



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

Phone +39 0381 96128

Fax +39 0381 969100

[www.amppisani.com](http://www.amppisani.com)

[info@amppisani.com](mailto:info@amppisani.com)

## **MOLDING MACHINES**

### **GENERAL CATALOGUE**





## PRESENTATION OF THE COMPANY



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

For more than 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.

Collarettie 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 and 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**

- Molding machines for foam and spacer fabrics class P88
- Molding machines for fabric with two molds class P92, P94, P96 P96/XXL P96/R170
- Single head molding machine P90 for small lots or prototyping (P90/XXL available for large sizes)
- Special molding machines for technical applications

### **2. AUTOMATIC AND MANUAL ROLL SLITTERS FOR ANY APPLICATION**

- Automatic and numerically controlled roll slitting machines class T/1800F, T1000/E\_LFT, T1000EX T/540 T/520EX T/500EX and automatic pneumatic model T/300EX.
- Manual roll slitting machines class T/100EX, T/50EX and T50EX\_HD

### **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 GCT and SPR/SYNCR0 or in the 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
- 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

Our R & D department is at your service for special applications and for customized projects

**THE BROCHURES OF ALL OUR MACHINES CAN BE DOWNLOADED**

**FROM OUR WEB SITE WEB [www.amppisani.com](http://www.amppisani.com)**



## AMP PISANI RANGE OF MOLDING MACHINES FOR BRA CUPS

AMP Pisani, a leading manufacturer of cutting room machines, has about 30 years of experience in the production of bra molding machines. AMP Pisani is also technical partner of important multinational groups and market leader of European companies.

Extensive experience in thermoforming allows AMP Pisani to offer a 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 foam, fabric, spacer fabrics, polyethylene cups and special applications

The machines have the following features:

1. All machines for fabric cup molding have a unique molding system of fabric 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) much shorter molding time (half time of the conventional systems;
  - c) no variation in the color of the molded fabric;
  - d) costs of molds greatly reduced.
  - e) the machines 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
2. The machines for fabric cups can mold:
  - a) Pre-cut fabrics and no die-cut (final shape) as a standard use;
  - b) A finished bra (Post-molding, feasibility depends on the style and on the material of the garment);
  - c) In case of a very deep neckline or with some special material, molding will be done with square fabrics and further die-cut of the shape with a clicking press or similar machine;
  - d) A seamless bra;
3. The machines class P88 can mold foam, foam laminated with fabric and spacer fabric .
4. Exact repeatability of all the molding parameters (heating temperatures, molding time, depth of the cup).
5. All the models (for foam and fabric) have a **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.
6. Heating resistances and thermocouple are inserted in the supports of molds and in the disks and plates of the fabric molding units. No need to have resistances on every mold or disk and faster heating of the machine at the start.
7. All machines ergonomically designed and protected against accidental contacts of the operator with any heated part



## MACHINES FOR FOAM AND SPACER FABRIC

	P/88/2E	P88/4E	P88/6E
NUMBER OF MOLDS	<b>2</b>	<b>4</b>	<b>6</b>
PLIERS TO HOLD THE MATERIAL	✓	✓	✓
MOLDING OF SPACER FABRIC	✓	✓	✓
PROGRAMMABLE START-UP TIMER	<b>R</b>	✓	✓
LASER POSITIONING	<b>R</b>	<b>R</b>	<b>R</b>

## MACHINES FOR FABRIC

	P90 P90/XXL	P92 P92/XXL	P94	P96 P96/XXL	P96/R170
NUMBER OF MOLDS	<b>1</b>	<b>2</b>	<b>2</b>	<b>2</b>	<b>2</b>
FIXED TABLE	✓	✓	✓		
ROTARY TABLE				✓	✓
ADJUSTMENT OF DISTANCE BETWEEN THE MOLDS			✓		✓
PROGRAMMABLE START-UP TIMER	<b>R</b>	<b>R</b>	<b>R</b>	✓	✓
LASER POSITIONING				<b>R</b>	<b>R</b>

✓ = STANDARD    **R** = ON REQUESTS



## BENEFITS OF AMP PISANI MOLDING SYSTEM FOR FOAM COMPARED WITH CONVENTIONAL SYSTEMS

CONVENTIONAL SYSTEMS	AMP PISANI FOAM MOLDING SYSTEM
<p>Not all the molding machines in the market have the movable plate.</p> <p>If existing, the adjustment of the foam braking during the movement of the material along the surface of the mold is not simple</p>	<p>The models E have a movable plate with laser cut shape for the following purposes:</p> <ul style="list-style-type: none"> <li>a) Eliminate the creases in the very deep cups or for low density laminated foam.</li> <li>b) In some case it is possible to reduce the dimension of the rectangle to mold with consequent saving of the material</li> <li>c) Very accurate adjusting of the braking by adjusting the compression of the material with increments of 0,1 mm</li> </ul>
Not possible to fix in position the MEGOL part during the molding	Possible molding of the material with insertion of a part in MEGOL to be used instead of steel wire because the clamp plate of the model E holds in position the MEGOL part during the movement of the upper mold.
Difficult adjustment of the closing distance. It requests a lot of time and excellent mechanic skills	Easy adjustment of the closing distance between the molds with increments of 0,1mm
<p>Time to change the mold could be quite long.</p> <p>The centering and alignment of the molds is difficult and it takes a long time</p>	<p>Time to change the mold very quick (not more than 5 min for one set of male + female mold)</p> <p>It is enough to put on the lower heating plate the male mold then to tighten two screws on the upper female mold support and the mold is ready, perfectly centered</p>
<p>Pre-heated molds cannot be manipulated easily and cannot be installed.</p> <p>It needs to wait the heating of the mold to start the operation</p>	<p>Possibility to load the pre-heated molds with a device to put on a forklift.</p> <p>The downtime of the machine is very short.</p>
Not possible such an accurate precision	Very precise and parallel descent of the upper mold with parallelism error of less than 0,1mm
Temperature control could not be very stable	Temperature control very stable along the whole working shift.
There are still in the market machines with the resistances inside the mold.	Heating resistances in the mold support plate (not into the mold). Only the thermocouple is in the mold and it can be easily connected to the temperature control system with a plug



## BENEFITS OF AMP PISANI MOLDING SYSTEM FOR FABRIC COMPARED WITH CONVENTIONAL SYSTEMS

CONVENTIONAL SYSTEMS	AMP PISANI SYSTEM
Hot air exits from the lower female mold. Inside the female mold the temperature is much less than on the metal	Hot air stays inside the upper oven. The temperature is just a little bit less than the metal
Positioning of the fabric on a hot mold. Not ergonomic for operator, operator exposed to hot air and high risks of burns	Positioning of the fabric on a cold table "C". Ergonomic for operator, no exposition of the operator to hot air, no risks of burns
Difficult to mold from pre-cut pieces with the final shape to stitch on the bra or molding from square pieces. Waste of material. Cutting operation after molding	Normally running with pre-cut pieces of Cotton/Spandex material. Save of fabric from 10% to 30% compared with molding from square pieces No cutting operation after molding
Time to change the mold in many cases quite long	Time to change the mold very quick (not more than 5 min for 2 molds)
Need to increase temperature and molding time because inside the female mold "B" the temperature is less. Molding time from 25 to 45 sec	No need to increase temperature and molding time because inside the oven "A" the air is hot. Better molding results. Molding time from 15 to 25 sec
Adjustment of the molding depth not easy	Very easy adjustment of the molding depth
Temperature control sometimes with temperature not very stable	Temperature control very stable along the whole working shift.
Strong change of color after molding. Shining on black and dark fabrics	Very less change of color after molding. No shining on black and dark fabrics

The steps of molding with AMP Pisani innovative system are:

STEP 1 → Positioning of the pre-cut pieces on the cold disk

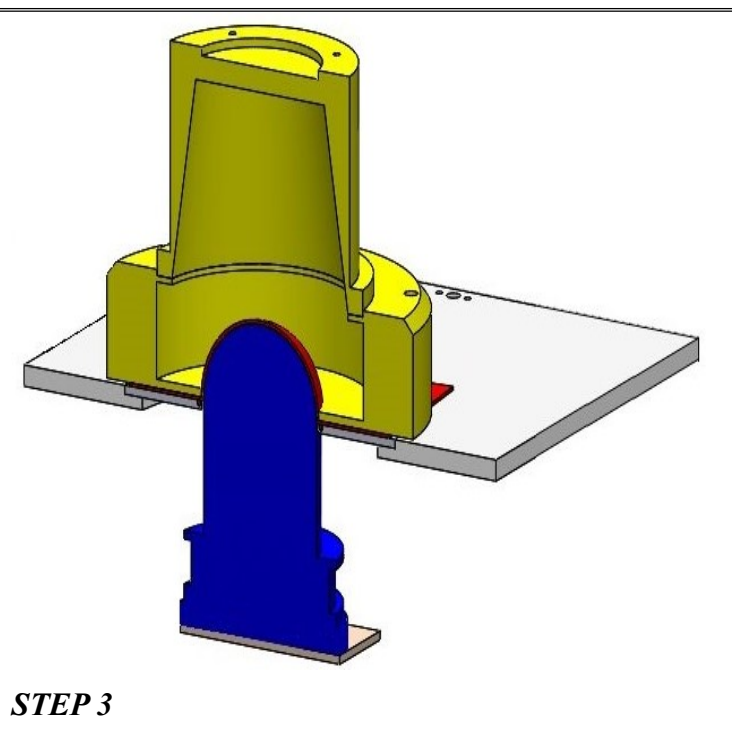
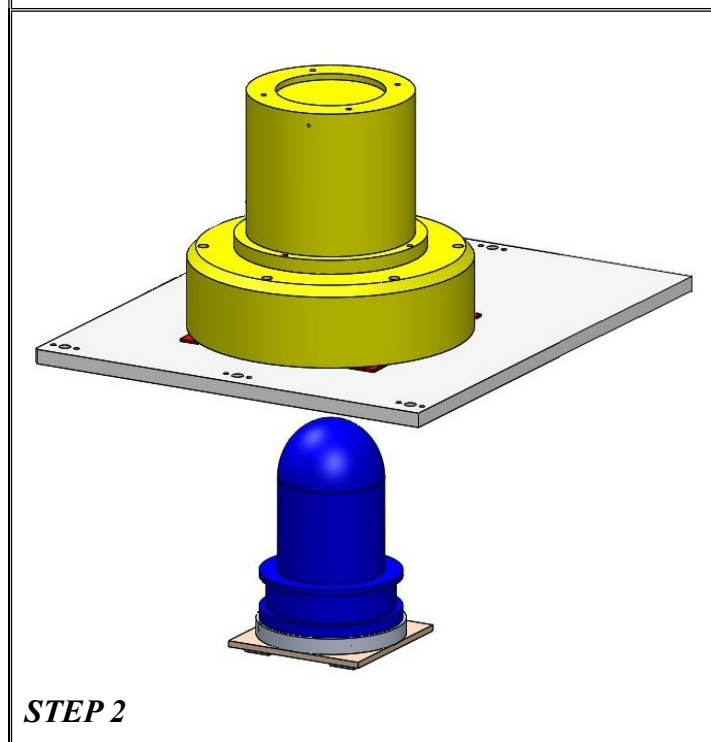
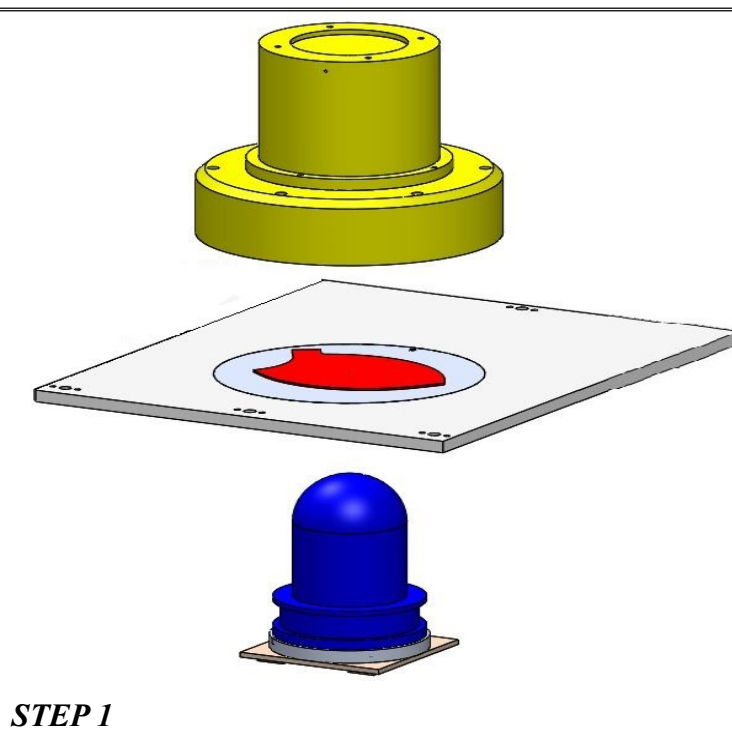
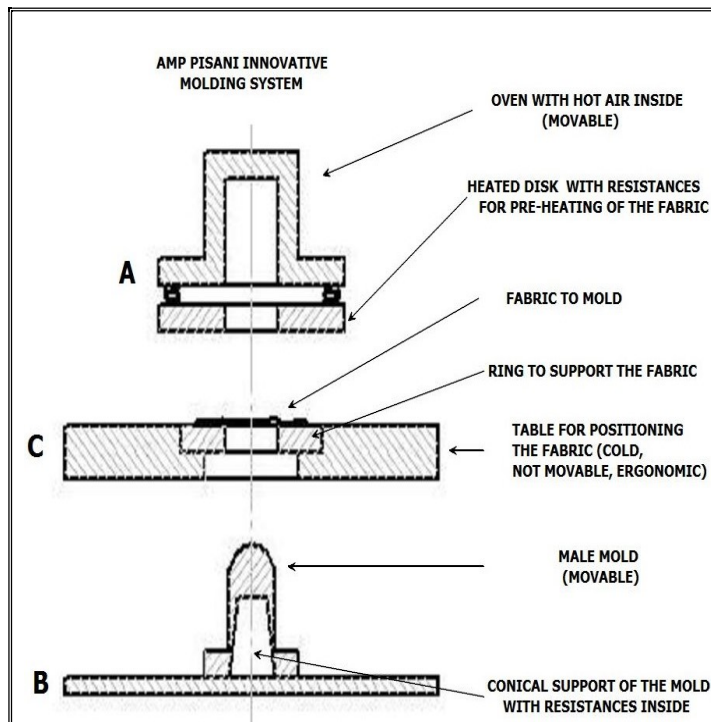
STEP 2 → Descent of the upper oven "A" on the material.  
An heated ring give a pre-heating on the fabric.

STEP 3 → Movement upwards of the male mold "B" to do the molding operation.

In the conventional molding system the operator positions the fabric on the hot lower female mold then male mold moves downwards

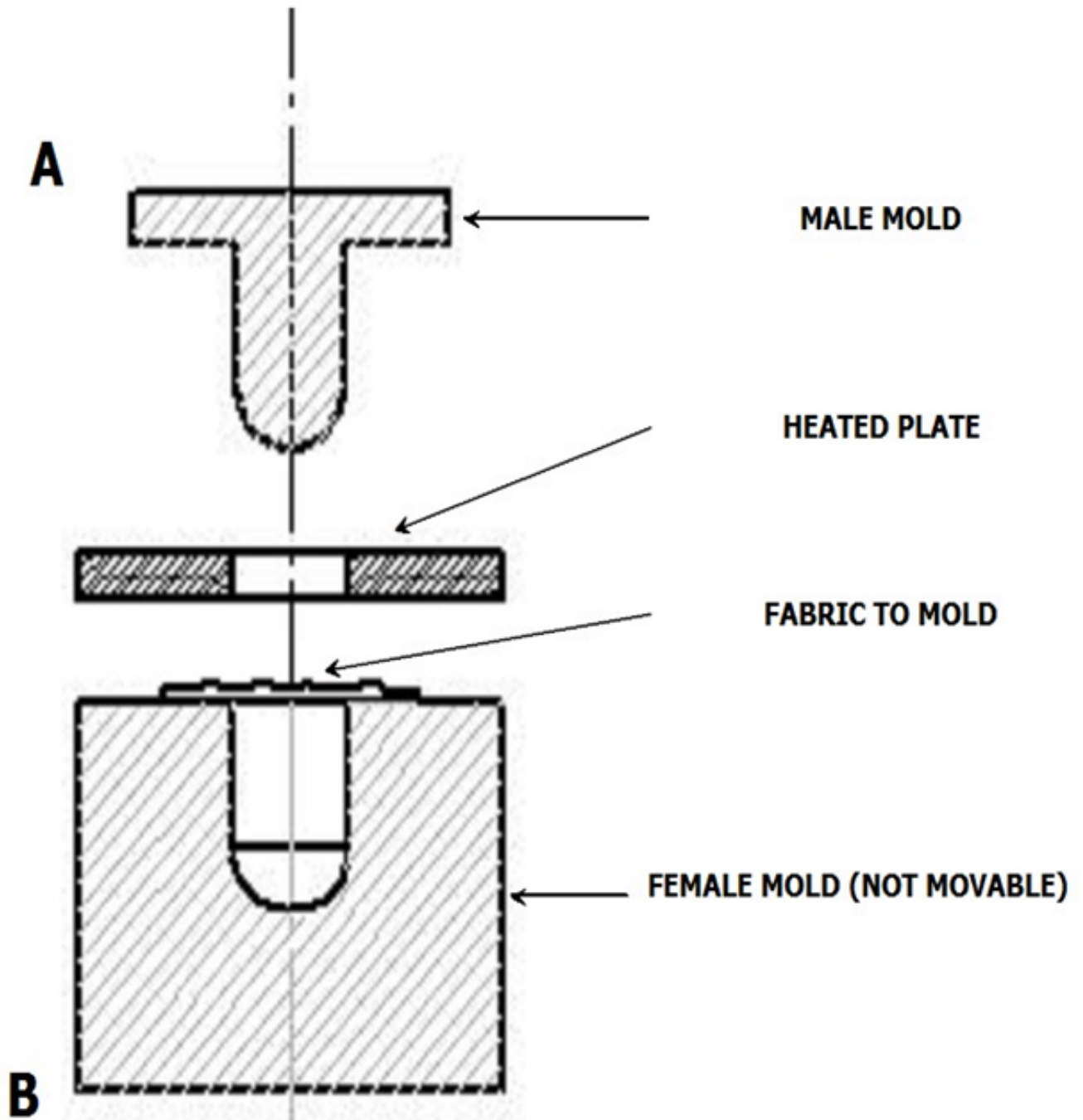


### AMP PISANI FABRIC MOLDING SYSTEM





**CONVENTIONAL MOLDING SYSTEM**





**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



**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 400 x 280 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.
- 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 ..... : 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 180 sec depending on the material
- Loading/unloading time ..... : 10 sec approx
- Production ..... : up to 100 cups/hour (for a molding time of 2 min)



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto: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 400 x 280 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.
- 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 .....: 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 180 sec depending on the material
- Loading/unloading time .....: 10 sec
- Production .....: up to 200 cups/hour (for a molding time of 2 min)



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



**P88/6E**

**MOLDING MACHINE FOR BRA CUPS IN FOAM WITH SIX MOLDS**



## **MOLDING MACHINE FOR BRA CUPS IN FOAM WITH SIX MOLDS CLASS P88/6E**

The machine P88/6E is a flexible unit with six DOUBLE molds and pliers specifically developed to mold bra cups in FOAM which produce No. 12 cups for each molding 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 normally double (two cups on each mold) and the max dimensions are 400 x 280 x H=150 mm.
- The operator positions the rectangular pieces of foam on the lower molds 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 P90/TIM 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 .....: 36 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 60 to 180 sec depending on the material
- Loading/unloading time .....: 12 sec
- Production .....: up to 300 cups/hour (for a molding time of 2 min)



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



## **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 counter mold (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 CILAVEGNA (PV) ITALY**

**Phone +39 0381 96128 Fax +39 0381 969100**

**[www.amppisani.com](http://www.amppisani.com) email: [info@amppisani.com](mailto: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 fabrics (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 to 20 - 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 with touch screen terminal.
- The operation of changing a mold and the disk is easy and fast, no need to do any electrical connection.
- Presetable timer for automatic start-up and shut down of the unit (on request).

### ON REQUESTS

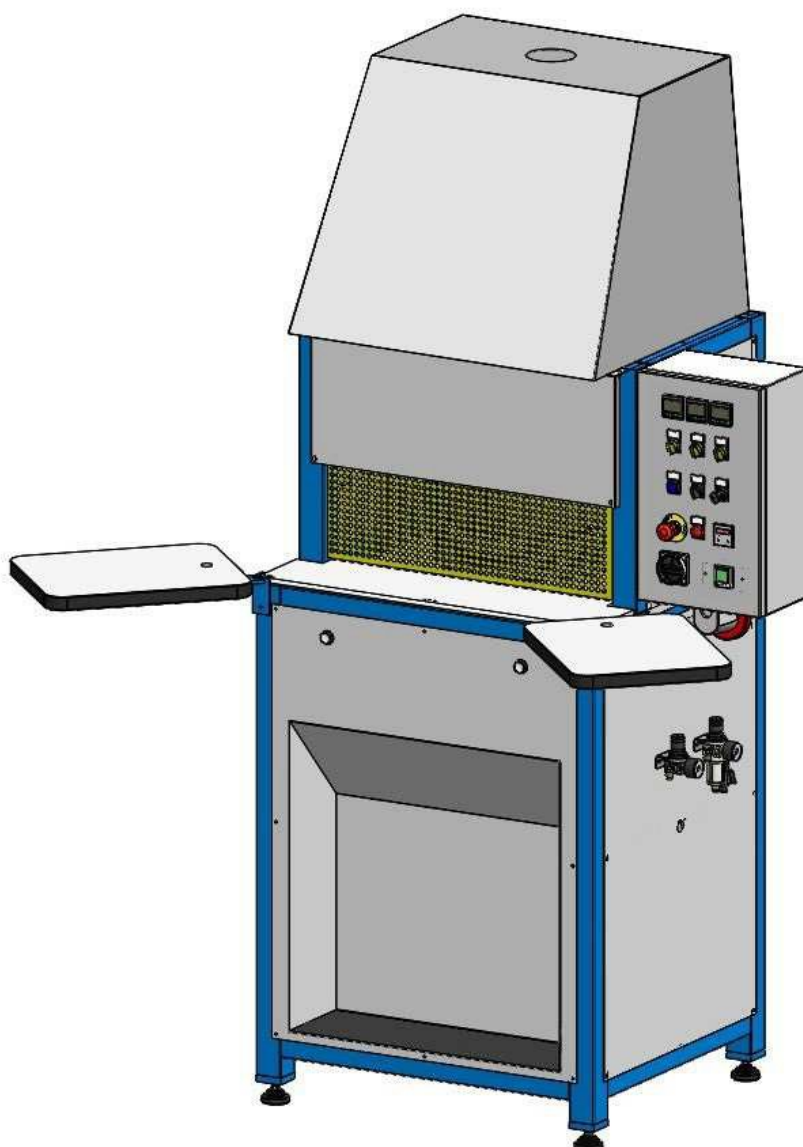
**P90/XXL** Machine for larger mold diameter from 140 to 295 mm

### TECHNICAL DATAS

- Max mold diameter .....: 195 mm. (7" ½)
- Min mold diameter .....: 77 mm. (3")
- Max molding temperature .....: 250°C.
- Installed power .....: 3 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 .....: 2 min



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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)



**P90/XXL**

**MOLDING MACHINE FOR LARGE BRA CUPS WITH ONE MOLD**



## MOLDING MACHINE FOR BRA CUPS WITH ONE MOLD BIG SIZE P90XXL

The machine P90XXL is a simple but flexible single-mold big size unit than can mold different types of materials (cotton, elastomeric fabrics, foam, microfibers, 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 to 20 - 25 sec or less depending on the type of material.
- 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 start-up and shut down of the unit (on request).

### TECHNICAL DATAS

- Max mold diameter .....: 295 mm. (11" ½)
- Min mold diameter .....: 140 mm. (5" ½)
- Max mold height.....: 200 mm ( 7" 7/8)
- Upper disk diameter.....: 400 mm (15" 7/8)
- Max molding temperature ..... : 250°C.
- Installed power .....: 10 kW 400V±5% 50 Hz 3-phase + Neutral + Ground.
- Compressed air ..... : 6 bar min (58.5 PSI), 200 liter / hour).
- Time to change a size ..... : 3 min.



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



**P92**

**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 the 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 to 20 - 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 P90/TIM for automatic start-up and shut down of the unit on request.
- On request, machine available with the option P92/XL for max diameter improved to 215 mm

### **TECHNICAL DATAS**

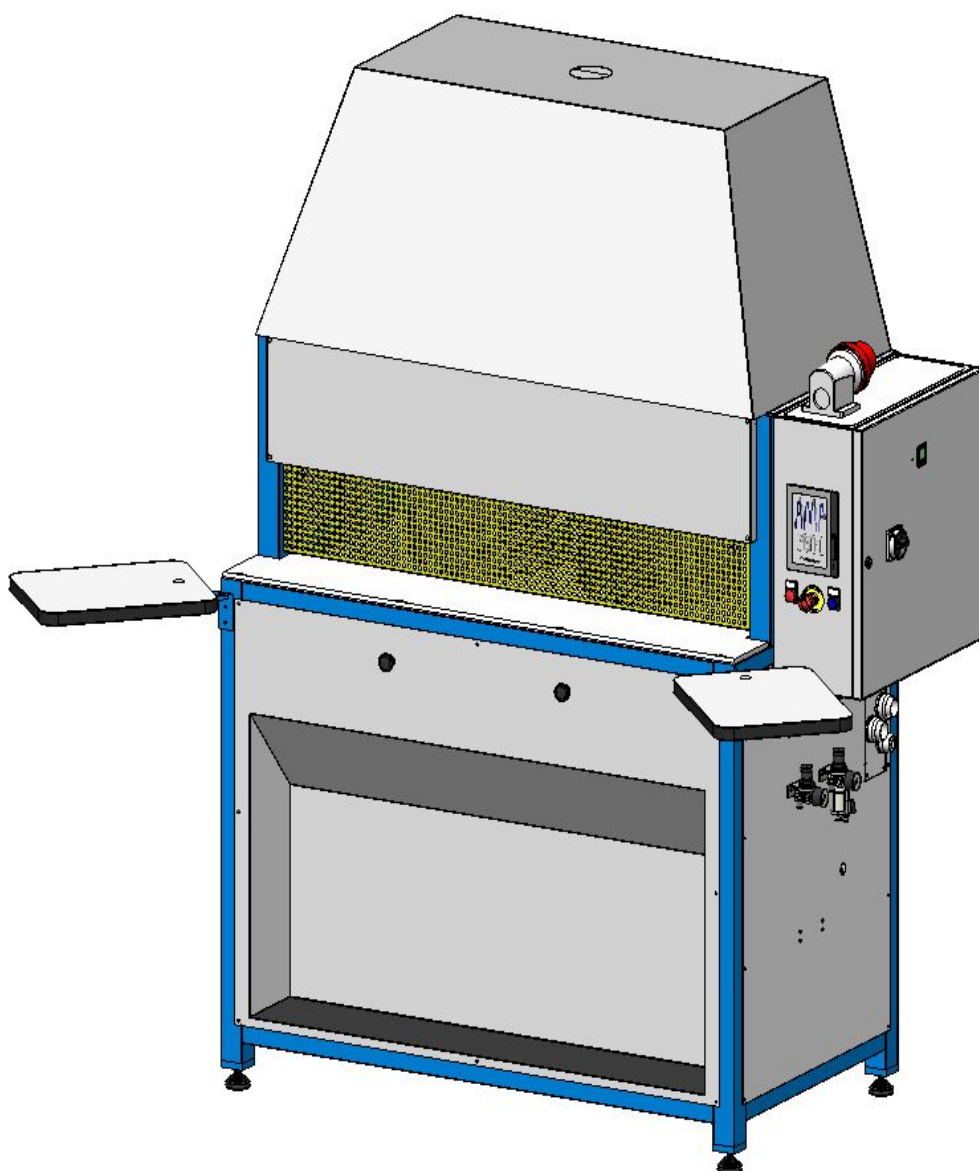
- Max mold diameter ..... : 195 mm. (7" ½)
- Max molding temperature ..... : 250°C.
- Installed power ..... : 6 kW 400V±5% 50 Hz 3-phase +Neutral+Ground.
- Compressed air ..... : 6 bar min (58.5 PSI), 200 lt/hour).
- Time to change a mold ..... : 3 min.



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



**P92/XXL**

**MOLDING MACHINE FOR LARGE BRA CUPS WITH TWO MOLDS**

## MOLDING MACHINE FOR BRA CUPS WITH TWO MOLDS BIG SIZE P92/XXL

The machine P92/XXL is unit with two big size molds unit than can mold different types of materials (cotton, elastomeric fabrics, foam, microfibers, 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 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 the heated bells to keep uniform the temperature around the fabric and then the heated molds move upwards for molding the cups.
- This exclusive system reduces the molding time from 20 to 25 sec or less depending on the type of material.
- 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 start-up and shut down of the unit (on request).

### TECHNICAL DATAS

- Max mold diameter .....: 295 mm. (11" ½)
- Min mold diameter .....: 140 mm. (5" ½)
- Upper disk diameter.....: 400 mm (15" 7/8)
- Max molding temperature .....: 250°C.
- Installed power .....: 20 kW 400V±5% 50 Hz 3-phase + Neutral + Ground.
- Compressed air .....: 6 bar min (58.5 PSI), 200 liter / hour).
- Time to change a size .....: 3 min.



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



## **P94**

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



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

The machine P94 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) 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 the 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 to 20 - 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.
- Presetable timer for automatic startup and shut down of the unit on request.

### TECHNICAL DATAS

- Max distance between the molds .....: 120 mm. (4"  $\frac{3}{4}$ )
- Min distance between the molds .....: 15 mm. (9/16 ")
- Max molding temperature .....: 250°C.
- Installed power .....: 6 kW 400V $\pm$ 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.



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



**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 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 unit 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 to 20 - 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.
- Presetable timer for automatic startup and shut down of the unit standard on the machine.
- On request, machine available with the option P96/XL for max diameter improved to 215 mm

### TECHNICAL DATAS

- Max mold diameter .....: 195 mm. (7" 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



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



**P96/XXL**

**MOLDING MACHINE FOR BRA CUPS  
WITH TWO MOLDS OF LARGE DIAMETER AND ROTARY TABLE**

## **MOLDING MACHINE FOR BRA CUPS OF LARGE DIAMETER WITH TWO MOLDS AND ROTARY TABLE P96/XXL**

The machine P96/XXL is a high productivity two molds unit with rotary table 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).

### **TECHNICAL FEATURES**

- Machine consists of a rotary table with two loading/unloading stations and two molding stations on the opposite side.
- 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 to 20 - 25 sec or even less.
- Once the cycle is finished, the circular table controlled by a brushless motor 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 therefore the productivity is much higher than with 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 touch screen panel to set machine data 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**

- Maximum mold diameter .....: 295 mm. (11" 9/16)
- Minimum mold diameter .....: 140 mm. (5" ½)
- Max molding temperature .....: 250°C.
- Installed power .....: 20 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



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



**P96G**

**MOLDING MACHINE FOR FOAM PIECES WITH ROTARY TABLE**



## MOLDING MACHINE OF FOAM PIECES WITH TWO MOLDS AND ROTARY TABLE P96G

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 biker pants pads.

### 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 variable 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



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



## **P96/R170**

**MOLDING MACHINE FOR FABRIC WITH ROTARY TABLE  
AND ADJUSTABLE DISTANCE BETWEEN THE MOLDS**

## **P96/R170 MOLDING M/C FOR BRA CUPS WITH TWO MOLDS ADJUSTABLE DISTANCE AND ROTARY TABLE**

The machine P96/R170 is a high productivity two molds unit with rotary table and adjustable distance between the two heads that can mold different types of fabrics (cotton with elastomeric fabrics, microfibers, 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).

This unit is also available in the model P96/R180 for molds with maximum diameter 180 mm

### **TECHNICAL FEATURES**

- Machine consists of a rotary table with one loading/unloading area and one molding area on the opposite side.
- The distance between the molds is adjustable from 15 mm to 270 mm.
- The upper and lower plates can be made with the distance between the holes for the molds from 15 mm to 270 mm upon request
- The operator positions the pieces on the loading/unloading area while the machine is molding the pieces on the opposite area.
- 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.
- 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.
- 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 data and display alarm messages.
- The loading/unloading operation for 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 .....: 170 mm. (6" ½)
- Min distance between the molds .....: 15 mm. (9/16 ")
- Max molding temperature .....: 250°C.
- Installed power .....: 10 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



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



**P88/BIG**  
**MOLDING MACHINE FOR SPECIAL APPLICATIONS**

## **MOLDING MACHINE FOR SPECIAL APPLICATIONS CLASS P88/BIG**

The machine P88/BIG is a flexible unit for special applications which accepts one mold in aluminium with maximum dimensions 60 x 47 cm or two molds with maximum dimensions 29 x 47 cm

The unit can be used for prototyping or for molding components of small dimensions in alternative to a more expensive molding with a steel mold.

### **TECHNICAL FEATURES**

- The machine consists of two molding heads, where two molds of maximum dimensions 29 x 47 cm or a mold of maximum size 600 x 470 mm can be mounted.
- The operator positions the pieces to mold then starts the operation.
- 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 operation of changing the molds is easy and fast. It is enough to connect the thermocouple plug to the socket on the machine.
- 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 and avoid the creation of creases (possible on some materials)
- Photoelectric safety barrier on the front of the unit to control the access in the molding area
- Compressed air tank for the pneumatic cylinder.
- All setting of temperature and times are adjustable with digital timers and thermoregulators.
- Graphic touch screen operator panel to set the molding temperature and time with complete diagnostic software to inform the operator of any possible alarm and to display instructions to restart the unit
- PLC controlled machine with a separate safety PLC to control the safety devices.
- Presettable timer P90/TIM for automatic start-up and shut down of the unit on request.

### **TECHNICAL DATAS**

- Dimensions of the molds ..... : Nr.1 mold 600 x 470 mm or Nr.2 molds 290 x 470 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).
- Molding force ..... : 29.000 N.
- Stroke of the upper cylinder ..... : 500 mm
- Time to change a mold ..... : 3 min



**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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)**



**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 temperature ..... : 250°C.
- Installed power ..... : 1,6 kW 220V±5% Single phase + ground.





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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)



**PR\_88**

**PRE-HEATING MACHINE FOR MOLDS OF FOAM CUPS**

## **PRE-HEATING MACHINE FOR MOLDS OF FOAM CUPS CLASS PR\_88**

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.



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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)



***"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 P96***



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](http://www.amppisani.com) email: [info@amppisani.com](mailto:info@amppisani.com)



**LTR/1600**

**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:

- 7 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 ..... : 7
- 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  $\pm$ 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