AMP PISANI SRL
Via Ungaretti 6/8
27024 CILAVEGNA (PV)
ITALY

Phone +39 0381 96128
Fax +39 0381 969100

www.amppisani.com
info@amppisani.com

MOLDING MACHINES
and
ROBOT CUTTER

GENERAL CATALOGUE
Our passion is creating machinery. We have been doing it since long time.

For nearly seven decades, AMP Pisani has been designing and manufacturing quality machinery for apparel and textile industries as well as for roll slitting applications and customized projects. We have been established since 1946.

Our vast product range consists of bra moulding equipments and robotic systems for trimming foam bra cups, roll slitters for any application and bias machinery.

Collarette cutters, complementary machines for cutting room and automatic equipments for technical applications are also included in our product range.

Our skill of innovation has enabled us to achieve numerous technological innovations within the market, most of them patented.

AMP Pisani’s machinery is exclusively manufactured at our facility in Italy by a skilled team of mechanics, electricians and software engineers who are able to design and manufacture customized units.

About 25,000 machines have been manufactured since our establishment.

Our headquarter and manufacturing facility is located in the city of Cilavegna, at 50 km from Milan city centre and at 40 km from Milan Malpensa International Airport.

A spare parts departments guarantee the quick delivery of spare parts and consumables (blades and grindstones) for all our equipments and our team can offer phone support, both technical an commercial, in the main European languages.

Our agents and distributors guarantee world wide distribution and technical assistance to our products.
AMP PISANI PRODUCTS

1. MACHINES FOR MOLDING BRA CUPS AND ROBOTS
   • Fully automatic robot cutter for trimming foam bra cups
   • Molding machines for foam and spacer fabrics class P88
   • Molding machines for fabric with two molds class P92, P94, P96 and double machine P96/2 consisting of two units P96 connected to the same electric box
   • Single head molding machine class P90 for small lots and prototyping (P90/BIG available for large sizes)
   • Molding machine for seamless bra class P84
   • Special molding machines for technical applications

2. AUTOMATIC AND MANUAL ROLL SLITTERS FOR ANY APPLICATION
   • Automatic and numerically controlled roll slitting machines class T/1000, T/900, T/500, T/300E.
   • Manual roll slitting machines class T/100E, T/50E and T/50HD

3. BIAS GROUP, WINDING MACHINES, PRESSING MACHINES AND OTHER EQUIPMENTS
   • BIAS GROUP for the production of bias fabrics with warp and weft at 45 degrees, available in the automatic model class GCT and SPR/SYNCR or in simplified model class C/2000E and SPR/2000S.
   • Automatic BIAS GROUP for sewing SISAL and cotton materials for polishing discs
   • Automatic winding machines class APR and manual machines class APM
   • Pressing machines for ribbons and waistbands class ROTOSTIR and MINISTIR
   • Winding machines for ribbons in bobbins class BOBINATORE
   • Hot cut machines class TX and MINICUT.
   • Perforating machines for edge control ribbons class PERF

4. COLLARETTE CUTTING MACHINES AND BANDKNIFE
   • Automatic collarette machines class TPM
   • Manual collarette machines class 972
   • Automatic machines for opening and rewinding the tubular fabric class SP/160
   • Band knife machines class BK

5. MISCELLANEOUS EQUIPMENTS
   • Automatic cutter for foam rectangles LTR/1600 and to cut/sew rectangles of fabric class LTR/1800
   • Die cutting machines for tubular fabric class PTA
   • Winding machines for fabric tapes AV/600
   • Automatic sewing systems for waistband double piping with cord insertion and other special units.

Our R & D department is at your disposal for special applications and for customized projects.
AMP Pisani, a leading manufacturer of cutting room machines, has over 20 years of experience in the production of bra molding machines. AMP Pisani is also technical partner of important multinational groups and market leader of Italian Companies.

Extensive experience in thermoforming allows AMP Pisani to offer complete after sale support. Sale support includes the study of molding parameters on the customers' materials that can be repeated exactly on the machines installed and supply of any type of mold requested.

The company offers a complete range of molding machines for seamless, for foam only and multi-purpose (fabric + foam).

The machines multipurpose have the following exclusive features:

1. **Unique molding system with heated bell** on the top instead of the countermold (requested only for foam) with the advantages of:
   a) possibility to adjust the height of the mold inside the bell to compensate the elastic return of the fabric that depends on the composition and on the finishing of the material;
   b) shorter molding time;
   c) no variation in the color of the molded fabric;
   d) costs of molds greatly reduced.

2. **Very short** time for changing the mold (2±3 min maximum) with possibility of using preheated molds and disks (with a normal oven) to have the machine immediately ready for production.

3. The machine can operate with all molding systems:
   a) with square fabrics and further die-cut of the shape with a clicking press or similar machine;
   b) with pre-cut fabrics and no die-cut (final shape);
   c) post-molding of the finished bra (feasibility depends on the style and on the material of the garment);
   d) on a tubular seamless bra;
   e) molding of foam or fiber-fill (countermold requested for this operation).

4. **Exact repeatability** of all the molding parameters (heating temperatures, molding time, depth of the cup).

5. Heating resistances and thermocouple inserted in the supports of molds and disks. No need to have resistances and thermocouples on every mold or disk and fast heating of the machine at the start-up (about 20 min).

6. **All machines ergonomically designed and protected against accidentally contacts of the operator with heated parts.**

7. **All machines for fabric can be prepared for the use of steam but we do not recommend to use it because, unless very particular cases, there are no advantages in the quality and in the productivity of the units.**
### Machines for Seamless and Foam

<table>
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<tr>
<th></th>
<th>P84</th>
<th>P88/2/BASIC</th>
<th>P/88/2E</th>
<th>P88/4/BASIC</th>
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### Machines for Fabric and Foam

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✓ = STANDARD  
R = ON REQUESTS
P/84

MOLDING MACHINE FOR SEAMLESS BRA CUPS
MOLDING MACHINE FOR SEAMLESS BRA CUPS P/84

The machine P/84 is a unit specifically designed for molding seamless bra and it can produce one complete bra every cycle.

TECHNICAL FEATURES

- The machine consists one upper molding head where it is possible to put two male molds plus and one female countermold on the lower part of the unit.

- The operator positions the seamless tubular on four adjustable shafts in front of the lower female molds then he pushes two buttons to start the molding cycle and the upper molds move downwards to do the molding operation.

- The upper molds (without electric resistances) are assembled on a support plate with heating resistances and thermocouples for temperature control. The distance between the upper molds is adjustable.

- The depth of the upper male molds in the lower mold is adjustable with two precision knobs and the approaching speed of the upper molds is pneumatically adjustable.

- The lower female molds, differently from the upper molds, is equipped with heating resistances and thermocouples and it is assembled on a mold support. Two plugs connects the mold to the electric box of the machine

- A plate coated with silicon foam is located on the lower female mold.

- All setting of temperature and times are adjustable with digital timers and proportional thermoregulators.

- Available on requests the device P84/PIA Heated upper plate kit with a pneumatic system to control the clamping pressure of the material and with a temperature control

- PLC Controlled machine

TECHNICAL DATAS

- Diameter of the molds : from 80 to 120 mm (on requests)
- Max molding temperature : 250°C
- Installed power : 4.5 kW 400V 50 Hz 3-phase + Neutral + Ground.
- Compressed Air : 6 bar min (58.5 PSI), 150 lt/hour.
- Time to change a size : 5 min + 2 min for the device P84/PIA

PRODUCTIVITY

- Movement time of the mold (down + up) : 4 sec
- Molding time : from 10 to 35 sec (adjustable)
- Loading/unloading time : 10 sec approx

DEVICES AND MOLDS

P84/KIT Set of No. 2 male molds + No. 1 double female mold complete with silicon coated plates
P84/PIA Upper heated plate with adjustable clamping device
P88/2/BASIC
MOLDING MACHINE FOR FOAM BRA CUPS WITH TWO MOLDS
MOLDING MACHINE FOR FOAM BRA CUPS WITH TWO MOLDS  P88/2/BASIC

The machine P88/2/BASIC is a flexible unit with TWO DOUBLE molds specifically developed to mold bra cups in FOAM and it can produce No.4 cups per cycle.

TECHNICAL FEATURES

• The machine consists of four molding heads where it is possible to put one male mold in upper position and one female countermold (fixed) on the lower table. The molds are double (two cups on each mold) and the max dimensions are 350 x 250 x H=150 mm.

• The operator positions the rectangular pieces of foam on the loading/unloading stations then he starts the molding cycle.

• The molding cycle consists of the descent from the top of the male mold on the female mold with approaching speed pneumatically adjustable.

• The molds (without electric resistances and equipped with self-centering system) are fixed on supports with heating resistances.

• All setting of temperature and times are adjustable with digital timers and thermoregulators.

• PLC Controlled machine.

• The operation of changing the molds is easy and fast, is enough to connect the thermocouple plug to the socket on the machine.

• Presettable timer for automatic start-up and shut down of the unit on request.

TECHNICAL DATAS

- Dimensions of the molds : 250 x 350 x H=150 mm
- Max molding temperature : 250°C.
- Installed power : 12 kW 400V 50 Hz 3-phase +Neutral + Ground.
- Compressed Air : 6 bar min (58.5 PSI), 150 lt/hour.
- Time to change a size : 3 min

PRODUCTIVITY

- Movement time of the mold (down + up) : 4 sec
- Molding time : from 50 to 150 sec depending on the material
- Loading/unloading time : 10 sec approx
- Production : up to 350 cups/hour
P88/2E
MOLDING MACHINE FOR FOAM BRA CUPS WITH TWO MOLDS
MOLDING MACHINE FOR FOAM BRA CUPS WITH TWO MOLDS P88/2E

The machine P88/2E is a flexible unit with two DOUBLE molds and pliers specifically developed to mold bra cups in FOAM and it can produce No.4 cups per cycle.

TECHNICAL FEATURES

- The machine consists of two molding heads where it is possible to put one male mold in upper position and one female countermold (fixed) on the lower table. The molds are double (two cups on each mold) and the max dimensions are 350 x 250 x H=150 mm (can be increased to 390 x 190 x H=150 mm if female mold is equipped with pliers).

- The operator positions the rectangular pieces of foam on the loading/unloading stations then he starts the molding cycle.

- The molding cycle consists of the descent from the top of the male mold on the female mold with approaching speed pneumatically adjustable.

- The molds (without electric resistances and equipped with self-centering system) are fixed on supports with heating resistances.

- The machine is equipped with a couple of height adjustable PLIERS to keep in position and to brake the flow of the material during the descent of the male mold to avoid the creation of creases (possible on some materials).

- All setting of temperature and times are adjustable with digital timers and thermoregulators.

- PLC Controlled machine.

- The operation of changing the molds is easy and fast, is enough to connect the thermocouple plug to the socket on the machine.

- Presetable timer for automatic start-up and shut down of the unit on request.

TECHNICAL DATAS

- Dimensions of the molds : 250 x 350 x H=150 mm
- Max molding temperature : 250°C.
- Installed power : 12 kW 400V 50 Hz 3-phase + Neutral + Ground.
- Compressed Air : 6 bar min (58.5 PSI), 150 lt/hour.
- Time to change a size : 3 min

PRODUCTIVITY

- Movement time of the mold (down + up) : 4 sec
- Molding time : from 50 to 150 sec depending on the material
- Loading/unloading time : 10 sec approx
- Production : up to 350 cups/hour
P88/4/BASIC

MOLDING MACHINE FOR FOAM BRA CUPS WITH FOUR MOLDS
MOLDING MACHINE FOR FOAM BRA CUPS WITH TWO MOLDS  P88/4/BASIC

The machine P88/4/BASIC is a flexible unit with four DOUBLE molds specifically developed to mold bra cups in FOAM and it can produce No.4 cups per cycle.

TECHNICAL FEATURES

• The machine consists of four molding heads where it is possible to put one male mold in upper position and one female countermold (fixed) on the lower table.
  The molds are double (two cups on each mold) and the max dimensions are 350 x 250 x H=150 mm.

• The operator positions the rectangular pieces of foam on the loading/unloading stations then he starts the molding cycle.

• The molding cycle consists of the descent from the top of the male mold on the female mold with approaching speed pneumatically adjustable.

• The molds (without electric resistances and equipped with self-centering system) are fixed on supports with heating resistances.

• All setting of temperature and times are adjustable with digital timers and thermoregulators.

• PLC Controlled machine

• The operation of changing the molds is easy and fast, is enough to connect the thermocouple plug to the socket on the machine.

• Presettable timer for automatic start-up and shut down of the unit on request.

TECHNICAL DATAS

- Dimensions of the molds ......................: 250 x 350 x H=150 mm
- Max molding temperature .....................: 250°C.
- Installed power .................................: 24 kW 400V 50 Hz 3-phase +Neutral+Ground.
- Compressed Air ...................................: 6 bar min (58.5 PSI), 300 lt/hour.
- Time to change a size .........................: 3 min

PRODUCTIVITY

- Movement time of the mold (down + up) .. : 4 sec
- Molding time ....................................: from 50 to 150 sec depending on the material
- Loading/unloading time .......................: 10 sec approx
- Production ......................................: up to 700 cups/hour
A.M.P PISANI S.r.l.   Via Ungaretti 6/8   27024 CILAVEGNA (PV) ITALY
Phone  ++39 0381/96128     Fax ++39 0381/969100
www.amppisani.com   email: info@amppisani.com

P88/4E
MOLDING MACHINE FOR FOAM BRA CUPS WITH FOUR MOLDS
MOLDING MACHINE FOR FOAM BRA CUPS WITH TWO MOLDS P88/4E

The machine P88/4E is a flexible unit with four DOUBLE molds and pliers specifically developed to mold bra cups in FOAM and it can produce No.8 cups per cycle.

TECHNICAL FEATURES

• The machine consists of four molding heads where it is possible to put one male mold in upper position and one female countermold (fixed) on the lower table. The molds are double (two cups on each mold) and the max dimensions are 350 x 250 x H=150 mm (can be increased to 390 x 190 x H=150 mm if female mold is equipped with pliers).

• The operator positions the rectangular pieces of foam on the loading/unloading stations then he starts the molding cycle.

• The molding cycle consists of the descent from the top of the male mold on the female mold with approaching speed pneumatically adjustable.

• The molds (without electric resistances and equipped with self-centering system) are fixed on supports with heating resistances.

• The machine is equipped with a couple of height adjustable PLIERS to keep in position and to brake the flow of the material during the descent of the male mold to avoid the creation of creases (possible on some materials).

• All setting of temperature and times are adjustable with digital timers and thermoregulators.

• PLC Controlled machine.

• The operation of changing the molds is easy and fast, is enough to connect the thermocouple plug to the socket on the machine.

• Presettable timer for automatic start-up and shut down of the unit on request.

TECHNICAL DATAS

- Dimensions of the molds : 250 x 350 x H=150 mm
- Max molding temperature : 250˚C.
- Installed power : 24 kW 400V 50 Hz 3-phase + Neutral + Ground.
- Compressed Air : 6 bar min (300 lt/hour).
- Time to change a size : 3 min

PRODUCTIVITY

- Movement time of the mold (down + up) : 4 sec
- Molding time : from 50 to 150 sec depending on the material
- Loading/unloading time : 10 sec
- Production : up to 700 cups/hour
P88/EP

MOLDING MACHINE FOR POLYETHYLENE BRA CUPS WITH TWO MOLDS
MOLDING MACHINE FOR POLYETHYLENE BRA CUPS WITH TWO MOLDS P88/EP

The machine P88/2/BASIC is a flexible unit with TWO DOUBLE molds specifically developed to mold bra cups in polyethylene and it can produce No.4 cups per cycle.

TECHNICAL FEATURES

• The machine consists of two molding heads where it is possible to put one male mold in upper position and one female countermold (fixed) on the lower table. The molds, not heated, are double (two cups on each mold) and the max dimensions are 350 x 250 x H=150 mm.

• The operator positions the rectangular pieces of polyethylene on the loading/unloading stations then he starts the molding cycle. Rectangular pieces of polyethylene are pre-heated by a group of quartz lamps with adjustable heating intensity.

• Easy and fast substitution of the moulds.

• The heating time is adjustable on a digital timer with buzzer to signal that the preset time has been reached

• Molding operation done with movement downwards of the upper mold towards the lower female mold with adjustable speed and molding time preset on a digital timer.

TECHNICAL DATAS

- Dimensions of the molds : 250 x 350 x H=150 mm
- Installed power : 3 kW 400V 50 Hz 3-phase +Neutral + Ground.
- Compressed Air : 6 bar min (58.5 PSI), 150 lt/hour.
- Time to change a size : 3 min

PRODUCTIVITY

- Movement time of the mold (down + up) : 4 sec
- Molding time : from 7 to 15 sec (adjustable)
- Heating time : approx. 10 sec (adjustable)
- Loading/unloading time : 10 sec approx
- Production : up to 600 cups/hour
A.M.P PISANI S.r.l. Via Ungaretti 6/8 27024 CILAVERGA (PV) ITALY
Phone ++39 0381/96128 Fax ++39 0381/969100
www.amppisani.com email: info@amppisani.com

P90

MOLDING MACHINE FOR BRA CUPS WITH ONE MOLD
MOLDING MACHINE FOR BRA CUPS WITH ONE MOLD P90

The machine P90 is a simple but flexible single-mold unit than can mold different types of materials (cotton, elastomeric fabrics, micro fibers, foam, multi-layer fabrics) including pre-cut pieces (i.e. cups with the shape to be sewn on the bra, no need of die cutting after molding) and in some cases even the finished garment (post-molding).

TECHNICAL FEATURES

- The machine consists of a molding area where the pieces are loaded/unloaded on a cold disk that can be changed depending on the size.
- The operator positions the pieces on the loading/unloading station then starts the molding cycle and waits until they are molded.
- The molding cycle consists of the descent from the top of a heated bell to keep uniform the temperature around the fabric and then a heated mold moves upwards for molding the cup.
- This exclusive system reduces the molding time even to 25 sec or less.
- Once the cycle is finished, the operator removes the molded cups and positions the new material.
- A simple adjustment enables the position of the mold in the heated bell to get the requested height of the cup.
- All setting of temperature and times are adjustable with digital timers and thermoregulators.
- PLC Controlled machine.
- The operation of changing a mold and the disk is easy and fast, no need to do any electrical connection.
- Presettable timer for automatic startup and shut down of the unit (on request).

ON REQUESTS
P90/BIG Machine for larger diameters of molds from 110 to 240 mm

TECHNICAL DATAS

- Max mold diameter ...................................................: 140 mm. (5’ ½)
- Max molding temperature .........................................: 250˚C.
- Installed power ......................................................: 3 kW 400V±5% 50 Hz 3-phase +Neutral+Ground.
- Compressed air ....................................................: 6 bar min (88.5 PSI), 200 lt/hour.
- Time to change a size ............................................: 2 min
MOLDING MACHINE FOR BRA CUPS WITH TWO MOLDS
MOLDING MACHINE FOR BRA CUPS WITH TWO MOLDS  P92

The machine P92 is a flexible unit with two molds than can mold different types of materials (cotton, elastomeric fabrics, micro fibres, multi-layer fabrics) including pre-cut pieces (i.e cups with the shape to be sewn on the bra, no need of die cutting after molding) and in some cases even the finished garment (post-molding).

TECHNICAL FEATURES

- The machine consists of two molding areas where the pieces are loaded/unloaded on a cold disk that can be changed depending on the size.
- The operator positions the pieces on the loading/unloading stations then starts the molding cycle and waits until they are molded.
- The molding cycle consists of the descent from the top of a heated bell to keep uniform the temperature around the fabric and then a heated mold moves upwards for molding the cup.
- This exclusive system reduces the molding time even to 25 sec or less.
- Once the cycle is finished, the operator removes the molded cups and positions the new material.
- A simple adjustment enables the position of the mold in the heated bell to get the requested height of the cup.
- All setting of temperature and times are adjustable with digital timers and thermoregulators.
- PLC Controlled machine
- The operation of changing the molds and the disks is easy and fast, no need to do any electrical connection.
- Presettable timer for automatic startup and shut down of the unit on request.

TECHNICAL DATAS

- Max mold diameter : 140 mm. (5 ½"
- Max molding temperature : 250˚C.
- Installed power : 6 kW 400V±5% 50 Hz 3-phase +Neutral+Ground.
- Compressed air : 6 bar min (58.5 PSI), 200 lt/hour.
- Time to change a size : 3 min.
P94

MOLDING MACHINE FOR BRA CUPS WITH TWO MOLDS AND ADJUSTABLE DISTANCE BETWEEN MOLDS
MOLDING MACHINE FOR BRA CUPS WITH TWO MOLDS AND ADJUSTABLE DISTANCE BETWEEN MOLDS P94

The machine P94 is a flexible unit with two molds that can mold different types of materials (cotton, elastomeric fabrics, micro fibers, multi-layer fabrics) including pre-cut pieces (i.e. cups with the shape to be sewn on the bra, no need of die cutting after molding) and in some cases even the finished garment (post-molding) but cannot mold foam materials.

TECHNICAL FEATURES

- Possibility to adjust the distance between the molds and the heated bell for molding the open garment with both cups on the same operation (one mold thermoform one cup).
- The machine consists of two molding areas where the pieces are loaded/unloaded on a cold disk that can be changed depending on the size.
- The operator positions the pieces on the loading/unloading stations and waits until they are molded.
- The molding cycle consists of the descent from the top of a heated bell to keep uniform the temperature around the fabric and then a heated mold moves upwards for molding the cup.
- This exclusive system reduces the molding time even to 25 sec or less.
- Once the cycle is finished, the operator removes the molded cups and positions the new material.
- A simple adjustment enables the position of the mold in the heated bell to get the requested height of the cup.
- All setting of temperature and times are adjustable with digital timers and thermoregulators.
- PLC Controlled machine
- The operation of changing the molds and the disks is easy and fast, no need to do any electrical connection.
- Presettable timer for automatic startup and shut down of the unit on request.

TECHNICAL DATAS

- Max distance between the molds : 120 mm. (4” 3/4)
- Min distance between the molds : 20 mm. (¾”)
- Max mold diameter : 140 mm. (5” ½)
- Max molding temperature : 250˚C.
- Installed power : 6 kW 400V±5% 50 Hz 3-phase +Neutral+Ground.
- Compressed air : 6 bar min (58.5 PSI), 200 lt/hour.
- Time to change a size : 3 min.
P94/E

MOLDING MACHINE FOR BRA CUPS WITH TWO MOLDS AND ADJUSTABLE DISTANCE BETWEEN THE MOLDS
MOLDING MACHINE FOR BRA CUPS WITH TWO MOLDS AND ADJUSTABLE DISTANCE BETWEEN THE MOLDS P94/E

The machine P94/E is a flexible unit with two molds that can mold different types of materials (cotton, elastomeric fabrics, microfibers, multi-layer fabrics) including pre-cut pieces and in some cases even the finished garment.

TECHNICAL FEATURES

- The molding cycle consists of the descent from the top of a heated bell then a heated mold moves upwards for molding the cup with the possibility to adjust the distance between the molds and the heated bell for molding the open garment with both cuts on the same operation.
- All setting of temperature and times are adjustable with digital timers and thermoregulators.
- Thermocouple for the measurement of the mould temperature installed on the external part of the mould support with possibility to compensate the offset to display the actual temperature of the mould.
- Molding pressure pneumatically adjustable and moulding plate coated with silicon foam.
- Presettable timer for automatic start-up and shut down of the unit (on request).
- Clamping device of the open bra with adjustable pliers (on request).
- Memorization, data acquisition and setup of digital thermoregulators directly from operator panel through a code.
- Position of the molds inside the heated bells and displacement speed (positioning accuracy 0.1 mm) programmable by operator panel to get the requested cup depth with memorization in the PLC memory. Programmable molding time with memorization in the PLC memory.

TECHNICAL DATAS

- Mold diameters: from 80 mm to 130 mm
- Distance between molds: from 25 mm to 120 mm
- Max mold temperature: 250°C.
- Max temperature of the heated bells: 260°C.
- Max disk temp. on the heated bells: 250°C.
- Installed power: 6 kW 400V±5% 50Hz 3-phases+Neutral+P.E.
- Compressed air: 6 bar min (58.5 PSI), 130 Lt/hour.
- Time to change a size: 3 min.
P96

MOLDING MACHINE FOR BRA CUPS WITH TWO MOLDS AND ROTARY TABLE
MOLDING MACHINE FOR BRA CUPS WITH TWO MOLDS AND ROTARY TABLE P96

The machine P96 is a high productivity two molds unit with rotary table that can mold different types of materials (cotton, elastomeric fabrics, micro fibers, multi-layer fabrics) including pre-cut pieces (i.e. cups with the shape to be sewn on the bra, no need of die cutting after molding) and in some cases even the finished garment (post-molding).

TECHNICAL FEATURES

- The machine consists of a rotary table with two loading/unloading stations and two molding stations at a distance of 90°.
- The operator positions the pieces on the two loading/unloading areas while the machine is molding the pieces on the remaining two stations.
- The molding cycle consists of the descent from the top of a heated bell to keep uniform the temperature around the fabric and then a heated mold moves upwards for molding the cup.
- This exclusive system reduces the molding time even to 25 sec or less.
- Once the cycle is finished, the table turns of half revolution to enable the loading/unloading of the thermoformed pieces while the machine is molding the new materials. The total cycle time is about the same of the molding time as the machine does not wait for the positioning of the pieces and therefore the productivity is much higher than machines without the rotary table.
- A simple adjustment enables the position of the mold in the heated bell to get the requested height of the cup.
- All setting of temperature and times are adjustable with digital timers and thermoregulators.
- PLC controlled machine with operator terminal to set machine datas and display alarm messages.
- The operation of changing a mold and/or a disk is easy and fast, no need to do any electrical connection.
- Presettable timer for automatic startup and shut down of the unit standard on the machine.

TECHNICAL DATAS

- Max mold diameter ...................................... : 140 mm. (5 ½"
- Max molding temperature ........................... : 250˚C.
- Installed power ............................................ : 6,5 kW 400V±5% 50 Hz 3-phase +Neutral+Ground.
- Compressed air ............................................ : 6 bar min (58.5 PSI), 200 lt/hour).
- Time to change a size ................................. : 3 min
P96/2

MACHINE FOR MOLDING BRA CUPS, TWO STATIONS, FOUR MOLDS AND TWO ROTARY TABLE
MACHINE FOR MOLDING BRA CUPS, TWO STATIONS, FOUR MOLDS AND TWO RotARY TABLE P96/2

The machine P96/2 is a ultra-high productivity unit with rotary table consisting of two double mold P96 machine heads connected to one electric box that can mold different types of materials (cotton, elastomeric fabrics, micro fibres, multi-layer fabrics) including pre-cut pieces (i.e. cups with the shape to be sewn on the bra, no need of die cutting after molding) and in some cases even the finished garment (post-molding). One operator can control the complete unit and it is possible to get a production double than a P96 unit.

TECHNICAL FEATURES

- The machine consists of two P96 machine heads, each one with circular rotary table, two loading/unloading stations and two molding stations on the other side of the table.
- On each unit, the operator positions the pieces on the loading/unloading areas while the machine is molding the pieces on the remaining stations.
- The molding cycle consists of the descent from the top of a heated bell to keep uniform the temperature around the fabric and then a heated mold moves upwards for molding the cup.
- This exclusive system reduces the molding time even to 25 sec or less.
- Once the cycle is finished, each table turns of half revolution to enable the loading/unloading of the thermoformed pieces while the machine is molding the new materials. The total cycle time is about the same of the molding time as the machine does not wait for the positioning of the pieces and therefore the productivity is much higher than machines without the rotary table.
- A simple adjustment enables the position of the mold in the heated bell to get the requested height of the cup.
- All setting of temperature and times are adjustable with digital timers and thermoregulators.
- Machine equipped with PLC and operator terminal to set machine datas and display alarm messages.
- The operation of changing a mold and/or a disk is easy and fast, no need to do any electrical connection.
- Presetable timer for automatic start-up and shut down of the unit standard on the machine.

TECHNICAL DATAS

- Max mold diameter ...................................................: 140 mm. (5" ½)
- Max molding temperature .........................................: 250˚C.
- Installed power ..........................................................: 13 kW 400V±5% 50 Hz 3-phase +Neutral+Ground.
- Compressed air .........................................................: 6 bar min (58.5 PSI), 400 l/hour).
- Time to change a size ....................................................: 5 min
P96G

MOLDING MACHINE FOR FOAM PIECES WITH ROTARY TABLE
The machine P96G is a high productivity two molds unit with rotary table that can mold different types of rectangular foam pieces max dim. 22 x 36 cm used for padding of sportswear such as the gusset for biking trousers.

TECHNICAL FEATURES

- The machine consists of a rotary table with two loading/unloading stations and two molding stations.
- The operator positions the pieces on the loading/unloading area while machine is molding the pieces on the other side.
- The molding cycle consists of the descent from the top of the upper molds then the lower molds move upward to mold the material.
- The normal molding time is from 20 to 50 sec depending of the type of material.
- After molding, the rotary disk turns of half revolution to unloading the moulded pieces while the new material goes to the molding area.
- The heating resistances are located on the plates to support the mold therefore it is sufficient to plug the socket of the thermocouples inside the mold for temperature control to the machine.
- The rectangular mold support has sloped sides for an easy positioning of the mold in the machine and to reduce to 2-3 min the time to change a mold. If new mold has been previously heated with an oven and machine is immediately in operation.
- All setting of temperature and times are adjustable with digital timers and thermoregulators.
- PLC controlled machine with operator terminal to set machine datas and display alarm messages.
- Presettable timer for automatic startup and shut down of the unit standard on the machine.

TECHNICAL DATAS

- Max dimensions of the mold .........................: 220 x 360 mm.
- Max molding temperature ...........................: 250˚C.
- Installed power ............................................: 12 kW 400V±5% 50 Hz 3-phase +Neutral+Ground.
- Compressed air ............................................: 6 bar min (58.5 PSI), 200 lt/hour).
- Time to change a size .................................: 3 min
PR_STAMPI
PRE-HEATING MACHINE FOR MOLDS
PRE-HEATING MACHINE FOR MOLDS CLASS PR_STAMPI

The machine PR_STAMPI is a unit for heating at the same time two molds for our machines class P90, P92, P94, P96, P96/2 for elastic fabrics

TECHNICAL FEATURES

- The machine consists of two support for molds protected by a guard.

- The operator positions the molds then he sets the heating temperature on digital thermoregulators.

- The unit can be used in prototyping departments equipped with single mold machine for sampling or in production departments to eliminate the waiting time (15-20min) for heating the new mold in the machine.

- The heating time up to 200 °C is 15-20 min

TECHNICAL DATAS

- Max molding temperature ..................: 250°C.
- Installed power ............................: 1,6 kW 220V±5% Single phase + ground.
PR_88
PRE-HEATING MACHINE FOR MOLDS OF FOAM CUPS
The machine PR_88 is a unit for heating at the same time two molds + two countermolds for our molding machines class P88

TECHNICAL FEATURES

• The machine consists of four support for molds protected by a guard.

• The operator positions the molds then he sets the heating temperature on digital thermoregulators.

• The unit can be used in prototyping departments equipped with single mold machine for sampling or in production departments to eliminate the waiting time (40-50min) for heating the new mold in the machine.

• The heating time up to 200 °C is about 40-50 min

TECHNICAL DATAS

- Max temperature ........................................: 220°C.
- Installed power .......................................: 12 kW 380 V±5% 3-phase + ground.
"ERGO" TYPE WITH ANATOMIC SHAPE
MOULD
FOR MACHINES P90 P92 P96

MOULD AND COUNTERMOULD FOR FOAM
FOR MACHINES CLASS P88

CIRCULAR MOULD
FOR MACHINES P90 P92 P94

MOULD AND COUNTERMOULD FOR FOAM
FOR MACHINES P90 P92 P96
RTC02 – ROBOT CUTTER FOR MOLDED BRA CUPS IN FOAM

FULLY AUTOMATIC SYSTEM FOR TRIMMING MOLDED FOAM CUPS.

ADVANTAGES:

VERY HIGH ACCURACY OF POSITIONING OF THE CUTTER

3-DIMENSIONAL CUT ALWAYS PERPENDICULAR TO THE MATERIAL

ACCURACY OF CUT ON THE CUPS: +/- 0,5 MM

(Accuracy depends on shrinkage of foam material after cut, can be different depending on the material)

NO NEED OF SKILLED OPERATOR

PRODUCTIVITY: Up to 4 pairs/min (up to 8 cups/min)

ALREADY RUNNING IN FACTORIES OF APPAREL INDUSTRY FOR THE DAILY PRODUCTION
FULLY AUTOMATIC MACHINE FOR CUTTING RECTANGULAR PIECES OF FOAM
**LTR1600 FULLY AUTOMATIC MACHINE FOR CUTTING RECTANGULAR PIECES OF FOAM**

**DESCRIPTION OF THE MACHINE:**
The automatic cutting system for laminated foam rolls class LTR1600 automatically cut rectangular pieces from a foam roll of large dimensions (max diam 150cm, max width 160cm) with automatic stacking of the cut pieces.

The operator loads the foam roll on the machine then he sets up the length and the quantity of rectangles requested for the production lot plus (with option device LTR/AUTO) the cutting width of each strip.

**TECHNICAL FEATURES:**
- 9 Blades groups equipped with one sharpener for each group and located under the material
- HSS steel blades diam. 150 mm cutting on an upper plate to support the material with a slot for the blade
- Each blade group has one single motor for blade rotation (fixed speed).
- Strongly recommended the device LTR/AUTO Automatic positioning system of the blades to the preset cutting width programmable on a touch screen panel. Blades move automatically to preset cutting width.
- A metering system with pliers pulls the laminated foam through the blades till to the preset cutting length
- The strips of material obtained will be separated by a transversal cutter and the rectangles will drop on the conveyor belt
- Once the full lot will be stacked and unloaded, conveyor belt will return to initial position to restart operations.
- Operator can remove the foam rectangles while machine is cutting and stacking the next lot (no idle time for unloading, machine always runs)
- Available on request a mechanic platform to move upwards the laminated foam roll for easy handling. When the roll is position, two chucks with expanding pliers will enter in the papertube to clamp and rotate the roll for feeding the material towards the cutting section (Device LTR/LOAD)
- Lazy loop device to feed the fabric without tension
- Roll platform with an area to keep a second roll in position ready for loading
- All the positioning devices and numeric controls for each positioning function guarantees the best possible accuracy of positioning but the final result depends on the material therefore the accuracy on the material could be less.

**ADVANTAGES:**
- The space occupation of this unit is 4.5 x 3.8 mt and it does the same production of a spreader plus a CNC cutter, therefore the investment and the space occupation for this unit is much less.
- One operator is able to cut and stack up 60 pieces/min (up to 3.600 pieces/hour)
- Huge reduction of manpower cost.
- No need of using a CNC cutter or a roll slitting machines.

**DEVICES ON REQUEST**
- LTR/AUTO Automatic positioning of the blades to the preset cutting width with step motor on each blade and automatic programmable sharpening system of the blades (recommended device)
- LTR/LOAD Mechanic platform for an easy loading of the roll on the unwinding device
- LTR/TV Camera with external TV screen to see inside the machine during automatic run

**TECHNICAL DATAS:**
- Minimum cycle time: 5.5 sec
- Average cycle time: 5.5 to 6.5 sec
- Blade diameter: 150 mm in HSS steel
- Number of blades: 9
- Positioning accuracy of pliers to cutting length: +/- 1 mm
- Positioning accuracy of blades to cutting width: +/- 0.5 mm with LTR/AUTO device
- Internal diameter of the foam roll tube: 150 mm (available on requests up to 200mm)
- Max dimensions of foam roll: Diam. 150cm, Width 160cm, Weight kg. 150
- Max length of each rectangle: up to 400mm
- Minimum cutting width of each rectangle: 100 mm
- Max stacking height: 38 cm
- Voltage: 400V ±5% 50Hz 3-phases (other voltages on request)
- Space requirements and weight: 550 x 380 cm
- Weight: 3.500 kg
- Installed power: 5.5 kW
- Compressed air: 6 bar