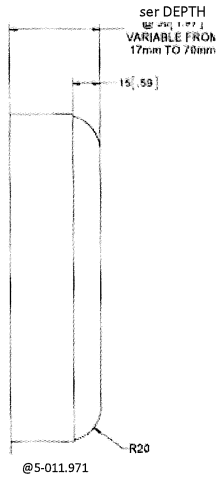
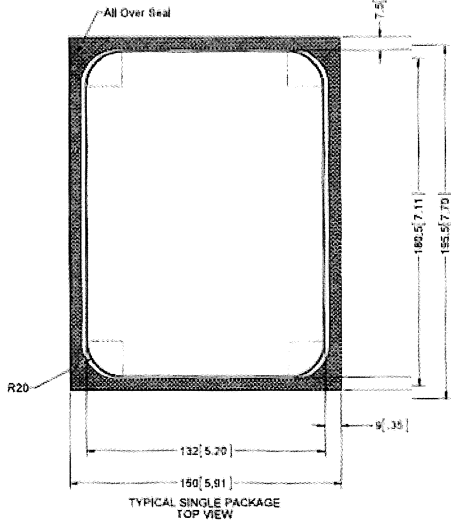
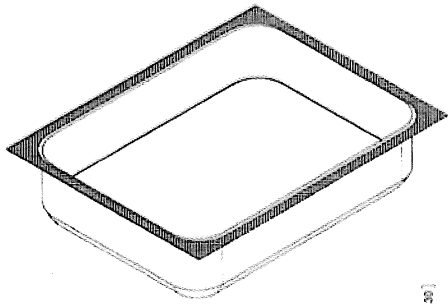
SHEET 1 OF 1

15000244133

1.62016

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1:1



PACKAGE ARRAY  
SCALE

6-7-1

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PACKAGE DESIGN N

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ARE IN INCHES

AIL OVER SEAL

zr2R PACKA  
kkee

ARRAY  
3.122014

**nu WAC**  
MILITARY DIVISION  
1100 N. ROCKAWAY AVENUE, KANSAS CITY, MO 64116  
TEL: 816-251-2800

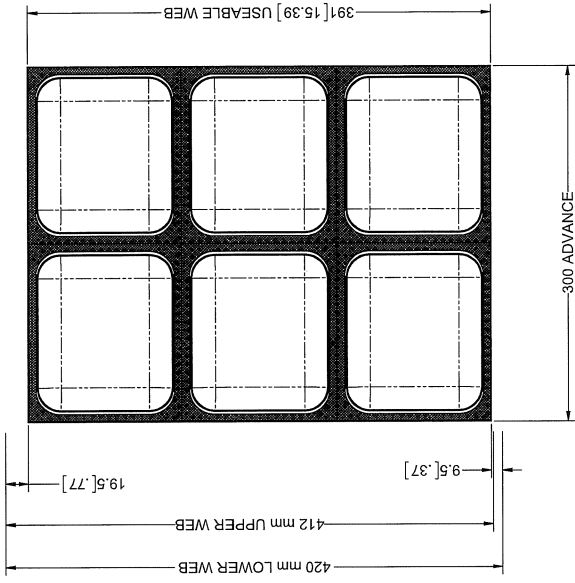
STOCK VARIO.DO NOT  
REVISE

The dimensions of the package blister are the inside dimensions of the forming mold. The inside dimensions of the blister are required due to film thickness and shrinkage properties of the package material.

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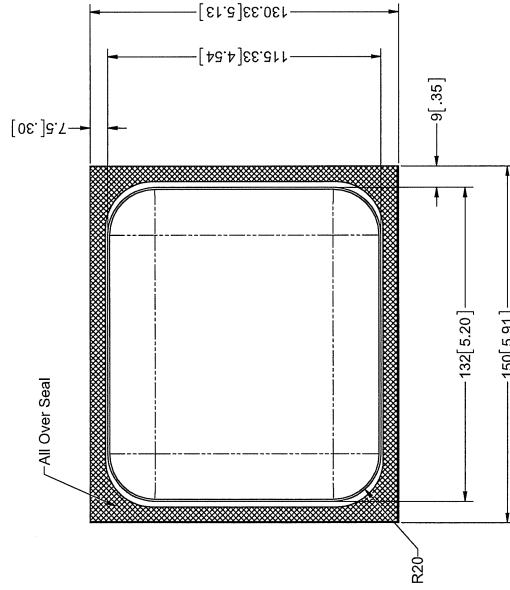
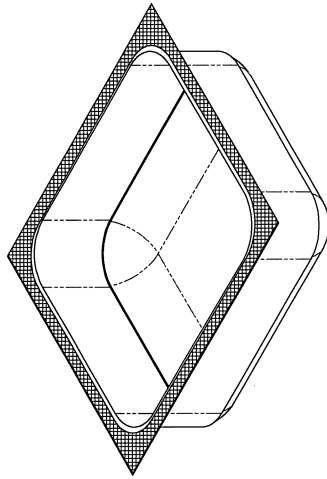
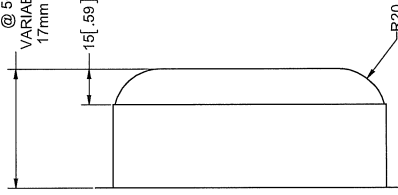
SHEET 1 OF 1

15000208143



TYPICAL PACKAGE ARRAY  
SCALE 1:2

SET DEPTH  
@ 50 [1.97]  
VARIABLE FROM  
17mm TO 70mm



TYPICAL SINGLE PACKAGE  
TOP VIEW

USA

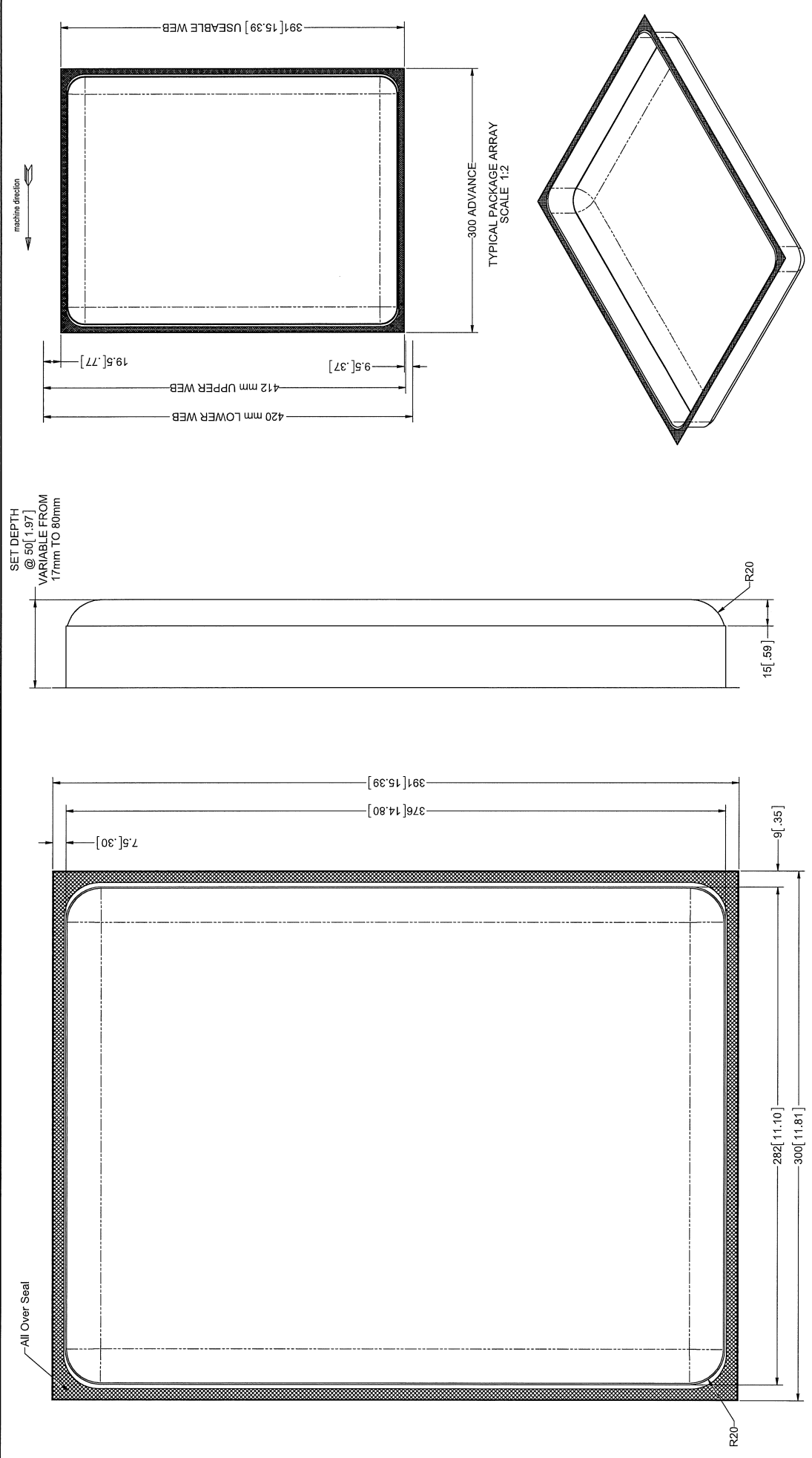
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**PACKAGE DESIGN NOTES**  
ALL DIMENSIONS ARE IN MILLIMETERS  
DUAL DIMENSIONS ARE IN INCHES

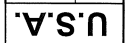
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RESALING NOTE: ALL OVER SEAL  
MULTIVAC HIGHLY RECOMMENDS PLUG ASSIST WHEN PACKAGE DEPTHS ARE GREATER THAN 61mm

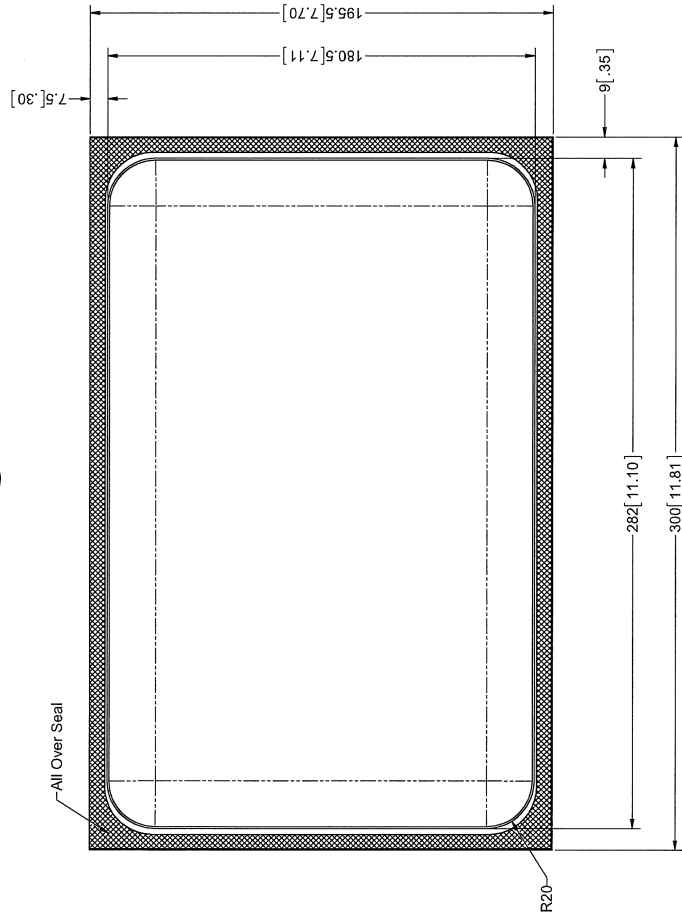
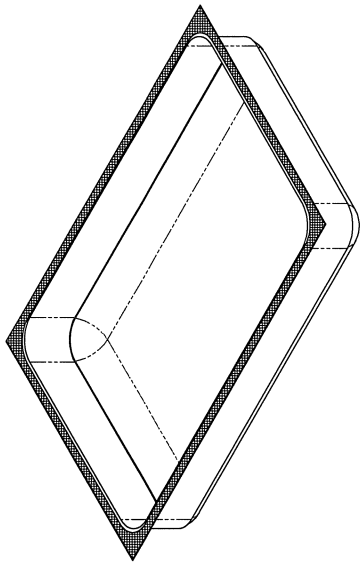
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CREATED BY: kkeever DATE: 3.12.2014  
CHANGED BY: kkeever DATE: 3.12.2014

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D	1:1	MULTIVAC MULTIVAC, INC. 11021 N. POMONA AVENUE, KANSAS CITY, MO 64153 TEL: 816-847-4650	DOCUMENT NUMBER: 15000208144
ANSWER ISSUE	SHEET 1 OF 1	REV:	0



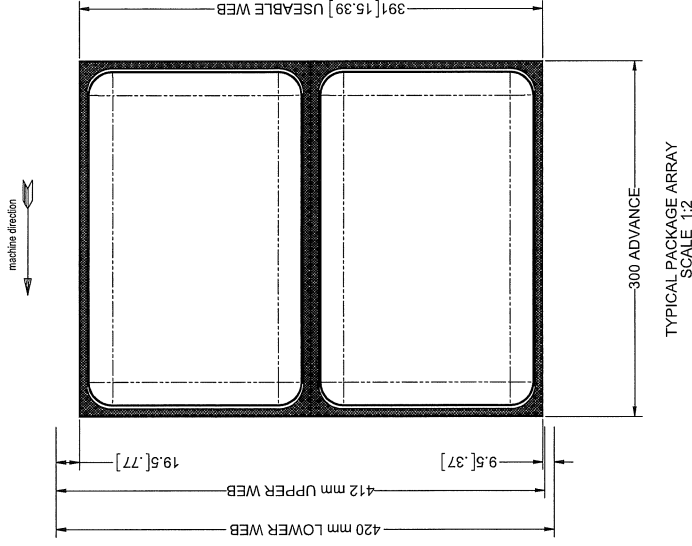
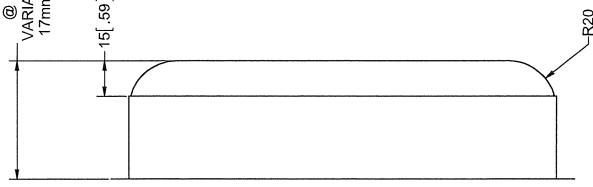
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		<b>CHANGED BY:</b> kkeever <b>DATE:</b> 3.12.2014	<b>SHEET</b> 1 OF 1		





TYPICAL SINGLE PACKAGE  
TOP VIEW

SET DEPTH  
@ 50 [1.97]  
VARIABLE FROM  
17mm TO 70mm



TYPICAL PACKAGE ARRAY  
SCALE 1:2



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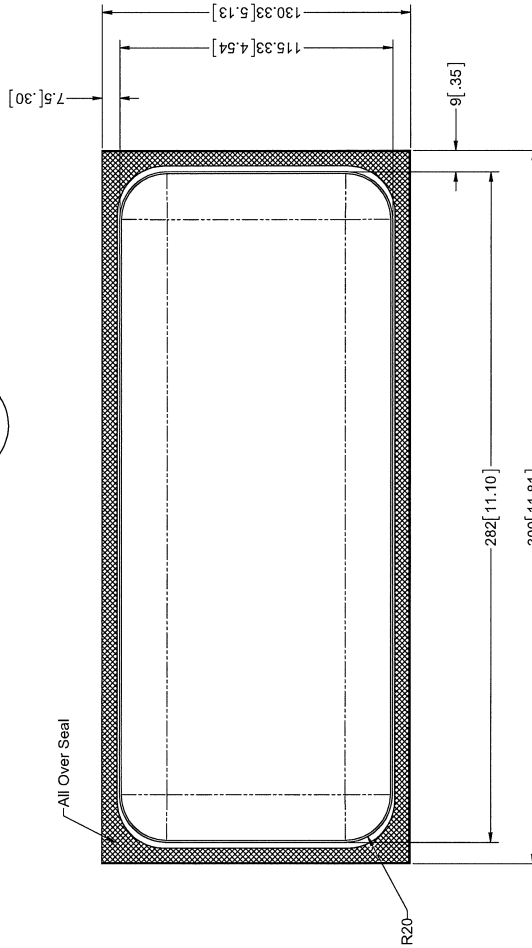
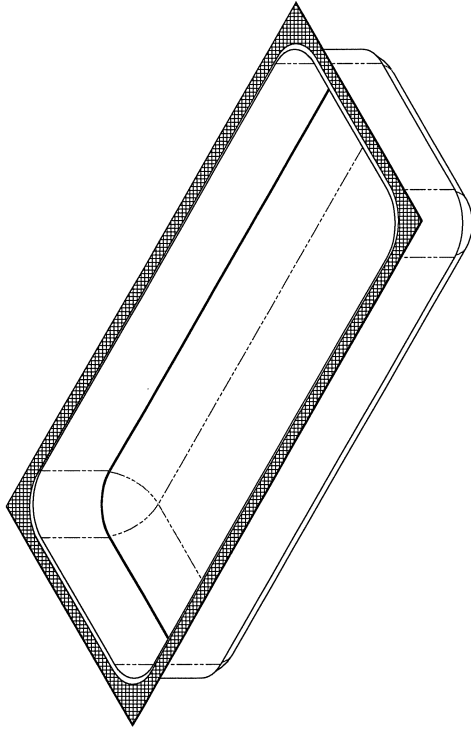
**PACKAGE DESIGN NOTES**  
ALL DIMENSIONS ARE IN MILLIMETERS  
DUAL DIMENSIONS ARE IN INCHES

**NOTICE:** PACKAGE DEPTH IS LIMITED BY MATERIAL FORMABILITY AND TOOLING CONSTRUCTION.  
**REMARKS:** ALL OVER SEAL

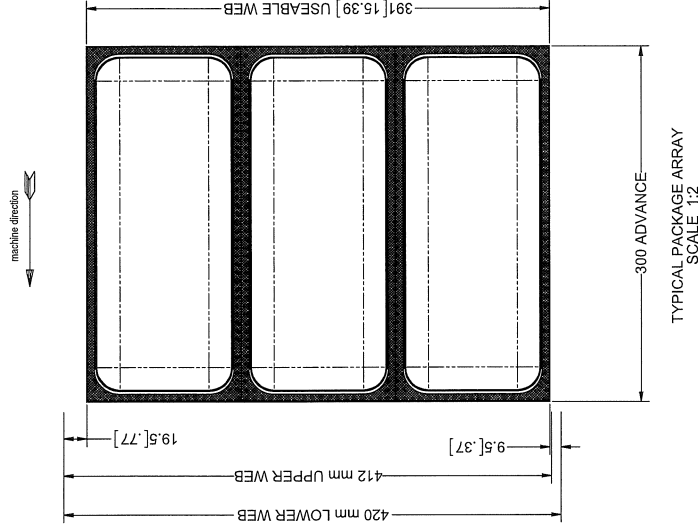
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**DATE:** 3.12.2014  
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**DATE:** 3.12.2014

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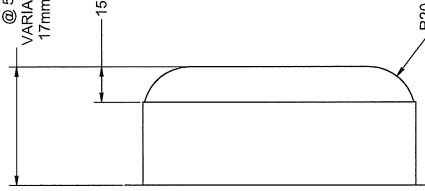




TYPICAL SINGLE PACKAGE  
TOP VIEW



SET DEPTH  
@ 50 [1.97]  
VARIABLE FROM  
17mm TO 70mm



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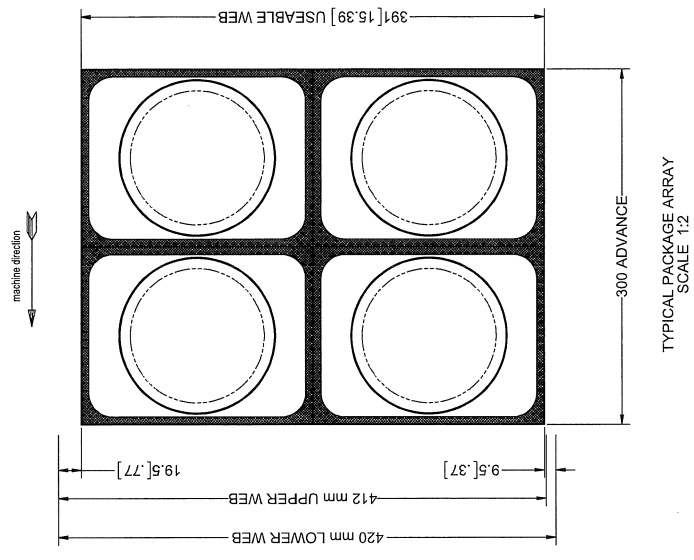
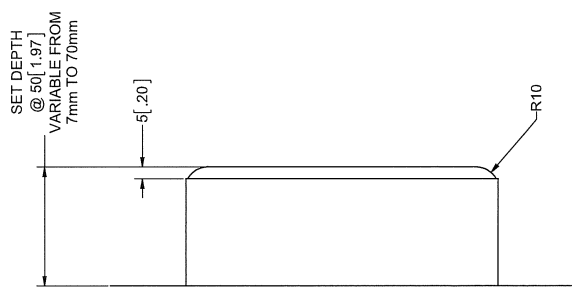
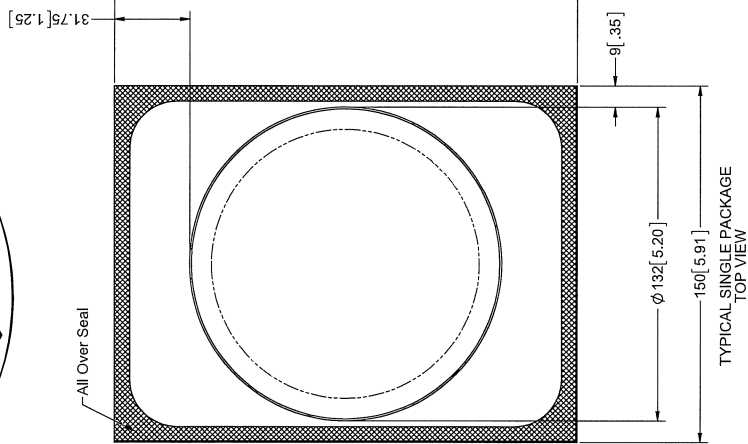
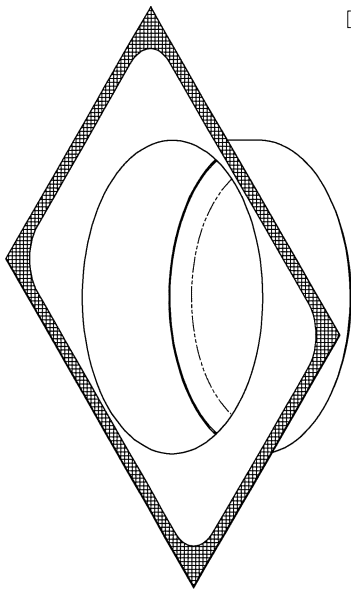
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SEALING NOTE: ALL OVER SEAL

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CREATED BY: kkeeper DATE: 3.12.2014  
CHANGED BY: kkeeper DATE: 3.12.2014

CHANGE NUMBER: D  
ANALYSIS SCALE: 1:1  
SHEET 1 OF 1

**MULTIVAC**  
MULTIVAC, INC.  
11021 N. POMONA AVENUE, KANSAS CITY, MO 64153  
TEL: 816-981-6555

CUSTOMER NAME: R-085 STOCK VARIO-DO NOT REVISE  
DRAWING NUMBER: 15000208140  
REV: 0



FILM WIDTH NOTE: Web thickness and exact composition must be known to determine proper web width for the application. Please provide the material with which you have provided these specifications and have received web width tolerances from us prior to ordering your materials.

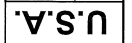
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MULTIVAC, INC. 11021 N. POMONA AVENUE, KANSAS CITY, MO 64153 TEL: 913-551-4050	DOCUMENT NUMBER:
REV: 0	

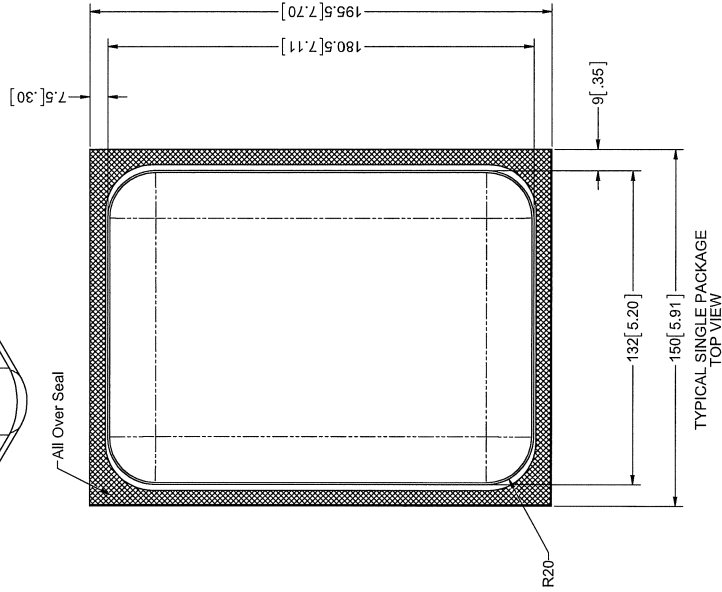
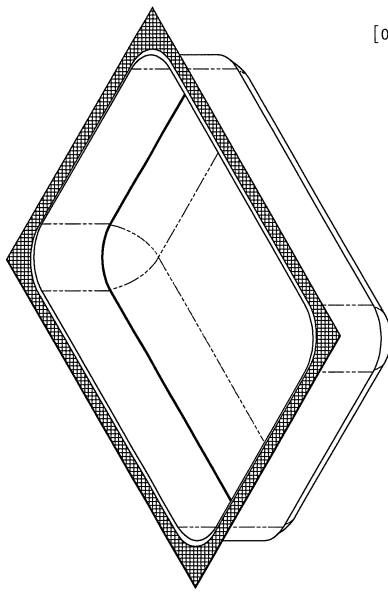
ALL DIMENSIONS ARE IN MILLIMETERS DUAL DIMENSIONS ARE IN INCHES	DATE: 1.6.2016
CREATED BY: kkeeper	DATE: 1.6.2016
CHANGED BY: kkeeper	

NOTE: PACKAGE DEPTH IS LIMITED BY MATERIAL FORMABILITY AND TOOLING CONSTRUCTION.  
SEALING NOTE: ALL OVER SEAL  
MULTIVAC HIGHLY RECOMMENDS PLUG ASSIST WHEN PACKAGE DEPTHS ARE GREATER THAN 60mm

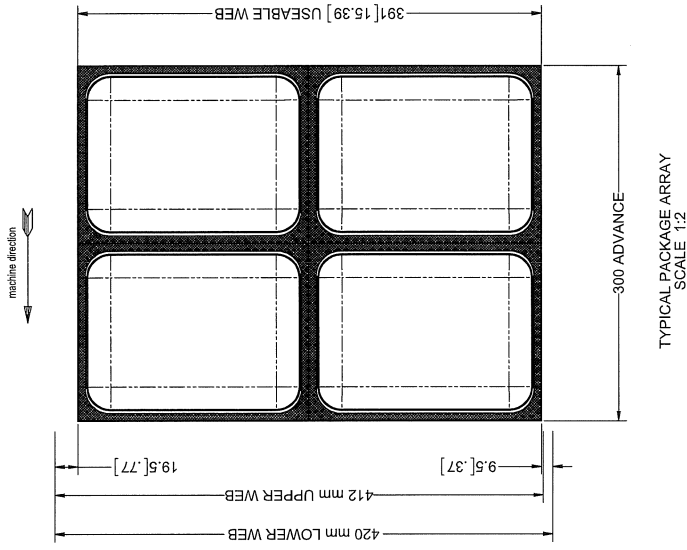
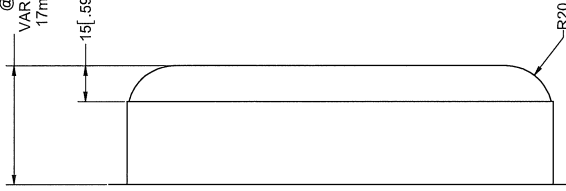
**PACKAGE DESIGN NOTES**  
SEAL: (SOLID) DESIGNED TO PROVIDE CONTACT SEAL ABOUT PERIMETER OF PACKAGE ONLY - SKIN PACK SMOOTH SEAL ON INTERIOR OF FLANGES

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SET DEPTH  
@ .50 [1.97]  
VARIABLE FROM  
17mm TO 70mm



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**PACKAGE DESIGN NOTES**  
NOTE: PACKAGE DEPTH IS LIMITED BY MATERIAL FORMABILITY AND TOOLING CONSTRUCTION.  
SEALING NOTE: ALL OVER SEAL

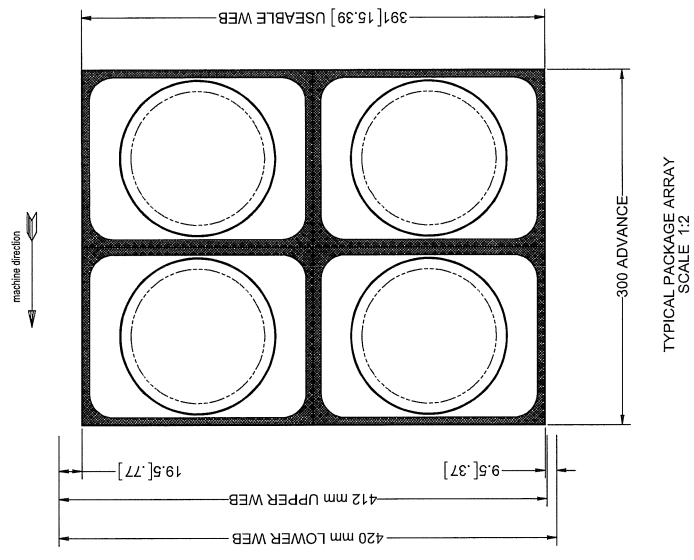
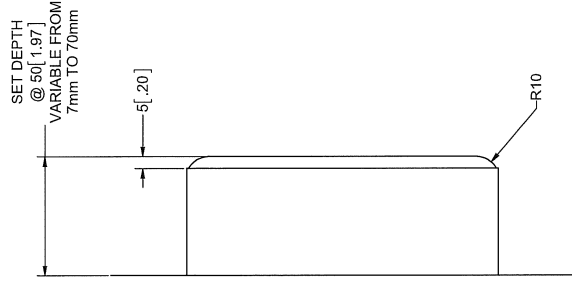
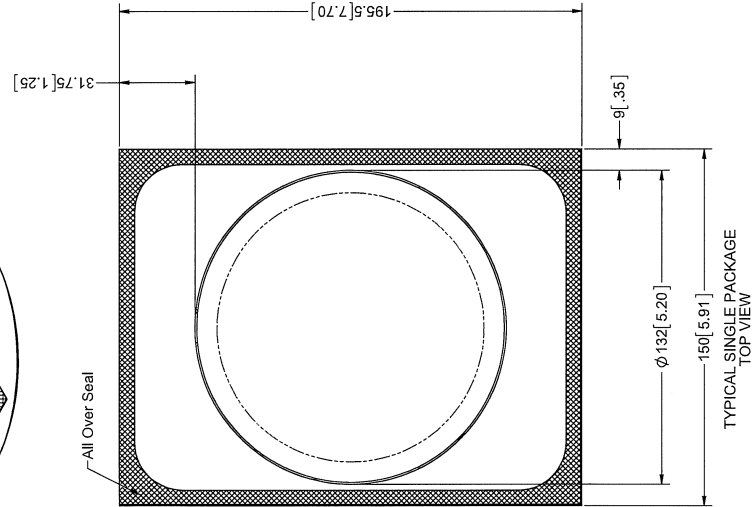
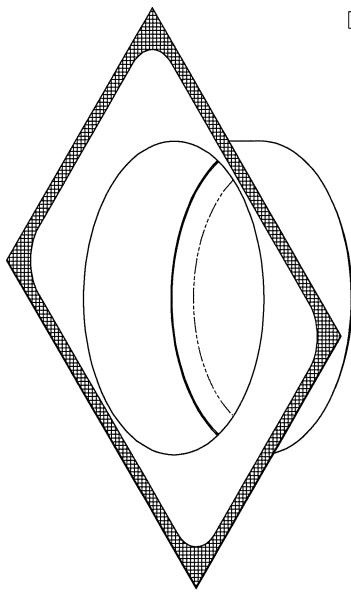
CREATED BY: kkeeper  
DATE: 3.12.2014  
CHANGED BY: kkeeper  
DATE: 3.12.2014

DESCRIPTION: 2T2R PACKAGE ARRAY

CHANGE NUMBER: D  
ANSI Z39.50 SCALE: 1:1  
SHEET 1 OF 1

CUSTOMER NAME: R-085 STOCK VARIO-DO NOT REVISE  
MULTIVAC, INC.  
11021 N. POMONA AVENUE, KANSAS CITY, MO 64153  
TEL: 816-871-0555

DOCUMENT NUMBER: 15000208143  
REV: 0



FILM WIDTH NOTE: Web thickness and exact composition must be known to determine proper web width for processing. The manufacturer must be consulted for the correct material with us or that you have provided these specifications and have received web width tolerances from us prior to ordering your materials.

CHANGE NUMBER		CHANGE DESCRIPTION	
D		1:1	
ANSI SIZE		SCALE	
SHEET 1		OF 1	
DOCUMENT NUMBER		15000244133	
REV.		0	
DESCRIPTION		2T2R PACKAGE ARRAY	

MULTIVAC, INC. 11021 N. POMONA AVENUE, KANSAS CITY, MO 64153 TEL: 913-551-4650	
CREATED BY:	kkeeper
DATE:	1.6.2016
CHANGED BY:	kkeeper
DATE:	1.6.2016

NOTE: PACKAGE DEPTH IS LIMITED BY MATERIAL FORMABILITY AND TOOLING CONSTRUCTION.  
SEALING NOTE: ALL OVER SEAL  
MULTIVAC HIGHLY RECOMMENDS PLUG ASSIST WHEN PACKAGE DEPTHS ARE GREATER THAN 60mm

PACKAGE DESIGN NOTES  
SEALING DESIGNED TO PROVIDE CONTACT SEAL ABOUT PERIMETER OF PACKAGE ONLY - SKIN PACK SMOOTH SEAL ON INTERIOR OF FLANGES

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The dimensions of the package blister are the inside dimensions of the forming mold. The inside dimensions of the blister are reduced due to film thickness and shrinkage properties of the package material.

