

Food packaging is increasingly being produced using multiple moulds and stack moulds.

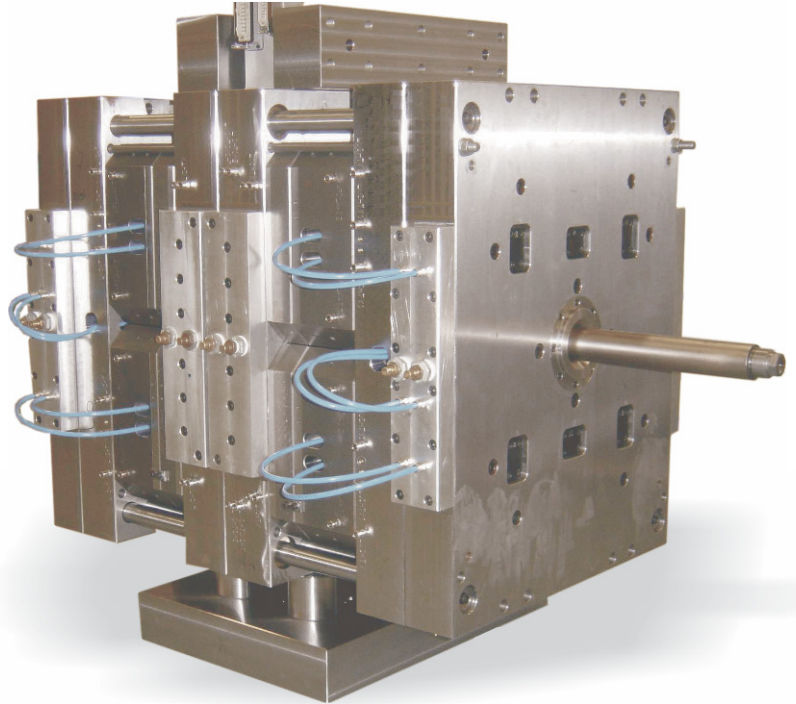
Van den Brink is specialized in the manufacture of these moulds.

The manufacture of stack moulds, in particular, requires a great deal of experience in and understanding of the art of injection moulding.

- An important factor is the construction. If the mould is designed correctly, its lifespan will be no less than that of a single mould. The correct heat regulation plays a very important role in determining how reliable production is.
- A second determining factor for a good stack mould is the precision with which the components are made and assembled.
- Stack moulds are customized, not ready-made, because the mould is adapted to suit the injection moulding machine.
- The gate plays an important role. The leak-tightness and balance in the gates are essential.



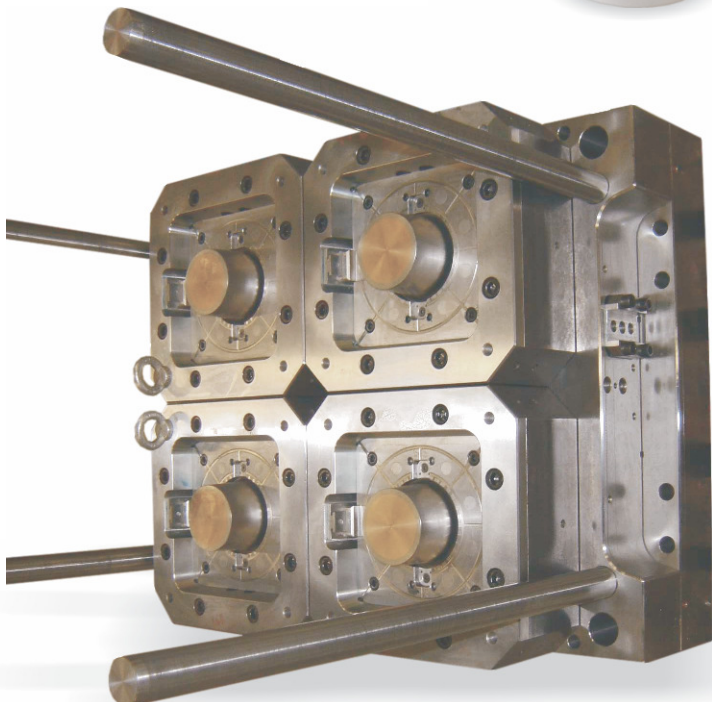
Stack moulds: "Every injection gives a double production"



A 4 + 4 stack mould for 500 cc tubs.
To the right is the gate (snorkel).
The middle piece slides on the injection moulding machine.

The need for peripheral equipment arises when using stack moulds in a production process. Van den Brink offers the following:

- Automation: Removal devices, closing (the valve), stacking and buffering.
- 1ML system: Flat labels, folding labels and wrap-around labels.
- Turnkey projects: Many of our deliveries concern turnkey projects. The entire production system is then delivered ready for use.



The fixed part of the same stack mould.

Theory <--> practice

Stack moulds work according to the theory that the same closing force can be used for two stacked moulds.
The result is twice as much production. In practice, 5-10% more closing force is necessary. The cycle time will also be slightly longer than for a standard mould.
Nevertheless, a stack production line can be very profitable.

Stack moulds



8 + 8 stack mould for lids.



1 + 1 stack mould for foldable boxes, including the closing mechanism.



4 + 4 stack mould for lids.



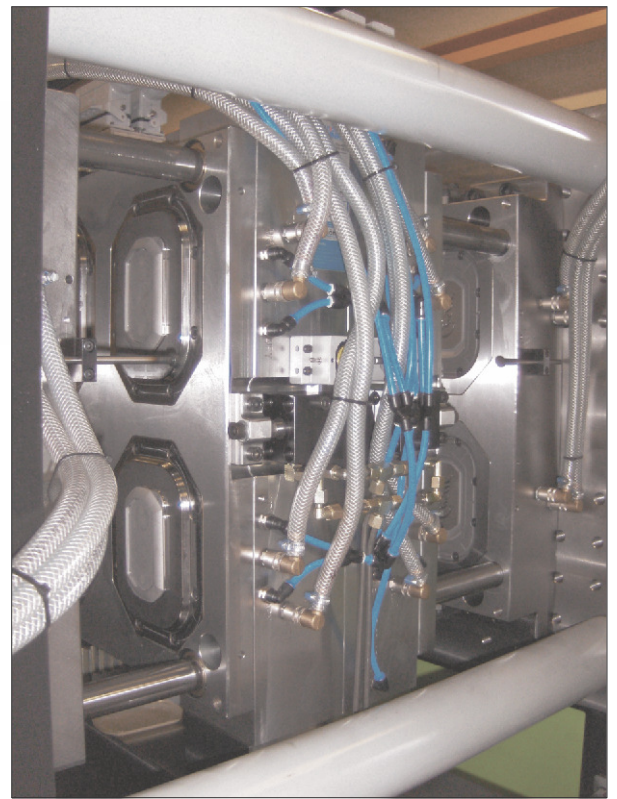
4 + 4 stack mould for tubs.



4 + 4 stack mould for containers.



6 + 6 stack mould for frames, including IML and closing.



A 4 + 4 stack mould for lids.

Both the machine plate and the middle piece of the mould have their own guide mechanism on the machine.



Stack mould automation. In this case, a side robot with a double y-axis. When stacking, the mould impression numbers are not all mixed together but are separated into each type.

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Detailed view.

The product has a relief print and is not labelled.