



Change-over time on demand

The patented VLM die adjustable system has several options in change-over time of the V- opening, from manually operated to fully CNC-automatic.

Option /Model	VLMBN	VLMDN	VL MEN	VL MFN
Manually	5 min/meter	6 min/meter	8 min/meter	9 min/meter
Semi-automatic mechanic/DPSM	3 min/meter			
Fully automatic CNC	1,5 min / total length			

Manually operated

The manually adjustable system is recommended when the V-opening doesn't change frequently (die parts and spacer bars adjusted manually)

For example:

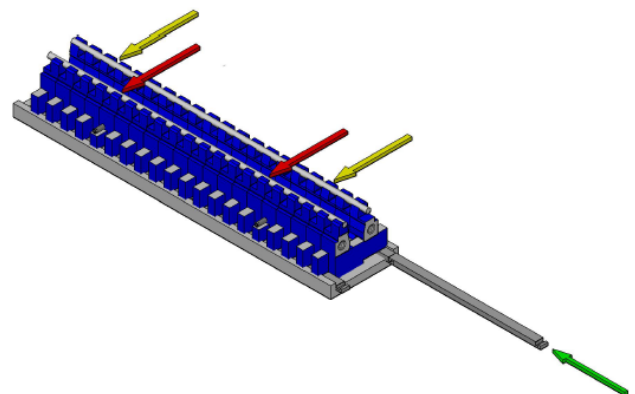
Manually change-over time V-opening of model;

VLMBN V- opening 25 – 125 mm
the change-over time is around **5 minutes/meter**.

VLMDN V- opening 65 – 185 mm
the change-over time is around **6 minutes/meter**.

VL MEN V- opening 120 – 300 mm
the change-over time is around **8 minutes/meter**.

VL MFN V- opening 150 – 400 mm
the change-over time is around **9 minutes/meter**.



Semi-automatic

1) **VLM - DPSM**

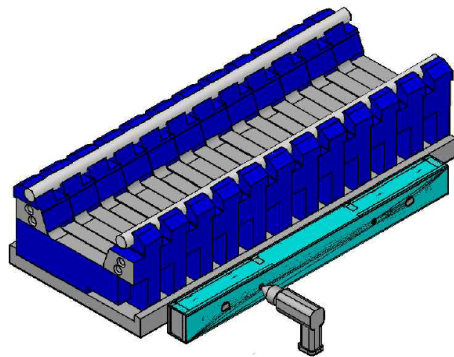
The change-over time of all VLM models - DP (die parts) semi-automatic (die parts adjusted by electric screw driver and spacer bars manually) is around **3 minutes/meter**.

Max. unit length VLMBN 2000 mm

Max. unit length VLMDN 2000 mm

Max. unit length VLMEN 1800 mm

Max. unit length VLMFN 1200 mm



Fully automatic CNC version

- 3) The change-over time of all VLM models - CNC automatic (die parts adjusted by electric drive, spacer bars by pneumatic cylinder and the V-opening by electro drive over CNC display), is around **1,5 minute total length**.

