



MACHINE MODEL:
Z-R2000

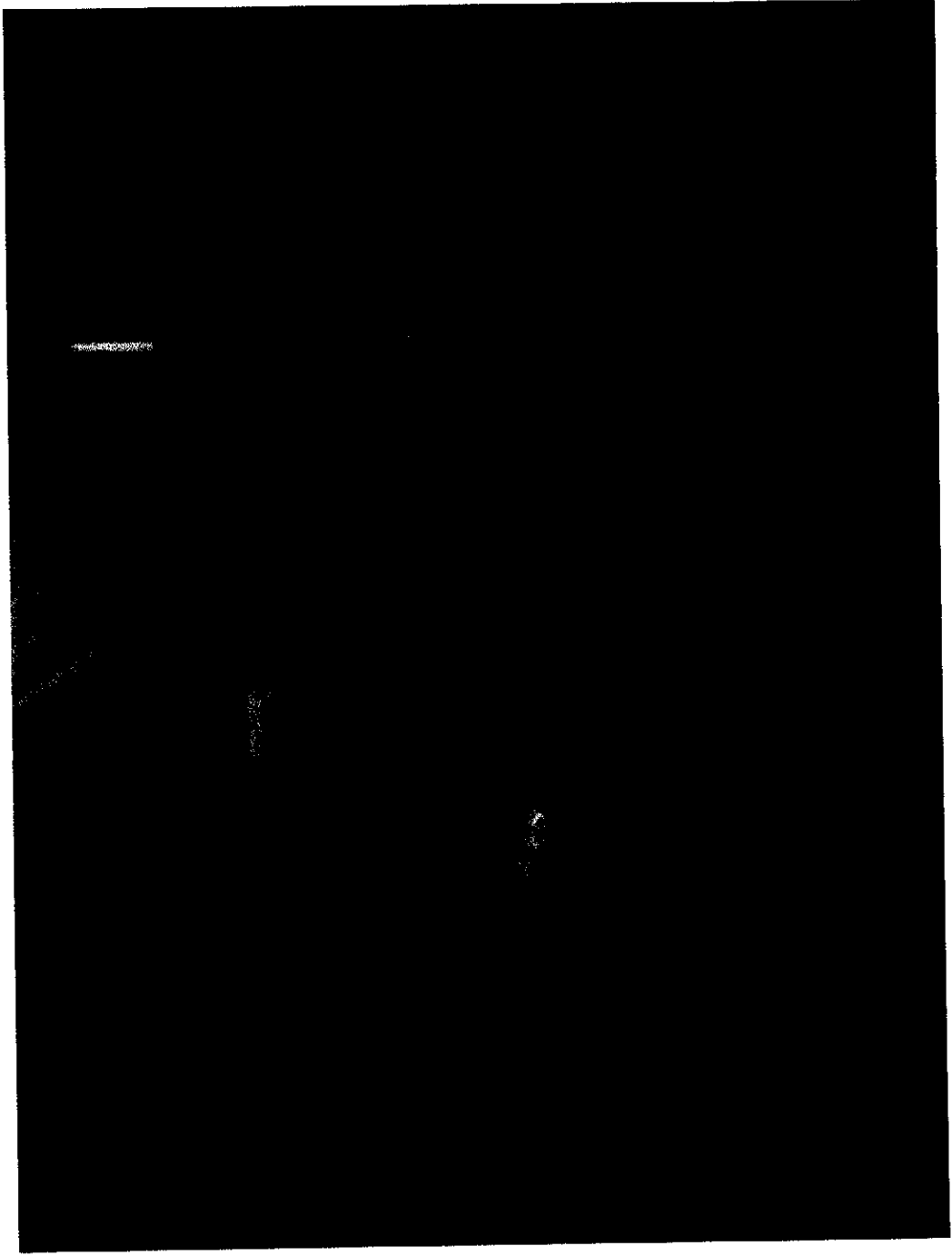
QUOTATION: 6543-1
DATE: 12/27/07



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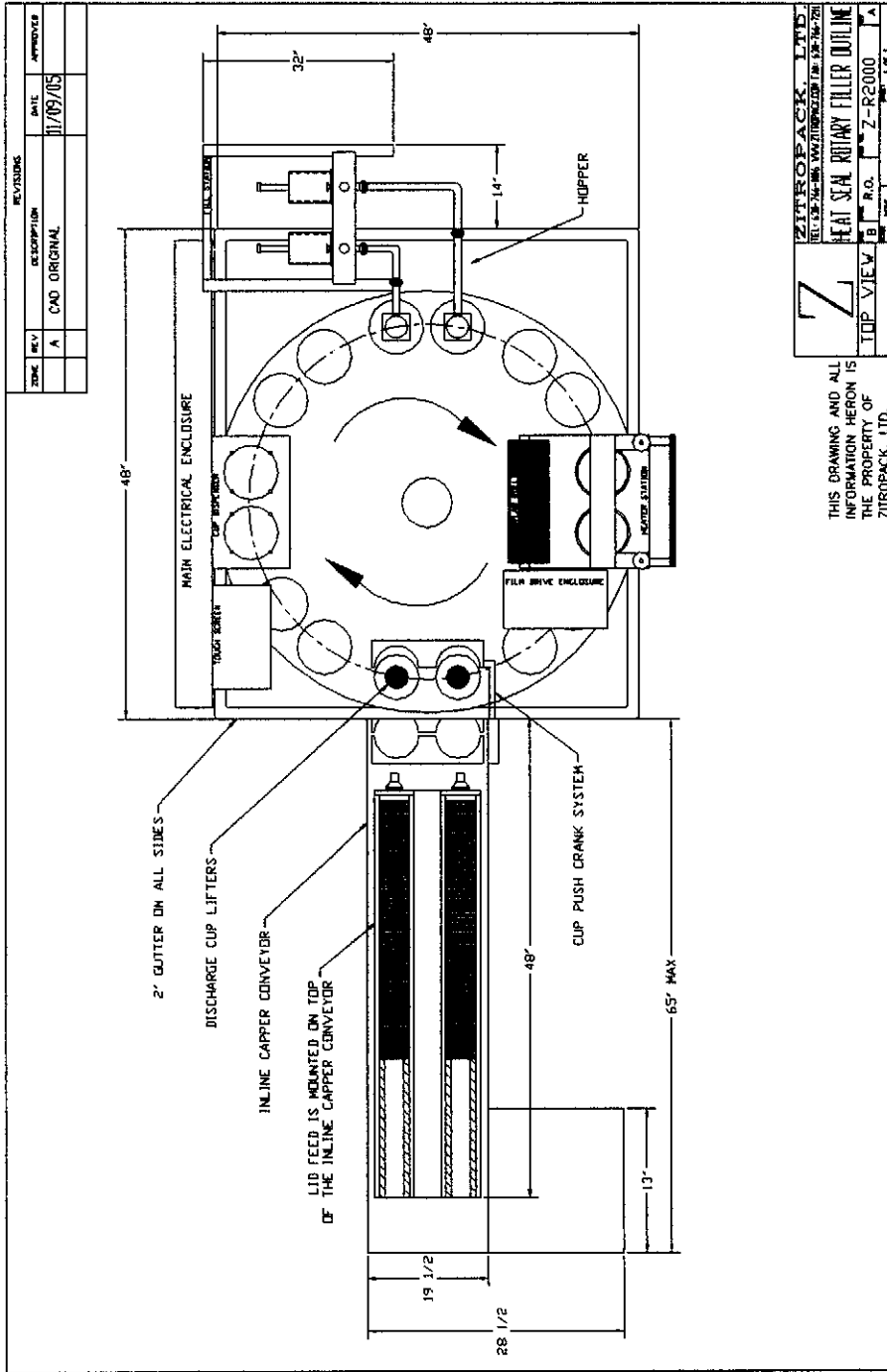




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ALL DIMENSIONS AND DESIGNS ARE BASED ON A BASIC MACHINE MODEL

QUOTATION NO: 6543-1
MACHINE MODEL: Z-R2000
CUSTOMER: Berry Plastics
DATE: 12-27-07
VALID: 30 Days

This quotation is in regard to the design and manufacturing of a dual lane, Z-R2000 rotary machine. Machine speed is based on the consistency of the product.

CONAINTER SIZE	MACHINE SPEED	MACHINE PRODUCTION
409	40 cycles per minute	80 cups per minute.
314	40 cycles per minute	80 cups per minute.

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Machine stations include:

- Wash down rated, stainless steel frame.
- Stainless steel Nema 4X main electrical enclosure.
- Operator touch screen, with stainless steel Nema 4X enclosure.
- Secondary emergency stop station located near the cup dispenser.
- Automatic cup dispenser station.
- Cup sensor station.
- Pump piston fill station.
- Roll stock film drive station.
- Tamper evident profile type cut and seal station.
- Inline stainless steel capper conveyor.
- Lid feed capper station.
- 314 dual lane change over attachment.

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1) Air requirements:

- Approximately 15.0 scfm. (standard cubic feet/minute)
- Customer needs to provide a ½” NPT inlet pipe from the ceiling.

2) Safety:

- Safety stickers placed along the machine.
- Clear Lexon doors mounted on top of the machine.
- Interlock sensors stop the machine if a top door is opened.
- In automatic mode, the machine will not start if any top door is open.

3) Main electrical enclosure:

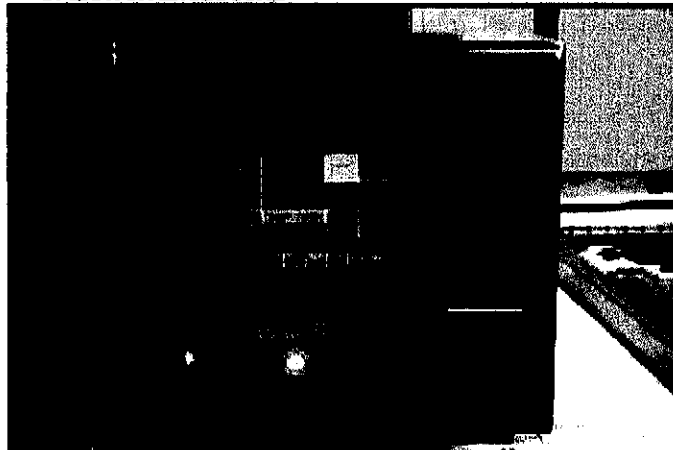
- Primary power: TBD by customer.
- 304 Stainless steel; Nema 4X enclosure.
- (2) Chromalox heater temperature controls.
- Stack light with start up alarm horn.
- Main circuit breaker disconnects: 240v, 3 phase, 60 Hz.
- Control circuit transformer with primary and secondary protection.
- IEC starters and protector.

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4) Operator enclosure:

- Nema 4X stainless steel.
- Operator touch screen.
- Machine reset push button.
 - Guarded.
 - Illuminated.
 - Momentary controlled.
- Machine cycle stop push button.
 - Guarded.
 - Illuminated.
 - Momentary controlled.
- Emergency stop push button.
 - Mushroom head.
 - Illuminated.
 - Momentary controlled.
- Machine speed potentiometer.

OPERATOR ENCLOSURE

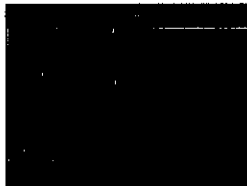


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5) Operator touch screen:

- Mounted on the operator enclosure.
- Ethernet compatible and capable of running with individual stations off.
- Touch screen menu options:
 - Cycle start.
 - Cycle stop.
 - Capable of running with individual stations off.
 - Digital rate indicator. (Cycles per minute)
 - Displays the current speed of the machine.
 - Current position
 - Displays the main drive shaft position.
 - Manual machine run.
 - Allows the machine to run without cups.
 - Jog function.
 - Jogs the machine to any desired position.
 - Alarm menu.
 - Displays the location of any alarm(s) occurring.
 - Displays the history of alarm(s) that have occurred.
 - PLS Menu.
 - Allows you to reset or modify the machine parameters.
 - Allows you to modify the resolver position.

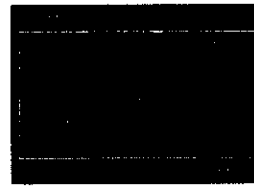
MAIN MENU



ALARM MENU



PLS PARAMETER MENU



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6) Secondary emergency stop station:

- Located near the cup dispenser station.
- Stainless steel Nema 4X enclosure
- Illuminated.
- Red mushroom head.
- Momentary controlled.

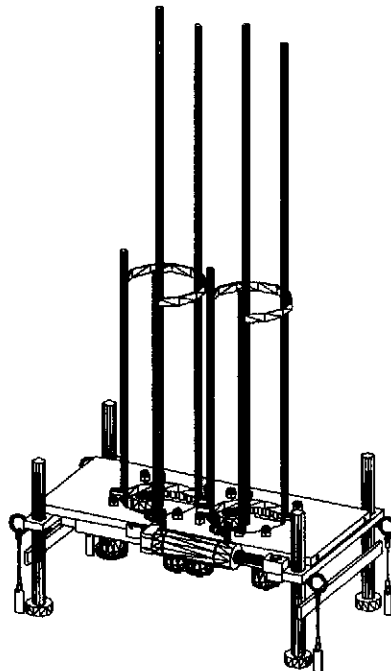
7) Machine construction and drive:

- Wash down rated stainless steel body and frame.
- Stainless steel lower chassis.
- Stainless steel lower splash guard doors.
- Cam driven gear box; 1 ½" hp motor with 30:1 reducer.
- Stainless steel rotary table laser cut into sectors.
- Laser cut sectors enable an easy change over when running different containers.

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8) Cup dispenser station:

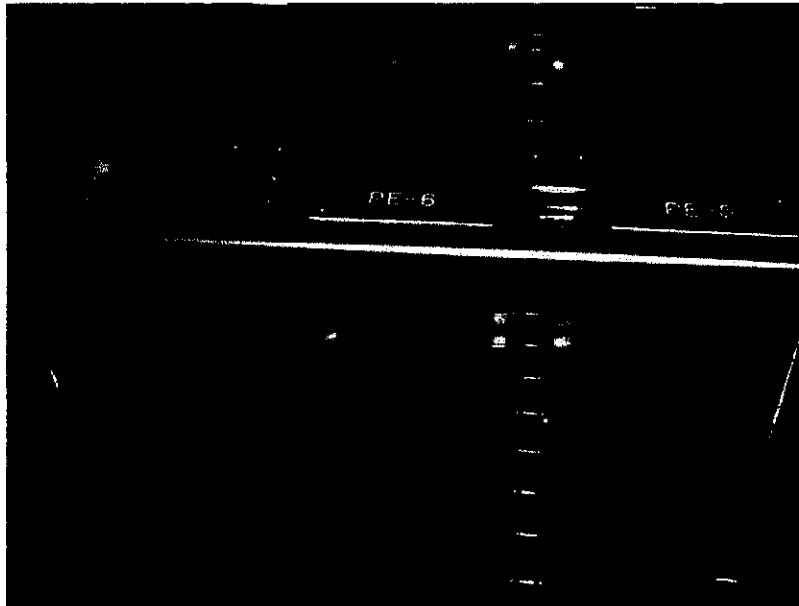
- Lanyard pin height adjustment.
- Capable of dispensing identical cup diameters with different heights.
- Uses the same attachment to run different cup heights.
- Operator feeds the cups from boxes to the magazine.
- Requires no lubrication and is very low maintenance.
- 304 Stainless steel cup dispenser plate.
- Dispenses the cups using stainless steel cam type spirals.
- Rack and pinion design.
- Pneumatically driven.
- PLC timed and electro cam controlled.



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9) Cup sensor station:

- Photo eye sensors are mounted after the cups dispense.
- Sensors detect the cups on every cycle.
- Sensors send a signal to the machine every cycle.
- The machine will stop if a missing cup occurs.



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10) Pump piston fill station:

- Mounted off the machine.
- No cup, no fill sensing system.
- Photoeye sensor insures the machine will not fill without a cup.
- Always stops in the shut off position, preventing dripping or over filling.
- Cam driven pump piston drive.
- Spool type shut off valve.
- Secondary pneumatic vertical shut off valve.
- Stainless steel pump block.
- Stainless steel hopper with cover.
- Stainless steel drip pan located under the nozzles catches any loose product.
- Individual lane mechanical micro adjustment.



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11) Roll stock film drive station:

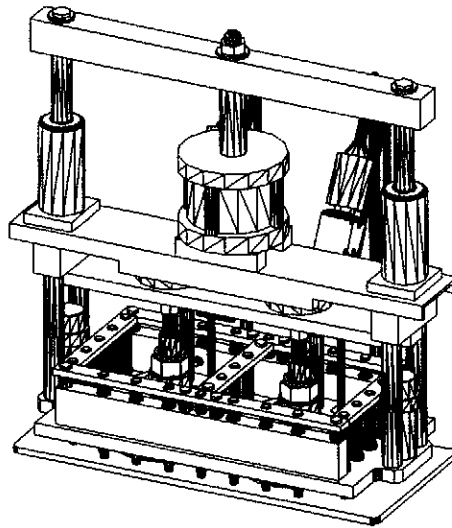
- Film station is designed for non registered film.
- Film drive will not activate if a missing cup occurs.
- Film advances with rollers and is mechanically driven.
- Photo eye sensor stops the machine when the film roll runs out.
- Soft roller arm rests on the film roll insuring a positive film feed.
- Excess film is wound to a take-up roller.



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12) Profile type cut and seal station:

- Tamper evident heat seal with a pull tab.
- Lanyard pin height adjustment.
- Capable of sealing different container heights with the same diameter.
- Heater heads descend down and apply pressure to the container.
- Heater knives simultaneously descend down and cut the film around the cup.
- Heater heads and knives simultaneously ascend up.
- Heater heads will not descend if a missing container occurs.
- Heater heads stays in an upright position when the machine is stopped.
- Prevents overheating the containers while the machine is idling.
- Heater heads self align, applying pressure to 100% of the surface.
- High temperature wire is insulated to the heater element.
- Thermocouple is mounted approximately 1/8" away from the sealing surface.

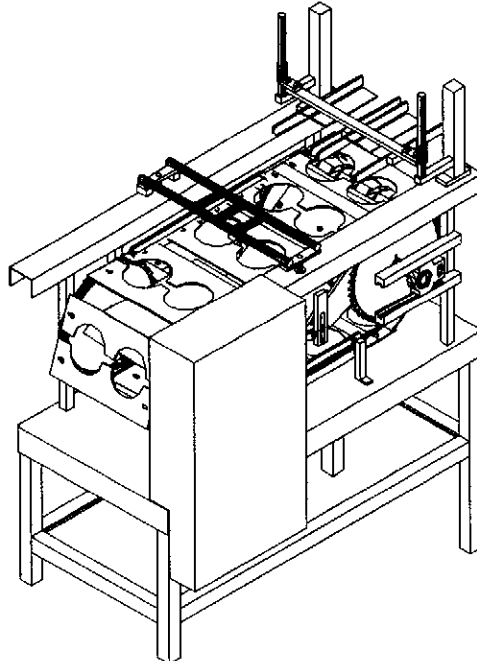


ABOVE PICTURE IS BASED ON A BASIC MACHINE MODEL.

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13) Inline capper conveyor:

- Stainless steel construction.
- Continuously driven capper conveyor.
- Inline capping conveyor is connected and timed with the rotary machine.
- Cam driven cup lifter lifts the cups from the rotary table.
- Mechanical driven crank bar pushes the cups onto the inline capper carrier plates.
- Carrier plates are removable without the use of tools.
- Carrier plate design enables an easy change over.
- Carrier plates advance the cups to the capping stations.

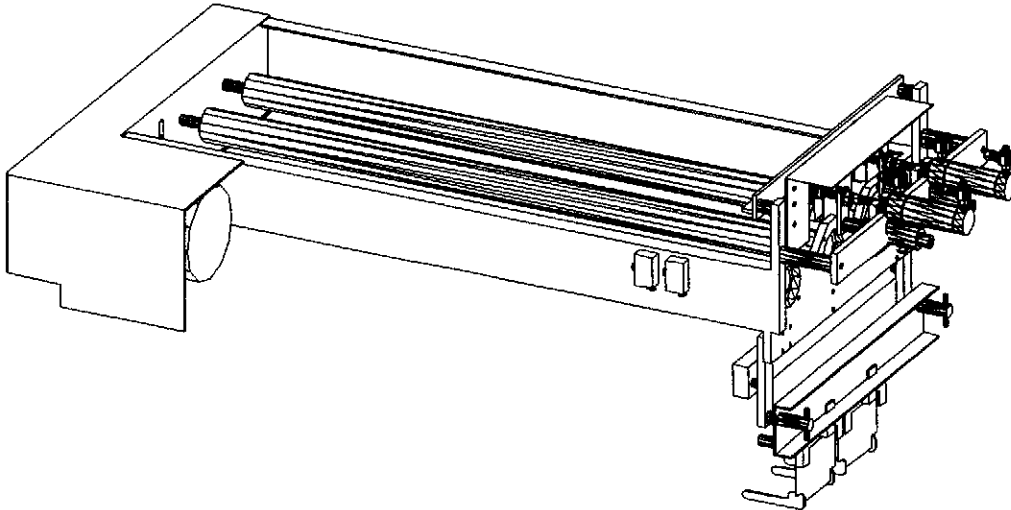


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14) Lid feed capper station:

- Lid feed capper station is mounted on top of the capper conveyor.
- Operator feeds the lids from boxes to the mechanically controlled spinning bars.
- Lid rollers adjust to run 314 containers.
- Vacuum picker system picks the lids one at a time.
- The lids are released and descend through a chute.
- Photo eye sensors maintain a full chute.
- The lids set up to a capping position.
- The cups catch the lids when the chain advances.
- The lid applicator bar mounted after the lid chute presses the lids to the cups.



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15) Cup discharge station:

- Cups ramp out and off the capper conveyor.

16) 314 Change over attachment:

- The following components are needed to run the 314 containers.
- Approximately 30 minutes are needed to change over to the 314 containers.
- Cup assist pull down station is only used to run the 314 containers.
 - Rotary table sectors.
 - Cup dispenser station.
 - Product shut off nozzles.
 - Cut and seal heater head station.
 - Capper conveyor cup lifters.
 - Capper conveyor carrier plates.
 - Lid feed capper chute.
 - Lid applicator.

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17) Machine manual:

- There will be 1 hard copy and 1 disk set of the manual provided.
- Operating instructions include:
 - Operator touch screen instructions.
 - Automatic production start up instructions.
 - Machine operation during production instructions.
 - Change over instructions.
- Maintenance instructions include:
 - Lubrication instructions.
 - Cleaning procedure instructions.
 - Spare parts ordering.
 - General machine trouble shooting guide.
 - Individual station trouble shooting guide.
- Emergency spare parts list. (pricing included)
- Recommended spare parts list. (pricing included)
- 3D or orthographic station assembly blueprints.
- Electrical settings.
- Electrical schematics.
- Electrical bill of material.