



BUCKET LINE

One Line. Full Flexibility
Automated bucket filling for maximum
flexibility, accuracy and output

KÖHL Bucket Filling Line for MYO

From bucket separation to sealed packaging

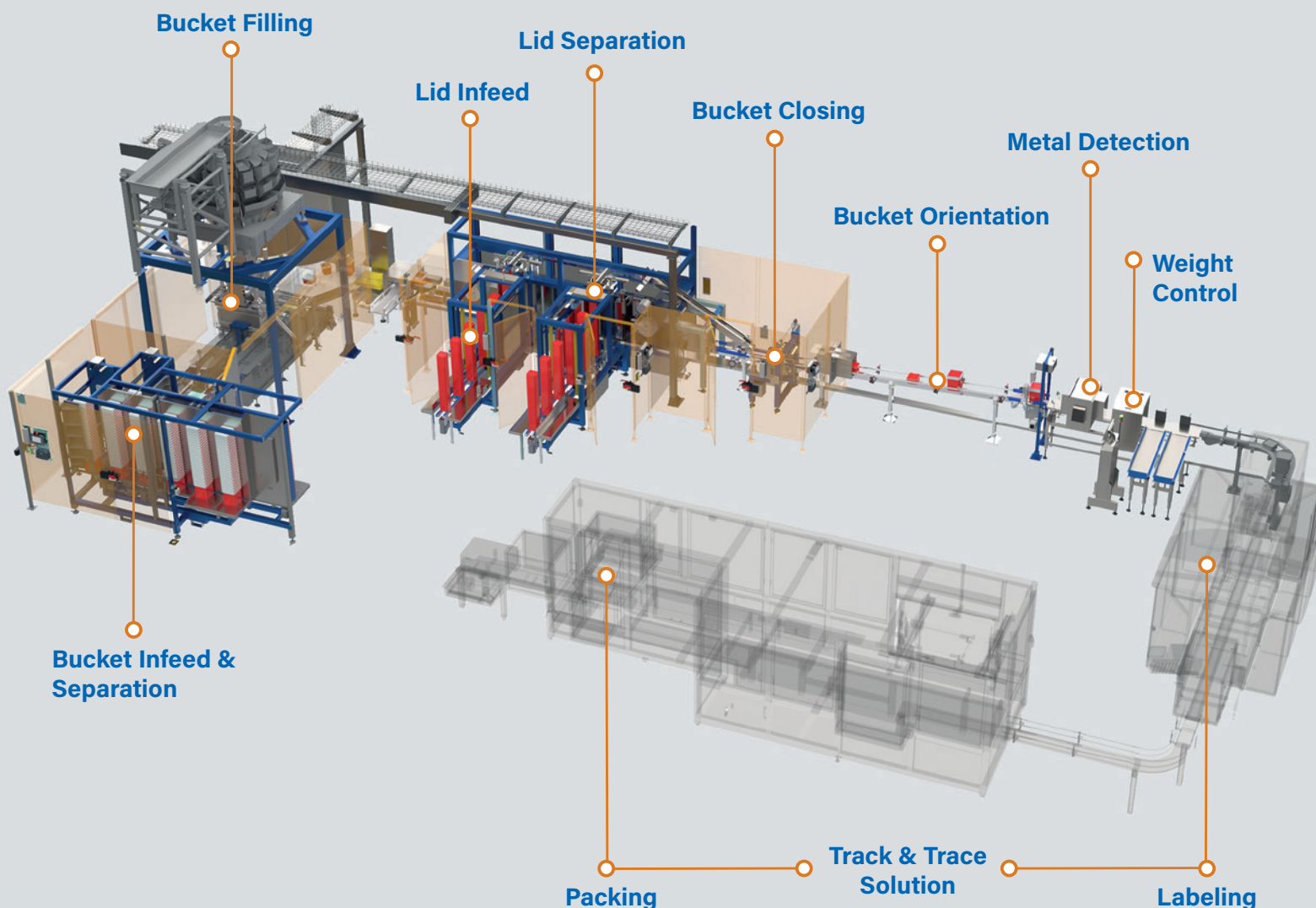
BUCKET LINE - FULLY AUTOMATED

Designed for maximum efficiency, flexibility and product quality, the **KÖHL Bucket Filling Line** offers a fully automated solution for a wide range of bucket sizes and filling weights.

From bucket destacking, precise weighing to filling, compaction and lid application, every process step is seamless-

ly integrated into one high-performance system.

As a turnkey solution provider, KÖHL delivers complete line integration, layout engineering, and CE conformity, ensuring reliable operation, maximum productivity, and long-term investment security.



From Empty Buckets to Finished Products

One Line. Reliable Processes & Performance

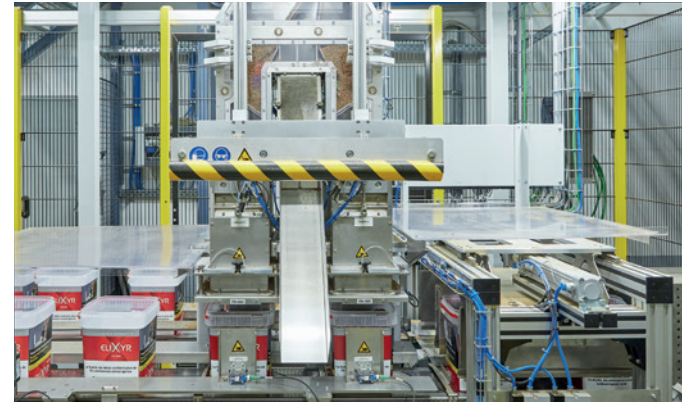
Smart Solutions - Precision in every step

Wide Bucket Size Range & Up to 30 Buckets / min



Bucket Infeed & Separation

- Twin line infeed & separation
- Buffer zone for 12 bucket stacks
- Variable bucket stacks height (up to 1.200mm)
- Suitable for 2-liter to 10-liter buckets
- Quick format change
- Up to 40 buckets / min



Bucket Filling

- 4 filling shafts
- Optimized filling shaft for 2-liter to 10-liter buckets
- Filling weight 50g up to 1.000g tobacco
- Reject of false weighing
- Enables single & double filling possibility
- Optimized filling & compacting procedure



Lid Infeed

- Twin line infeed & separation
- Buffer zone for 12 lid stacks
- Variable lid stacks height (up to 1.200mm)
- Suitable for 2-liter to 10-liter bucket lids
- Quick format change
- Up to 40 lids / min.



Lid Separation

- Enables integration of HumiPad application
- Two independent HumiPad applicators
- Single sided bobbin changes during production
- Verification of HumiPad application



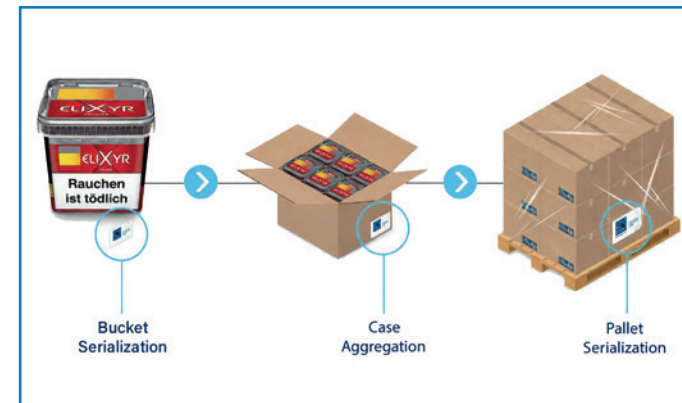
Bucket Closing

- Adjustable process gap between buckets
- Continuous flow lid application
- Continuous flow lid closing with driven pressure roller
- Suitable for 2-liter to 10-liter bucket lids
- Quick format change
- Up to 40 lids / min



Metal Detection & Weight Control

- Metal detection with separate reject buffer
- Check weigher with separate reject buffer



Track & Trace Solution

- Full T&T incorporation (up to pallet aggregation)
- Supply of printing & reading hardware devices
- T&T compliant software interfaces to high level systems
- Integration into existing machinery (retrofit) possible



Automized Palletizing

- Fully automated stacking of shipping cases onto pallets
- Handling of multiple case sizes / various setting pattern
- Handling of multiple pallet sizes
- Automated pallet supply / de-stacking
- Pallet wrapping & labeling
- Verification and reject

Performance & Benefits

Intelligent Control & Visualization

FACTS & FIGURES

- Suitable for 2-litre to 10-litre buckets
- Filling weight 50g up to 1.000g tobacco
- Total line capacity up to 30 buckets / min
- Optimized end-to-end plant operating concept
- Optimized end-to-end safety concept
- Optimized end-to-end tool concept
- Optimized easy and quick format change
- Purely mechanical format change with coded format sets
- Various bucket formats (160mm up to 240mm)
- Various bucket manufacturers and designs
- Bucket format recipe management
- Availability of various interfaces (MOM, SAP, ...)

The Bucket Filling Line is equipped with a Siemens PLC-based control system, ensuring reliable and precise operation throughout the entire process.

A central HMI panel provides operators with a clear real-time overview of machine status, production data, and diagnostics, while additional local operator panels enable efficient handling directly at key process stations. The intelligent automation concept ensures smooth interaction between all line components, delivering maximum process reliability, high operational efficiency, and full production transparency.

Features & Benefits

- Siemens PLC Control
- Proven technology for reliable operation
- Central HMI Visualization
- Real-time process monitoring and intuitive operation
- Local Operator Panels
- Fast access to key functions and diagnostics.
- Integrated Automation Concept
- Seamless coordination of all process steps

WIDE BUCKET SIZE RANGE

Product: MYO, Pipe, VOL; **Performance: up to 30 Buckets / min.;** Weight: up to 1000g / Bucket



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