

Plaiting Machine Type 306

(Decatising Machine)

(Edition 2017/08)



This machine serves for steaming, plaiting, and decatizing, and drying of the gentlemen`s hat (Fedora). This combination of 4 different working tasks required a special and careful construction which presents itself as follows:

In a lower pot, there is a turnable plaiting plate which easily can be rotated by the worker. The spring tensioned upper plate stretches the brim of the hat on all sides uniformly and keeps it fast during the whole working procedure. The saddle sheets are mounted fast on the upper and lower plates and consists of stainless steel. All machine parts which are subject to wear are made of stainless steel and casting whereby the pot and the plates are manufactured of silumin. The machine is completely equipped electrically and will be supplied ready to start operation. A red safety controllamp indicates if all parts of the machine operate properly.

The Working Procedure is performed as follows:

The dry and lightly pre-steamed hat is entered into the open machine with the hat downwards. The plaiting cover is being closed and secured by a quick locking device. The steam valve operated by foot pedal is being opened, and the head hood is well steamed. During the time of steaming, the operator caps off the pressure form with the handwheel, removes the silumin mould from the previously worked hat which is laying on its back on the feeding table and presses the

mould into the steamed hat by hand as far as possible. The lever is folded in, the handwheel is being turned to a rigid, in its height adjustable position. The steam is being shut off and the hat under tension including the mould is turned by 180° whereby the head hood shows placed o the plaited hat from the backside whereby the hat is being dried with combined ray and circular heat.

The succession of the various jobs is laid out in such a fashion that all manipulations require only a few seconds and are by all means fully safe. If they require considerable amount of time, they interlace conveniently. The drying is constructed in such a fashion that the hot air blows intensively to the position of the band, whirls around the hat and is being re-sucked new with additional fresh air.

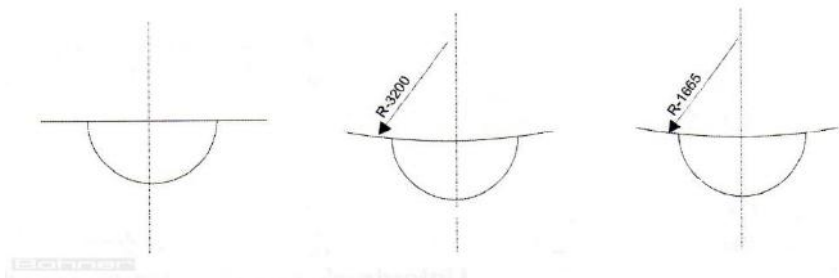
Therefore, allow pressure area in the drying zone is being achieved which intensifies the drain considerably. It works with a special heating of low temperature with high air velocities (drying time approximately 2 to 3 min).

It is possible to achieve with this working operation a complete and exact plaiting according to the mould and saddle with exact ribbon places and equal hat sizes without consideration due to shrinking when drying as well as excellent decatizing. The machine pays for itself within a short time based on ist especially rational working process and due to the combination of various working processes which were done separately up to now.

Output per an 8-hours' shift	Attendance	Installation
750 / 850 pieces	1 man	Four plaiting machines with one head and provided with exchange plates (each machine with a drying hood).
1500 / 1600 pieces	2 men	Eight plaiting machines with one head , each of which the right and left place is constructed for taking the exchange plates (each machine with a drying hood).
2250 / 2550 pieces	3 men	Twelve plaiting machines with one head each of which both the places are constucted for taking the exchange plates (each machine with a drying hood).

On demand, we gladly submit to you proposals for the installation of a plant which allows a larger capacity.

When ordering, please state the shape of the saddle:



1. Table flat, in effect both pressure plates plain
2. Arched with a middle radius of 3200 mm in effect slightly arched
3. Arched with a middle radius of 1600 mm in effect strongly arched

The thickness of the felt is supposed to be on an average 2mm. In case same would exceed 2,7 mm, please state this on order.

Technical Data

Measurements approx.	900 x 1400 x 1500 mm
	35,4 x 55,1 x 59,1 inch
Dimensions seaworthy packages approx.	1000 x 1500 x 1600 mm
	39,4 x 59,1 x 63,0 inch
Space required approx.	1000 x 1600 x 1700 mm
	39,4 x 63,0 x 67,0 inch
Weight	
net approx.	156 kg
	343,92 lbs
gross seaworthy packed approx.	230 kg
	507,06 lbs
Capacity 1 unit machine	about 100 to 140 pieces per shift, plaited and ready dried
Capacity per man	about 750 to 850 pieces per shift, plaited and ready dried

