

THE LAWRENCE MEGA 60 OP/AL SYSTEM



The Lawrence Mega 60 OP/AL System



Application

For the automation of proofing and loading in the production of pressed flour tortillas, wraps, and other flat breads.

Capacity

- 6" up to 5,760 Dz/Hour
- 8" up to 3,300 Dz/Hour
- 10" up to 2,300 Dz/Hour
- 12" up to 1,500 Dz/Hour

Construction

- OP: All stainless steel mainframe, exterior doors and shafts.
Stainless steel sprockets trays, chains and miscellaneous hardware.

Standard Features

- Precision timing gate interfaces divider and OP to assure consistent loading
- All continuously guided roller chains
- Concealed utility ducts for air, electrical and water service
- Interface hardware for AL

- Patented third station heated discharge platen for superior product roundness & release for smooth transfer
- One Touch system control
- Independently servo driven discharge/reciprocating belt features low maintenance
- Plastic belting and patent pending tensioning system



Continuous monitoring camera on critical divider to proofer transfer. Proofer exit for emergency dough ball evacuation.

Options

- Cool air input to proofer configured with steam & humidity system and auto temperature control
- Vault style insulated and hinged proofer door and double wall insulated top
- CE or CSA Conforming
- Press camera auto sizing system
- Double loader (can hold two programs at once)
- Second tier air chute turnaround air powered on oven
- Automatic steam/dryer and humidity control
- First and second tier cooling conveyor jam free air system
- Remote viewing panel for Inspection System
- Stack transfer
- Custom char grilling drum



LEFT: One Touch control screen
RIGHT: All camera position viewing screen

Auto Loader One Touch Control System

The One Touch Control allows the operator to recall a recipe saved for all the following parameters:

- Divider timing
- All zones of press temperature control
- Press pressing time
- Press belt delay time
- Oven dwell time
- Oven belt temperatures
- Cooler infeed belt speed (if separate)

- Main cooling conveyor speed
- Cooler discharge belt speed (if separate)
- Proofer cycle rate
- Auto loader program
- Multiplexed camera system
- Photo cell jam detection and alarm
- Proofer humidity set point
- Proofer heat set point
- Clean-in-place system
- Counter stacker row counts



Patent Pending SELF CLEARING loader plate

Mega 60 Vacuum Head Press

Standard Features

- Patented quick change Teflon coated pressing skin with product specific shims are changeable in less than 2 minutes
- 60" wide x long platen is hydraulically actuated
- Accurate, electronic, dual direct drive, dual drive Teflon belt rollers (both rollers are driven), belt-indexing system. System features repeatable digital speed control to allow easy timing with OP/AL system.
- Magnetically Encoded Belt with connecting pin facilitates belt removal and replacement
- Auto Tracking system eliminates need for repeated adjustment of Teflon belt
- Main conveyor design and air assist prevents cripples at discharge roller
- Patented continuous platen cover reel system allows the operator to index a new platen cover into position within (1) minute
- Teflon "Belt Saver"



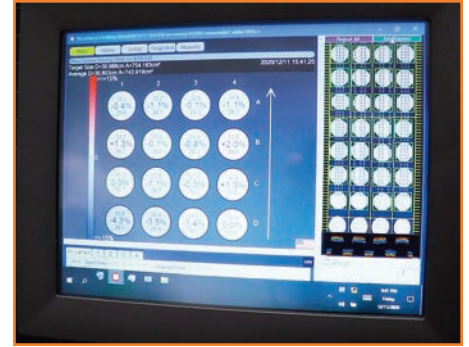
Complete press head insulated enclosure with electric lift system

Touch Screen Control

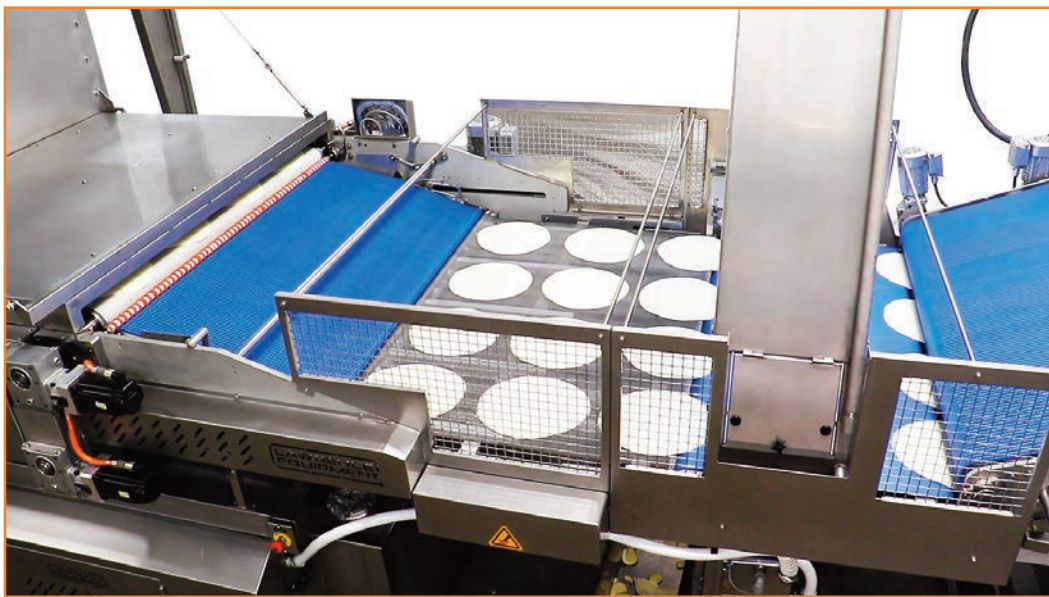
- Multi-zone temperature control system assures superior platen temperature control
- Touch Screen interface displays all error messages and prompts operation data input
- Temperature controls include faulty heater message via PLC
- Multi-zone temperature control system assures superior platen temperature control
- Touch Screen interface displays all error messages and prompts operation data input

Construction

- 1-1/4" Vacuum shimming platen with dual 2" platens
- 18 heaters top and bottom (36 total) plus heated discharge platen
- All high strength cast steel structural press components.
- Patented heated discharge platen
- All cast A frame, top and bottom H frames as well as "frog"



Accutrol auto sizing and QC system control screen. Advanced shim advice and specific defect removal, before oven.



Accutrol QC system looking at sixteen 12" (30cm) tortillas before oven

Micro Blower Premix Oven

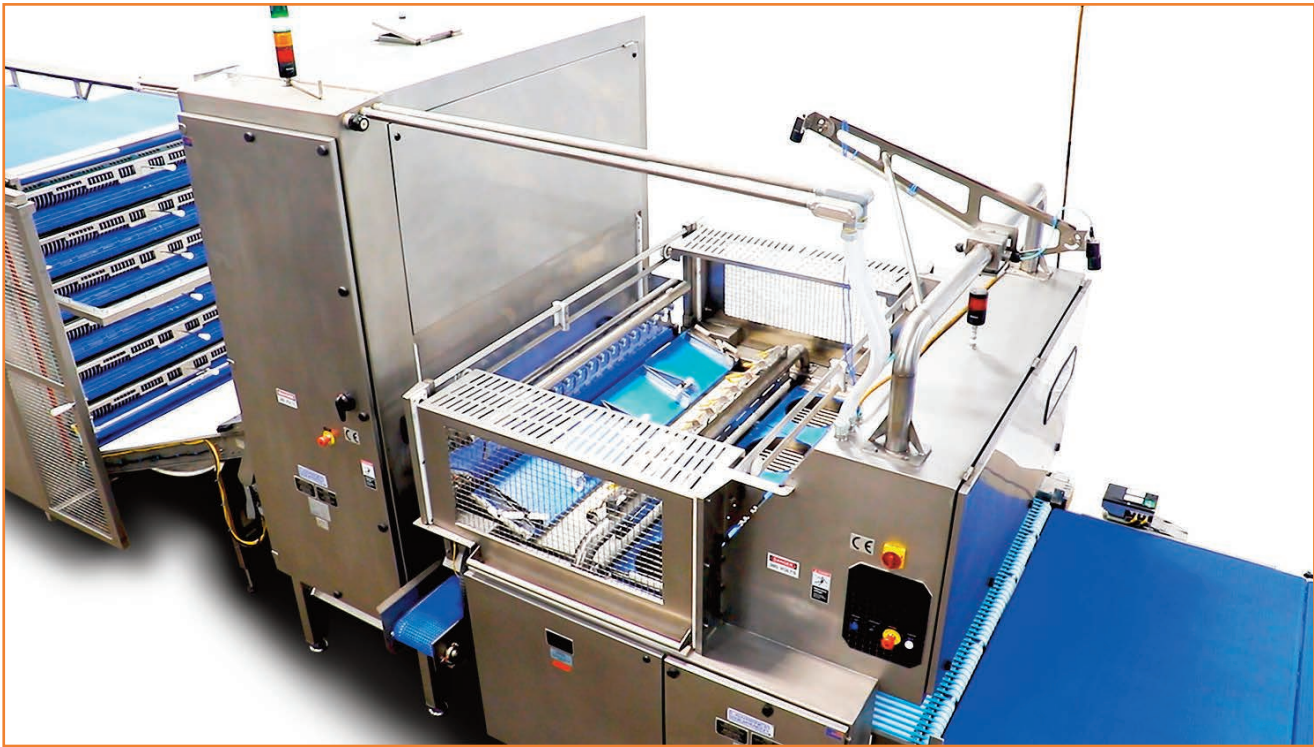
- Independent premix blowers with infrared eye surface temperature thermostatic control per tier for optimal bake
- All stainless steel main frame, double insulated doors and hood
- First tier air turnaround, second tier optional
- Free standing UL approved control panel with color Touchscreen and One Touch interface
- Electronic ignition
- Unique retractable plastic mesh discharge eliminates waste from entering cooling as well as downstream packaging
- Plastic belt with patented rope transfer with retract feature

Lawrence Positive Positioning Cooling Conveyor

- Patented positive positioning turnarounds preserves orientation without increasing maintenance
- All sanitary wash down frame design eliminates standing water or debris collection
- Double end drive with poly chain belt drive for low maintenance and quiet operation or independent Lenze drives

Lawrence All Inverter Indexing Counter Stacker

- Airlift reduces the risk of tortillas folding into the catch cups
- Ultra-light high-speed digital interrupt gates eliminates inconsistency and high maintenance of pneumatic cylinders
- Patented oscillating stack cylinders assure stack concentricity
- Replaceable plastic guides with dedicated rows 3, 4, 5 & 6



Patent pending self clearing counter stacker with continuous monitoring camera

OP/AL Option

Lawrence Accuview Tortilla Vision Inspection System sorts and rejects on the following criteria:

- Diameters
- Flat edges
- Holes
- Overlaps
- Toast points (baked marks)
- Sorts up to 8 lanes and 200 tortillas/minute per lane

System includes:

- Touch screen operator interface
- Rugged industrial PC
- LED illumination for uniform view of product and low cost of operation
- Color camera with high definition and air purge to prevent lens contamination
- Pneumatic reject bar with food grade air filters
- Easy cleaning plastic conveyor belting

Mega Press Camera Option

- Assures producer more consistent diameters & greater control of size due to changing dough conditions
- Adjusts hydraulic pressure based upon computer analysis of camera views. Target diameter vs. actual diameter at a pressure is displayed on the press control screen when this option is added
- Normally integrated with Lawrence Proofing System
- HMI display screen
- Digital chart recorder shows actual and target set point deviation graphed over time

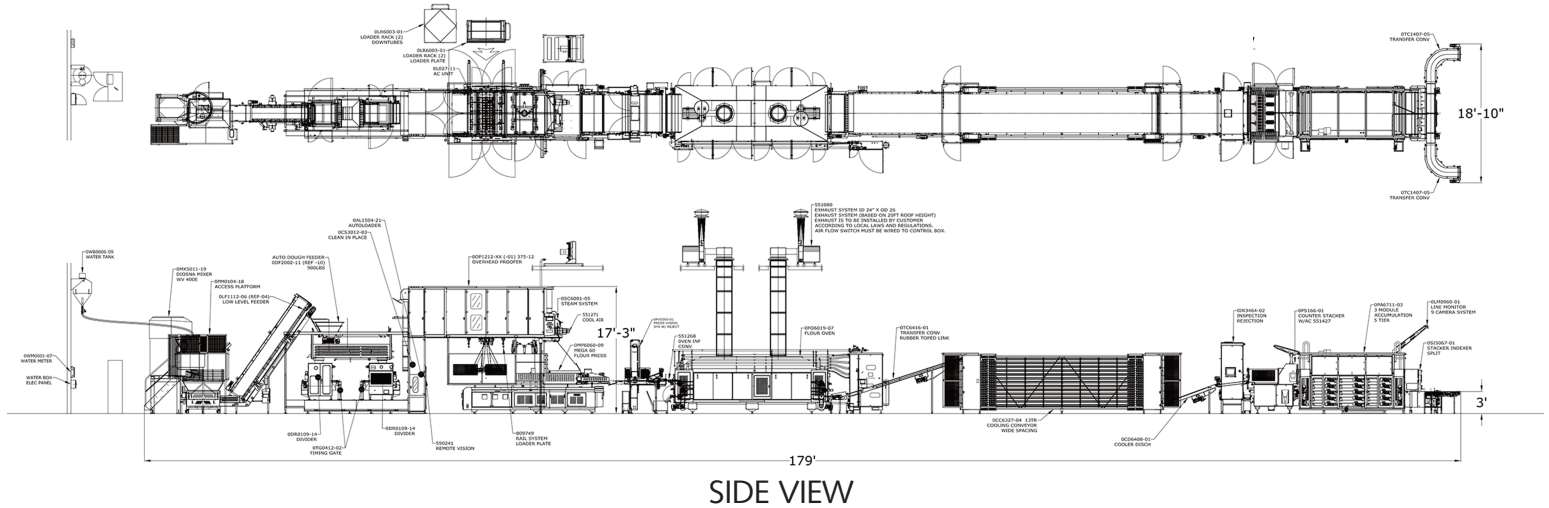
Small Product Pressure Control System for Small Diameter Product Option

- Assures superior control of hydraulic pressure when there is a low resistance present and near zero pressure is still too much
- Allows the operator control of oven pressing force when the diameter for a given loader plate is smaller than the normal diameter run on that pre-press program

Tortilla Char Griller Option

- Used for creating rustic grilled markings on product, after pressing and before baking
- Production rate equal to 90% of normal operating speed
- All stainless-steel frame and exterior sheet metal
- HMI operation interface with capacity for One Touch integration
- Screw jack elevating main frame for product to by pass without grill marks

OVERHEAD VIEW



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