

Packaging Systems

Since 1970, Hoonga has been persistent in its efforts to supply packaging systems in global markets, keeping up with fast changing trends and customers needs.

Continuous development and creative thinking enable Hoonga to provide innovative solutions and applications for automatic packaging systems.



Blister Packaging Machine

HM V6

HM V6 (v6⁺)

HM V6's design paves a way for streamlined operation with flexibility. Thermoforming and Cold Forming blisters adds even greater versatility to the pharmaceutical blister systems. Integration of Programmable Logic Controller (PLC) along with a touch panel creates an operator friendly environment and vital components such as one touch quick tool setting and more support GMP directives. Safety designs are governed by CE regulations that satisfy European Directives.

HM V6 consists of :

- Forming film supply stand.
- Pre-heating plate with teflon-coated.
- Options of thermoforming, cold forming or plug assist forming.
- Extendable feeding bed for accommodating various automatic feeding systems, product inspector, tear detector and more.
- Lid foil supply with tension control and exhaustion sensor.
- Sealing upper plate lift-up system on machine stop.
- Draw off performed by a mechanical cam drive with a lever.
- Punching station with a zigzag design.
- Discharge conveyor.
- Waste spool winder.

Machine features:

- Blister packaging for a wide range of solid products such as a tablet, hard and soft gelatin capsules, caplet, candy, chocolate ball and square shaped chewing gum is available on HM V6 with feeders that are designed for specific purposes.
- Applicable forming materials include PVC, PVC/PVDC, PVC/ACLAR, PET, cold forming material, aluminum film.
- Lid foil applicable for packaging with materials including aluminum, paper and multilayer foil for child resistant and so on.
- PLC and a touch panel for operator friendly environment to manage general operation which includes altering various parameters for products and format molds, perform trouble shooting and observe running speed, production output counts and target quantity.
- Convenient and fast changeover of format mold.
- Simple switchover between thermoforming and cold forming by adjusting format mold on the touch panel without any mechanical change.
- Every station is actuated by the mechanical cam drive on the strong solid spline shaft driven by inverter motor control.
- Each station is controlled by an individual dial.
- Complete safety features with panel guards and interlocks.





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1. Forming Station

Thermoforming station which can also facilitate cold forming (Alu/Alu) and plug assist forming.

2. Sealing and Cooling Station

Format molds are designed for one-touch setting to ensure rapid and effortless changeover. The upper plate of sealing station can be installed with a lift-up system optionally what will be actuated when the machine halts.

3. Feeding Section

Various feeding systems can be incorporated to accommodate different products as well as tear and feeding detectors.

4. Draw-off System and Punching

Draw-off system with two grippers where one is movable and the other is fixed, can be controlled by the combination of a lever and a dial. Punching station with a pick-and-place device aligns blister packs for down-streaming with a vacuum pad.



Automatic feeding facilities :

- Hopper with vibrator
- Tablet alignment system by spiral track with vibration
- Universal brush box feeder
- Shutter gate feeder
- Vibrating tube channel feeder for convex tablet
- Track feeder
- Shift feeder

Optional facilities :

- Alignment facility in-line with downstream cartoner
- Movement system for feeding tracks
- Product feeding inspector by camera system, optical sensor
- Tear detector for cold form and lid foil
- Individual ejection of an inferior blister
- In-line printer for lid foil
- Print registration control system
- Deep draw forming up to 30mm
- Vacuum and/or plug assist forming
- Waste chopper instead of spool winder
- Steel-It painted

HM V6/TR (V6/TR⁺)



HM V6/TR is a customized (tailored) version of HM V6 for manufacturing 'Tropical Blister' (Aluminum/PVC/Aluminum) packaging. It consists of additional components such as tropical blister aluminum foil supply, cold forming station for base tank forming, sky bridge bypass guide (bypass bridge) for normal blister and more on top of HM V6.

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1. Tropical Film Supply

Tropical film is supplied from rear side and turned to the right to converge with PVC/Alu blister processing direction.

2. Tropical Blister Forming Station and Overpass

Tropical blister forming by plug assist immediately after the tropical film converges towards the processing direction. PVC/Alu blisters are bypassed through overpass installed over tropical blister forming station.

3. Matching both Tropical Form and PVC /Alu

Both tropical film and PVC/Alu blisters are aligned and flow into the second sealing station to complete the sealing process.



*Performance with extreme flexibility for
pharmaceutical blister packaging*

ISO 9001: 2000 / ISO 14001



Feature of HM V6 / Blister packaging machine

TECHNICAL DATA

HM V6

Output	Thermo forming	min. 20 ~ max. 50 cycles/min
	Cold forming	min. 15 ~ max. 30 cycles/min
Forming format range	Width	max. 250 mm (V6 ⁺ : max. 280 mm)
	Index	max. 145 mm
	Depth	max. 18 mm (Alu/Alu : max. 12 mm) (Special depth up to 30 mm as option)
	Effective area	242 mm width x 143 mm index
Packaging material	Forming material	PVC, PVC/PVDC, PVC/ACLAR, COC, PET, Alu forming material, etc.
	Lidding material	Alu-hard / soft, Child Resistant Lid Foil, etc.
Utilities	Electric power connection	220V, 3-phase, 50/60Hz (other voltages available on request)
	Electric connection	15 KVA
	Compressed air pressure	6 bar within 10% fluctuation
	Air consumption	350 NL/min
Machine dimensions	Chilled water	240L/H in automatic circulation by installed chiller
	Length	approx. 5,390 mm
	Width	approx. 1,160 mm
	Height	approx. 1,940 mm
	Weight	approx. 3,500 Kgs

HM V6/TR

Utilities	Electric power connection	220V, 3-phase, 50/60Hz (other voltages available on request)
	Electric consumption	18KVA
	Compressed air pressure	6 bar within 10% fluctuation
	Air consumption	400 NL/min
	Chilled water	280L/H in automatic circulation by installed chiller
Machine dimensions	Length	approx. 6,960 mm
	Width	approx. 1,210 mm
	Height	approx. 2,100 mm
	Weight	approx. 3,800 kgs

Specifications of output, format range, form film and lid foil are same with above as HM V6.

Contents on this catalogue are to assist understanding of the machine only and are subject to technical modifications without prior notice. The final specification is as per our quotation offered to you exclusively.

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