



**KRONES** Variocol  
Carton lid sealer

# Precise and secure sealing

The Variocol carton sealer glues full cartons with hotmelt securely, precisely, and fully automatically. This machine is used in combination with the carton erectors and packing systems. It seals up to 60 packs/min, and with its double-lane design up to 120 packs/min. The continuous production process enables gentle carton processing. The machine can be changed over in a very short

time, since container handling parts do not have to be exchanged. All adjustments can be read as reference displays, and therefore can be easily reproduced.

#### System advantages:

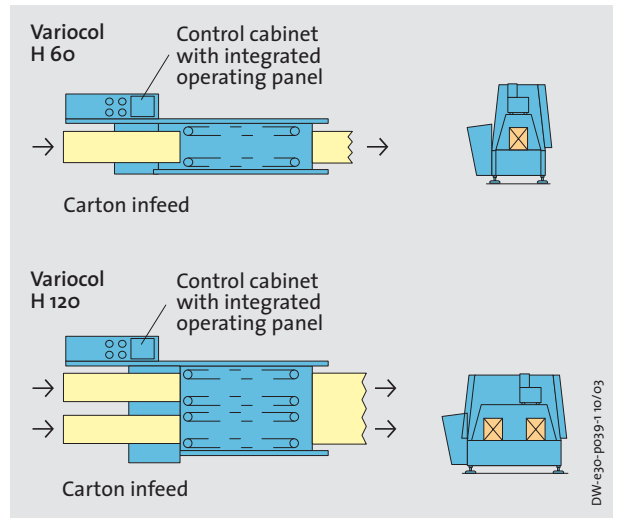
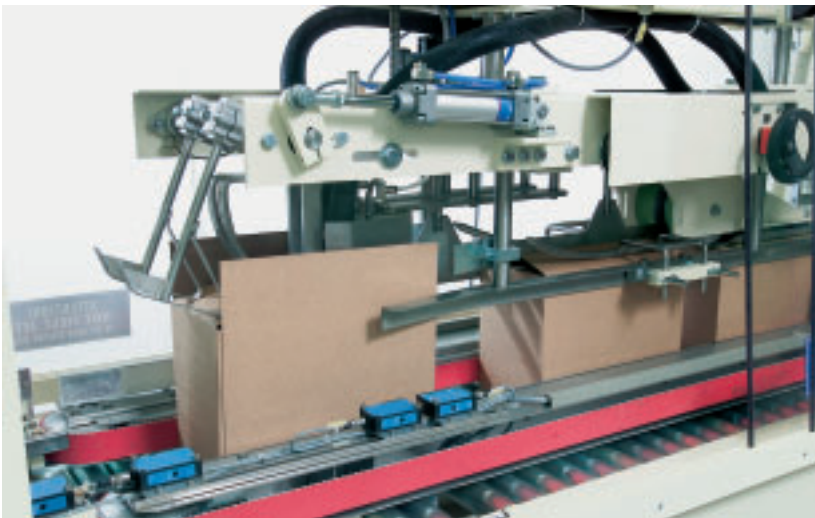
- Well-arranged machine setup
- Ease of access
- High operating convenience
- Short changeover times
- Low-noise and product-gentle material flow



# Principle of operation

The open cartons are first accumulated in front of the machine infeed via a driven belt conveyor. Then, they pass through the machine on a roller conveyor, where they are moved by lateral and synchronously circulating belts, which are driven by frequency-controlled motors. The front stop-end flap is folded with a fixed holder, the back stop-end flap is folded by a pneumatically actuated device.

The folded flaps are sprayed with hotmelt. Then, the lateral flaps are folded with fixed holders, and glued together with the front stop-end flaps.



In the press-on area, the carton is guided by another driven belt conveyor from top. Spring-supported press-on plates press the belt conveyor against the cartons for compensating carton height tolerances.

*The front stop-end flaps and lateral flaps are automatically folded and glued (top picture).*

*After gluing, the flaps are pressed on (bottom picture).*

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	Output	Carton dimensions			
	Pack/min.	Length (mm)	Width (mm)	Height (mm)	Flap length (mm)
Variocol H 60	60	200 – 500 (one lane)	120 – 400	100 – 380	40 – 200
Variocol H 120	120	200 – 500 (two lanes)	120 – 300	100 – 380	40 – 200

H: Hotmelt

## Design features:

- Continuously operating machine
- Sealing head for long flaps
- Use of Nordson hotmelt units
- Intelligent frequency converter system with operating field
- Free passage of plastic crates and trays
- Guarding with sliding doors on both sides

## Additional equipment:

- Sealing head for short flaps
- Programmable logic control Siemens S7 with touch-screen user interface
- Automatic format changeover – only in combination with PLC
- Guarding with lift door at the operator side
- Central lubrication system

## Service

Our worldwide network of sales and service offices provides optimum support even after the start-up of your line. Our modern storage system allows us to supply spare parts immediately if required. Our qualified service engineers ensure fast and reliable machine maintenance and service.