



# Popular CM wrappers still lead the way after 30 years



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- 1 **CM-6**, overwrapping of products on edge
- 2 Film cutting unit
- 3 Film tower
- 4 Machine principle



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### Bosch Packaging Technology B.V.

Bosch Packaging Technology B.V., formerly known as Tevopharm, was founded in 1959 and has almost 50 years of experience in providing packaging machines, distribution and infeed systems. The company has been part of Bosch Packaging Technology division since 2003. By collaborating closely with other companies within the division, it now supplies solutions combining years of experience in a wide range of packaging applications.

### The CM wrapper

One of the main products has been the **CM** wrappers, with the first **CM** machine having been built in 1975. Now, 34 years later, numerous machines have been installed worldwide. This envelope pack style packaging machine is suitable for packaging sandwich biscuits, crackers, extruded bread and much more and can be adjusted to various individual product shapes, such as round, oval, rectangular or square. The latest incarnation of the series, the **CM-6**, offers outstanding accessibility and quick and easy changeovers, as well as an impressive list of options to satisfy the needs of many different customers.

### Papadopoulos

One such customer is Papadopoulos, a successful Greek company supplying biscuits and other foods. Papadopoulos is the Greek market leader for biscuits with a market share of about 70% by volume. The company also holds a significant position in the bread substitutes segment. As well as introducing new brands, Papadopoulos already offers a large range of products that are already widely known such as Papadopoulos Petit Beurre, Miranda, Papadopoulos Cream Crackers, Papadopoulos Sandwich biscuits and Caprice. In striving to fulfill customer's needs, it holds three principles very highly: quality, innovation and respect.

### Papadopoulos CM-6 project

Papadopoulos has worked with **CM** machines for many years and, last year, the decision was taken to add another machine. Although the principle of the **CM-6** remains unchanged, the machine's specifications have been modified in order to make it more operator friendly. This offers significant benefits, such as shorter changeover times. Thanks to the stainless steel covers, cleaning the machine has also become much easier. Furthermore, the machine has been equipped with a tear strip applicator, as well as an additional roller for a

cardboard feeder. The use of five sets of sealing heads allows for an improvement in the seal quality, with a tighter and better looking seal being produced, but without loss in machine speed.

### New developments

Although the **CM-6** is a machine with a long history, this envelope pack style remains very popular and still allows for innovation and improvement. Bosch Packaging Technology has recently come up with an innovative **CM-6** solution in which a labeling unit has been integrated into the film tower of the machine. This unit makes it possible to put a label onto the film at a predetermined position, before wrapping the product and therefore ensures that the labels are always placed at the same position on the package.

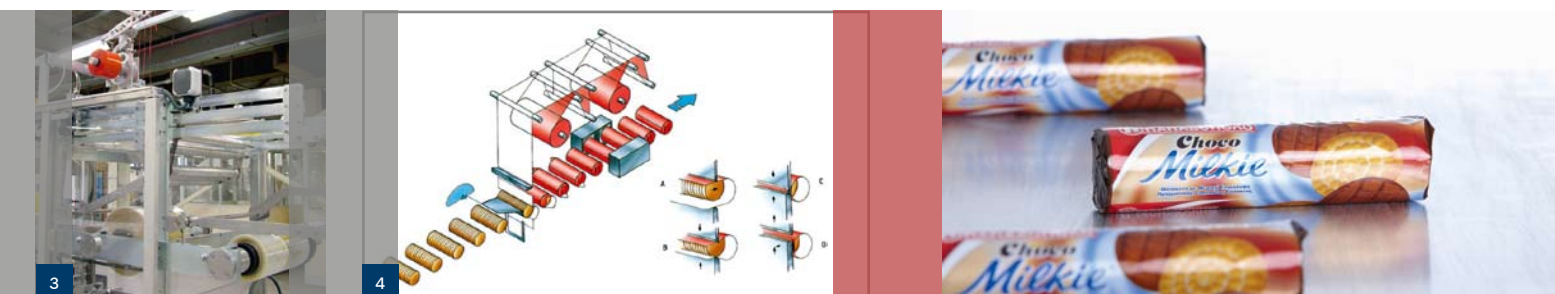
So, as you can see with the **CM-6**, the **CM** wrapper is still evolving and continues to successfully serve many customer's needs.

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In 2001, Farmer's Tobacco of Cynthiana, Inc. (Cynthiana, Kentucky), launched the Kentucky's Best brand of whole-leaf tobacco cigarettes. Recently, the company saw an opportunity to expand this established brand with a product line extension. As a result of higher tax rates on carton cigarettes, there has been increasing demand for "roll your own" (RYO) tobacco delivered in a bag format. This represented a significant opportunity to expand the Kentucky's Best brand into the RYO market.

Having concentrated exclusively on pre-made cigarettes in cartons, Farmer's Tobacco required an entirely new packaging solution to offer its tobacco in the RYO format. A key requirement was a resealable bag that would keep the tobacco fresh during storage and use. An additional need was a flexible solution that would allow different bag sizes and future packaging line upgrades.

#### Packaging requirements

Farmer's Tobacco had already decided on two sizes (6 oz. and 16 oz.) of polyethylene bags. The clear packaging film was critical for success in the RYO market as research indicated that consumers like to view the product to inspect its quality. A resealable closure was also important as it ensures freshness during use and storage.

#### Packaging machinery solution

A critical component of the operation was the band sealer from Dobo, a Bosch Packaging Technology brand. The **B-500** Continuous Band Sealer offered industrial performance in a compact size, which was an ideal solution for a company attempting to upgrade its operations and enter a niche market in a cost-effective manner.

After product sorting and check weighing, the filled tobacco bag is presented to the Bosch **B-500** sealer, which applies the final seal, after which the finished product is placed in secondary packaging for distribution. The weighing and sealing process is conducted by one operator, an important requirement from Farmer's Tobacco to keep labor costs down and simplify operations. A key benefit the machine offers is the precise placement of seals. Placing the



# A Brand New Bag: New packaging solution for the “Roll Your Own” market

Farmer’s Tobacco breaks into the “roll your own” market with packaging solution

seal too high up on the bag may cause the seal to be ruined on initial opening and inhibit resealable functionality, whereas placing it too low may cause product bunching and affect quality. A consistent, reproducible seal is an important packaging feature, especially for a newly launched product, as consumers must be able to open and re-close the package and access the product in a convenient way. The **B-500** accomplishes this seal with bag top control, with full

length urethane time belts gripping the bag to ensure consistent speed and bag control. Heating and cooling bars provide consistent pressure throughout the sealing process.

With manual feeding into the sealer, the **B-500** currently runs 12–14 inches per minute (6–8 bags per minute). However, the machine is also designed for higher speed applications and can process linear speeds up to 750 inches per

minute. This ensures that, if demand rises, Farmer’s Tobacco could add two weighing and filling stations, or even augment line capacity with an automated infeed, and still continue sealing with the **B-500**.

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- 1 Sealing bars produce 6 mm wide seals
- 2 Dobby **B-500** Band Sealer

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