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**BULLETIN  
NO. 25**



**'ROTOREX'  
TEA MACHINES**

**Packaging - Processing**  
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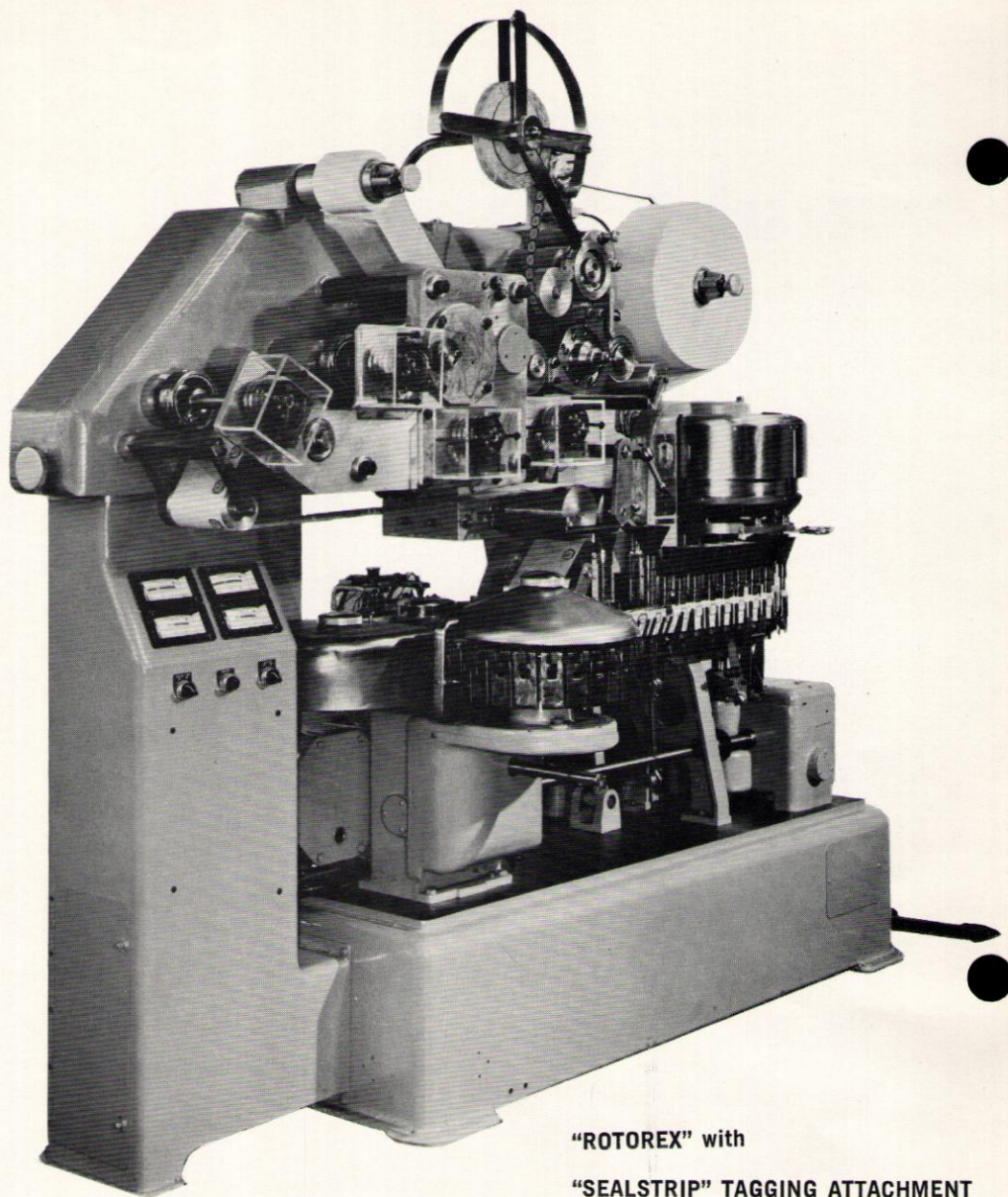
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## TEA BAG MACHINE

### PROGRESS

Since D. & W. created the Model "MT" machine, for the processing of sewn gauze bags, back in the early 1930's, up to our latest development, outlined in this bulletin, we have maintained our reputation of producing tea bag machines of the highest quality, high speed, and high efficiency performance. "Rotorex" machines truly deserve your consideration, and for this, we promise sales and service continuity, to the very best of our ability. Please write, or telephone, for additional information.



**"ROTOREX" with  
"SEALSTRIP" TAGGING ATTACHMENT**

## TEA BAG MACHINE OPERATION

Machine was designed for tea bag forming, filling, and sealing at speeds of better than 400 per minute. Unit may be equipped for production of tagged or untagged, plain or gusseted bags. It is also suitable for packaging other products; such as yeast, sugar, crystal materials, and many free flowing powders.

**BAG SIZE RANGE** — The "Rotorex" tea bag machine handles packet sizes between 2-7/16" and 2-11/16" high with a fixed width of 2-7/16". Single-web feed of heat sealing material is from a roll 15" to 20" in diameter with 3" I.D. core.

**OPERATION** — Mandrel mounted tea bag paper web, complete with affixed tag and tape, is drawn by power feed rolls to a position where paper is then directed through guide mechanism, to form a trough of paper (for gusseted or standard tea bags), by chain carried grippers, which open and close at intervals around the machine. Funnel tubes, which are carried by a chain

running in a track above the grippers, descend into the trough of paper as the grippers close to form a continuing series of pockets. The closed sections of paper trough are then cut by knives between each set of grippers to form separate bag sections.

As the bag sections pass in a rotary motion, tea, or whatever product is being handled, is measured into the funnel tubes and deposited into the partially formed container. Funnels are then withdrawn to leave tea in bag sections which are then heat sealed on sides and top. Completed bags are automatically removed from the grippers by a picker wheel assembly for placement to succeeding operation, manual, semi-automatic, or completely automatic packaging.

**MACHINE DIMENSIONS** — Overall length 96"; Width 42"; Height 86".

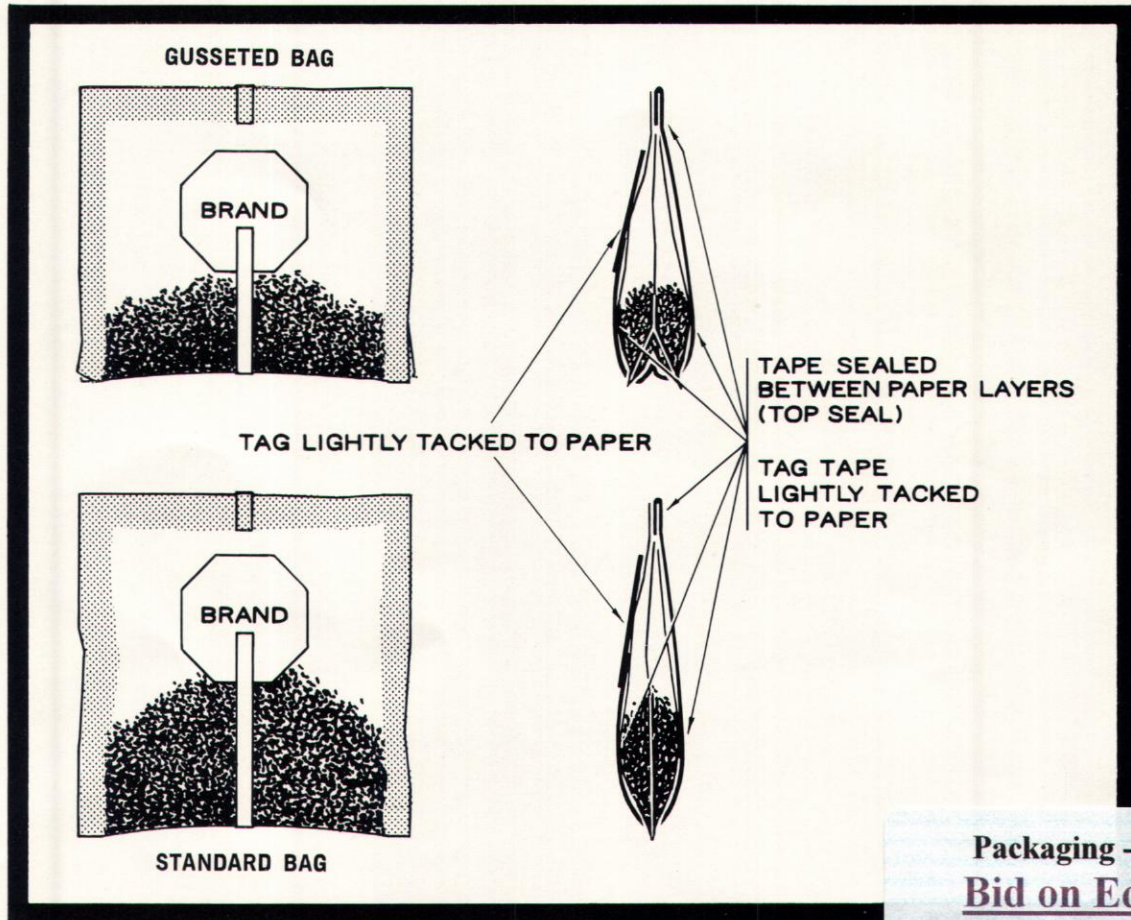
Estimated Weight 3400 lbs.

## COMPLETELY AUTOMATIC PACKAGING

Adding to the already versatile "Rotorex" machine, Delamere & Williams' engineers are collating customer requirement information, in order to complete details for final design on an automatic cartoning attachment. This development is expected to be completed very soon, and up-to-date information is available on request.

## TEA BAG BOTTOM GUSSET FEATURE

To minimize overall standard tea bag height, when producing bags to be wrapped in sanitary envelopes (or without wrapper, if desired), a bag gusseting feature can be attached to machine to perform this operation. Tea bag is reduced in height up to 1/2".



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## "SEALSTRIP" TAGGING FEATURE

(NO STAPLES)

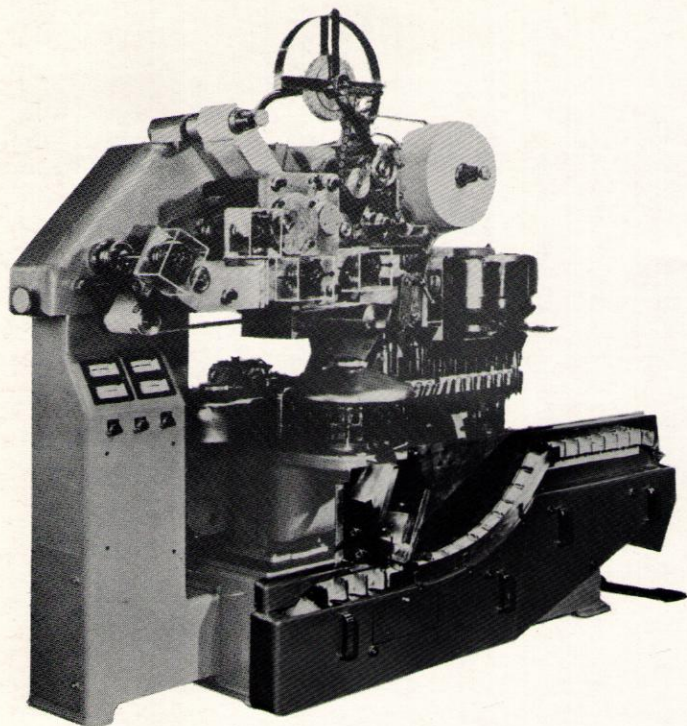
### TAGGING OPERATION

Tags are fed from roll, cut into individual units, and placed in position on tea bag paper, which is fed simultaneously. Tags are held in position by vacuum means, until tag is lightly, but adequately, tacked (heat sealed) to paper. The paper with fixed tag then proceeds to next operation, shearing and positioning of tape strip. The tape is then tacked to paper in two places to achieve wrap-around effect on completed bag. Next, the tape, or strip, is firmly heat sealed to tag and finally the other end of the tape is folded and tacked over edge of paper completing the initial operational sequence. The paper, with affixed tag and tape, is then processed through the "Rotorex" machine for tea filling and bag sealing (3 sides), and removal of com-

pleted bags from machine operational track, for manual, semi-automatic, or automatic packaging into carton or poly bag containers.

The "Sealstrip" tagging unit uses standard board tag stock (9 to 12 mil.), die cut to hexagon, or other acceptable shapes. Tag rolls are approximately 16" diameter with a 6-1/2" core. The "Sealstrip" tape, clear or in colour, is obtainable in 10" diameter rolls with a 3" core. The "Rotorex" machine and strip tagging combination eliminates the use of controversial metal staples in tagged tea bag processing, and produces an extremely neat tea bag, at guaranteed production speeds of 400 per minute.

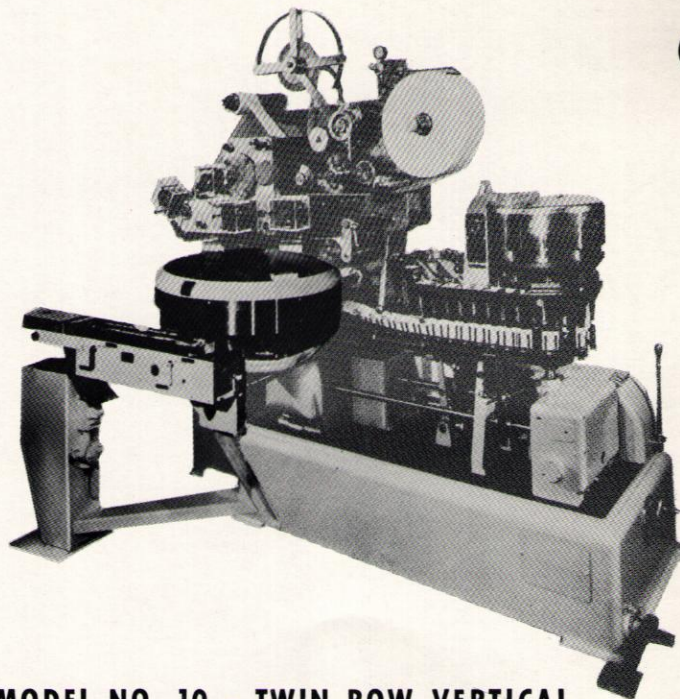
## TEA BAG COUNTERS & STACKERS



### MODEL NO. 8 - COUNTED HORIZONTAL STACKS

This attachment to the "Rotorex" machine places completed tea bags horizontally into tray receptacles, in counts of 8, 9, or 10 bags per stack.

The bags are also alternately stacked in tray units, to facilitate handling by operator and for neat container loading. One operator can inspect bags for quality, place into container, in bag counts ranging from 16 to maximum requirements, at machine production speed.



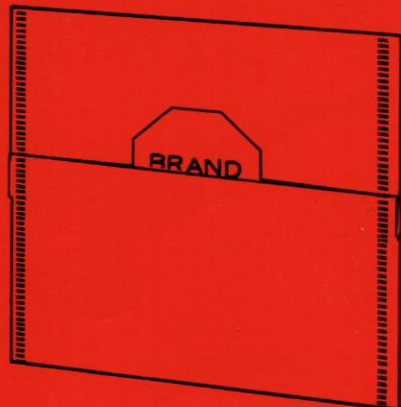
### MODEL NO. 10 - TWIN ROW VERTICAL

This type of stacking attachment is suitable for processing end load type cartons, or poly bags.

Completed tea bags are removed from machine operational track by picker wheel principle, and divided into two rows onto a synchronized paddle and chain carrier, in a vertical position. Double row of adjacently placed bags, interleaved (1/8") between rows, then move to bag counting section of stacking conveyor. Bag counting is achieved by use of revolving chain with arrow type count indicators, also specific paddles on carrier chain are marked to assure correct tea bag count. Bags are then propelled into positioned container (carton or bag) by operator.

One operation can process bags into container, in counts ranging from 60 to 120 bags, at machine production speeds.

### SANITARY ENVELOPE FEATURE



Tea bags can be overwrapped, if desired, by attaching a special unit to the standard "Rotorex" machine, which overwraps bags, tagged or untagged, in manner (illustrated). Wrapper paper 2-7/8" wide, is fed from roll stock, formed around tea bags, to partially expose or totally enclose tea bag tag. The ends of the wrapper are fastened by an interlocking milled strip method. Wrapping paper, random pattern prints, or paper with positive panel design, requiring electric eye panel registration, can be used.