



POUCH MAKING SYSTEMS

Available in 610, 820 & 1020 mm widths



VALUE FOR TRUST



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Servo Driven Unwind Nip and Dancer



Made to

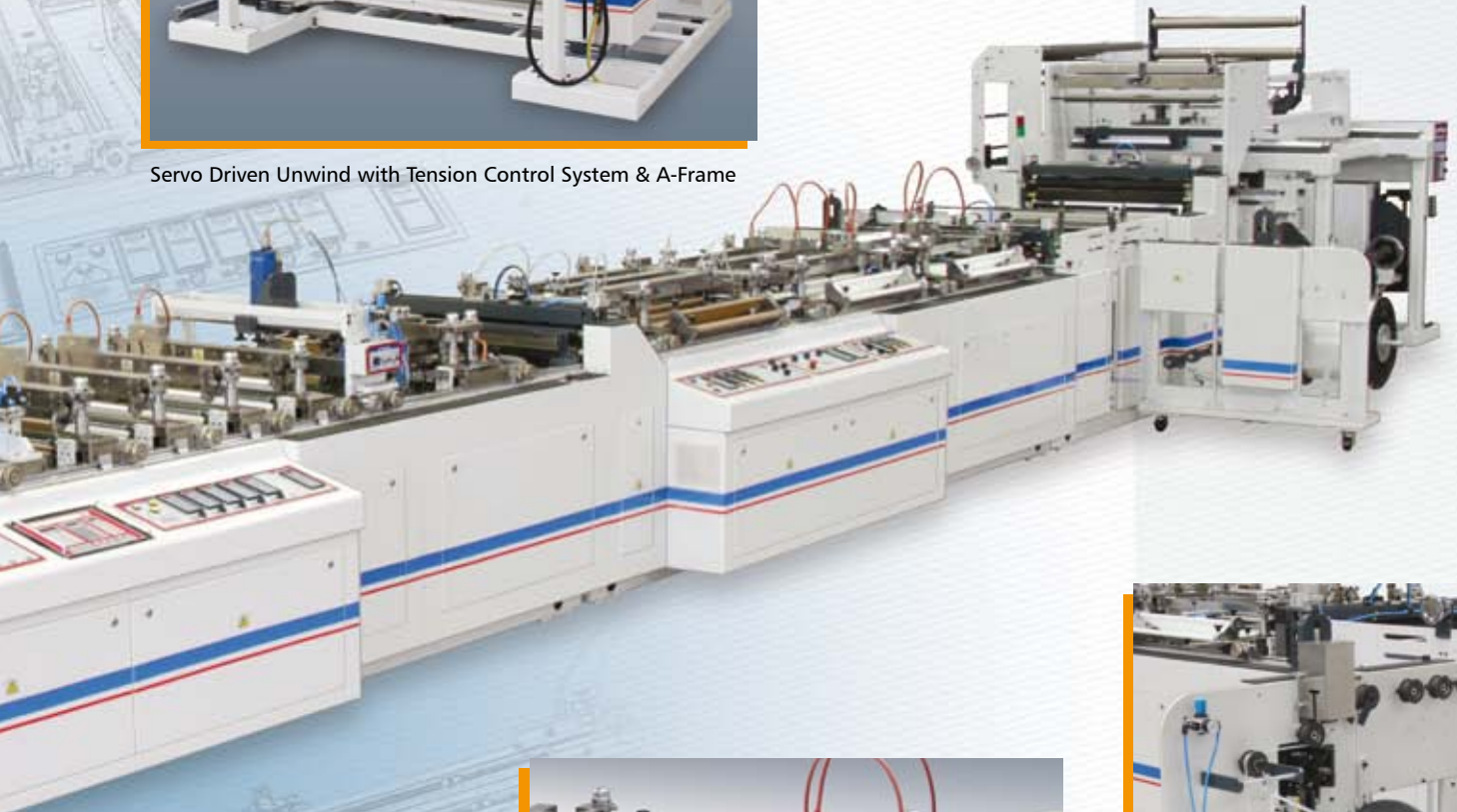
Transform

Transverse Seal Module





Servo Driven Unwind with Tension Control System & A-Frame



Zip Seal Module



Zip Insertion Unit


Long Seal & Cool Module





POUCH MAKING SYSTEMS

Available in 610, 820 & 1020 mm widths

 Our Vega^{Plus} pouch making system is uniquely engineered ALL SERVO very versatile and user-friendly system Pouch Making System, available in different configurations. Its modular design allows freedom to adapt to differing conversion needs and process Supported Films (Laminates) and Un-supported Co-Ex films with equal ease.

The machine applies servo technology to achieve and enhance processing advantages especially in two areas of tension control and real seal time control.

Available in processing widths of 610 mm (24"), 820 mm (32") and 1020 mm (40"), this is truly a robust, versatile and flexible system providing excellent value for money solution for converting needs.

Highlighting Features:

- Zone wise Tension control with Precision and consistency
- All servo Unique Sealing system
- Unique zipper sealing system
- Intelligent User Friendly Control system
- Processability of wide variety of Pouch styles on single platform

Let us look at these features in detail...

Unique Sealing System :

The design of the Sealing Station plays the most important Role to process any pouch from a Supported (Laminated) or an Un-supported Co-Ex Structure. What differentiates Mamata pouch systems is its sealing mechanism, which incorporates excellent sealing pressure and sealing time control resulting in very consistent and high output at great efficiency.

In other systems, sealing pressure is conventionally achieved by good pneumatic or hydraulic controls, which relies on pressures and other conditions of air. Mamata's VegaPlus pouch system eliminates such reliance and uses an unconventional software application for Servo which drives the sealing head and generates sealing pressure. The software enables system to be very consistent and precise on sealing pressure control.

Sealing time control includes precision timing software through microcontroller. The timers have 1 mil. Sec. precision. All sealing bars and bases are equipped with PID auto tuning type temp. Controllers. All control settings are memorized for future use.

Vega Plus Pouch systems can be set up at as low as 10% speed and then switched to 100% speed. This is possible due to this unique sealing system we offer.

To facilitate mounting of wide variety of sealing modules we offer, we can configure our sealing attachment zones in different lengths.

Our multipurpose sealing modules are available in different configurations to do longitudinal seals, zipper seals and Transverse seals. Talk to our team today for more details on the same. All Multipurpose Sealing modules are facilitated with easy changeover of seal bars and seal tools. All Seal bars have replaceable sealing tools for ease of processing different seal widths with choice of Metal tool OR Si-Rubber.

Unique Zip Sealing System :

We have designed an innovative process of sealing zippers. The system consists of servo driven zip sealing mechanism with digital control. All what is required is to program zip sealing thickness and system is ready to seal Zipper on pouch.

Mamata's zip sealing system is the only system known for sealing zip without flange separators. Unlike most of the systems available in the market, NO FLANGE SEPARATORS ARE REQUIRED.

Our zipper systems are benchmarked with zippers from suppliers like Zip-pak, Presto, SVP, LPS, etc. For other supplier's zipper processing, talk to us today!

Zone Wise Tension Control with Precision and Consistency

Effective and efficient web tension control and precise edge control is a prime need for better quality and consistent output. Vega Plus pouch system has an option of up to four independent tension control zones.

These zones include unwinding and forming, Unwind Nip, dancer & Insertion area for zippers and Gussets, Sealing in line with web and sealing across the web. All these zones are equipped with independent servo tension controls. Let us look at each Zone in detail.

Zone-1 : First tension control zone deals with Continuous web section of Vega Plus pouch making system. SERVO DRIVEN UNWINDER feeds film in to this first tension control zone. This zone controls tension between Unwinder and Nip. Two options available are rotary pneumatically tension control and Servo Tension Control System.

This tension zone is very useful specially while running Un-supported Co-Ex Films or making Self-in Bottom gusseted Pouches or Side gusseted Pouches as all the forming for these pouches takes place in this section.

Zone-2 : From Unwind nip roll to Secondary Index roll of Long seal section is second zone of tension control system. The web from here on is indexed for registration and sealing purpose. This process has an added dynamic effect on web due to indexing accelerations and decelerations. A uniquely configured tension control system absorbs shocks due to accelerations and decelerations of web due to Index and same dancer also imparts digitally set tension required for processing.

The tension control in this zone is also very important as insertion of zippers or Bottom / side gussets takes place in this zone.

We also offer option of Pneumatic Tension Controlled Pivoted Dancer if applications are limited to three side seal pouches. This dancer configuration is with 3 loop pivoted dancer and is pneumatically tensioned with adjustable Pressure.

Zone-3 : It has front and back Driven Nips, where secondary Index Nip (tail feed) is mechanically linked to the front servo driven Index Nip. This is the section where long sealing/cooling module and zip seal module with 610 (24") long bars for sealing in line of web direction are mounted. You have choice to add this section at a later date.

As the seal is performed in machine direction, it requires different tension values and this zone achieves tension control on web in this zone through air pressure control on rear nip and Servo driven Index Nip in front.

Zone-4 : In this zone, the sealing is done across the web and requires different tension values. Many attachments accessories are also mounted in this zone and needs good tension control to process pouches with ease using these attachments. In this zone, with primary and Secondary Servo driven Nips, web is fed smoothly with required tension in to the sealing area. This minimizes stretch or shrinks while sealing across the web, which is crucial for Un-supported Structures including PE films.

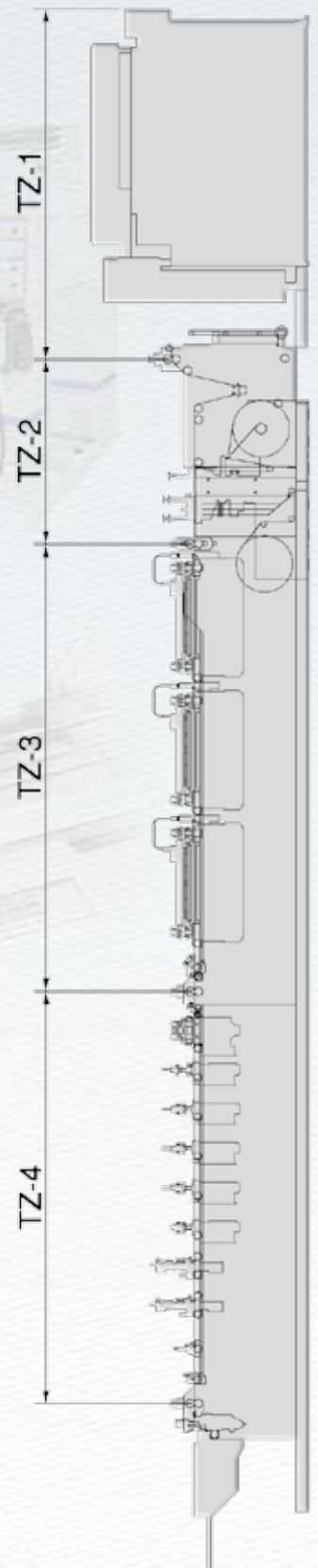
Intelligent User Friendly Control system

Key features of the control system are:

- Tailor made to suit the applications for the Pouch Making system.
- Respective Controls located near system element for ease of setting up. All controls are ergonomically laid out and fully digital.
- Operator console is designed truly to be operator friendly.
- All functions are a key stroke selection with clear description of what the key stands for. This is the necessity today to reduce burden of having very skilled operator for setting variety of jobs.
- TRUE MEMORY allows system to remember what settings are done for a typical job. Operator is not required to repeat most of the settings like draw size, draw speed, bags/batch, temperature (PID temperature control), dwell time, attachment time etc. including their respective status (ON or OFF) and values of parameters.
- Up to 100 Jobs can be memorized.

Option of Fully computerized "Supervisory Control and Production Management System" is also available. This system has,

- Touch Screen Panel
- Network Connectivity for direct access from your System
- Capability to add your equipment to your VPN.
- Full production Data Logging and Monitoring
- Full function control from one point





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Processability of wide Variety of Pouch Styles on Single Platform :

We offer a wide variety of Pouch Processing capability on Vegaplush Pouch Machine systems. It can process several varieties of three side seal pouches or press to close zipper and stand up pouches or side gusseted quad seal, fin seal or lap seal pouches from single or multiple webs.

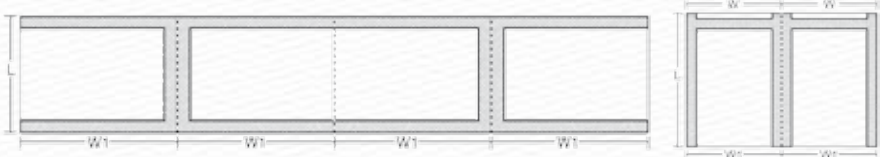
With Unwinds to insert separate Bottom or side gusset films, it can do Registered Bottom Gussets or Side Gussets for a stand-up Pouch or a quad seal Pouch. We offer registration control for up to 4 separate Webs.

With the adjustable Double cut facility, it would also run notch-less Rounded corner retort Pouches as well as full Bleed Pouches with adjustable size of double cut slit straight from the Control Panel. No mechanical hassles involved

Take a look at some of the standard Pouch Configurations and specifications. For more varieties, talk to us today!

A. Three Side Seal Pouches

Supported & Unsupported Films



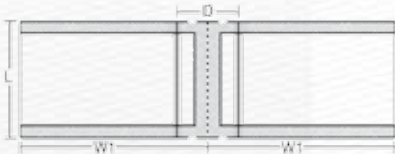
Pouch Dimensions mm (inch)	Minimum	Maximum	
		48" Unwinder	60" Unwinder
Pouch Depth (W1) x No. of Lanes	100 (4")***	610 (24")	760 (30") *
Pouch Width (L)	50 (2")	610 (24") OR 410 (16") #	
Pouch Width with skip (L)	100 (4")	1220 (48") OR 820 (32") #	

* Applicable to pouches made from one web and should be less than PW - Processing width. For pouches made from two webs, this dimension should also be less than smaller of max. web width that can be accommodated on the two Unwinders.

*** Minimum 2 (two) lane processing required. # Maximum limited by long sealing module size.

B. One or Two up Zipper Pouches

Supported & Unsupported Films



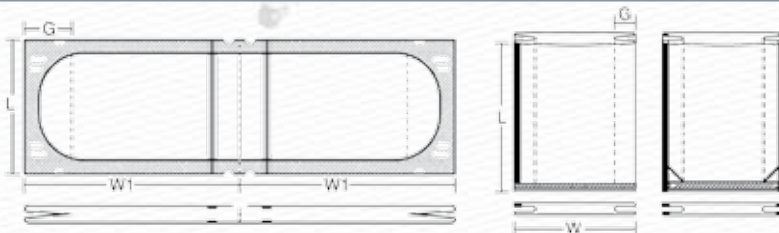
Pouch Dimensions mm (inch)	Minimum	Maximum	
		48" Unwinder	60" Unwinder
Pouch Depth (W1) x No. of Lanes	100 (4")***	610 (24")	760 (30") *
Pouch Width (L)	50 (2")	610 (24") OR 410 (16") #	
Pouch Width with skip (L)	100 (4")	1220 (48") OR 820 (32") #	
Distance Between Zips (D)	60 (2.5")	PW - 60 mm	

* Applicable to pouches made from one web and should be less than PW - Processing width. For pouches made from two webs, this dimension should also be less than smaller of max. web width that can be accommodated on the two Unwinders.

*** Minimum 2 (two) lane processing required. # Maximum limited by long sealing module size.

C1. Two up Stand-up or One up Side Gusseted Pouches

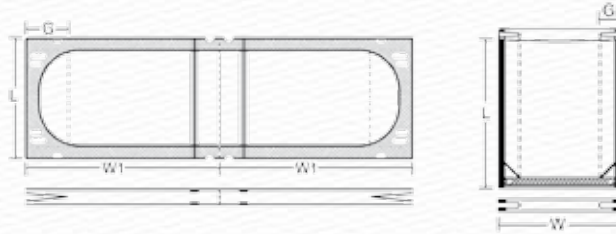
(From Single Web)



Pouch Dimensions mm (inch)	Two up stand up Pouch		
	Minimum	Maximum	
		48" Unwinder	60" Unwinder
Pouch Depth with min. Gusset (W1)	100 (4")	250 (10")*	320 (12.5")*
Pouch Depth with max. Gusset (W1)	100 (4")	155 (6")*	230 (9")*
		Five / One side seal side gusseted Pouch	
Pouch Width with min. Gusset (W)	200 (8")	505 (20")**	610 (24")**
Pouch Width with min. Gusset (W)	200 (8")	310 (12")**	460 (18")**
Pouch Width (L)	50 (2")	610 (24") OR 410 (16") #	
Pouch Width with skip (L)	100 (4")	1220 (48") OR 820 (32") #	
Gusset Depth (G)	30 (1.25")	90 (3.6")	

* Must be less than half of PW (Processing Width). Also $W1 < \text{Quarter of } WW^* - 1.5 \times (G+t)$. For 1 up, double these sizes or PW, which ever is lower. 't' is trim allowance. ** Must be less than. Also $W < \text{Half of } WW^* - 3 \times (G+t)$.

WW is Web width of machine. # Maximum limited by long sealing module size.



C2. Two up Stand-up or One up Side Gusseted Pouches

(Separate Gusset insert)

Pouch Dimensions mm (inch)	Minimum	Maximum	
		48" Unwinder	60" Unwinder
Pouch Depth one up (W1)	200 (8")	610 (24")*	760 (30")*
Pouch Depth two up (W1)	100 (4")	305 (12")*	375 (15")*
Five / One side seal Pouch			
Pouch Depth (W)	200 (8")	610 (24")*	760 (30")*
Dimension (L)	50 (2")	610 (24") OR 410 (16") #	
Pouch Depth with skip (L)	100 (4")	1220 (48") OR 820 (32") #	
Gusset Depth (G)	30 (1.25")	90 (3.6")	

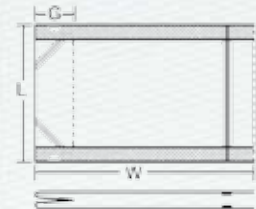
* Applicable to pouches made from one web and should be less than PW - Processing width For pouches made from two webs, this dimension should also be less than smaller of max. web width that can be accommodated on the two Unwinders. # Maximum limited by long sealing module size.

Pouch Dimensions mm (inch)	Minimum	Maximum	
		48" Unwinder	60" Unwinder
Pouch Depth with min. Gusset (W)	200 (8")	575 (22.5")*	725 (28.5")*
Pouch Depth with max. Gusset (W)	250 (10")	510 (20")*	660 (26")*
Pouch Width (L)	50 (2")	610 (24") OR 410 (16") #	
Gusset Depth (G)	30 (1.25")	90 (3.6")	

* Must be Less than PW and (Half of WW - (G + t)). 't' is trim allowance.
Maximum limited by long sealing module size.

D. One up Self-in Gusset Stand-up pouches

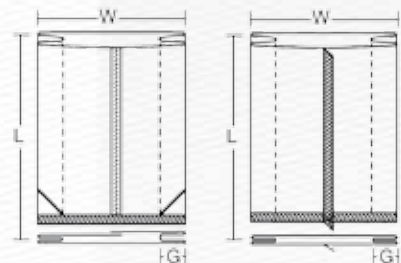
'K' or Round Bottom with Shape Sealer



Pouch Dimensions mm (inch)	Minimum	Maximum	
		48" Unwinder	60" Unwinder
Pouch Width with min. Gusset (W)	200 (8")	350 (14")**	440 (17")**
Pouch Width with max. Gusset (W)	200 (8")	220 (8.5")**	320 (12")**
Pouch Depth (L)	100 (4")	610 (24") OR 410 (16") #	
Pouch Depth with skip (L)	200 (8")	1220 (48") OR 820 (32") #	
Gusset Depth (G)	30 (1.25")	90 (3.6")*	

* Higher gusset sizes available on request.
** Size with 10 mm fin. Pouch width W should be less than (one third of WW* - 2 x G - F).
Maximum limited by long sealing module size.

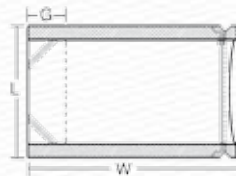
E. Center Lap / Fin Sealed pouches



Scope of supply for this provision includes :

- Separate Control Module in Zip Seal area
- Software and hardware provisions
- Pl. Refer Pouch type 'D' for pouch sizes that can be processed.

Note : This is provision in our system for attaching other Slider Zip system manufacturers' attachment

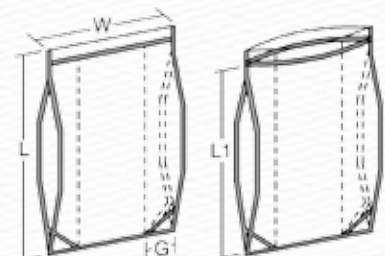


F. Provision for Slider Zipper Pouches

Pouch Dimensions mm (inch)	Minimum	Maximum	
		48" Unwinder	60" Unwinder
Pouch Width (W)	150 (6")	610 (24")*	610 (24")*
Pouch Length (L)	200 (8")	PW	
Gusset Length (L1)	150 (6")	PW-50 (2")	
Gusset Depth (G)	30 (1.25")	90 (3.6")	

* limited by long sealing module size.
PW - Processing width

G. Side Gusseted Pouch with Zipper (SGZ)



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Specifications:

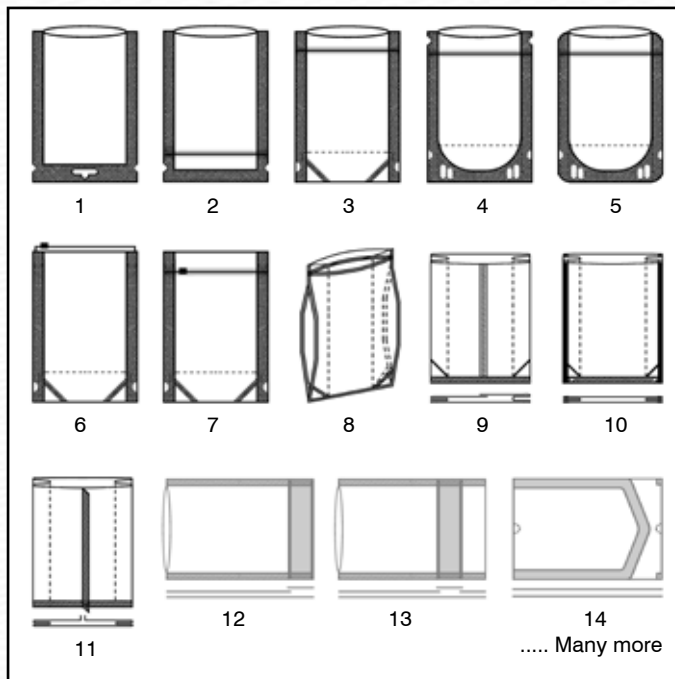
Pouch Type	A		B, C1, C2, D, F, G		E	
Films Processed	Minimum	Maximum	Minimum	Maximum	Minimum	Maximum
Laminates of Polyester, BOPP, CPP	40	200	40	200	30	125
Co-ex. Films based on Nylon, EVOH, LD/LLD etc.	50	200	75	200	-	-
BOPP	30	100	30	100	30	100
Other films that can be processed include structures of Alu. Foil, Coated Paper, Tyvek® etc. #						
Sizes Processed (Unwinders) (mm)	Maximum			Minimum		
Web Width (WW) with 60" Unwinder	1520 (60")			410 (16")##		
Web Width (WW) with 48" Unwinder	1220 (48")			410 (16")##		
Vega ^{Plus} Pouch System (mm)						
Processing Width (PW) For Vega ^{Plus} 610	610 (24")**			210 (8")**		
Processing Width (PW) For Vega ^{Plus} 820	820 (32")**			250 (10")**		
Processing Width (PW) For Vega ^{Plus} 1020	1020 (40")**			300 (12")**		
Off-wind Reel Diameter	1000 mm (40") or Upto 700 Kg. (1500 Lbs)					
General Data	Vega ^{Plus} 610	Vega ^{Plus} 820	Vega ^{Plus} 1020			
Maximum Cycling Rate *	210	210	210			
Max. Line Speed (Mtr / Min) *	50	50	50			
Electrical Power	220/240/380/415/480 VAC +/- 6 % 50/60 Hz					
Total Connected Load	35 KVA	35 KVA	35 KVA			
Air Consumption @ NTP (Ltr. / Minute)	1000	1100	1200			
Machine Weight (MT)	~ 6.5	~ 7.0	~ 8.5			

PW - Processing width. • WW - Web width. ** Refer Detailed Specifications for pouch types. * Above specifications are for basic machine only.

Some structures of film may not be suitable for processing all types of Pouches. We need to take process trials in such cases. Please consult us for other film types. Tyvek® is registered trademark of DuPont™.

Please choose the Pouch type you wish to make and add attachments / accessories from following list.

- 1520 mm (60") Servo driven Unwind (for 610 mm (24") wide Machines)
- Additional Unwinds to run separate top and Bottom Webs
- Multipurpose seal Module 1 for Pre-seal, K seal, Cross seal etc. (1 or 2 stations)
- Multipurpose seal Module 2 with 100 mm Platen
- Multipurpose seal Module 3 with 50 x 410 mm or 100 x 410 mm Platens
- Extra Rubber Base or top for seal bars
- Additional seal tools for Long seal / transverse seal Module
- Additional zip seal tools
- Additional shape seal tools for Stand-up Pouches
- Punches
 - "V" Notch Punch
 - Round Hole Punch
 - Rounded Corner Punches (half cut and full cut)
 - Euro Hole (Mexican Hat) Punch
 - Tear Slit Punch
 - Carry Handle Punch
 - "V" Cut Punch for Flap
- Double Cut Capability for Notch-less rounded corners or Full Bleed Printed pouches
- Dual Auto stacker
- System for Header Pouches
- System for Chevron Pouches
- Ultrasonic Zip Crushing System for 1-up or 2-up
- Customer's Special Requirements



Photographs may show attachments or accessories, which may not be part of the standard scope of supply.

The company reserves the right to modify, alter, change or substitute any feature & specifications which are subject to change without notice.

India Office & Works :

MAMATA
MACHINERY
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Survey No. 423/P, Sarkhej - Bavla Highway, Moraiya,
Tal.: Sanand, Dist.: Ahmedabad - 382 213, INDIA.
Phone: +91 2717 300700 • E-mail : sales@mamata.com
Website: www.mamata.com

USA Office :

MAMATA
ENTERPRISES, INC.

2275, Cornell Ave., Montgomery, IL-60538, USA.
Phone : +1 630 801 2320 • Fax : +1 630 801 2322
E-mail : info@mamatausa.com
Website : www.mamatausa.com