



Used complete filling Krones CSD PET line - 22.000 bph



Machine type: Complete Bottling Line
Ref: LC582
Year: 2010
Speed: 22000BPH
Condition: Ready for operation
Formats: 0.50 L, 1.0 L, 1.5 L
Containers: PET
Products: Soft Drinks

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Technical details

Fill type:	Isobaric	Neck type:	PCO 1810; PSO 28 mm; 1810/1881 short neck
Isobaric:	Yes	Safety features:	Yes
Manuals:	Yes	---	---

Machine type	Manufacturer	Model	Year
Blow molder	Krones	Contiform S12M	2010
Ultra Clean filler-capper monobloc	Krones	VODM-PET 2.160-66-103 + capper K123932	2010
Labeler	Krones	Contiroll OPP 720-15	2010
Shrink-tray packer	Krones	VarioPro FS	2010
Palletizer	Krones	Robopox Modulpal	2016
Handle applicator	Twin Pack		
Processing/Premix	GEA	TDS Processing Plant (flash pasteurizer, mixer, carbonator, degasser, tanks)	2010
Laser coder	DOMINO	DDC 3 (laser)	2010
Bottle/label inspection	Krones	Checkmat 731 FM-X+L / 731 EM	2010
Pasteurizer	GEA	Flash pasteurizer	2010

Description



Used Complete Krones CSD PET Bottling Line - 22,000 BPH - Overview

This second hand, ultra-clean Krones CSD PET bottling line is a complete, high-efficiency solution for beverage production and industrial packaging across carbonated soft drinks, cider, sparkling water, still water and CO₂-mixed juices. Built by Krones and GEA in 2010 and kept in production with OEM service, the line delivers up to 22,000 bottles per hour (0.5 L) and 18,000 bph (1.5 L), combining a Contiform S12M blow molder directly coupled to an ultra-clean isobaric filler-capper bloc. It is a market-ready used bottling line designed for reliability, hygiene, and quick format changeovers in PET.

Technical Specifications & Performance Data

- Manufacturer: Krones and GEA
- Year of manufacture: 2010
- Working hours: approx. 47,000
- Nominal capacity: 22,000 bph (0.5 L) | 18,000 bph (1.5 L)
- Products handled: carbonated soft drinks, cider, sparkling water, still water, juices with CO₂
- Filling technology: Ultra-clean, isobaric, volumetric PET filling
- Current product: Apple juice with water and CO₂
- Neck finishes: PCO 1810, PSO 28 mm, 1810/1881 short neck
- Controls: Siemens Simatic S7 PLC platform

Main Equipment Scope

- CIP: Krones VarioClean F AUT fully automatic CIP system, 4 x 5000 L, 30 m³/h
- Process: GEA TDS plant with flash pasteurizer, mixer, carbonator, degasser and process tanks
- Preforms: Preform tipper/kipper and feeding conveyors; Krones Contifed RS preform feeding system; Prejet Linear preform cleaning unit
- Caps: Cassner cap feeding with cap rinsing and sterilization
- Blow molder: Krones Contiform S12M, directly connected to the ultra-clean bloc (no air conveyor)
- Filler/Capper bloc: Krones Volumetric VODM-PET 2.160-66-103 with integrated capper; Krones Vario Dos filler-bloc cleaning
- Coding and inspection: Domino DDC 3 laser coder; Krones Checkmat 731 FM-X+L filling level inspector; Krones Checkmat 731 EM label inspector
- Conveying and testing: SYNCO bottle conveyors; Krones Flowliner bottle leak tester
- Labeller: Krones Contiroll OPP 720-15, double roll-feed wrap-around labels with hot glue
- Secondary packaging: Krones VarioPro FS shrink-tray packer; Krones Multico S packet conveyors; Twin Pack handle applicator
- Pack coding: Leisinger Jet 3 ink coder
- Palletizing: Krones Robopox Modulpal (2016)

Advanced Automation & Control Systems

Line Control & PLC

- Siemens Simatic S7-series PLC for coordinated line control, interlocks and diagnostics
- Integrated filler-bloc cleaning via Krones Vario Dos for validated ultra-clean cycles
- Recipe and parameter management supporting fast changeovers between PET formats



Quality Assurance & Traceability

- Laser date coding (Domino DDC 3) on primary packaging; inkjet coding (Leisinger Jet 3) on packs
- In-line inspection with Krones Checkmat systems for fill level and label presence/position
- Leak detection via Krones Flowliner for container integrity

Production Line Integration Capabilities

Upstream (Preforms to Bottles)

- Automated preform handling: tipper, conveyors and Krones Contifeed RS for steady feed
- Preform cleaning (Prejet Linear) to protect blowing and ultra-clean downstream process
- Contiform S12M blow molding machine directly coupled to filler bloc without air conveyor, minimizing contamination risk and footprint

Filling & Capping (Ultra-Clean Isobaric Bloc)

- Volumetric VODM-PET 2.160-66-103 filler for precise, repeatable dosing in CSD and carbonated beverages
- Integrated capper with sanitized cap feed, rinsing and sterilization for hygienic closure application
- Ultra-clean design and controlled environment for sensitive beverages

Downstream Packaging & End-of-Line

- OPP wrap-around hot-melt labelling (Krones Contiroil OPP 720-15)
- Shrink-tray packaging (Krones VarioPro FS) and handle application (Twin Pack) for retail-ready packs
- Automated palletizing with Krones Robopox Modulpal (2016) for high throughput end-of-line

Machine Condition & Maintenance History

- Service history: maintained by Krones; reported in excellent condition.
- Approx. 47,000 operating hours, consistent with careful OEM-serviced use

Operational Performance & Versatility

- Formats: PET 0.5 L, 1.0 L, 1.5 L; multiple neck finishes (PCO 1810, PSO 28 mm, 1810/1881 short neck)
- Applications: carbonated soft drinks, cider, sparkling and still water, CO2-mixed juices
- Hygiene: ultra-clean isobaric filling suitable for sensitive beverages
- Efficiency: direct blow-to-bloc configuration reduces handling, energy use and contamination risks
- Consistency: volumetric/isobaric filling ensures accurate dosing and minimized product loss

Installation Requirements & Site Preparation

The following guidelines are indicative and should be confirmed during a site survey and OEM review:

- Electrical: industrial supply compatible with European specs (e.g., ~400 V, 50 Hz, 3-phase); proper grounding and harmonics control
- Compressed air: clean, dry air for blow molding, actuators and pneumatics (typically 6–10 bar; drying to low dew point)



- Process gases & utilities: CO2 for carbonation and product pressurization; steam and/or hot water for CIP and pasteurization; chilled and/or glycol water loops for process cooling; potable process water with appropriate filtration
- Product preparation: syrup/mix room integration with GEA TDS mixer, degasser and carbonator
- Drainage & effluent: hygienic floor drains for CIP returns and wash-down; effluent handling sized for CIP flow rates
- Environment: controlled air quality around the ultra-clean bloc; adequate HVAC and overpressure where specified by OEM
- Materials handling: pallet infeed/outfeed logistics, film and tray storage, label stock and adhesive management
- Layout: direct connection blow molder → filler bloc reduces footprint and eliminates air conveyor; verify conveyor runs and accumulation zones to match target speed

Safety Standards & Compliance Certification

- OEM design consistent with European machinery safety practices (e.g., CE framework), including guarding, interlocks, E-stops and lockout/tagout provisions
- Food-contact materials and hygienic design aligned with beverage industry best practices
- Integrated inspection systems for process control (Checkmat) and container integrity (Flowliner)
- Documentation, conformity and validations to be reviewed and confirmed during technical inspection

This used PET bottling line offers a turnkey platform for second hand beverage production, combining Kronen and GEA process technologies with robust automation, ultra-clean isobaric filling and complete end-of-line industrial packaging.



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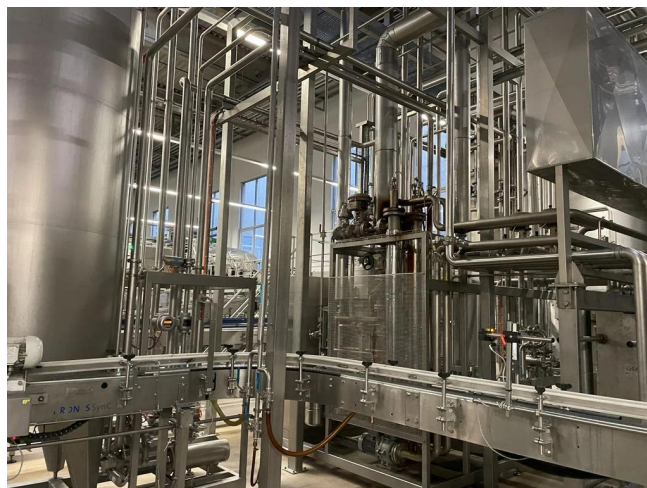
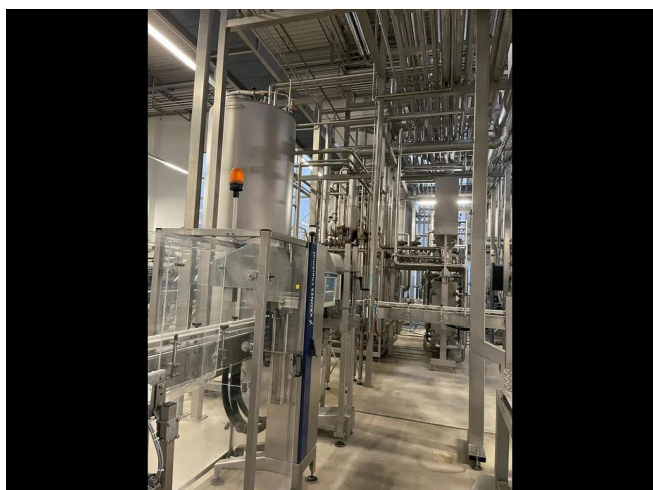
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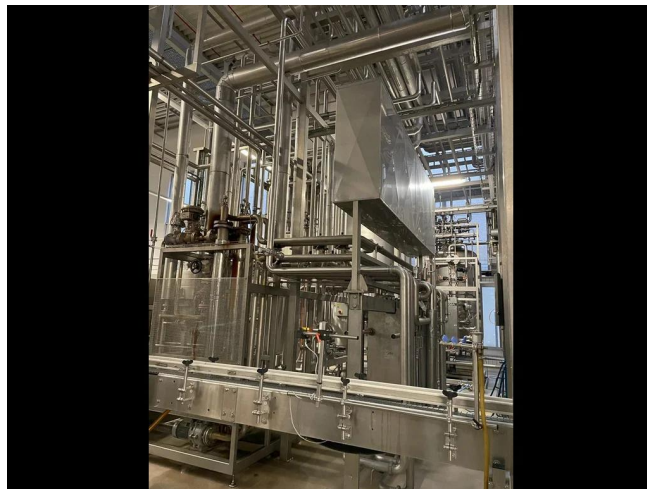
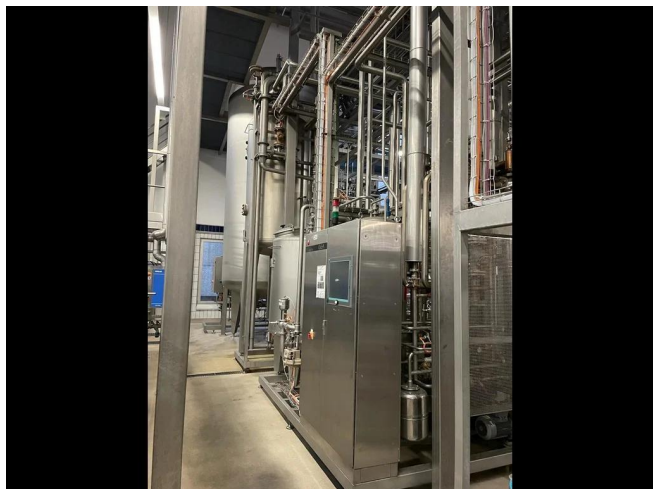
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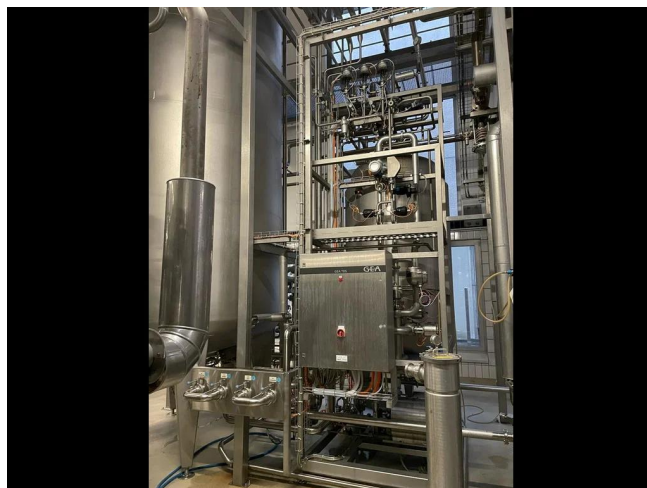
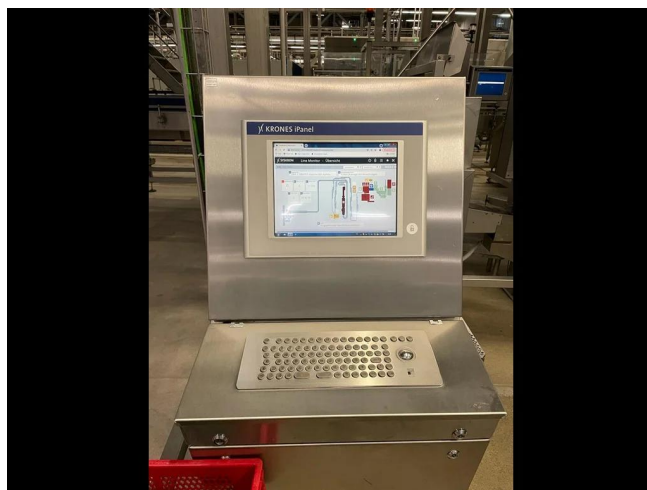
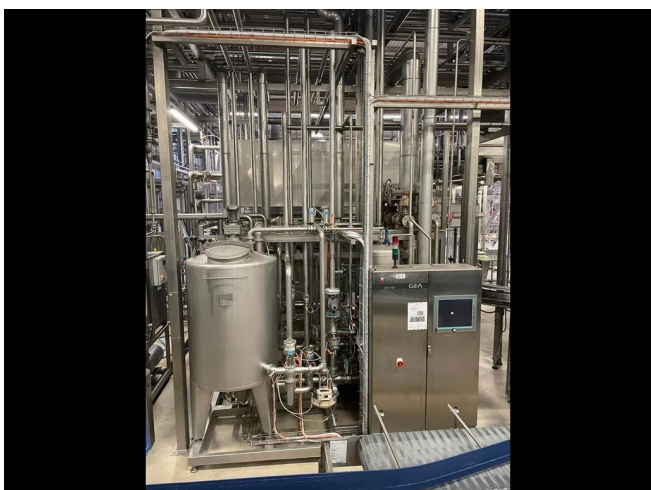
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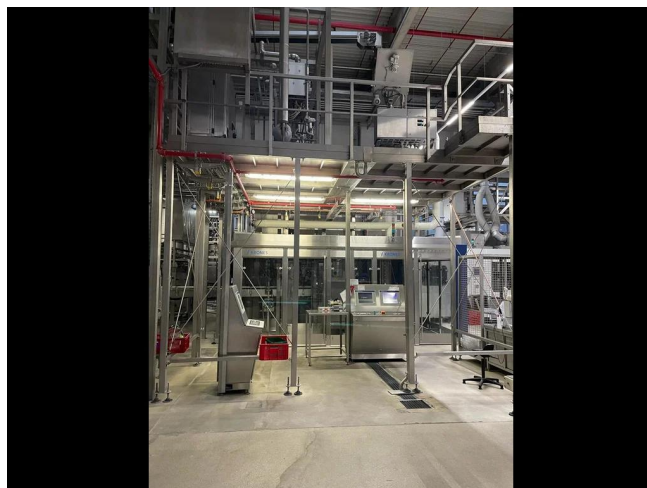
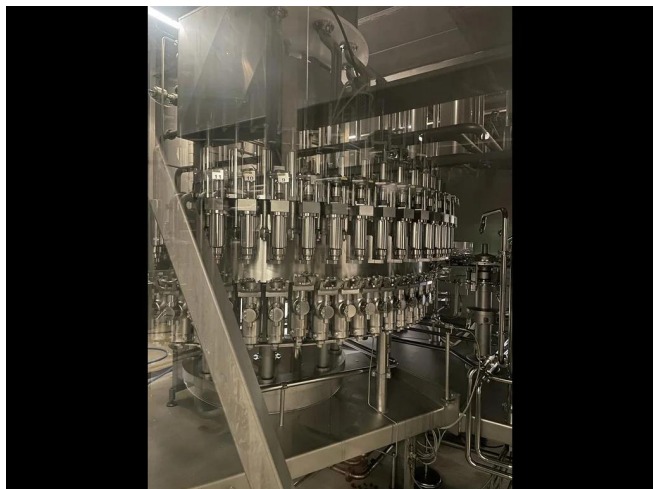
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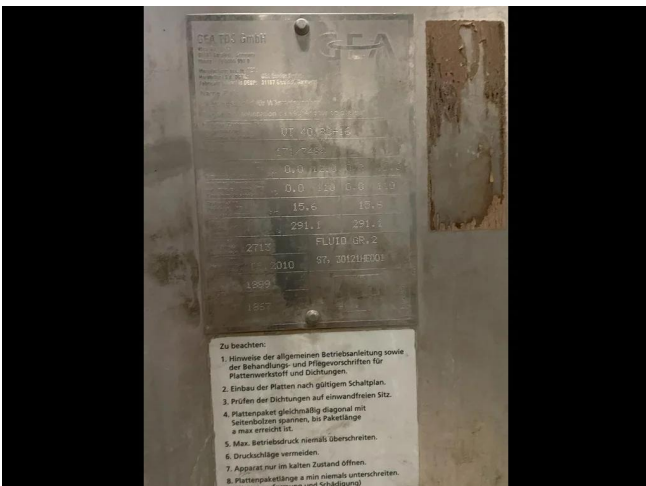
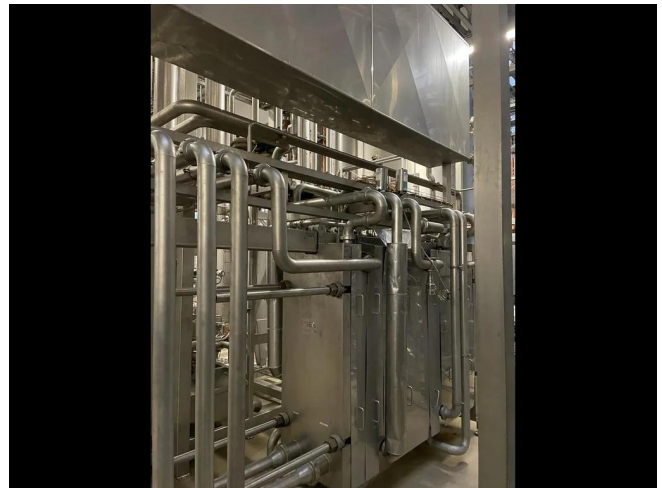
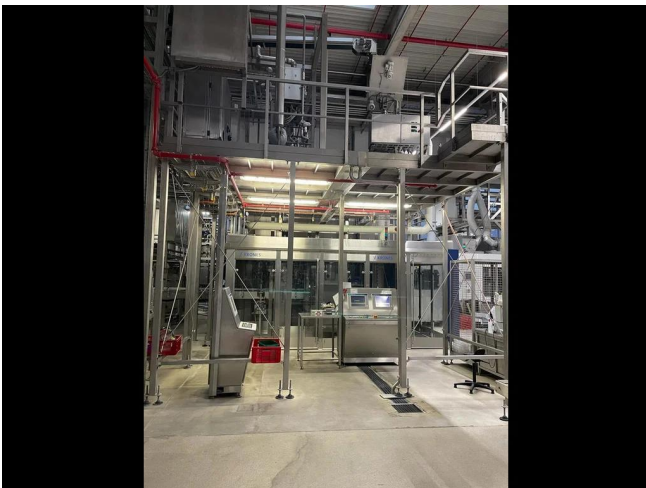




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