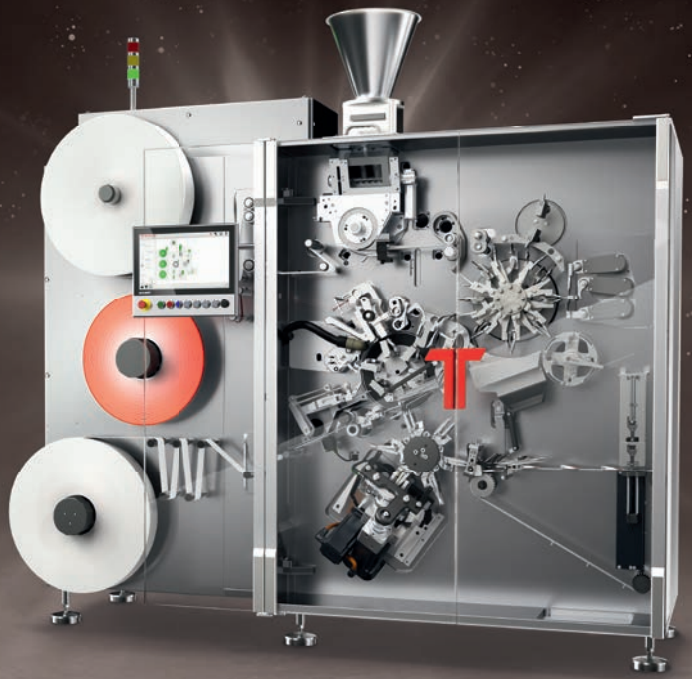
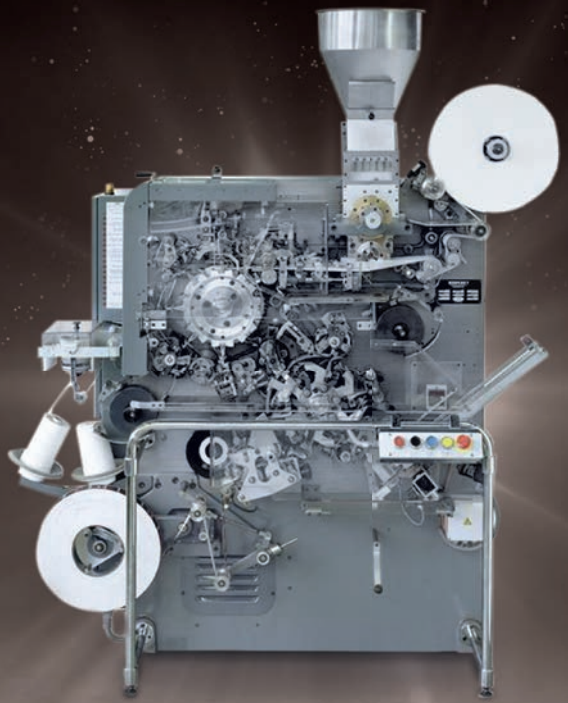
CONSTANTA



TEEPACK

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GERMAN RELIABILITY...

In **1948**, the late **Mr. Rambold invented the first double chamber tea bag.** However, as a man who was always thinking ahead, he also developed the machine to produce it. He took his time, meticulously going over every part and improving them restlessly.

The result was a machine that **revolutionized the market** when introduced in 1949, a machine that is still reliably working in factories around the world, a machine that is still being considered the benchmark for those who love good tea in proper tea bags.

We not only honour our founder in keeping his philosophy alive, but also by keeping his spirit alive: always on the cutting edge of development and setting new standards. **Let us honour him together!**

...WITH GLOBAL FLEXIBILITY

ADVANTAGES OF CONSTANTA

MODULARITY

- Wide array of consumables
- “Plug and play” approach
- Easily expandable in the field
- Integrated tag punching station

RELIABILITY

- Low energy consumption
- High ratio of good tea bags
- Ease of maintenance
- Automatic faulty bag ejection

LOW OPERATING COSTS

- Mechanically focussed
- Improved materials flow
- Ergonomic design
- Knotted bags only

HYGIENIC DESIGN

- Enclosed working chamber
- Only needed parts in working chamber
- Optional dust extraction system

CONSTANTA



PRODUCTION SPEED:

up to 180 bags/minute

TEA BAG SIZES:

- Format 02
  (40x60 mm/9.5 cm^3)
  (Knots at bag & tag)
- Format 03
  (44x60 mm/12.5 cm^3)
  (Knots at bag & tag)

TYPES OF BAGS:

- String & Tag
- Crimped paper envelope
- Heat sealed foil envelope

REMOVAL OPTIONS:

- Hand removal (String & Tag)
- Pre-grouping (S&T/Envelopes)
- ELC (S&T/Envelopes)

OPTIONS:

- Upgrade to CONSTANTA^{250}
- Hopper loader for tea
- Dust extraction system
- Auger in tea filling box

DIMENSIONS OF MACHINE*:

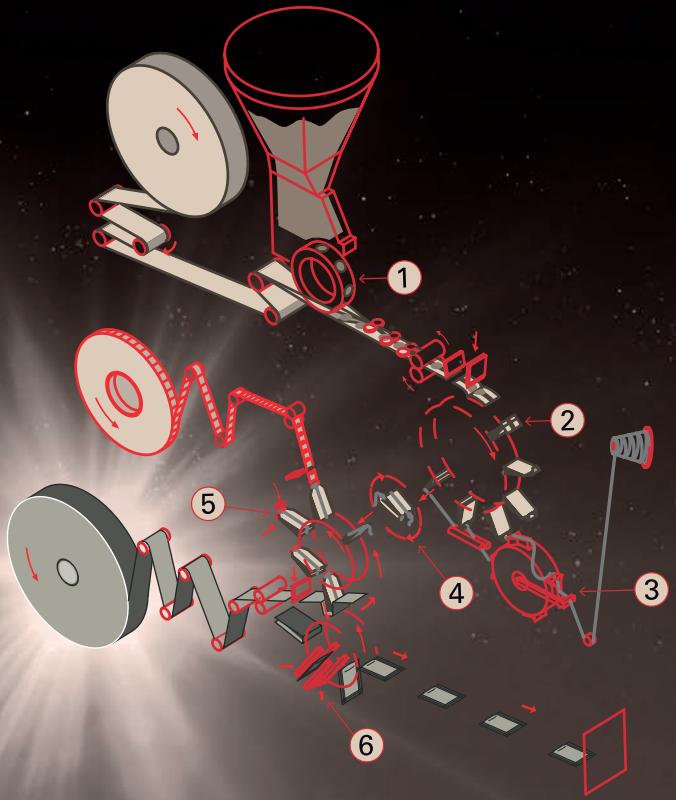
Length: 2900 mm
Width: 1178 mm
Height: 2274 mm

WEIGHT OF MACHINE*:

approx. 3,000 kg

*depending on configuration

CONSTANTA 250



PRODUCTION SPEED:

up to 250 bags/minute

TEA BAG SIZES:

- Format 02
  (40x60 mm/9.5 cm³)
  (Knots at bag & tag)
- Format 03
  (44x60 mm/12.5 cm³)
  (Knots at bag & tag)

TYPES OF BAGS:

- String & Tag
- Crimped paper envelope
- Heat sealed foil envelope

REMOVAL OPTIONS:

- Hand removal (String & Tag)
- Pre-grouping (S&T/Envelopes)
- ELC (S&T/Envelopes)

OPTIONS:

- Hopper loader for tea
- Dust extraction system
- Auger in tea filling box

DIMENSIONS OF MACHINE*:

Length: 2900 mm
Width: 1178 mm
Height: 2274 mm

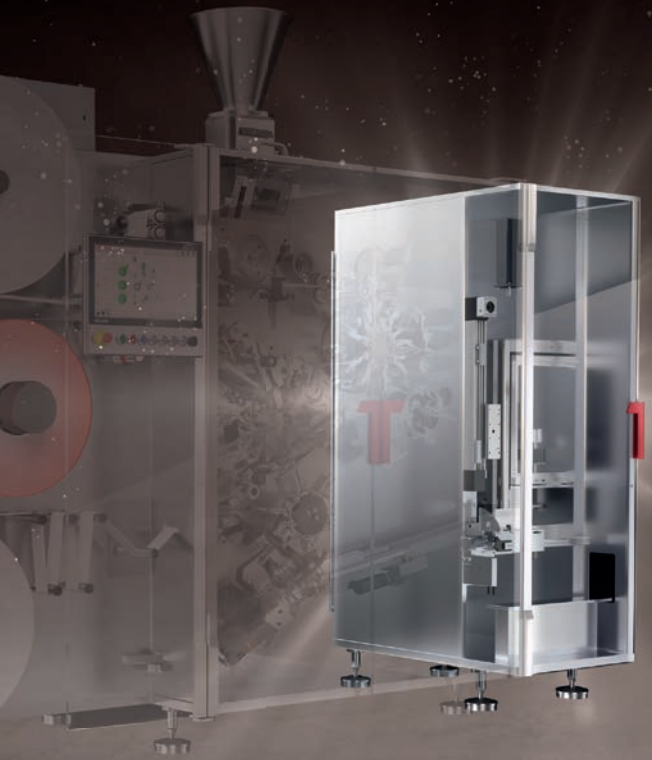
WEIGHT OF MACHINE*:

approx. 3,000 kg

*depending on configuration

1. Dosing
Tea is placed onto the filter paper.
2. Bag forming
Bag is formed from filter paper.
3. Bag head knotting
Thread is knotted to the bag.
4. Bag reversing
Thread is wrapped around the bag.
5. Tag knotting
Tag is placed & knotted to the thread.
6. (Enveloping)
(Bag is sealed into an envelope.)

END OF LINE FOR CONSTANTA



TYPES OF BOX:

Single row folding box
- Tuck-in closure
- Kurzlaschen closure

CARTON SPECIFICATION:

- Weight: 280–320 g/m^2
- Thickness: 0.40–0.45 mm

CAPACITY:

10–30 bags/box
(less than 10 b/b on request)

DIMENSIONS OF BOXES:

- Width: 42–70 mm
- Height: 60–80 mm
- Length: 80–180 mm

TYPES OF BOX:

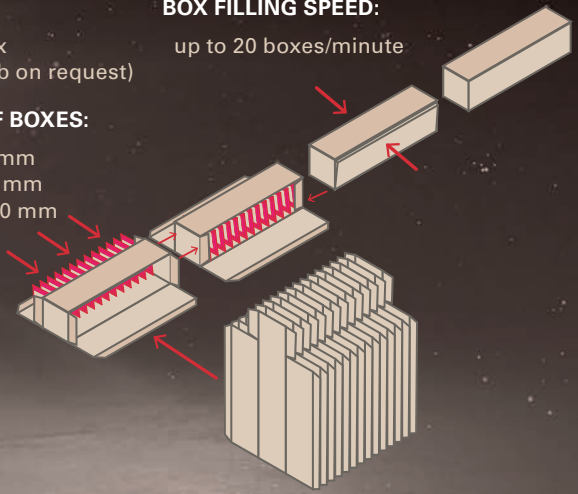
- String & Tag
- Crimped paper envelope
- Heat sealed foil envelope

TEA BAG SIZES:

- Format 02 (40x60 mm)
- Format 03 (44x60 mm)

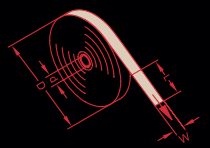
BOX FILLING SPEED:

up to 20 boxes/minute



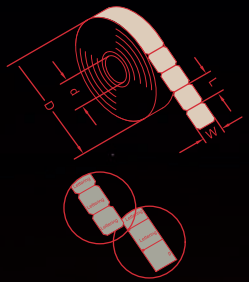
TECHNICAL SPECIFICATION OF CONSUMABLES

FILTER PAPER REEL SIZES



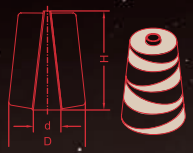
Size	Dm (mm)	d+2 (mm)	L (mm)	W+0.5 (mm)	g/m²
02 (40x60)	600	75	152	94	12
03 (44x60)	600	75	152	103	12

CARDBOARD TAG SIZES (standard size "Z")



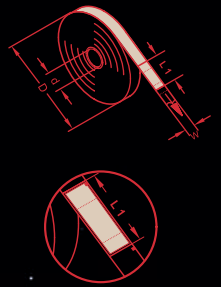
Size	W (mm)	L (mm)	d (mm)	Dmax (mm)
Z	28	32	120 or 152	500
M	28	28	120 or 152	500
X	26	28	120 or 152	500
T	25.4	31.75	120 or 152	500
Q	23	28	120 or 152	500
Y	20	24	120 or 152	500

THREAD SPOOL SIZES



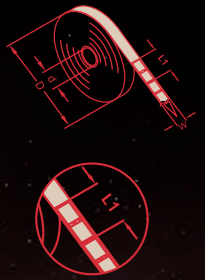
Size	Dmax	+/-0.3	Hmax
02	180	47	180
03	180	47	180

ENVELOPE PAPER REEL SIZES



Size	Bag type	Dmax (mm)	d+1 (mm)	L1+/-0.5 (mm)	W+/-0.2 (mm)	g/m²
02 (40x60)	56x67	600	75 or 152	144.5 (145)	56	60–70
02 (40x60)	55x67	600	75 or 152	145	55	60–70
03 (44x60)	60x67	600	75 or 152	144.5 (145)	60	60–70
03 (44x60)	63x72	600	75 or 152	157.5	63	60–70

ENVELOPE FOIL REEL SIZES



Size	Bag type	max. bag volume (cm³)	Dmax (mm)	d+1 (mm)	L1+/-0.5 (mm)	W+/-0.2 (mm)
02 (40x60)	66x77	7.0	600	75 or 152	154	66
02 (40x60)	63x72	7.0	600	75 or 152	144	63
03 (44x60)	66x77	9.5	600	75 or 152	154	66
03 (44x60)	63x72	9.5	600	75 or 152	144	63



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DISCOVER ALL THE VARIANTS ONLINE

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