

Wrapping technology from Sapal helps **Italian success**

The IN.AL.PI. S.p.A. dairy group was founded in the town of Moretta, in the Piedmont region of Italy, in 1966. Specializing in the production of butter and processed cheeses, the company has grown into a pan European group, with estimated sales for 2008 of 31 million euros.

As part of its operation, the company has various lines for the production of processed cheese slices, with an annual capacity of 75,000 tons. In 1993, it started using machinery from Sapal, a Bosch Packaging Technology Company, and now has six processed cheese slice packaging lines.

IN.AL.PI. is continuously expanding and has just completed a 10 million euro program to increase its plant to 44,000 square meters. Giovanni Invernizzi, IN.AL.PI.'s quality control manager, believes the Sapal lines have played a major part in this growth. According to Giovanni, "With the continuous expansion and with the need for the certified quality of our products, the packaging platform provided by Sapal has played

a fundamental role. For example, thanks to the collaboration with Sapal we have been experimenting with new wrapping films on the machines and have managed to use films as thin as 18 microns".

Using such thin film is highly challenging since film elongation is possible due to cheese temperatures and the length of process but it has the major advantage of reducing the changeover frequency of





- 1 IN.AL.PI.-Moretta Factory
- 2 Kustner-KD
- 3 Kustner-KF





the reels, thanks to a greater amount of film per reel.

Among the Sapal equipment at the plant are the **Kustner-KF** and **Kustner-KD** (dual line) continuous process wrapping machines for cheese slices. The Kustner brand belongs to the Bosch portfolio since 2007. The **Kustner-KF** is a high-speed machine, specifically designed for the production of individually packed cheese slices. It is compact, takes up minimum floor space and delivers the highest reliability. The machine has a production speed of up to 1,000 slices a minute for cheese slices measuring 86 x 86 mm, with thicknesses from 1.7 to 5.2 mm and weights from 13 to 40 g.

A unique forming belt group allows the flattening of the filled tube, forces the cheese from the area to be sealed and

calibrates the slice. Most settings can be adjusted while the machine is in operation. Film consumption is only 2.1 square decimeters per slice and each slice is individually packed and tightly sealed for an extended shelf-life.

After the slices have cooled down by passing through a cooling tank, the Sapal **Kustner-KF** can pile them up in stacks of at least three items to a maximum height of 75 millimeters. The machine can also be connected to any downstream placed flow pack wrapper.

The Sapal **Kustner-KD** has the same characteristics as the **KF** model but can produce up to 1,600 slices a minute. Both the **Kustner-KF** and **-KD** machine models are equipped with a highly sophisticated cutting & distribution drum construction for precise cutting at any

speed, in order to deposit the slices in predetermined stacks. A downstream flow wrapper system will single or twin-wrap these stacks before the cartoning process.

IN.AL.PI. has also bought the state-of-the-art **KG** electrostatic conveyor for slices. This had an immediate impact in boosting the company's productivity and prompted it to swap the mechanical **KB** cassette conveyors of its two **Kustner-KD** lines, despite their excellent track record, for this more modern **KG** model.

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Flowrapped IWS slice stacks