

**BEHN + BATES**



**TOPLINE**  
**Automatic Packing System**  
**for Open Mouth Bags**

# TOPLINE

## Filling of open mouth bags – today, tomorrow and the time after



Different types of bags that can be filled with the TOPLINE

BEHN+BATES was founded in 1933 and is one of the technologically leading manufacturers of packing machines for food and feed products. Our state-of-the-art packing solutions for valve bags have convinced food and animal feed producers all over the world for years.

BEHN+BATES now also offers the optimum solution for the clean and precise filling of pinch-top and pre-made open mouth bags of any kind:

**the TOPLINE -  
the new generation of  
open mouth bag packaging**



Choice of products that can be filled by the TOPLINE



TOPLINE packing system with lateral empty bag magazine

### The TOPLINE

is a modern fully automatic packing system, that has been especially designed for the packaging of fine free-flowing powders.

All necessary steps from the filling up to the closing of the open mouth bags take place in a compact cabinet.

**Weighing range**  
5 - 25 kg

**Bag dimensions**  
bag lengths: 450 - 900 mm  
bag widths: 260 - 400 mm  
gussets: 100 - 170 mm

### Functions

- empty bag placing
- bag filling
- product densifying and/or deaeration
- impulse sealing (of PE inliner)
- bag top folding
- bag closing (welding, folding, sealing, sewing)
- inline or 90° discharge of full bags

**Capacity**  
200 - 900 bags per hour



Double wall-flap filling spout with bag clamps on all sides and integrated bag deaeration

# Functional Description



Empty bag separator/transfer to the bag placer



Empty bag pre-opening



Empty bag placing at the filling spout



Sealing of the PE inliner

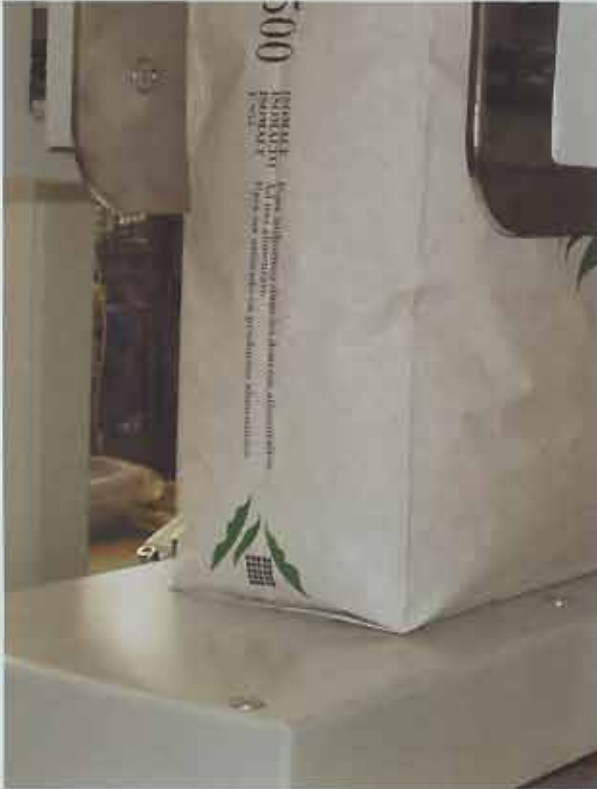
## Operation cycle

The empty bags are singled and taken out of the empty bag magazine that is chosen according to your needs. This empty bag is placed on an intermediate table in order to be correctly positioned for the following bag placing process. It is properly opened, securely transferred and exactly placed at the filling spout by suction bars.

During the filling bag clamps grab the bag from all sides in a secure and dust-tight way. The clean and gentle product filling is ensured by the double wall flap filling spout with integrated deaeration that has especially been developed for the food industry.

The product is optimally densified in the bag during and after the filling process by the optional bottom and side vibrators. As a result you will find block-shaped and clean bags that are easy to palletize.

The full bag is transferred to the closing station that is located in the same height.



Perfect bag shape due to the use of vibrators

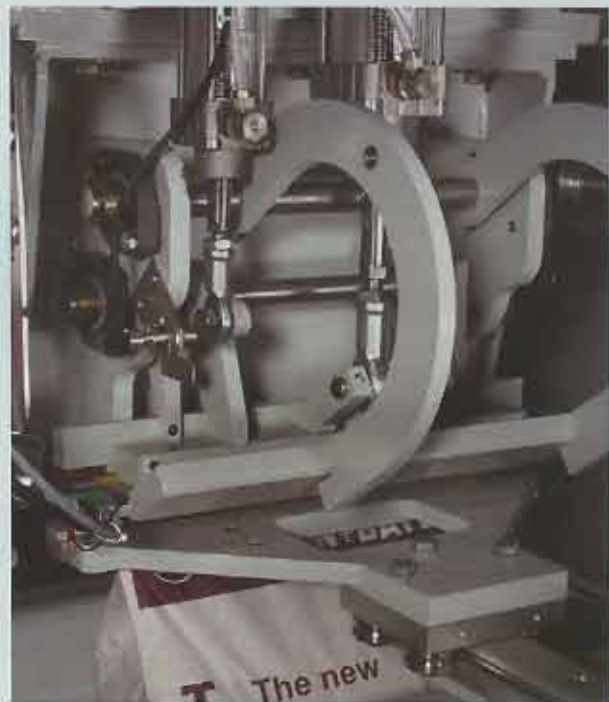


Bag top folding

The following closing alternatives are available: sewing, folding, sealing and/or hot melt activation. These closing alternatives are modular systems and can easily be integrated in the TOPLINE cabinet.

**Additional advantages:**

- The BEHN+BATES TOPLINE can be supplied as gross or net weighing system.
- Bag magazines with capacities of up to 500 bags are available.



Bag closing and hot melt reactivation

## Your Profits

### Clean – compact – flexible

- clean product filling due to the new double wall flap spout with integrated bag deaeration
- good product densification in the bag due to vibrators
- different closing alternatives for an exact and tight bag closing directly after the filling
- clean packing environment and compact packing room due to the integration of all necessary filling and closing modules in one cabinet
- empty and full bag transfer at the same height during the complete filling and closing cycle
- „Plug 'n Pack“ system with an integrated control panel for an easy and quick installation
- easy operation due to the integration of a touch panel with visualization



Suspended, height-adjustable bag discharge belt conveyor, even bottom for easy cleaning



Rear view of the TOPLINE with empty bag magazine and bag placer

### ... and especially for the food industry

- power supply arranged out of the dust area
- large doors made of food grade security glass, plane with the TOPLINE frame, for easy maintenance and cleaning
- even TOPLINE bottom for easy cleaning
- ATEX design available
- strip bag device for the separation of the inner bag made of PE film from the outer bag (to ensure the hygienic further product handling)

# Control and Operation

## MEC III

All the BEHN+BATES filling machines are supplied with the latest weighing and evaluation technology in the form of the MEC.

### Advantages:

- high operating convenience
- easy to programme
- PTB and OIML authorisation
- 99 product type memories
- operator guidance via a clear text display with selection of languages
- Ethernet connection

## Infrared touch panel TP 104

for the easy operation and error analysis with the help of the visualization

### Advantages:

- clear structure
- indication of all operation parameters (capacities, times, welding temperature, etc.)
- graphical error display
- testing of each individual machine sequence
- operating surface made of coated scratch resistant compound glass
- Ethernet connection

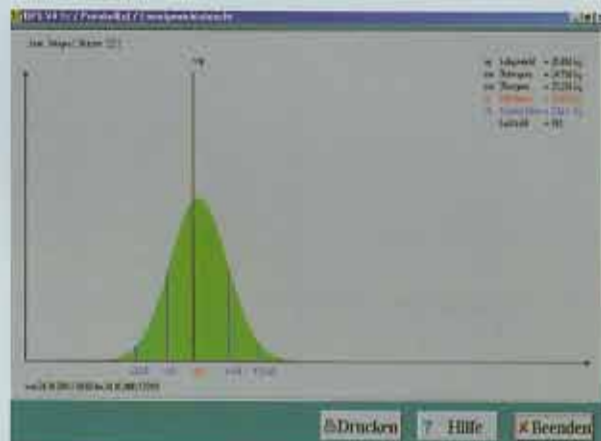
## Data processing system DPS

for the graphical and spreadsheet analysis of the filling process

MEC weighing electronics



Data processing system DPS



Touch panel – Module „filling spout“



Touch panel – Module „bag closing“

# BEHN + BATES

**Your professional partner for food packaging**

## Step by step to success

We accompany you from the detailed design over the manufacturing to the in-time installation and commissioning of your packing plant ... and even longer.

Our project managers are committed to long-term relationship with you in order to provide you with correct spare parts as well as professional regular maintenance.

**BEHN + BATES – Your reliable partner.**



BEHN + BATES Sackomat – The high capacity packing system for open mouth bags  
(up to 1,200 bags per hour)

## BEHN + BATES

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