HTF 940 / HTF 1270
The facts.

<table>
<thead>
<tr>
<th></th>
<th>HTF 940</th>
<th>HTF 1270</th>
</tr>
</thead>
<tbody>
<tr>
<td>Speed max.</td>
<td>12'000 strokes/hour</td>
<td>12'000 strokes/hour</td>
</tr>
<tr>
<td>Cardboard min.</td>
<td>180 gsm</td>
<td>180 gsm</td>
</tr>
<tr>
<td>Cardboard max.</td>
<td>600 gsm</td>
<td>600 gsm</td>
</tr>
<tr>
<td>Corrugated board</td>
<td>E/F/N</td>
<td>E/F/N</td>
</tr>
<tr>
<td>Size of blanks min.</td>
<td>100 x 100 mm</td>
<td>100 x 100 mm</td>
</tr>
<tr>
<td></td>
<td>3.9&quot; x 3.9&quot;</td>
<td>3.9&quot; x 3.9&quot;</td>
</tr>
<tr>
<td>Size of blanks max.</td>
<td>940 x 500 mm</td>
<td>1270 x 500 mm</td>
</tr>
<tr>
<td>1 stream operation</td>
<td>37.0&quot; x 19.7&quot;</td>
<td>50.0&quot; x 19.7&quot;</td>
</tr>
<tr>
<td>2 stream operation</td>
<td>420 x 500 mm</td>
<td>590 x 500 mm</td>
</tr>
<tr>
<td>3 stream operation</td>
<td>250 x 500 mm</td>
<td>360 x 500 mm</td>
</tr>
<tr>
<td>4 stream operation</td>
<td>-</td>
<td>250 x 500 mm</td>
</tr>
<tr>
<td>Tray depth min.</td>
<td>approx. 15 mm</td>
<td>approx. 15 mm</td>
</tr>
<tr>
<td></td>
<td>approx. 0.6&quot;</td>
<td>approx. 0.6&quot;</td>
</tr>
<tr>
<td>Tray depth max.</td>
<td>approx. 320 mm</td>
<td>approx. 320 mm</td>
</tr>
<tr>
<td></td>
<td>approx. 12.6&quot;</td>
<td>approx. 12.6&quot;</td>
</tr>
<tr>
<td>Tray side angle</td>
<td>5° - 50°</td>
<td>5° - 50°</td>
</tr>
</tbody>
</table>

**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)

**Floor space**
- HTF 940: approx. 4.20 x 1.50 m
- HTF 940 with flanging station: approx. 6.03 x 1.50 m
- HTF 1270: approx. 4.20 x 1.80 m

**Height**
- HTF 940/1270 with gluing unit by soft pads: approx. 1.60 m / approx. 5.3'
- HTF 940/1270 with gluing unit by spray nozzles: approx. 2.10 m / approx. 6.9'

**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

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Member of the Arbeitskreis Prägfoliendruck e.V. Germany / FSEA Foil & Specialty Effects Association, USA / ECMA European Carton Makers Association, Holland / FFI Fachverband Faltschachtel-Industrie e.V., Germany / FNAT Fédération Internationale des fabricants et transformateurs d’Adhésifs et Thermocollants sur papiers et autres supports, Netherlands

HTF 940 / HTF 1270
Tray Forming at its best.
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. Modular machine configuration
   Even if the machine is originally equipped for one stream 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 fixed forming station is available with the corresponding forming dies. In just a few steps, these fixed forming stations can be fitted to the machine, which dramatically reduces the make-ready times. All fixed forming stations are set, tested and adjusted upfront at Gietz.

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 optimal 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 has manufactured 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 setup. The horizontal delivery of the completed trays simplifies the removal of erected trays at optimal height and with a minimum number of operators.

Fixed forming stations
Fixed 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.