

# PMB's HSO

## HIGH SPEED CIGAR ROLLING MACHINE

For over 50 years the speed of cigar overrolling machines for natural wrapper has been limited, mainly because the wrapper die-cutting was performed by an operator at the machine, at approximately 20 per minute.

The introduction of systems using bobbins with die-cut wrappers opened the gates for the development of fully automatic cigar overrolling machines.

This development started with the introduction of so-called BUD's (bobbin unwinding devices) and speed-up kits for the conventional cigar rolling machines. The machines that are automated in this way can produce approx. 50% more, which is already quite an achievement for a conventional cigar machine.

For mass-production, however, the automation with BUD's was only a half-way measure. Therefore PMB designed its high speed cigar overrolling machine, type HSO-Nt.200, with an output of approx. 200 products per minute.

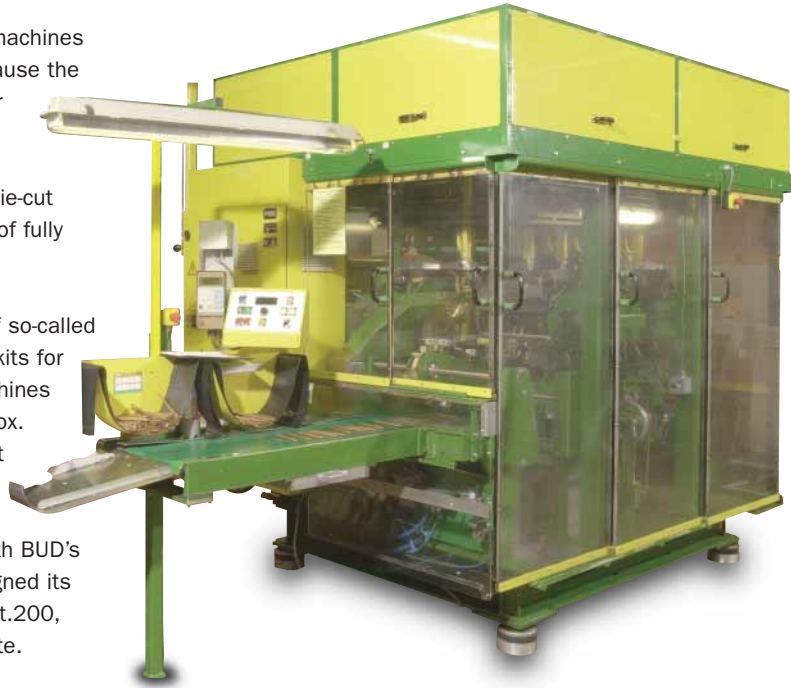
The machine can be equipped for most current cigar shapes. Perfecto shapes have to be wrapped in single lengths, cigarillo some coronas and most other shapes in double lengths.

The bunches are fed into the HSO with the well-known PMB hopper feeder, type JL-200.

Bobbins can hold approx. 8.000-10.000 die cut wrappers, depending on their size and shape. Whilst unwinding, the position of the die cut wrappers on the bobbin carrier material is scanned by photoelectric eyes. Unwinding speed and axial adjustment of the bobbin is automatically and continuously governed.

Bobbins are automatically exchanged. During normal operation a new filled bobbin can be put in advance on the second reel carrier.

As soon as the first bobbin is emptied, the machine will hold and automatically switch to the second bobbin, and so on.



Each wrapper leaf carrier is cleaned by means of a rotating brush, immediately before a new wrapper is picked up from the bobbin unwinder.

For cigarrolling the HSO-Nt. 200 uses 13 rolling devices. Each rolling device has its own needle arrangement to bring a wrapper down from one of the 13 leaf carriers that run synchronous. In this way the rolling of the cigar is performed with the same rolling speed as it is done in a conventional MID or MIL cigar machine, assuring the same high standard of cigar finishing.

After rolling, the cigar ends are knurled and, if required, also trimmed. For double length products cutting may be performed at both ends. A middle-cut device can (optionally) be fitted as well.

All vital movements and situations in the machine are electronically checked. Built-in controls are for instance that no bunch will be fed if the relative wrapper is missing.

**Specialists in machinery and equipment for the cigar industry**



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## TECHNICAL DATA PMB'S HSO



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Machine speed:	stepless adjustable up to approx. 200 r.p.m.
Realistic production:	approx. 9.600 products per hour (single or double lengths, depending on shape).
Machine dimensions:	506x218x256 cm
Machine weight:	net approx. 5.000 kg.
Power consumption:	17 kVA, excl. of energy for compressed air).
Required compressed air:	approx. 100-120 ltr./min. at 6 bar.
Main drive motor:	3,8 kW.
Two fan motors:	each 3 kW.
Product range:	min.-max. bunch diameter: 8 - 18 mm. min.-max. bunch length: 100 - 230 mm. other dimensions on application.
Bobbin dimensions:	bobbins with die-cut natural wrappers or reels reconstitute wrapper: max. bobbin diameter 350 mm. Recommended bobbin cores: Inner diameter min. 70 mm, outer diameter min. 90 mm.

**The PMB policy is one of continuous development and, therefore, we reserve the right to alter the above specification without notice.**

The speed of the machine is stepless adjustable. The accumulated production figures and the actual machine speed are continuously shown on digital counters.

For reconstituted tobacco wrapper leaf, PMB designed a special version, the HSO-Bt. 200 machine, fitted with a special cutting device instead of the bobbin unwinder for natural wrappers.

The HSO-Bt. 200 version cuts the wrappers from a wide reel of reconstituted tobacco. For double lengths the wrapper are cut in a V-shape as in the well-known PMB rolling machine type BKF. Thanks to this V-shape it is possible to overroll also certain Corona models in double length.

For both HSO versions PMB offers optionally a set of extra noise reducing guards and "hood" to be put on top of the machines. The 2 fans that are located on top of the HSO will then become completely enclosed and the exhaust air does not need to be lead away.



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