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**GCT/SYNCRO
MODEL 2500**

AUTOMATIC TUBESEWING MACHINE

NUMERICALLY CONTROLLED AUTOMATIC TUBESEWING MACHINE CLASS GCT/SYNCRO Model 2500

The fully automatic high speed tubesewing machine class GCT/SYNCRO Model 2500 sews a roll of open fabric with maximum width 250 cm (100") into tubular form. The numerical control permits to vary the stitch length in the tubesewing machine and synchronizes the puller rollers of the seamed tubular with the sewing head.

The unit automatically sews the fabric with the following steps:

- Automatic alignment of the selvages before seaming
- Sewing in a tubular form with lockstitch or overlock head and possibility to adjust the stitch length.
- Edge trimming of the selvedge with vacuum system to remove the cut fabric
- Folding and pressing of the selvedge with a special guide (available for different fabric thickness) and rewinding of the fabric in roll (or collected flat folded in a box)

This machine has been designed with the utmost attention to safety features to obtain, for the first time in the market, from IMQ (www.imq.it Italian Institute for Quality Trademarks) the Certification of Examination "CE" for standards 2006/42/EC (Ref. IMQ/306). The technical file of the machine has been deposited by IMQ organization that has certified the conformity to "CE" European Community Safety Standards.

This means that, while AMP PISANI issues the "CE" certification of the machine, IMQ (Independent organization) confirms that the unit fulfils the requirements of the aforementioned directive.

STANDARD DEVICES

- Digital inverter to adjust the sewing speed depending on the stitch length and puller for the seamed tubular with pneumatic adjustment of the pressure.
- Pressing system of the seam edge with digital electronic temperature control up to 180 °C and possibility to adjust the ironing pressure
- Numerical control to adjust continuously the stitch length from 1,5 to 2,5 mm with separate AC drive to control the puller of the seamed tubular.
- New photocell system for the automatic alignment of the selvages with automatic centering of the roll in the middle of the folding triangle and adjustable inclination rollers for final alignment of the selvages.
- Fabric end stop with photocell system and sensor to stop the machine in case of thread breakage in the sewing machine
- Servomotors for the lateral movement of the folding triangle and for vertical positioning of the open fabric roll and automatic lock of the vertical roll shaft to the upper support for an easier loading of the machine
- Servomotor with gearbox (device GCT/LOAD) to lift vertically the open fabric roll support (max weight kg.50) from the horizontal loading position to avoid the fatigue of the operator
- Programmable meter counter presettable with machine stop in case of empty bobbin (for lockstitch machine) and fabric end on the touch screen panel.
- PLC controlled machine with a separate safety PLC to control the safety devices and equipped with a software to inform the operator of any possible alarm and to display instructions to restart the unit on a touch screen graphic panel.

MAX PRODUCTIVITY OF THE MACHINE

The max productivity of the unit depends on the sewing machine installed and on the stitch length which can be adjusted continuously from 1,5 to 2,5 mm

The table below indicates the max speed for a 2 mm stitch length. In case of shorter or longer stitch length the productivity will be proportionally increased or decreased.

SEWING MACHINE TYPE	STITCH LENGTH	MAX ROTATION SPEED (N/min)	MAX SEWING SPEED (Mt/min)
LOCK STITCH	2 mm	4.200	8,4
OVERLOCK	2 mm	6.500	13

DEVICES ON REQUESTS

- GCT/JERSEY/250 Roller feeding device for light fabrics like knits and jersey and for very heavy fabric to adjust the overfeeding of the fabric before sewing and sew it without tension
- GCT/FALD Device to collect flat folded the seamed tubular
- GCT/TRI Auxiliary feeding triangle to feed the machine with flat folded open fabric in pallet

TECHNICAL FEATURES

- Installed power: 2.0 kW + 0,55 kW (GCT/JER)
- Voltage.....: 400 V 50Hz 3-phase or 220 V 60Hz 3-phase
- Compressed air: 6 bar – 300 lt/h
- Rewinding shaft diameter: Standard 49 mm (other diameters on request)
- Rolls dimensions: Width from 70-to 250 cm (27"½-100")
: Max. diam. 30 cm(13"¾) Weight 50 Kg max.

