

MAINTENANCE

MACHINERY WORLD Rollo



Hoyer

MACHINERY WORLD





Hoyer

GENERAL CONDITIONS OF SALE AND DELIVERY

8.0

1.0 Preamble

- 1.1 The following General Conditions of Sale and Delivery shall apply, unless anything to the contrary is stated in Hoyer's offer or order confirmation or the parties agree to the contrary in writing.
- 1.2 Any special purchase conditions or specific requirements made by the buyer concerning the purchased goods and stated for example in the buyer's general conditions of purchase, acceptance, order or elsewhere, shall not be binding on Hoyer unless Hoyer has in writing accepted such special conditions, whether or not Hoyer has expressly rejected such purchase conditions or specific requirements.
- 1.3 Hoyer's order confirmation or delivery of the goods without Hoyer's simultaneous objection to the buyer's contradictory purchase conditions, if any, shall not constitute a tacit acceptance by Hoyer of any of the buyer's purchase conditions.

2.0 Contracting

- 2.1 A final contract is not entered into until Hoyer has forwarded to the buyer a written order confirmation.
- 2.2 Unless Hoyer has expressly and in writing accepted any other conditions, cf. clause 1.2, the contract is entered into on the terms and conditions appearing from Hoyer's offer, order confirmation and the present General Conditions of Sale and Delivery. Should there be any divergence between, on the one hand, the offer and order confirmation and, on the other hand, the present General Conditions of Sale and Delivery, the terms and conditions stated in offer and order confirmation shall have priority over the the present Conditions of Sale and Delivery.

3.0 Delivery terms

3.1 Unless anything to the contrary is expressly agreed upon, the delivery term shall be »FCA (free carrier), incoterms 1990» with such changes and additions as may appear from Hoyer's offer, order confirmation and the present Conditions of Sale and Delivery.

4.0 Delivery time

- 4.1 Unless otherwise agreed in writing, the delivery time shall run from whichever is the latest date of either the clarification of all technical details and Hoyer's receipt of information and drawings to be supplied by the buyer or Hoyer's receipt of the first due instalment of the purchase amount, and confirmation that the buyer has opened the letter of credit mentioned in clause 7.1 no later than one month after Hoyer's receipt of first instalment.
- 4.2 Successive delivery is allowed.
- 4.3 Should the buyer be unable or unwilling to accept physical delivery of the purchased goods at the time agreed upon, and this is not due to force majeure, cf. clause 11.0 Hoyer shall be entitled to have the goods stored at the buyer's expense and risk, and in such case delivery shall be deemed to have taken place when such storage has been effected and Hoyer has notified the buyer thereof. In such case, the purchase amount shall be due for payment as originally assumed and agreed upon.
- 4.4 In the event of force majeure, cf. clause 11, the delivery time shall be postponed.

5.0 Drawings and proposals

- 5.1 Any drawings and proposals shall be Hoyer's property and may be used by the buyer in connection with the purchased goods only.
- 5.2 Without Hoyer's prior written consent, the buyer shall have no right to copy or reproduce the drawings, nor shall the buyer have any right to pass on such drawings to any third party or inform any third party of their contents.
- 5.3 Illustrations and drawings as well as statements of capacity, weight and quantity are approximate and not binding on Hoyer, unless otherwise agreed in writing.

6.0 Prices

- 6.1 As regards goods for export, the prices are based on delivery FCA, including export packing according to Incoterms 1990. Any export costs, consular fees, taxes etc. in the recipient country are not included in Hoyer's prices.
- 6.2 Hoyer reserves the right to adjust prices when invoicing, should increases affecting the delivery in question occur in the prices of materials, wages, rates of exchange, etc. during the period of manufacture.

7.0 Terms of payment

7.1 Half (50%) of the purchase price shall be paid through a bank remittance when placing the order. For the remaining half (50%), an irrevocable letter of credit shall be opened. The letter of credit shall be confirmed by a Danish bank, preferably Den Danske Bank, Aarhus, and shall be payable in Denmark against presentation of documents for dispatch by ship, rail, road, air or transshipment or, in case the dispatch cannot be effected for reasons beyond Hoyer's control, payable when the bank receives either warehouse receipt or notification to the effect that the goods are ready for dispatch, if necessary accompanied by a receipt from the forwarding agent to the effect that he has re-

ceived the goods. Cancellation of an order does not entitle the buyer to hold back any part of the purchase sum. In case of overdue payment, Hoyer shall, after having sent to the buyer a written reminder, from the due date be entitled to calculate an annual interest on the due amount at a rate of 5% above the LIBOR rate of Den Danske Bank for a one month loan for the currency in which payment shall be made.

Title

8.1 Hoyer shall retain full and unencumbered title to all products until the purchase price has been paid in full. The buyer undertakes to handle the products with due care and insure them for their full value against all risks, including fire, with a recognized insurance company as long as they are still, wholly or partly, the property of Hoyer.

9.0 Dispate

9.1 If the terms of delivery are either delivery free of charge or C.I.F., the freight and insurance rates existing at the time of entering into the contract shall be used. Any later increase in these rates before dispatch will be for the buyer's account. If Hoyer finds it necessary in order to ensure quick and efficient dispatch, Hoyer shall be entitled to make transshipment at the buyer's expense.

10.0 Delays

- 10.1 In case of delays due to Hoyer, but not due to force majeure, cf. clause 11, the buyer shall be entitled by written notification to Hoyer to insist on delivery and to fix a final time-limit of minimum 15 days. If delivery does not take place within such final time-limit as fixed by the buyer, the buyer shall be entitled by written notification to Hoyer to claim damages which can amount to no more than 1/2 per cent per week of the total purchase amount, counting from the latest delivery date fixed. However, the damages cannot total more than 5% of the total purchase amount agreed upon on the basis of the delivery term stated in clause 3.0.
- 10.2 The buyer shall have no other rights due to delays than a right of such damages as mentioned in clause 10.1. Thus, the buyer cannot, inter alia, cancel the purchase or claim any additional damages of any kind, including damages for expenses, loss of output, loss of profits, or advance any other claims due to such delay.

1.0 Force majeure

- 11.1 In the event of force majeure, by which is understood circumstances beyond Hoyer's control occurring after the conclusion of the contract, Hoyer shall be entitled to defer delivery by a period of time equal to the period during which such circumstances exist with the effect that such deferred delivery in every respect shall be deemed punctual, the case of force majeure, the buyer shall not be entitled to cancel the purchase and shall have no other rights due to breach, including any right of damages. See, however, clause 11.4.
- 11.2 Force majeure situations which cause a deferment of the time of delivery include among others, but are not limited to, strikes, work stoppages, blockades, lockouts, late or incorrect delivery from sub-contractors, buyer or third party, for which Hoyer is not responsible, fire at Hoyer's premises or a sub-contractor, acts of God, lack of transport facilities or transport accidents, war, currency restrictions, import/export restrictions and any other circumstances beyond Hoyer's control.
- 11.3 In cases where Hoyer will rely on force majeure, Hoyer shall be under an obligation to promptly notify the buyer stating the cause and the time the force majeure situation is expected to last. At the same time Hoyer shall endeavour to overcome the force majeure situation as soon as possible and subsequently perform its contractual obligations without undue delay.
- 11.4 Where a force majeure situation lasts more than 6 (six) months, both Hoyer and the buyer shall be entitled to terminate the contract without such termination being considered breach of contract. In the event that the buyer so terminates the contract, the buyer shall thus have no rights against Hoyer due to breach.

2.0 Approval and permission

12.1 The buyer shall obtain, and bear the risk of obtaining, any necessary approval and permission to deliver, assemble, install, start, test and run the plant.

13.0 Suitability test

13.1 Samples of product recipes, ingredients, packaging materials, sticks, cups, cones and the like sent to Hoyer by the purchaser in the agreed quantity and by the agreed date will be tested by Hoyer for their suitability, and Hoyer may make recommendations based on previous experience or agreed laboratory tests. However, since it is not always possible to foresee or simulate actual and local production conditions, these recommendations shall be regarded as a guide only and shall in no way be considered as a warranty or guarantee or constitute any kind of legal obligation on Hoyer's part.

Erection and mechanical test

14.1 Erection, installation, starting up and testing of the delivered plant at the buyer's premises are not included in the purchase contract and thus not included in the purchase price. According to previous arrangement Hoyer will place at the buyer's disposal a qualified fitter according to Hoyer's general terms for the provision of technical personnel for plants and machinery abroad.

- 14.2 In case it has been specifically agreed that erection, installation and mechanical test are included in the purchase contract and thus included in the total purchase price, the buyer shall ensure that the work can be commenced immediately on the fitter's arrival. For instance, the plant shall be in position for erection, the premises ready for the starting up, all brick-laying finished, windows and doors in place and the plant area sufficiently heated and lit. Further, all necessary installations (electricity, sanitary appliances etc.) shall be ready, so that no delay arises for that reason. Extra costs incurred through such delays shall be borne by the buyer, as shall costs incurred through the interruption of erection or any other delay of the starting up for which the supplier is not responsible.
- 14.3 The buyer shall, free of charge, place at Hoyer's disposal the skilled and unskilled labour necessary for the transport and erection of the plant and equipment. The buyer further arranges for the future machine operators to be present for instruction and training. Assistance and access to necessary facilities in at least six days a week from 6 am to 10 pm is presupposed.
- 14.4 If sub-clause 14.2 applies, the delivery is concluded with a mechanical test run without production of the products after which a "Mechanical Completion Certificate" is signed by both parties and the risk of the delivery is transferred to the buyer. If material defects are established a new mechanical test run is carried out when Hoyer has informed the buyer in writing that the defects have been remedied.

15.0 Commissioning

- 15.1 If Hoyer according to agreement is also responsible for the commissioning of the plant, this will be commenced immediately after the signing of the "Mechanical Completion Certificate". Hoyer shall inform the buyer of the time schedule thereof.
- 15.2 The commissioning procedure includes a test run of the plant during a limited period of time, at which test run the products are produced under the supervision of Hoyer in order to prove that the plant meets the agreed demands as to the output and product. The test run is divided into two phases. The first phase is finished with the signing of a "Product Approval Certificate". The plant is then fine-tuned and on the basis of a capacity test a "Take Over Certificate" is signed.
 - Before the commissioning is commenced the following conditions shall be fulfilled:
 - (1) The plant shall be properly erected, installed and connected and if Hoyer has been responsible for the erection, a »Mechanical Completion Certificate« shall be signed.
 - (2) Equipment and connections not supplied by Hoyer shall be compatible and correctly installed.
 - (3) The quantity and quality of the raw materials, auxiliary materials and consumables to be used shall be correct and paid for by the buyer.
- 15.3 If the buyer cannot comply with the above conditions, Hoyer shall not be obliged to commence or continue any tests until such conditions have been met. Any additional costs incurred in this connection shall be borne by the buyer.
- 15.4 The plant is considered to be delivered to and taken over by the buyer, and the risk of the delivery transferred to the buyer, when the »Product Approvai Certificate» and the »Take Over Certificate» have been signed, unless material defects have been established. If that is the case, new test runs have to be arranged when Hoyer has informed the buyer in writing that the defects have been remedied.
- 15.5 Hoyer is under an obligation to remedy minor defects established at the test runs as soon as possible and the parties shall agree on a time limit for this. The buyer is not entitled to retain any part of the purchase price or to offset against such due to minor defects, if any, established at the test runs.
- 15.6 As a schedule to the "Product Approval Certificate" and the "Take Over Certificate" a document is drawn up which shall be signed by Hoyer and the buyer and in which minor defects and other things pointed out by the buyer are stated. In the document, which is a schedule to the "Take Over Certificate", the parties shall state whether they, irrespective of any minor defects, consider delivery to have taken place and thus the risk to have passed on to the buyer.
- 15.7 In case the buyer is prevented from being present at the agreed time of the test runs, Hoyer shall, with a reasonable time limit to be fixed by Hoyer, inform the buyer of a new date for such test runs. If the buyer fails to attend the postponed test run, this test can be carried out in his absence, but he shall in that case bear all costs in connection with the postponed test run. After the completion of the postponed test run Hoyer shall, as soon as possible, inform the buyer thereof and of the content of the document prepared as a result of the test run.
- 15.8 In case the buyer de facto starts using the plant or any part thereof,

irrespective of the extent and character thereof, before the signing of the "Take Over Certificate", then the plant shall be considered taken over by and delivered to the buyer and the risk transferred to him and the remaining part of the purchase price due. In that case Hoyer's responsibility for the output and capacity of the plant, to the extent Hoyer has accepted such responsibility in the contract between the parties, shall cease. The buyer is in that case not entitled to retain any part of the purchase price due to works not yet performed or defects claimed in the delivered machinery.

15.9 The plant shall be at Hoyer's operational disposal until the buyer takes over the plant.

16.0 Defects

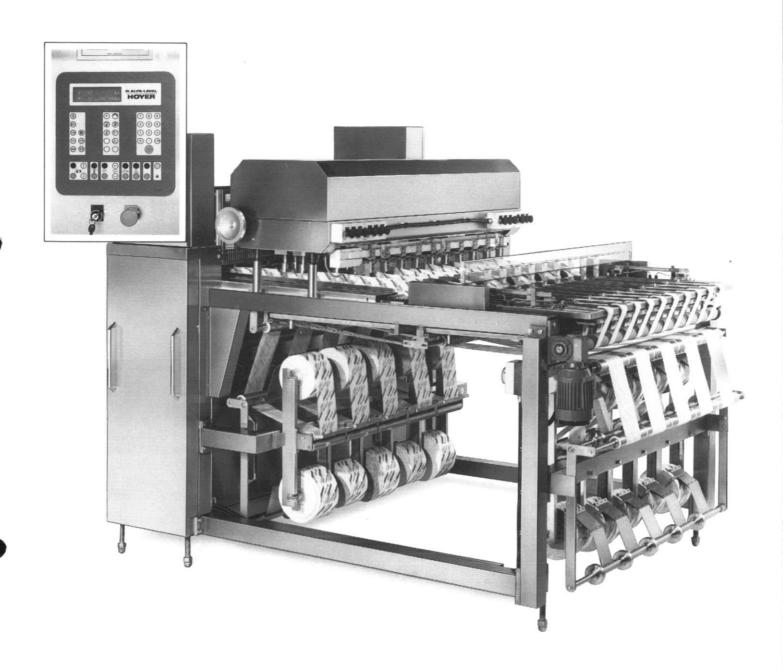
- 16.1 Hoyer is only liable for defects in new machines of their own make.
- 16.2 Used machines are taken over in their existing condition without Hoyer being liable, and consequently the buyer cannot hold Hoyer responsible for defects, if any, whether latent or noticeable.
- 16.3 Hoyer's liability for defects which can be attributed to deliveries from Hoyer's sub-contractors or third party shall be limited so that Hoyer does not assume further liability for such defects than the subcontractors or third party have assumed towards Hoyer to the effect that Hoyer in relation to the buyer only is liable for defects to the same extent as the sub-contractors and third party are liable for defects towards Hoyer.
- 16.4 Hoyer's liability for defects is conditional on the buyer fulfilling his obligations according to the agreement, in particular that he has fulfilled all payment obligations. The buyer is thus not entitled to retain the purchase price wholly or partly or to offset against any payments due as a result of defects claimed.
- 16.5 Hoyer is liable for all defects due to defects of manufacture, construction or material and which are established within 12 months from the completion of the mechanical test and the signing of the "Mechanical Completion Certificate", however, not more than 15 months from the date of dispatch from Hoyer.
- 16.6 The length of the period of liability mentioned in clause 16.5 is conditional on the plant being in operation not more than 1,800 hours per year. After 1,800 working hours Hoyer is no longer liable for defects, cf. clause 16.5.
- 16.7 Hoyer shall have no liability for defects for which Hoyer is not responsible, for instance but not limited to defects due to incorrect information and drawings received from the buyer, normal wear and tear, in sufficient maintenance, non-compliance with Hoyer's operation instructions, overload, insufficient lubrication, unusual or incorrect use of the delivered machinery, changes made by the buyer without Hoyer's written consent, defects of repairs carried out by the buyer etc. Further Hoyer's liability does not include cooling medium, driving betts, refrigerant and the like.
- 16.8 In the case of defects established and claimed towards Hoyer, Hoyer is entitled and obliged at their own option either to carry out a replacement delivery, or to remedy the defect or to reduce the agreed purchase price proportionately after which the defect is considered definitely remedied. If defective parts are replaced the replacement is conditional on the buyer sending the defective part carriage-paid to Hoyer Replacement parts will be delivered by Hoyer FOB or FCA Arhus, Incoterms 1990, exclusive of installation to be performed by the buyer.
- 16.9 Hoyer's liability for defects shall not exceed an amount equivalent to 5% of the total purchase price. Thus, no claims for damages exceeding this amount can be advanced against Hoyer.
- 16.10 Hoyer shall, apart from what is laid down above, not be liable for defects and the buyer cannot claim other breaches of contract than what appears from the above. In no circumstances is Hoyer liable for loss of output, loss of profits or other indirect or consequential losses suffered due to defects established and this notwithstanding simple or gross negligence displayed, if any.
- 16.11 It is particularly emphasized that the buyer in every respect is precluded from cancelling the agreement due to defects established.

17.0 Disputes

- 17.1 Any dispute arising in connection with the present General Conditions of Sale and Delivery or otherwise in connection with any agreement between the parties shall be settled by arbitration at the international court of arbitration (*Den Internationale Voldgiftsret*) in Copenhagen and shall be subject to Danish law. All proceedings shall be in the English language. The venue shall be the court having jurisdiction over the county in which Hoyer is domiciled at the time in question.
- 17.2 Notwithstanding clause 17.1, Hoyer shall be entitled, at Hoyer's own choice, to institute proceedings at a court having jurisdiction over the buyer, provided the claim made by Hoyer pertains to the collection of amounts due pursuant to an agreement between the parties.

ALFA-LAVAL HOYER

HOYWRAP ML 700/1100/1400 Multi-lane Flow Wrappers



The Hoywrap ML, multi-lane, flow wrapper is designed for continuous wrapping of a wide range of food products, for instance candy bars, nutrition bars, biscuits, cakes and other baked products, convenience foods, ice cream novelties etc.

With operating speeds of up to 60 cuts per minute and with up to 16 lanes, the Hoywrap multi-lane wrapper can wrap up to 60,000 products per hour.

The relatively low operating velocity of the Hoywrap ensures greater reliability and reduces downtime.

Operating Principle

The unwrapped products are transferred from the processing line to the Hoywrap via a multi-lane feed-in unit which spaces the products correctly by means of register spades. Different accumulating and spacing systems are available, depending upon the specific product and processing line.

The wrapping material is lead by driving rollers to a set of sealing rollers where fin sealing takes place either by heat sealing or cold sealing. With heat sealing the rollers are electrically heated whereas with cold sealing the pressure of the rollers against the wrapping paper is sufficient to make the weld. Cross-sealing and cut-off are carried out by independent sealing jaws and knives mounted on two rotating shafts. After wrapping the products are led to a HMI stacker/interleaver and then transferred to a packing system, typically a Hoypack automatic cartoner.

A built-in PLC control system controls all functions of the Hoywrap and ensures synchronization with the machine, to which it is connected.

The wrapper is driven by a built-in gear motor which is regulated by means of a frequency converter.

Standard Design

The wrapper is built on sturdy stainless square tubes (RHS tubes). All main components including the control panel are covered with stainless steel sheeting ensuring easy cleaning.

The membrane switch control panel displays data such as speed and sealing temperature.

The wrapper is designed for free placing on the floor and is equipped with adjustable stainless steel legs.

The transformer, frequency converter, PLC etc. are contained in a control cabinet which may be mounted on a wall or stand separately. The control cabinet is provided with a main switch. The paper roll suspension is mounted beneath the paper lanes as an integral part of the machine which saves space.

There are two paper rolls for each lane of the wrapper — one running during production, and one stand-by roll for continuous roll-change. Roll change is carried out without stopping production thus avoiding down time and product loss.

The wrapper is equipped with wrapping material brakeaction, ensuring a continuous, gentle paper feed. The wrapping lanes, which are situated above the paper roll suspension, run in open U-profiles to guide the products into position.

The Hoywrap is available in three different sizes, ML 700 up to 7 lanes wide, ML 1100 up to 12 lanes wide and ML 1400 up to 16 lanes wide. All models may be prepared for:

- · heat and cold sealing of paper (standard) and
- heat and cold sealing of plastic laminates, plastic/ aluminium laminates, OPP and PE materials etc. optional, or
- cold sealing of paper only (optional).

Product Dimensions

In standard design the Hoywrap ML can handle products with the following dimensions (stick products incl. 35 mm (1.4") protruding stick):

	Minimum	Maximum*
Length	110 mm (4.3")	180 mm (7.1°)
Width	15 mm (0.6")	0.5 × Hoywrap pitch less 6 mm
Thickness	10 mm (0.4")	35 mm (1.4")
Paper width	80 mm (3.2*)	1.6 × Hoywrap pitch
Bag length	160 mm (6.3")	230 mm (9")

^{*} Not all maximum dimensions at the same time.

Normal Paper Width

Max. circumference of product including coating plus 30 to 35 mm (1.2" to 1.4") depending on shape of product.

Normal Bag Length

Total length of product plus 40 to 50 mm (1.6" to 2") depending on product thickness. A cut-off gear wheel for one specific bag length is included as standard. One tooth of the gear wheel corresponds to 2 mm (0.08") bag length.

Minimum Pitch

Between wrapping lanes: 78 mm (3.1")

Paper Specifications

The Hoywrap is designed for the following types of paper:

Cold sealing: 35-40 g/m² bleached kraft +

5 g/m² cosil

8 g/m² saran may be added 35-40 g/m² bleached kraft +

Paper 8 Plastic 0

Heat sealing:

8—12 g/m² PE (polyethylene) OPP + PE or other heat sealing materials with a thickness from

25-40 micron.

Printing inks on the outside of the wrapping material must be heat resistant up to 180°C (356°F). Before final selection of wrapping materials and dimensions, samples should be sent to Hoyer for laboratory tests and approval.

Roll diameter: max. 400 mm (15.8")

Core diameter: standard 71 mm or 76 mm (2.8" or 3") Core diameter must be specified at time of order.

Production Capacity

Up to 60 cuts per minute, corresponding to max. 3600 products per lane per hour. Actual capacities will depend on type of product, wrapping paper etc.

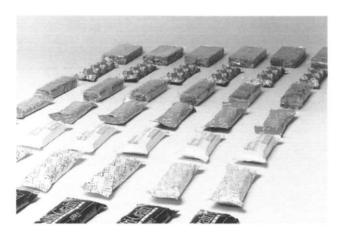
Optional Equipment

- 4.00 Paper formers and register spades for alternative paper widths and bar widths.
- 4.01 Cut-off gear wheel for alternative bag lengths.
- 4.02 Photo-electrically controlled »picture in place« cut-off.
- 4.03 Extra driving rollers for wrapping in both plastic laminates and paper.
- 4.04 Coding system for continuous printing on paper.
- 4.16 Gas flushing equipment for adding inactive gas.
- 8.00 Spare parts for 2 years' operation.

Typical food products suitable for continuous wrapping on the Hoywrap ML multi-lane wrapper.



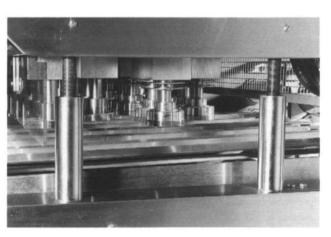




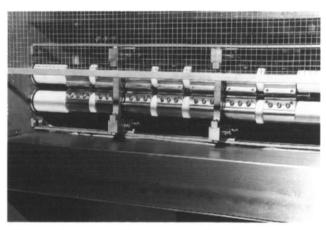




View of gearbox controlling the drive and sealing rollers for fin sealing.



Mechanical drive of the sealing and driving rollers ensures optimum accuracy and full synchronization.



The sturdy cross sealing and cut-off shaft is fitted with extra bearings at intervals along the shaft to provide extra support.

Technical Data	HMW 700	HMW 1100	HMW 1400
Heating Coils			Α.
Cross sealing	1 kW	2 kW	2 kW
ongitudinal sealing	1 kW	2 kW	2 kW
Connection	4 kW	6.5 kW	6.5 kW
Voltage — standard		$3 \times 380 \text{ V}$, 50 Hz	
optional	accord	ing to customer specific	ations
Air consumption	2.0 m ³ (71 cu. ft.)/h	2.0 m ³ (71 cu. ft.)/h	2.0 m ³ (71 cu. ft.)/h
Air pressure	5-7 bar (73-102 psi)	5-7 bar (73-102 psi)	5-7 bar (73-102 psi)
Shipping Data			
Net weight	800 kg (2200 lbs)	900 kg (1980 lbs)	1000 kg (2425 lbs)
Gross weight	1000 kg (1770 lbs)	1100 kg (2425 lbs)	1300 kg (2866 lbs)
Volume	7.3 m ³ (258 cu. ft.)	9.3 m³ (328 cu. ft.)	11.5 m³ (406 cu. ft.)
Main Dimensions			
4	2330 mm (92")	2330 (92")	2330 mm (92")
3	1210 mm (48")	1580 (62")	1950 mm (77")
	1800 mm (71")	1960 (77*)	1960 mm (77*)
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Suitability of Packaging Materials

Samples of packaging materials for use with this equipment must be sent to Hoyer in the agreed quantity and by the agreed date. Hoyer will evaluate the suitability of the samples and make recommendations based on previous experience or agreed laboratory tests. Since it is, however, not always possible to foresee or simulate actual production conditions these recommendations shall, unless otherwise agreed, be regarded as a guide only and shall in no way be considered as a warranty or legal obligation of any kind.





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Phone: +45 86 29 29 11 Fax: +45 86 29 22 00 Telex: 6 87 70 alhoy dk

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731,900

Hoyer

Quotation

1015219-1

Aylesbury Ice Cream 25 Aylesbury Street P.O. Box 3579 Tygerpark 7536 South Africa

Your ref		Date: November 1993
Item Qty		USD
	With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 80008 E7, which form an integral part of this quotation, we take pleasure in offering you as follows:	
01 1	HOYER Ice Bar Freezer, Type ROLLO 35	
	of standard design including:	
	 Main drive Brine tank and evaporators Defrosting system Control panel PLC control Mould table segments with freezing pockets of standard design. Standard number of freezing pockets: 2016 Top filling machine for one-coloured ice cream, incl. column Automatic stick dispenser Extractor and lay-off device Chocolate coating equipment Complete filling unit for 2 colours per radial row, incl. column and single, divided hopper Complete filling unit for one-coloured water ice incl. column. Split ice equipment for one colour per radial row incl. vacuum tank, return pump and new ice cream filler pistons Washing and sterilizing apparatus 	
	- Platform of galvanized steel - Bridge	
	- Standard spares and tools	

O. G. Hoyer A/S



Aylesb	ury Ice Cream 1015219-1	23-11-93
Item Qty		USD
01A 1	Optional Equipment: Additional mould table for Rollo 35 Additional Price	111,100
01 B 1	Special filling unit for water ice with fruit pieces	
	Additional Price	48,000
02 1	Hoywrap ML 35 Multilane Wrapper - 7 Lanes	
	Standard design according to enclosed product description No. PD 80220, including:	
	 Basic machine with drive controlled by VLT frequency converter and all functions controlled by PLC Built-in paper rack with extra paper roll suspension for each lane One set of paper formers One set of register spades One set of positive pressure lengthwise sealing rollers One set of drive rollers Rotating positive pressure sealing jaws with built-in knives for cross sealing and "straight-edge" cut-off Synchronization with lay-off from stick novelty freezer Control panel (stainless) Separate power supply board (non-stainless) Extra driving rollers for wrapping in plastic laminate Outlet conveyor for connection to manual packing table 	
	Price	209,900
	Optional Equipment:	
02A 1	Photo-electric registration system	
	(picture-in-place cut-off) with standard photocell system	
	Additional Price	37,300



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Aylesbu	ry Ice Cream 1015219-1	23-11-93
Item Qty		USD
02B 1	Date and/or price coding system	
	Endless printing by means of a hot printing roller, including:	
	- Markem 686 A coder - Brackets for mounting - 1 set of standard letters and numbers	
	Additional Price	38,800
02C 1	Parts for additional product size	
•	Additional Price	5,900
	The Prices:	
	are to be understood F.C.A. Aarhus, Denmark, incl. packing for the transport in question.	
	"INCOTERMS 1990" apply.	
	Delivery (Shipment from Denmark) :	
	4 to 5 working months after receipt of order.	
•	The above mentioned time of delivery is to be reckoned from the date all relevant technical information/samples necessary for production of the machine have been received and approved by Hoyer.	
	In addition, the time of delivery depends on the downpayment being paid according to agreed terms of payment.	
	Payment:	
	30 % downpayment to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus, Denmark, not later than 15 days after the date of the proforma invoice.	

Teirs Laval Food



Avlesh	ury Ice Cream	1015219-1	23-11-93
	ury ice Cream	1013219-1	
Item Qty			USD
	70 % of the contractual amount to be paid against presentation shipping documents, or, if, owing to conditions beyon control, shipment cannot take place at the time agreed against warehouse receipt.	nd Hoyer's	
	The payment must be secured by an irrevocable letter of cred opened by a first-class bank, and to be payable at sight at the and confirmed by Den Danske Bank, Aarhus, Denmark.		
	The letter of credit must be opened on order and be valid for month after estimated delivery, allowing partial shipment and transshipments.		
	All costs in connection with the confirmation and keeping in Letter of Credit - abroad and in Denmark are for the account		
	Validity:		
	Our quotation is valid for two weeks from date of quotation.		
	Exclusions:		
	Our quotation includes only the equipment and services ment thus e.g. not:	ioned and	
	- Any building works		·
	- Service installations such as air (compressor), water, steam refrigeration, pipes and valves used for service medias	, electricity,	
	- Conveyors and packing tables at production machines excepspecified	pt for those	
	- All handtools necessary in the production such as buckets,	scales, etc.	
	- Customs duty and purchase tax of any kind		
	- Electrical main switchboards		
	- Oil, brine and NH ₃		
	·		



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Ayles	bury Ice Cream 1015	219-1	23-11-93
Item Qty			USD
	Leaflets enclosed serve for informative purposes only and any specificatures or optional extras are only included in our supply if specific mentioned in our specifications.		
	Other Conditions :		
	All samples must be sent free of charge to Hoyer for comments. Ho comments to be considered guidelines only as a realistic test can on made on the finished line in operation.		
	Time, number or amount of samples to be received by Hoyer to be upon in order to keep the stated delivery time.	agreed	
	We hope our quotation is in accordance with your wishes and look forward to receiving your order. Should you have any further quest we are of course at your disposal with further information.	ions	
	Yours faithfully		
	O.G. HOYER A/S Knud Leth Jørgensen		



Hoyer

TELEFAX

TO FAX NO:

009 27 21 9487302

FROM FAX NO: +45 86 29 22 00

COMPANY:

Aylesbury Ice Cream

16:21

South Africa

FROM:

Knud Leth Jørgensen

DATE:

26 - 11 - 1993

REF.:

KLJ/bhj

NO OF PAGES (INCL. THIS):

6

Please hand over this telefax (6 pages) to our Mr. Finn Kallemose.

Thanks in advance.

d.G. HOYER A/S DENMARK

Taira Laval Food



Hoyer Aylesbury Ice Cream

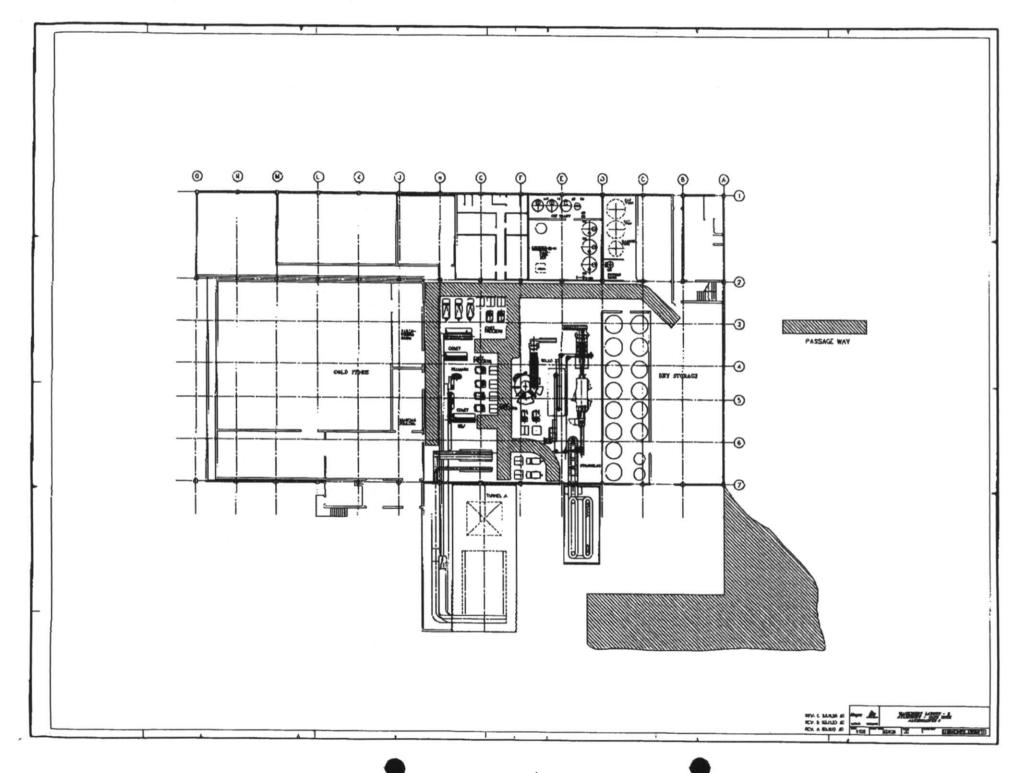
1015035-2

22-11-93

Aylesbury Ice Cream 1015		5035-2 22-11-93	
Item Qty	SPECIFICATIONS	USD	
5.02 1	Installation Equipment		
	Including:		
	17 ETP04-49xx level transmitters for 38 mm clamp erection		
	17 BTP04-9122 connecting branches for tanks		
	36 electrodes		
•	12 level switches		
	29 PT-100 temperature transmitters, output 4-20 mA for 38 mm clamp erection		
	4 conductivity transmitters		
,	4 probes for conductivity transmitters	ľ	
	4 PD340 flow transmitters		
	3 weighing cells	·	
	1 weighing amplifier		
	52 proximity switches		
	Price	74,200	
5.03	Technical Assistance	·	
	Supervision of Installation		
	based on Hoyer specialists for a total of 16 man weeks (60 hours/week).		
	Price	88,100	
	Start-Up Assistance		
	based on Hoyer specialists for a total of 10 man weeks (60 hours/week).		
	Price	55,100	
	Travel expenses, board and lodging and local transport will be invoiced according to actual costs.		
•		1	
•			



HOY	Yer ylesbury Ice Cream 1015015-2	22-11-93
Item Qty	SPECIFICATIONS	USD
	SECTION 20.00 - START-UP	
	Start-up assistance is not included in this quotation. The start-up assistance will be invoiced according to actual time consumption using below rates valid for 1993.	
	- One Hoyer specialist normal hour USD 77 One Hoyer specialist travel hour USD 66	
	Travel expenses, board, lodging, local transport and pocket money will be invoiced according to actual costs.	
	Please note that we estimate 22 man weeks (40 hours/week) for start-up of the products included.	
	Total Price for the estimated 22 weeks of start-up assistance excl. travel expenses, board and lodging and local transport	70,500
	In the start-up period less production than specified and more than normal manpower must be expected and allowed for.	
	Furthermore in accordance with our "General Terms for Providing of Technical Personnel for Plants and Machinery Abroad", No. QT 80006.	
	If further assistance is needed, it will have to be paid for separately according to the above-mentioned conditions.	
	Estimated Price for travel and board and lodging	54,500
•		

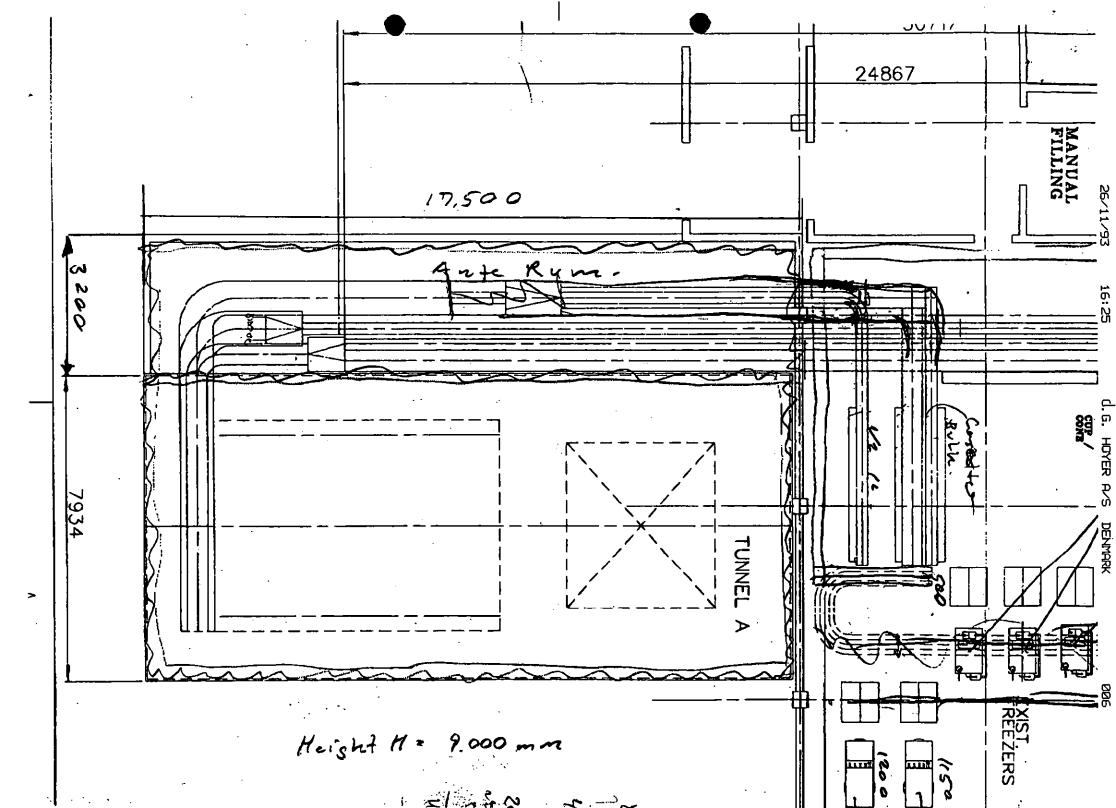


Insulated Enclosure for the Polyflex Hardening Tunnel incl. Erection

The enclosure has outside dimensions of approx. 11.5 m wide x 9 m. high x 19.5 m long. The height of the enclosure is exclusive of base w. h floor neating. The base is horisontal.

The enclosure will consist of the following elements:

- Floor insulation of High density type, polyurethan foam of 125 mm thickness. The floor insulation includes load block of 400 x 400 mm of sufficient strength for column loads of up to 10 tons.
- A welded stainless bottom tray will be placed on the top of the floor panel.
- Support structure for roof and walls.
- Walls made of 125 mm insulated panels with 0.6 mm profiled metal sheeting PVC coated.
- Roof made of 125 mm insulated panels with 0.6 mm profiled metal aheeting PVC coated.
- Two (2) 1.0 m wide x 2.0 m high insulated doors.



16:18

Insulated Enclosure for the Polyflex Hardening Tunnel incl. Erection

The enclosure has outside dimensions of approx. #S in wide x^S in. high x19.5 m long. The height of the enclosure is exclusive of base w. h floor neating. The base is horisontal.

The enclosure will consist of the following elements:

- Floor insulation of High density type, polyurethan foam of 125 mm thickness. The floor insulation includes load block of 400 x 400 mm of sufficient strength for column loads of up to 10 tons.
- A welded stainless bottom tray will be placed on the top of the floor panel.
- Support structure for roof and walls.
- Walls made of 125 mm insulated panels with 0.6 mm profiled metal sheeting PVC coated.
- Roof made of 125 mm insulated panels with 0.6 mm profiled metal sheeting PVC coated.
- Two (2) 1.0 m wide x 2.0 m high insulated doors.

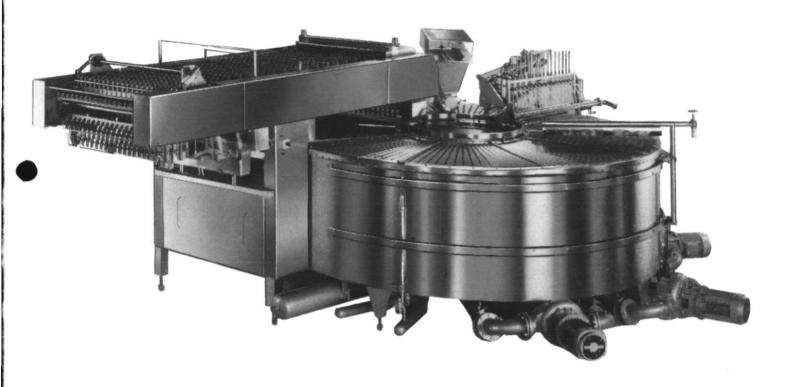


Hoyer

Product Description

ROLLO 35

Automatic Ice Cream Bar Freezer



Application

Automatic, continuous production of ice cream, sherbet, or fruit-juice bars, with sticks.

Operating Principle

The production of ice cream bars is carried out in six main stages:

- 1. Filling of ice cream into the moulds.
- 2. Insertion of wooden sticks into the ice cream.
- Freezing of the bars in a cold brine bath at −40°C (−40°F)
- Defrosting of a thin outer layer of the bars in a warm brine bath at +25°C (+77°F)
- 5. Extraction of the frozen bars from the moulds.
- 6. Lay-off for packing.

Between extraction and lay-off, the bars may be coated with chocolate or dry stuffs.

The moulds, in which the bars are shaped and frozen, are built into an annular, rotary table situated on top of the brine tank.

Capacity

Depends on the size and shape of the bars. A typical example is 32,000 bars per hour of the rectangular type containing 75 cc (2.5 fl.oz.) of ice cream.

Standard Design

Brine Tank. The double-walled annular tank is welded, and insulated. The outside of the tank is covered with stainless steel.

Two rails are placed on the outside of the brine tank for mounting the stick dispenser, the cleaning equipment, the filling equipment, etc.

The brine tank is divided into a freezing zone with cold brine and a defrosting zone with warm brine.

Cooling System. The primary cooling system consists of evaporating coils placed at the bottom of the brine tank. Ammonia is used as refrigerant. The secondary cooling system is a cold brine bath, and the cold brine is

circulated by a centrifugal pump. The cold brine distribution trough is made of stainless steel.

The ammonia system is for pump circulation. The evaporation coils are built into the brine tank and equipped with oil drain valves. A stop valve is mounted in the liquid line. A suction stop valve is also supplied.

Defrosting System. The warm brine is heated either by electricity or by steam. The choice must be made when ordering. The brine is sprayed onto the underside of the moulds through a nozzle system. The defrosting system is equipped with a separate centrifugal pump. A thermostat prevents operation of the extractor if the warm brine temperature is too low.

Main Drive. All main functions are mechanically actuated and controlled through cams. The auxiliary functions and other functions with limited power demands are pneumatically controlled and actuated. The speed of Rollo 35 varies between 10 and 30 strokes per min.

Electrical Equipment. The equipment is housed in a separate epoxy-coated power cabinet and consists of a main circuit breaker, circuit breakers, motor starters incl. protection, control relays for heating elements, transformers for control voltage and a time totalizer.

Control Panel. Operation is carried out from one control panel mounted on the machine. All functions are PLC controlled providing a high degree of automation. Pushbuttons, pilot lamps and digital displays for ammonia evaporating temperature and for cold brine temperature are installed. The warm brine temperature is electronically controlled and is also displayed on the control panel. A 6-digit display shows strokes/min. and number of extracted products while an alpha-numeric display provides operating and diagnostic information. An audio alarm is also included.

Communication with a central computer is available as an optional extra. Another available option is the substitution of the standard PLC by a larger computer which can provide a higher degree of automation and reporting e.g. computer control of other sections of the line such as wrapping and cartonizing, start-up and shut-down programs, production data memory, etc.

The computer equipment includes an alpha numerical keyboard and 14" color monitor.

Mould Table. The mould table is made of stainless steel segments, and the freezing pockets are made of stainless steel and electropolished.

The standard mould table is equipped with sixteen freezing pockets per radial row, but tables with up to a maximum of twentyfour pockets per radial row are available.

Filling Equipment. The standard ice cream filler is designed as a drum type volumetric filler for top filling of ice cream and consists of a column and a filling head on which the interchangeable filling equipment is mounted. The standard machine is equipped with a filler for one-coloured ice cream.

Stick Dispenser. Fully automatic stick dispenser.

Extractor and Lay-Off Device. This device consists of an »in-line« chain conveyor with 50 extractor arms carrying extractor tongs for wooden sticks. The tongs are made of stainless steel. The release of the products is actuated by the downward movement of the extracting arm, and the products are transferred to the wrapping machine.

Chocolate Coating Equipment. This equipment is mounted beneath the extracting device and comprises a dipping cup and a chocolate vessel with drip scraper. The height of the dip cup can be adjusted according to the level of "dip" required. The chocolate vessel is equipped with an electrically heated water jacket. The temperature is thermostatically controlled and indicated on a thermometer.

Washing and Sterilizing Apparatus. For cleaning-inplace (CIP) and sterilizing, a washing apparatus is supplied for mounting on the supporting rails on the brine tank. The apparatus requires connection to water and steam

Platforms. Three platforms made of galvanized steel are supplied.

Standard Accessories

Set of tools. Set of normal spares.

Optional Equipment

- 2.03 Rack for the storage of mould segments, galvanized or stainless steel.
- 3.01 Filling equipment for two-coloured ice cream, vertically divided side by side.
- 3.02 Filling equipment for the filling of two-coloured ice cream, horizontally divided.
- 3.03 Filling equipment for two-coloured ice cream, concentric filling.
- 3.04 Filling equipment for two-coloured ice cream, vertically divided in a »zebra-pattern«.
- 3.05 Bottom filling machine for one-coloured ice cream.
- 4.00 Filling equipment for one-coloured water ice (for fitting to standard ice cream filler).
- 4.01 Independent filling unit for one-coloured water ice (required for two-coloured water ice, horizontally divided and for topping-up).
- 4.02 Equipment for two colour water ice lollies, per radial row, each lolly being one-coloured. (Three and four colours per radial row also available).
- 4.05 Filling equipment for two-coloured water ice, vertically divided (twin-type lolly only).
- 5.00 Filling equipment for shell and core split-ice: shell of water ice, core of ice cream.
- 6.00 Pencil filler with equipment for two strings of ripple mass per bar.
- 7.01 Automatic stick dispenser.
- 9.01 150 litre (40 gall.) chocolate floor tank with electrically heated and thermostatically controlled water jacket and electrically driven chocolate circulation pump. The floor tank is a separate unit on transport wheels and with hoses for connection to the dipping vessel on the Rollo machine.
- 10.00 Dry coating equipment for coating the bars with granulated dry stuff, nuts, candy, etc.
- 14.01 Extended set of spare parts for two years' operation.

Other optional equipment is available and full details can be obtained on request.

	·		, 					
PRODUCT- EXAMPLES				Two-coloured			Û	
OPTIONAL EQUIPMENT	One-coloured ice cream	Bottom filled one-coloured ice cream	Two-coloured ice cream, vertically divided	ice cream, vertically divided »zebra pattern«	Two-coloured ice cream, concentric	Two-coloured ice cream, horizontally divided	One-coloured water ice	Two-coloured water ice horizontally divided
One-coloured ice cream equipment (incl. in standard machine)	•		•	•	•	• .	•	•
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3.02						•		
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PRODUCT- EXAMPLES OPTIONAL EQUIPMENT	One-coloured water ice, two different colours per radial row	Two-coloured water ice, vertically divided (twin type)	Split ice	Pencil filled ice cream	Ory coated ice cream	Chocolate coated bars		
One-coloured	100,0.70.7	(,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Op. N. IOO	100 0100.11	.00 0.02	-		<u> </u>
ice cream equipment (incl. in standard machine)			•	•	•	•		
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6.00				•				
10.00					•			
Chocolate coating equipment (incl. in standard machine)						•		

Suitability of Product Recipes, Ingredients, and Packaging Materials, Sticks, etc.

Samples of product recipes, ingredients, packaging materials, sticks and the like must be sent to Hoyer in the agreed quantity and by the agreed date. Hoyer will evaluate the suitability of the samples and make recommendations based on previous experience or agreed on laboratory tests. Since it is, however, not always possible to foresee or simulate actual production conditions these recommendations shall, unless otherwise agreed, be regarded as a guide only and shall in no way be considered as a warranty or legal obligation of any kind.

Technical Data

Electrical Motors

3 kW 1400 r.p.m. Main drive 3×5.6 kW 1400 r.p.m. 1.1 kW 1400 r.p.m. Cold brine pump Warm brine pump 0.4 kW 1400 r.p.m. Chocolate pump 1.1 kW (optional extra) Dry coating equipment 1.5 kW 2800 r.p.m. Vacuum pump

Heating Elements

Warm brine, heated either by electricity or by steam. The choice must be made when order-

Installed Max. Effect:

Electricity 63 kW Low pressure steam 100 kg (220 lbs)/h Consumption of max. effect when in production: 55-75% 150 litre chocolate container 3 kW 0.15 kW Chocolate dipping vessel

Pipe Connections

NH₃ liquid line, pump recirculation 75 mm NH₃ suction line 200 mm Main inlet for air 20 mm

Piping dimensions for ice cream not less than the outlet of the continuous freezer.

5,600 litres/ 7,200 kgs **Brine Quantity** (1,485 gall./15,900 lbs)

Ammonia Quantity

for filling the 700 litres/458 kg evaporator (185 gall./1,070 lbs)

Air Consumption

(Standard Machine) 0.9 m3 (32 cu.ft.)/min. Min. working pressure 8 bar (116 psi)

Normal Working Temperatures

-45°C (-49°F) -40°C (-40°F) Evaporating temp. Temp. of cold brine Temp. of warm brine +25°C (+77°F)

Refrigeration Load

Max. 280,000 kcal/h at -45°C (-49°F)

Weight

In »ready-to-work« condition

24,000 kg (52,900 lbs) approx.

Shipping Data

16,350 kg Net weight (36,000 lbs) 20,500 kg Gross weight (45,200 lbs) Volume 100 m (3,530 cu.ft.)

Main Dimensions

Total height of Rollo 35

max.

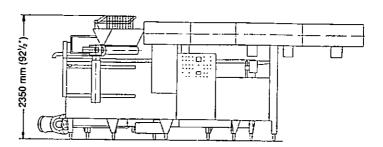
2,800 mm $(110<math>^{\circ})$

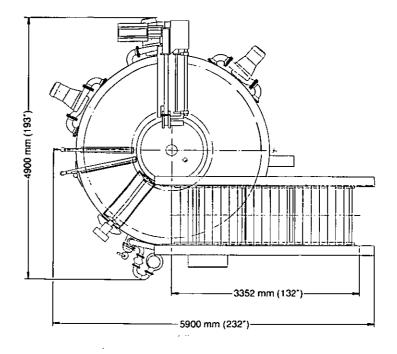
Height of table above floor

1,500 mm (59")

Normally required floorto-ceiling height

3,000 mm (1187)





Hoyer



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Fax: +39 2 9880171 Telex: 315127 Mark i

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Phone: 414 248-8950 Fax: 414 248-2883

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Fax: +45 86 29 22 00 Tlx: 6 87 70 alhoy dk

DANICE SERVICES A/S Søren Nymarksvej 11 DK- 8270 Højbjerg/Århus Denmark Phone: +45 86 29 36 33

Fax: +45 86 29 33 30 Tlx: 6 86 49 danis dk

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Tlx: 315 127 mark I

Phone: +1 414 248 8950 Fax: +1 414 248 2883

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HOYER FRANCE Z I le Chêne Sorcier F - 78340 les Clayes-Sous-Bois France

Phone: +33 1 - 30 81 81 81 Fax: +33 1 - 30 81 81 60

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Spain Phone: + 34 1 37 90 652 Fax: +34 1 35 80 103 HOYER UNITED KINGDOM Interchange Park GB - Newport Pagnell Buckshire MK16 9PS United Kingdom Phone: +44 908 616 699 Fax: +44 908 617 990

HOYER JAPAN 306-Minami Aoyama Skyhights 21-18-4, Minami Aoyama Minato-Ku, Tokyo Japan Phone: +81 3 3401 3809 Fax: +81 3 3401 7707

HOYER HONG KONG c/o Alfa Laval (HK) Ltd. 701 Guardian House 32, Oi Kwan Road Happy Valley Hong Kong Phone: +852 833 9939 Fax: +852 575 4227 Tix: 74174 alhk hk

HOYER BEUING c/o Tetra Pak China Ltd. Beijing Representative Office Room 416, Tian An Building Hua Long Street Dong Cheng District Beijing 100006 China Phone: +1 512 8844 ext. 455 Fax: +1 513 2141

HOYER SHANGHAI c/o Tetra Pak China Ltd. Shanghai Representative Office Room 805-806, Block 3 Donghai Computer Building 1486 Nanjing (W) Road Shanghai 200040 China Phone: +21 247 6775 Fax: +21 247 2248

HOYER PHILIPPINES Service Centre 5th Floor, Jaka 1 Bldg. 6794 Ayala Avenue Makati, Metro Manila Philippines Phone: +63 2 810 1968 Fax: +63 2 815 6693



DUN ROBIN PRODUCTS

40 Industria Ring Road, Parow 7490 P.O. Box 1021 Parow 7500 (021) 933-6670 Fax: (021) 933-668

DUN ROBIN	21) 933-0086	
Datum 6 7 2000 TW/VAT NO. 4840143889 Bester	l Nr. 26	04
Bestelvorm / Purchase Order M CONVENDENCE FOOD Sy	••	
w Conventience tood Sy	STEM	
REG BY BRENT		
BESKRYWING / DESCRIPTION	<i>BEDRAG / AM</i> R	IOUNT C
1 X KOLLO MOULD TABLE		
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Sub Totaal / Sub Total		
B.T.W. / V.A.T.	 	
Totaal Verskuldig / Total Due		

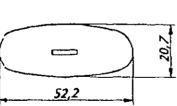
KWIK KOPY PRINTING BELLVILLE TEL. (021) 948-1225

X min. **ROLLO 14** ROLLO 20 ROLLO 27 ROLLO 32 ROLLO 35 34

Brent Chaussens TOP EDGE OF 6/07/2000 **MOULD TABLES**

105 :4

NSIDE MOULD



YOLUMENS:

Volume of mould (at L = 105 mm), V_{mould} = 75,0 CC

Estimated volume of ice taken out of mould, Vice - 72,0 CC

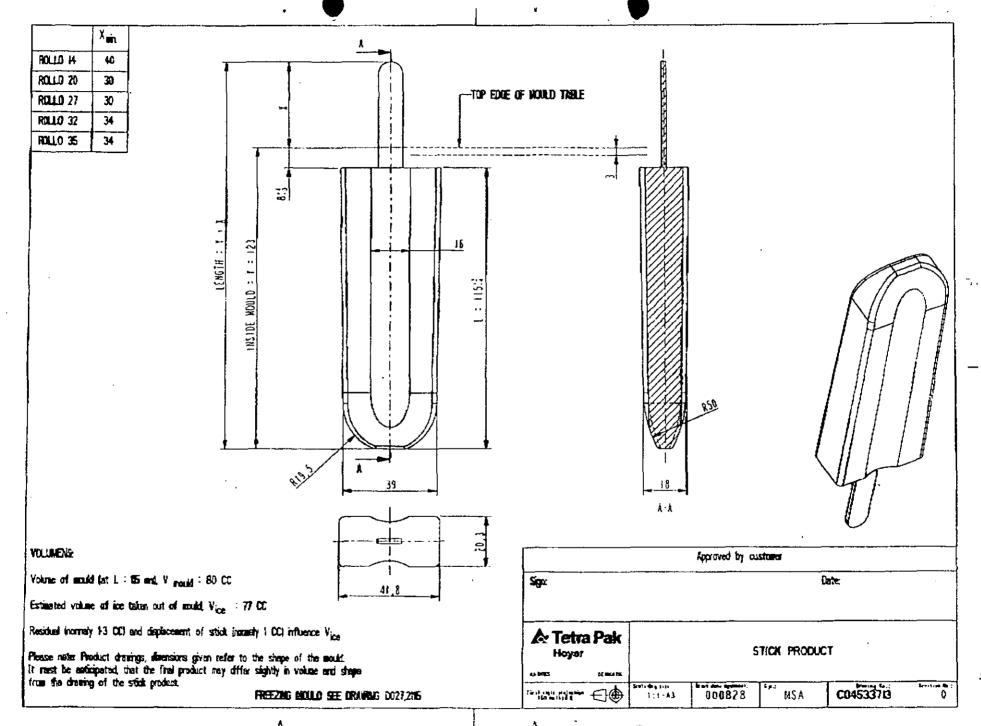
Residual (normaly 1-3 CC) and displacement of stick (normaly 1 CC) influence Vice

Please note: Product drawings, dimensions given refer to the shape of the mould. It must be anticipated, that the final product may differ slightly in volume and shape from the drawing of the stick product.

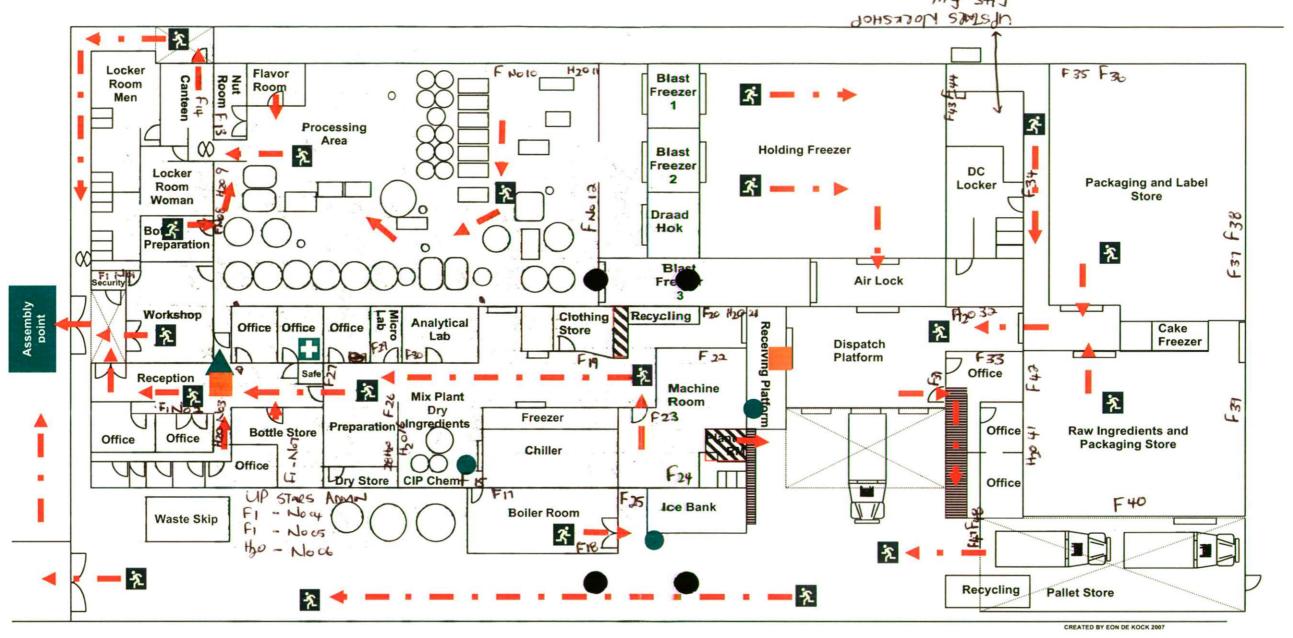
Freezing mould see drawing:

Approved by customer							
Sign.:		Date:					
A: Tetra Pa	k	\$1	FICK PRODU	ст .			
AARMOS DEMA							
tininganities (11-A3	000620	hkg ,	C04533585	terrine 4.:		

ATE/TIME	FUNCTION	No.	DESTINATION	DURATION	PGS.	RESULT
JUL. 3 9:46	Transmit	* 865	5345771	0.00.24.	001	ок
	Transmit	*866	0119741888		001	ок
	Transmit	* 8 6 8 ⁻		0, 00, 36,	001	ок
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13:16	Transmit	* 8 7 2	0117929775	0 00 32	001	ок
15:16	Transmit	· * 876	011 393 1567	0.00.29.	001	ок
	Transmit	* 877	011 393 1567		001	ок
JUL. 4 7:51		*880	021 9336333		001	ок
	Transmit	# 8 8 1		0, 00, 30,		OK
8:54	Transmit	± 8 8 3	021 9336688	0, 00, 20,	002	<u>ок</u>
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	Transmit	*886		0" 06' 12"	011	OK
	Transmit	*889	021 9492280		001	OK
	Transmit	* 89 1 - 00 2	021 9336688		007	OK OK
14:21	Transmit	* 892	021 9312804	0 00 43	002	ОК
	Transmit	* 894	0119747447		001	ОК
	Transmit	* 895	021 616774		001	OK
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	Transmit	*904	3343771	0* 00' 23"	001	OK OK
	Transmit	905	021 9336688		001	ok
	Transmit	907	+27215514036			ОK
14:27	Transmit	910	021 9319422	0, 03, 08,	002	ОК
15:42	Transmit	912	, 021 9336333	0" 00' 38"	100	ок
JUL. 6 8:39	Transmit	914	021 9336688	0.01,00.	002	ок
9:00	Transmit	915	021 9336688	0 00 25	001	ок
9:03	Transmit	916	021	0" 00' 25"	001	ок
9:53	Transmit	919	021 4615715		003	ок
	Transmit	920	021 4615715		003	ок
	Transmit	921	021 4615693		004	ок
10:35	Transmit	923	0215550420	0.00.29.	002	ок
JUL. 3 12:21		*870		0" 00' 51"		ок
	Receive	• 873	0317005743		001	ОК
	Receive	* 8 7 4	0317005743			ок
	Receive Receive	* 8 7 5 * 8 7 8	021542036	0" 01' 01"		ок ok
101 4 7:35	Panalus	*879	021 9336688	0.00, 347	001	OK
JUL. 4 7:25	Receive	*8/9 *884	+27 21 8091450			OK OK
	Receive	*890	021 9312804			OK OK
	Receive	*893	021 9336688			ок
	Receive	*896		0" 00' 37"		ок
JUL. 5 8:57	Receive	* 897	27 21 5516096	0 00 51	001	ок
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	Receive	917	0317005743			ок
9:48	Receive	918	+2721 9342580			ок
10 - 2 -	Receive	922	0215550420	0.00.471	001	ок



PARMALAT ICE CREAM (AYLESBURY) PAROW INDUSTRIA EMERGENCY EVACUATION PLAN 9h \downarrow sh \downarrow



	Legend	Emergency Tele	ephone Numbers
-	Assembly point	N1 CITY HOSPITAL: 590 4111	SHE CO-ORDINATOR 0826783958 Greg Fortuin: 083 386 6344
	Fire equipment	TYGERBERG HOSPITAL: 983 4711	SECURITY Ice Cream: (021) 937 7414
	Breathing Apparatus Ammonia Suit	FIRE DEPARTMENT: 590 1900	SECURITY UHT: (021) 937 3849
+	First Aid Box	POLISE DEPARTMENT: 932 7551	SECURITY: DC: (021) 937 3749
	Safety Shower Eye wash	OH HEALTH CLINIC: Parow: 937 3635 Stell: 809 1046	FIRST AIDER : DAVID PAYNE/ MAC MAQEDA
	Siren Station	EMERGENCY CO-ORDINATOR Johan Steenkamp: 083 400 3685	SAFETY REP : ABDURAGHMAAN KARELSE
	Critical Valve isolation points	PLANT MAINTENANCE Johan Steenkamp: 083 386 6143	
炙	Evacuation routes	PLANT MANAGER Brent Claassens: 083 386 6158	

ICEHOY

Tetra Pak Hoyer - Bilwinco - Limitech

To:	Pan	malat ice cream	From:	Sam Greenaway	
ATT:	Mr E	Brent Claassens	Pages:	4 page\s including	this one
Fax:	021	933 6689	Date:	00-09-12	
Re:	Quo	otation for a swirl Unit	CC:		
□ Urg	ent	☐ For Review	☐ Please Comment	☐ Please Reply	☐ Please Recycle
Dear F	Brent				

I thank you for your valued enquiry and take pleasure in quoting the following for your kind attention. Herewith is a quotation for a swirl unit plus the nozzle used to extrude a stick type product as shown in the drawing. The price for the complete unit with nozzle ex works is USD 9400.

However, if you look at the drawing I have circled the actual swirl section. We can estimate the costs for the swirl only to be USD 4800 ex works.

The USD 1,00 = R 7,00 for Rand estimates.

If you have any further questions please feel free to contact me.

Kind Regards

Sam Greenaway.

ICEHOY

P.O. Box 60764, Flamingo Square, 7441, Cape Town, South Africa. 81 Libertas Ave, Table View, 7441, Cape Town, South Africa. Tel: +27 21 557 7205, Fax: +27 21 557 5547, Cell: 083 483 5730. Email: sammy.g@iafrica.com



Quality Assurance Department

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<u>www.cleardata.co.uk</u> tel: 01670 356 734 fax: 01670 356 439 11/09 100 477 08141 172

♠: Tetra Pak Hoyer

Quotation

A011708-1

Parmalat Ice Cream SOUTH AFRICA

Your refu-

Outet:

Date: 14-Sep-00

USD

LAS/DOK Qty With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 0102 GB2, which form an integral part of this quotation, we take pleasure in offering you as follows: For Bulk Production: Swirl Unit Including: - Simple 1-flavour nozzie for one lane The Price: is to be understood F.C.A. (free carrier) Aarhus, Denmark, incl. packing for the transport in question, excl. installation. "INCOTERMS 1990" apply. Délivery: Approx. 10 working weeks after receipt of order. The above mentioned time of delivery is to be reckoned from the date all

In addition, the time of delivery depends on the down payment being paid according to agreed terms of payment.

relevant technical information/samples necessary for production of the machine have been received and samples must be sent to Hoyer for

Tetra Pak Hoyer A/S

comments.

Soeren Nymarks Vaj 13, DK-8270 Hoejbjarg, Derimark
Telephonia + 45 89 39 39 39, Telefax + 45 95 29 22 00
Bankers: Dan Danske Bank A/S, Aernus Branch, Reg. No 3627, Account No 3266-13389-7
Export VAT No 29?48356, Central Business Register and Import VAT No 41852119
e-mail: hoyen@hoyer.dk, web-site* www.tetrapakhoyer.com

11/09 '00 MAN 08:42 FAX

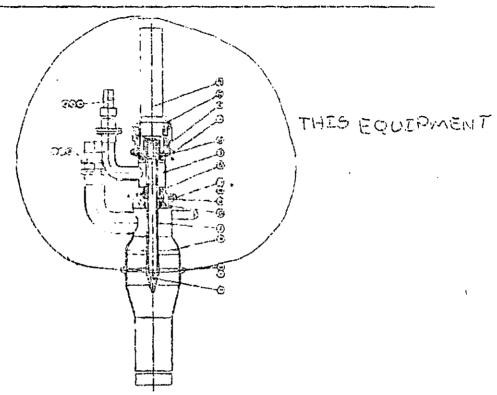
Quotation

A011708-1 11-Sep-00 Parmalat Ice Creun. USD Qty Payment: 30 % of the contractual amount to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus Branch. Denmark, not later than 2 weeks after order. 70 % of the total amount to be paid on delivery. Validity: Our quotation is valid for order received not later than 60 days from date of quotation. · 中央市场的水水场运输运输运输中部市场的水场的大型中域的水场的大型车车的大型车车 (1) We hope our quotation is in accordance with your wishes and look forward to receiving your order. Should you have any further questions we are of course at your disposal with further information. Yours faighfully, Tetra Pak Hayer A Lars string Sogrensen

A: Tetra Pak Hoyer



Straightline Section 9 89.D Extrusion Nozzle with Swirl Effect



Extrusion Nozzie with Swirl Effect

Application

For vertical extrusion of slices. Depending on the nozzle design swirl unit can be used for production of stick products and for bulk filling.

Standard Design

The nozzle and swirl unit are made of stainless steel. The propeller for distribution of ripple is driven by a special air motor. The air motor can run with clean compressed air without oil content.

All assemblies are made with clamp connections for easy dismantling during cleaning. The extrusion nozzle is delivered with suspension for easy mounting on Smaight Line motorcuners.

Operating principle

During extrusion the ripple mass is distributed into the ice cream flow through a rotating propeller. The rotating propeller is creating the swirl effect.

Advantages

Easy installation on Straight Line motorcutter. Optional extrusion nozzle designs can be mounted on the rippling unit.



PROJECT - ENGINEERING

NATIONAL DAIRY EQUIPMENT (PTY) LTD. 13 MONTAGUE DRIVE, MONTAGUE GARDENS, CAPE TOWN, SOUTH AFRICA P.O. BOX 38619, CHEMPET 7442. TELEPHONE (021) 552-2170. TELEFAX (021) 552-2228 E-MAIL ADDRESS max.adamou@nde.co.za

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FAX MESSAGE

TO:	PARMALAT ICE CREAM
ATT:	BRENT CLAASEN
FAX NO:	
FROM:	MAX ADAMOU
DATE:	22 June 2000
SUBJECT	REPLACEMENT OF GRAM FREEZING CYLINDER

Dear Brent

OUR QUOTATION NO. 207 FOR REPLACEMENT PARTS FOR GRAM FREEZER

We thank you for your enquiry and are pleased to submit our quotation as follows:

QTY	DESCRIPTION	ARTICLE NO	UNIT PRICE RAND	AMOUNT
3	O-Ring (CR) 446-215,27x7,00	55084021913	258	773
1	Exchangeable Freezing Cylinder	78171277113	281,750	281 750
1	Gasket O350/320/270	78171277213	523	523
1	Gasket O340/310/240	78171277413	281	281
1	Service Charge	00001785097	287	287
	TOTAL			283 614-00

2/.....

682 455 8673

A011273-1

Parmalat Ice Cream

SOUTH AFRICA

Your refit

Our ref.:
AA/IN

Date: 30-May-00

EURO Oty With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 0102 GB2, which form an integral part of this quotation, we take pleasure in offering you as follows: Straightline 400 1 Line for the extrusion, hardening and coating of stick products as described below. Capacity: Up to 4800 stick products per hour The basic machine includes: - Box insulated by means of high density polyurethane 100 mm thick. Floor provided with water drain. Inspection doors, Internal lighting plant - Internal stainless steel frame to support the trays and drive the stainless steel chain - Main drive with a motoreducer suitable for low temperature, placed inside the cold box, with speed regulation by menas of an inverter - Mechanical gear for the motion of the working stations - External worktable to place the working stations - Centralized electrical panel to control and adjust all the devices by means of a PLC and user interface - Internal finned tube evaporator for ammonia with six fans, mounted on top of the frame with defrosting system by water. Evaporation temperature - 45°C. - Electrical and pneumatic plant The unit has to be connected to a suitable power source and to the centralized ammonia system.

Tetra Pak Hoyer A/S

Speren Nymerks Vej 13, DK-8270 Hoejbjerg, Denmark
Telephone + 45 89 39 39 39, Telex 6 87 70 elhoy dk, Telefax + 45 86 29 22 00, Telegrams trigohoy azirhus
Bankers; Den Danske Bank A/S, Aarhus Branch, Reg. No 3627, Account No 3256-13389-7
Export VAT No 29348359, Central Business Register and Import VAT No 41852119
e-mail: nover@hoyer.dk, web-site: www.tetrapakhoyer.com

PHONE NO.: 0215550420

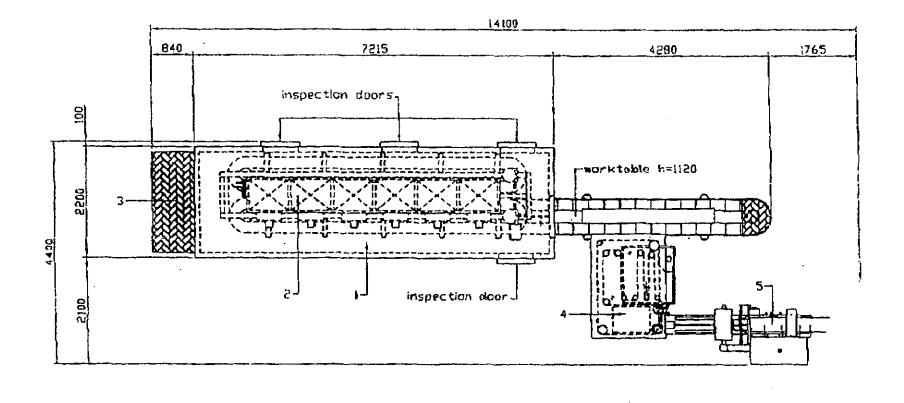
Qty		EUR
4-3		
1	Washing brush	
1	Set of 460 flat trays in stainless steel - 200 x 295 mm	
1	Single wire horizontal cutting device including wire drive and extruder support	
ţ	Vertical extruder - 1 outlet	
1	Vertical extruder 2 flavours 5 outlets	
1	Size change over for single stick inserter	
1	Single stick inserter 95 x 10 mm pneumatically actuated	
1	Single hammer, upper position	
1	Pick-up for sticks – 145 grippers Apparatus for synchronized pick-up and chocolate enrobing of stick products, extruded and hardened by the SL production lines.	
	The device includes: - Stainless steel frame - Chain with 145 articulated pincers - Double jacket chocolate dipping tank, complete with pump, electric heating elements, thermostat. The tank is provided with sheels and can be removed for the cleaning operations. - Product release station - By-pass station - Electric control panel	
1	Pick-pack Wrapping Machine Designed to pack different sizes and shapes of ice cream products and can be used with a variety of wrapping materials, e.g. polyethylen, PVC and polikraft. Both hot and cold sealing can be carried out. Pick-pack is completely built in AISI 304 stainless steel and equipped with double paper roll suspension and an electronic speed variator with progressive start resulting in a faster operation. A friction system centralizes the products in the wrapping material and operates also as a safety device	

· Parmal	at Ice Cream	30-May-00
Qty		EURO
1	The machine is fitted with a longer inlet conveyor facilitates the manual placement of products. Gearing is built-in, avoiding direct contact with the products. Up to 6,000 products/hour and with photocell, which centralizes the wrapping material so welding and cut are always carried out at the same point in the wrapper design (picture-in-place). Chocolate Tank 1001	
1	Set of recommended spare parts	
•	Total price for Straightline 400	371,500
	The Price: is to be understood F.C.A. (free carrier) Milan, Italy, incl. packing for the transport in question, excl. installation. "INCOTERMS 1990" apply.	
	Delivery:	
	12 working weeks after receipt of order.	
•	The above mentioned time of delivery is to be reckoned from the date all relevant technical information/samples necessary for production of the machine have been received and samples must be sent to Hoyer for comments. In addition, the time of delivery depends on the down payment being paid	
	according to agreed terms of payment.	
	Payment:	
	50 % down payment to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus, Denmark, not later than 15 days after the date of the pro forma invoice.	

Parmala	t Ice Cream	30-May-00
Qty		EURO
	of the contractual amount to be paid against presentation of shipping documents, or, if, owing to conditions beyond Hoyer's control, shipment cannot take place at the time agreed upon, against warehouse receipt.	
	Or according to enclosed leasing proposal.	
	The payment must be secured by an irrevocable Letter of Credit to be opened by a first-class bank, and to be payable at sight at the counters of and confirmed by Den Danske Bank, Aarhus, Denmark.	
•	The Letter of Credit must be opened one month before estimated delivery and be valid for at least one month after estimated delivery, allowing partial shipment and transhipments.	
	All costs in connection with the confirmation and keeping in force of the Letter of Credit - abroad and in Denmark are for the account of the buyer.	
	2% per month interest fee for late payment will be added to the last invoice amount.	
	Validity:	
	Our quotation is valid for order received not later than 60 days from date of quotation.	
	Exclusions:	
	The TP Hoyer delivery comprises the above specified only, and thus does not include, for example, the following:	
	1. Installation and start-up assistance of any kind.	
	Electrical work consisting of external conduit runs, wiring, nor the materials or labor to install such equipment.	
	3. Pneumatic work - consisting of external conduit runs, pneumatic tubing, fittings, connections, nor the materials or labor to install such equipment.	
	4. The main power supply and/or pneumatic supply to the control componentry as may be required.	

Parmalat	Ice Cream	30-May-0
Qty		EURO
	5. Supply or installation of an enclosed lockable enclosure for storing installation materials, tools, expendables, etc. This is to be customer supplied upon request.	
	6. Supply or installation of refrigeration equipment required for the system's operation nor the required connections between such refrigeration equipment and the Hoyer supplied equipment. Excl. circulation pump, pipes and fittings and insulation.	
	 Any building construction modifications or materials which may be required. 	
	8. Supply or installation of any sanitary or CIP piping to or from the Hoyer supplied equipment.	
	9. Receiving or off loading of the Hoyer supplied equipment.	
	10. Oil or lubricants.	
	Leaflets enclosed serve for informative purposes only, and any special features or optional extras are only included in our delivery if specifically mentioned in this quotation.	

	We hope our quotation is in accordance with your wishes and look forward to receiving your order. Should you have any further questions we are of course at your disposal with further information.	
	Yours faithfully,	
	Tetra Pak Hoxer A/S	
	Allan Bjerring Andersen	



1-Straightline-400 (h=2490) 2-R22 air cooler

3-R22 refrigeration unit

4-Pick-up for sticks

5-Pick-pack wrapping machine

Date Seete	150 1:50	A: Tetra Pak Hoyer 8.p.A.	αρπ
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<u> </u>		SL400 - DIMENSIONS	SLC011
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Quality Assurance Department

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www.cleardata.co.uk

tel: 01670 356 734 fax: 01670 356 439

INDICATIVE EXAMPLE, INTEREST RATE SUBJECT TO CONFIRMATION

Date/Datum/date Customer/Kunde/Client: Parmalat, South Africa 3 YEARS Rent Quarterly payments EUR EUR Amount/Betrag/Somme..... 371.500 Currency/Wert/Cours C.I.F. cost/kosten/frais 0 Condition: Adv.Paym./VorrausZ/Paym.Anticip: 15% 55.728 1)Bank Guarantee from 1st Class Bank To be financed/Finanzier./ 315.775 2) Separate Contract

Security/Sigherner/Caution:

INTEREST RATE:

7,50% p.a. fixed

Payment Balarice Balance Arnere Termin Instalm/Abz/MensualtInt./Zins/Int. End Date/Datum/date Total Begin 01-09-00 5.921 292.140 1 23.635 29.556 315.775 01-12-00 2 268.062 5.478 29.556 292.140 24.078 3 268.062 243.532 01-03-01 24.530 5.028 29.556 01-06-01 4 24.989 4.566 29.556 243.532 218.543 01-09-01 5 29.556 193.085 25.458 4.098 218.543 01-12-01 6 25.935 3.620 29.556 193.085 167.150 01-03-02 7 140.728 3.134 29.556 167,150 26.422 113.811 01-06-02 8 26.917 2.639 29.556 140.728 01-09-02 9 27.422 2.134 29.556 113.811 86.389 58.453 01-12-02 10 27.936 1.620 29.556 86.389 01-03-03 11 28.460 1.098 29.556 58.453 29.993 1.000 01-06-03 12 28.993 562 29.556 29.993 354.669

39.894

314.775

Lease Sy - Parmaiat Xi S.

31-05-00

PHONE NO. : 0215550420

31-05-00

3 Years lease. Quarterly

payments

DRAFT PROPOSAL

Lease Agreement No. S.A. - 2000 - 1001 - 01

1.)	This Lease Agreement is an integrated part of orderconfirmation no dated
	Parmalat Ice Cream - South Africa
	in the following referred to as the <u>Lessee.</u>
2.)	The Lessor will let out and the Lessee will rent the equipment specified in the the above mentioned order confirmation hereafter referred to as "the Equipment" under the terms and conditions laid out herein.
3.)	The rented Equipment: according to specification in above mentioned accepted order confirmation no
	The total price of the Equipment is Euro 371.500,- FCA Aarhus, Denmark (Incoterm 1990), packing included. All other conditions according to contract.
4.)	The Equipment is rented for use at the address of Lessee only.
5.)	No costs and charges, taxes, duties of whatsoever nature in connection with import of the Equipment are included in the above amount and shall, if any, be paid directly by the Lessee.
6.)	The Leasing Period is to be understood from delivery of the Equipment at the Lessee's address, and during the forthcoming 36 months. Delivery is expected to take place week xx 2000. First payment under the lease contract to take place 1 xx 2000.

31-05-00

Page 1 of 5

7.) It has been agreed that Payment will take place as follows:

Down payment:

115% i.e Euro 55,725

12 Quarterly rates of:

Euro 29,556

according to the enclosed

schedule, first time xxx, 1st 2000 and the

isucceeding 11 quaters.

Invoices will be presented to the Lessee concerning each payment. The due dates for payments are as mentioned above or the first banking day following immediately after the above-mentioned dates. A penalty fee of 2.0% of the amount due per starting month will be charged in case the payment has not been credited Tetra Pak Hoyer A/S's account No. 3627-3258-133897 with Den Danske Bank. Copenhagen, Holmens Kanal 2:12, 1092 Copenhagen on due date. All payments are to be secured by a bank guarantee from a first Class Bank.

- 8.) All costs in connection with payments of the Rental Fee as e.g. but not limited to taxes, fees, commission, V.A.T., withholding tax and duties are not included in the Rental Fee and are to be paid directly by the Lessee and are of no concern to the Lessor.
- 9.) This lease agreement is a net Lease amount, and by signing this agreement the Lessee gives his consent to pay all Rent. The right of the Lessor or any assignee in and to such Rent is unconditional and not subject to counterclaims, set-offs or the like of whatever nature.
- 10.) The Lessee is obliged at his own cost to keep the Equipment adequately insured, equivalent to the full and new value of the equipment.

Furthermore, the Lessee agrees that the Lessor shall not be liable to the Lessee for any loss, liability or proceedings with respect to any injury or damage of whatsoever nature and whatsoever cause arising out of or in connection with the Equipment or the use thereof.

The Lessee shall take out a Liability Insurance, including product liability according to local law.

The Lessee is obliged to use the Equipment according to the Lessor's instructions.

31-05-00 Page 2 of 3

- 11.) The enclosed "General Conditions of Sale and Delivery" No. QT 80008 E9 shall apply unless anything to the contrary is stated in order, order confirmation or the parties agree to the contrary in writing.
- 12.) The Lessee will at his sole expense keep the Equipment free and clear of all levies, liens and encumbrances. The Equipment shall be equipped with a sign stating that it is the property of Tetra Pak Hoyer A/S. Tetra Pak Hoyer A/S reserves the right to inspect the condition of the equipment at any time and, if necessary, to request a repair at the expense of the Lessee.
- 13.) This Lease Agreement is a valid contract when signed by both Lessor and Lessee, not later than (to be decided i) and when the bank guarantee has been received and accepted by Tetra Pak Hoyer A/S
- 14.) The Lessor has the right to assign, forfait, transport or sell the whole or part of the Bank Guarantee, if any, and the leasing contract to any third party.
- 15.) Together with the down payment the Lessee is obliged to forward documentation stating that all licences and import permits have been obtained and paid, or stating that such permits are not required.
- 16.) The Lessee shall keep the Equipment in good repair, condition and working order at all times during the Lesse Term. The Lessee shall, at his own cost and expense, furnish all parts, mechanisms and devices required for proper operation and maintenance of the Equipment. This does not exclude Hoyer's obligations under the 12 months guarantee period, according to the enclosed general conditions of Sale and Delivery.

Maintenance of the Equipment shall be performed by the Lessee in accordance with the directions given by the Lessor as well as any supplementary directions given by the Lessor or by the Lessor's designated agent.

The Lessee shall only permit the Equipment to be repaired by a person or persons approved by the Lessor and to use only spare parts supplied by the Lessor or by an agent designated by the Lessor. The

31-05-00

Page 3 of 5

Lessee shall immediately inform the Lessor of any defect(s) that has appeared on the Equipment.

The Lessee shall not make any alterations or adjustments to the Equipment nor do anything which might affect its proper working without Lessor's prior written consent.

The Lessee agrees to use the Equipment solely for the type of operations originally envisaged unless otherwise has been agreed with the Lessor.

The Lessee shall use the Equipment in a careful and proper manner. In conformity with the Lessor's and/or the manufacturer's instruction manual and shall comply with, and conform to, all federal, state, municipal or other laws, ordinances and regulations in any way relating to the possession, use or maintenance of the Equipment.

The Lessor and/or the Lessor's designated agent shall have the right from time to time during reasonable business hours to enter upon the Lessee's premises or elsewhere for the purpose of inspecting the Equipment, observing its use and operation and making alterations, improvements or additions thereto as the Lessor shall deem desirable.

17.) <u>Title</u>

The Lessee shall have no right, title or interest in the Equipment other than the right of full enjoyment and use of the Equipment for the full Lease Term (including any Additional Lease Term) provided that no Event of Default has occurred.

The Lessor may require labels, plates or other markings to be affixed to or placed on the Equipment, indicating the Lessor as owner of the Equipment, and the Lessee agrees to affix and keep the same prominently displayed on the Equipment.

The Lessor and the Lessee hereby confirm their intent that the Equipment shall always remain and be deemed movable property, even though said Equipment may hereinafter become attached or affixed to real property.

The Lessee further agrees to execute and deliver instruments, documents or other forms necessary and/or desirable by the Lessor to protect the Lessor's ownership in the Equipment.

Lessee guarantees Lessor's free access, including trespassing to the leased equipment.

31-05-00

Jul. 25 2000 09:25AM P14

Page 4 of 5

FROM : CONVENTENCE FOOD SYSTEMS PHONE NO. : 0215550420

18.) This Lease Agreement shall, in all respect, be governed and construed in accordance with the laws of the Kingdom of Denmark.

All disputes arising out of or in connection with this Lease Agreement shall be finally settled in Copenhagen, under the Rules of Conciliation and Arbitration of the International Chamber of Commerce by one or more arbitrators appointed in accordance with those rules.

Notwithstanding the foregoing, the Lessor shall have the right at his absolute discretion to refer any dispute to the proper court in the territory where the Lessee has his legal residence.

19.) At the end of the leasing period Lessee has the option to buy the equipment for Euro 200,- or a fair market value, whatever is the cheapest - or to prolong this agreement for 12 months for the amount of Euro 200,- pr month as lease payment for this period. The Lessee is obliged to inform Lessor which of the options he chooses 2 months before the turnover of the original leasing period.

<u>Termination</u> of the contract can take place provided that Lessee pays to the Lessor the remaining balance and a termination fee of DKK 25.000,- All tax related issues in that connection, and in general is the responsibility of the Lessee and of no concern of the Lessor

If the Lessee terminates the Lease Agreement by <u>not paying</u> according to the contract, the Lessee is obliged to dismantle and return the Equipment to Lessor without cost for Lessor and to pay that part of the remaining balance consisting of instalments plus an additional fee of 2% of the same balance.

20.) This contract is made in 2 originals of which the Lessee holds 1, and the Lessor 1.

This edition cancels all previous editions and drafts.

Lessee: Parmalat Ice Cream	Lessor: Tetra Pak Hoyer A/S.
authorised signature	authorised signature
witness to the signature	witness to the signature

31-05-00

Page 5 of 5

Parmalat Ice Cream SOUTH AFRICA Att.: Danie Schoeman

Your ref.:

Our ref.. AA/AA

66016 dec =

Date:

31-May-00

Gentlemen

Quotation for Straightline 400

First of all I would like to thank you for your kind hospitality extended to me during my recent visit to South Africa.

It is as always a pleasure to visit your factory and meet people with visions and ambitions.

As we agreed upon enclosed you will find the following documents:

- 1. Quotation for a Straightline 400
- 2. Leasing agreement for a period of three years
- 3. Layout for the Straightline 400

As we discussed during our meeting the Straightline 400 that we are now quoting includes equipment for the production of one "Magnum" product type and one Funny Face

The Straightline 400 is equipped with an ammonia evaporator that has to be connected to a central ammonia system at an evaporation temperature of -45° C.

Tetra Pak Hoyer A/S

Soeren Nymarks Voj 13, DK-8270 Hoelblerg, Denmark
Telephone + 45 89 39 39 39, Telex 6 87 70 alhoy dk, Telefax + 45 86 29 22 00, Telegrams trigotion aarhost bankers; Den Danske Bank A/S, Aarhos Branch, Reg. No 3327, Account No 3256-15369-7
Export VAT No 29348359, Cantral Business Register and Import VAT No 41852119
e-mail: hoyer@hoyer.dk, web-site: www.tetrapakhoyer.com

e-mail hover the may went site, which aparticles

Parmalat Ice Cream

31-May-00

The Straightline 400 can at a later stage be equipped for the production of the following products:

- Ball top cones
- Sandwich products
- Logs

In the following we have given an example of a cost brake down per unit based on the 3 years leasing proposal.

In broad terms the payments are as follows with the example of a three-year lease:

- Down payment Euro 55,725.
- 2. Quarterly instalments of Euro 29,556 for three years.
- Based on a separate agreement at the end of the leasing period the equipment will be acquired for a symbolic amount of e.g. Euro 200.

The calculation, which outlines the saving for a three-year lease, will look as follows:

Leasing per year

Euro 118,224

Deductible company tax (30% of Euro 118,224) - Euro 35,467

Estimated cost of lease per year after tax, year one Euro 82,757

Euro 82,757 equals approximately RAND 512,403.

Estimated production per year:

6 million sticks

Capital cost per stick: RAND 512,403. 6 million =

8.5 cent per stick

As we discussed, and as the numbers show, an investment of this extent should be a sound investment and pay itself back within a short time.

141, 25 2000 09:19AM P2

PHONE NO.: 0215550420

Parmalat Ice Cream

31-May-00

Please check the above assumptions with your local accountant, having knowledge of the exact tax rules in South Africa.

We are at the moment checking the best timing for a visit to Egypt where the line can be inspected.

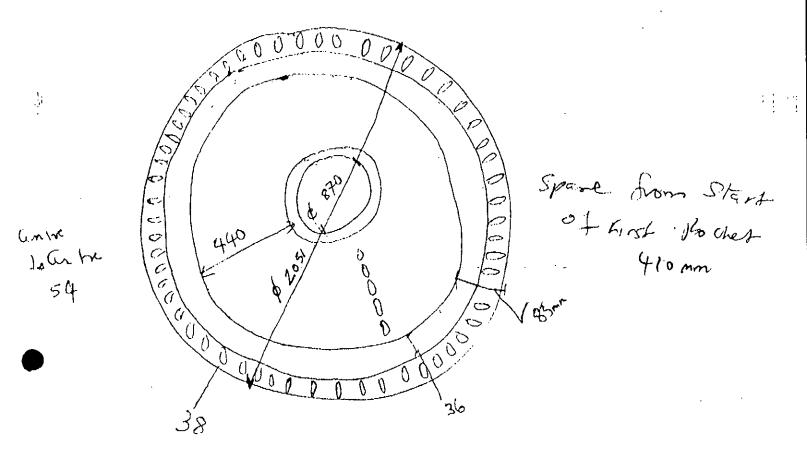
As soon as we have a video of the line in question we will forward it to you.

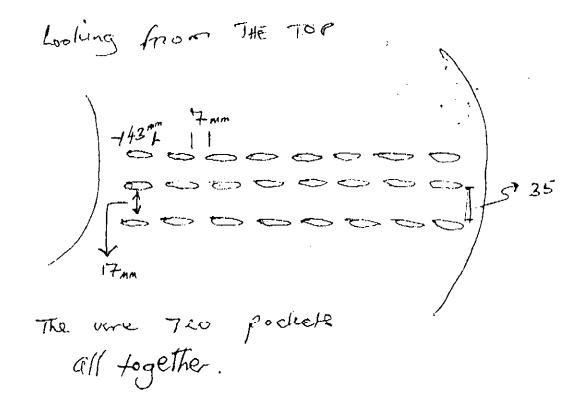
We hope that our quotation is in accordance with your expectations and are looking forward to hearing from you.

Best regard

Tetra Pak Hoyel A/S

Allan Bjerring Andersen







FAX

Parmaiat Zembia Ltd

HEAD OFFICE Mungwi Road P O Box 34930 Lusaka Zambla Tel +26 (01) 286855/286321 Tel +26 (01) 287745/289311

Fax +28 (01) 289388 e-mail: parmalat@zamnet.zm

TO

BRENT CLAASSENS

PRODUCTION MANAGER

+ 00 2721 933 6689

PARMALAT SA

ICE CREAM DIVISION - PAROW

FROM:

DAVE THOMAS

PARMALAT ZAMBIA

DATE:

14TH JUNE 2000

NUMBER OF PAGES: 1 + COVER = 2





PARMALAT SA (PTY) LTD

Reg. No. 95/02768/07

ICE CREAM DIVISION: INCORPORATING AYLESBURY AND DUN ROBIN

40 INDUSTRIA RING ROAD PAROW INDUSTRIA 7499

36718,CHEMPET,7441

SOUTH AFRICA

(27) (21) 9336676

FAX (27) (21) 933 6689

Emial: brentc@parmalat.co.za

FAX/FAKS

TO/AAN:

Parmalat Zambia

FOR ATTENTION/VIR AANDAG:

Dave Thomas

FAX NO/FAKS NO:

092601289388

FROM/VAN:

Brent Claassens

DATE/DATUM:

12-Jun-00

NUMBER OF PAGES: AANTAL BLADSYE:

1 PLUS

Here are a few measurements I need you to look at to see if the mould is compatible. It would be greatly appreciated if you can get back to me today as I need the information urgently.

Regards

Brent Claassens Production Manager



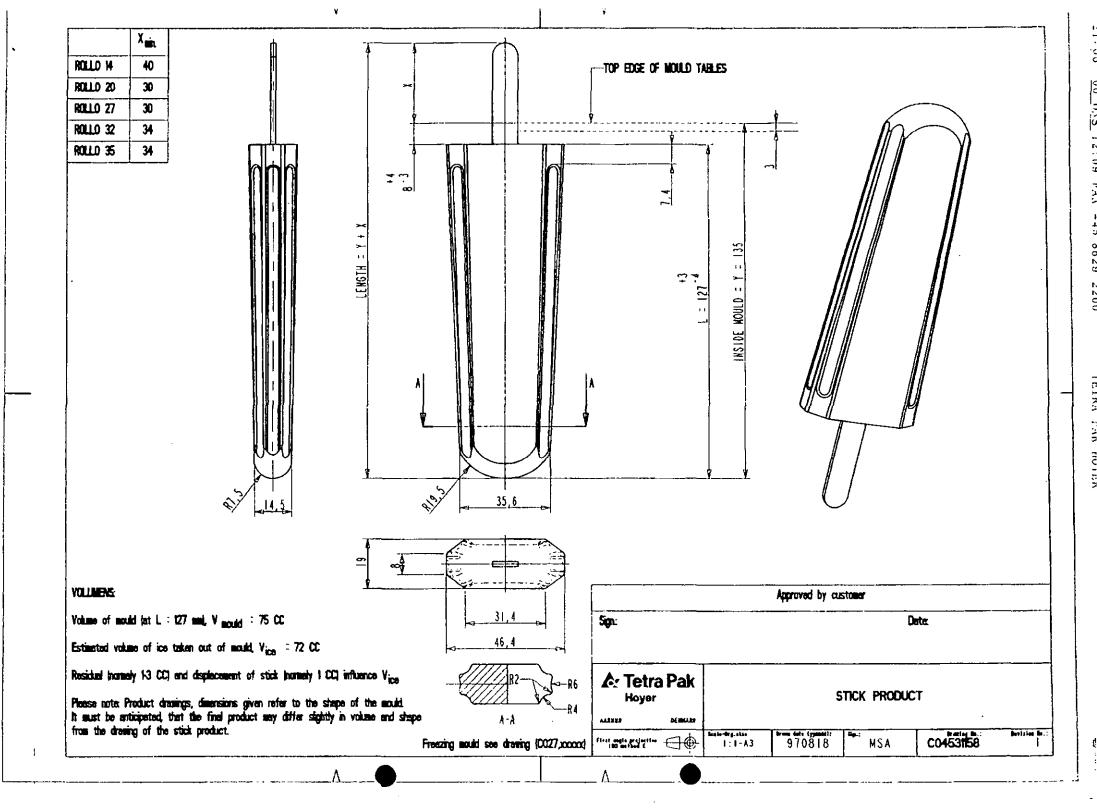


You will be Looking at the mould up-sine Looking from THE TOP There To 720 pocket all Together 120 x 6 = 720 Can you please have a Look at This

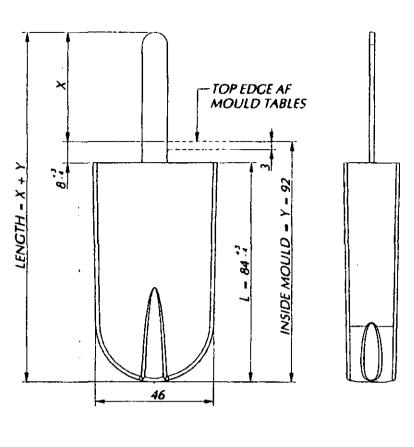
Brens

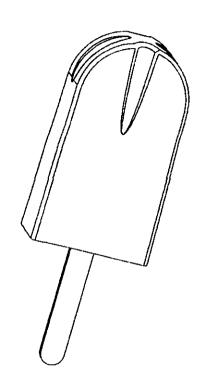
Thank

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	Transmit	• 5 7 2	023 616 2410			OK OK
	Transmit	• 5 7 3		0.00.30.		ok ok
	Transmit	576	0153031603			ок
JUN. 9 8:37			PARMALAT PLANT EL.	0. 00. 35.		ок
9 - 5 2	Transmit	• 589	021 9336688	0.00,32,	001	ок
	Transmit	•591	021 9336333			OK OK
	Transmit	+592		0.00.32.		ок
	Transmit	• 593		0 00 25		ок
	Transmit	• 5 9 7	0448759953			ок
12:32	Transmit	• 600	0285511621	0, 00, 34,	001	OK
	Transmit	+608	041 4512228			OK OK
	Transmit	*609	0215511336			ok ok
	Transmit	+610	021 9312804			ок
JUN. 12 9:23		±616	021 9336688			ок
D : 45	Transmit	+618	4217726	0.05.05.	004	OK
	Transmit	+619		0.00.41.		OK OK
	Transmit	+620	0119747447			оĸ
	Transmit	621		0 00 25		ок
	Transmit	+622	+27 21 8091450			ок
10:33	Transmit	6 2 4	+260 1 286407	0" 01' 23"	002	ок
บท. 8 9:03	Receive	+574	27215514036	0 03 45	005	<u>ок</u>
	Receive	• 5 7 5	0219822246			ок
	Recelve	• 5 7 7	021 9336688	0" 01' 42"	003	ок
11:08	Receive	• 5 7 8	27 21 53 11179	0 00 54	001	ок
11:30	Receive	*579	27 21 873 1536	0, 00, 33,	001	ок
12:40	Receive	+580	5577372	0.01.51.	001	ок
13:44	Receive	* 5 8 1	BONNITA (PTY) LTD. IT.	0 00 46	002	ок
14:06	Receive	*582	BONNITA (PTY) LTD. IT.	0" 01' 49"	004	oĸ
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14:28	Receive	≠584	021521959	0. 00. 23.	001	ок
15:00	Receive	-585	021 9312804	0* 01 47*	002	ок
15:02	Receive	* 5 8 6	021 9336688	0" 00' 47"	001	ок
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10:23	Receive	* 594	021 543890	0.00.29.	002	ок
10:47	Receive	+595	BONNITA	0" 01' 24"	002	ок
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14:03	Receive	*607	021 9336688	0.00.53.	001	OK
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18:48	Receive	* 6 1 2	0219335414	0 00 57	001	ок
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	X min.
ROLLO 14	40
ROLLO 20	30
ROLLO 27	30
ROLLO 32	34
ROLLO 35	34







VOLUMENS:

Volume of mould (at L - 84 mm), $V_{mould} -$ 75,0 CC

Estimated volume of ice taken out of mould, V_{ice} - 72,0 CC

Residual (normaly 1-3 CC) and displacement of stick (normaly 1 CC) influence Vice

Please note: Product drawings, dimensions given refer to the shape of the mould. It must be anticipated, that the final product may differ slightly in volume and shape from the drawing of the stick product.

Freezing mould see drawing: (D027,20359)

			Approved by cu	stomer		
Sign.:			Date:			· · ·
Æ: Tetra l Hoyer	Pak		S 1	TICK PRODI	JCT	
ANDRUS	TA	Scale: Dog siza 1:1-A3	From date Egymedit: 000620	nkg	C04533586	4

Tetra Pak Hoyer

Quotation

WI HUZ

A011323-3

Dun Robin Products (Pty) Ltd. 40 Industrial Ring Rd

Parow 7490 P.O. Box 1021 Parow 7550 SOUTH AFRICA

SAM Greenaway

Your tol.;

Om tell:

Date: 14-Jun-00

	CHO/DOK	14-Jun-00
Item Qty		DKK
	With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 0102 GB2, which form an integral part of this quotation, we take pleasure in offering you as follows:	
	New Stick Product on the existing Rollo 20, (Serial no. Z312,1411):	
1. 1	Mould Table	
	Consisting of: - 6 mould pockets per row - 120 radial rows	
	Price DKK 247,400	
1	Modification of Production Equipment	
	Price	
	Total Price, Item 1	272,
2	Equipment for Production of "Filur" Product:	
	The functionality of this Hoyer equipment has recently been upgraded and improved.	

Totra Pak Hoyer A/S Seeran Nymarka Vej 13, DK-8270 Hoojbjerg, Denmark Telephone + 45 89 39 39 39, Telex 6 87 70 alhoy dk, Telefax + 46 86 29 22 00, Telegrams frigohoy samus Bankers: Dan Dunske Bank A/S, Aamus Branch, Reg. No 5627, Account No 3258-13309-7 Export VAT No 28348369, Central Business Register and Import VAT No 41852119 e-mail; nover@noyar.dk, web-site; www.totrepaktioyer.com

105, 14 2000 02:40PM PZ

PHONE NO. : 0215558420

LYON : CONVENTENCE FOOD SYSTEMS

PACKING SLIP EDI Copy

Origin

Tetra Pak Hoyer A/S (LA) Søren Nymarksvej 9-13 Hoejbjerg DENMARK Delivery Address
Convenience Food Systems
P.O.Box 60962
Flamingo Square
7441 Centurion Office Park
Unit 5 Bosmandam Road
Milnerton Cape Town
South Africa

Customer : EDIB5

Date : 16-06-00

Forw.Agent:

Note No: 527

Pos. Delivery	Item	Cont.	Ordered	Delivered Qty	Unit	Back Order
Orde.	s Order : 600632 r Date : 13-06-2000 Ref. :					
PO: HD 1054) 1
Order 800471/H	G					į.
3	00960019	SET OF GASK	2,0000	2,0000	stk	
6	00910318		2,0000	2,0000	stk	1
		IMPELLER				1
9	00910048	STAR WHEEL	2,0000	2,0000	stk	1
12	00102082	5178K WIIDED	4,0000	4,0000	stk	
		GASKET				*
15	03720721	COATING	2,0000	2,0000	stk	
18	57369006		1,0000	1,0000	stk	
		SENSOR				
21	CSFREIGHT		1,0000	1,0000	stk	
24	CSINSURANCE	Freight	1,0000	1,0000	etk	
∵ 1	CO I SOTUMOD	Insurance	1,0000	1,0000	JUN	
nt.2,1		2				

nt.2,1 bt.2,6

1 pk. 34 x 28 x 23

#4264



PROJECT ENGINEERING

NATIONAL DAIRY EQUIPMENT (PTY) LTD. 13 MONTAGUE DRIVE, MONTAGUE GARDENS, CAPE TOWN, SOUTH AFRICA P.O. BOX 36619, CHEMPET 7442. TELEPHONE (021) 552-2170. TELEFAX (021) 552-2228 E-MAIL ADDRESS max.adamou@nde.co.za

Ref: MA/dm/1179 No of pages 2

FAX MESSAGE

TO:	PARMALAT ICE CREAM
ATT:	BRENT CLAASSENS
FAX NO:	933 6670
FROM:	MAX ADAMOU
DATE:	31 MARCH 2000
SUBJECT	QUOTATION FOR RIPPLE PUMP AND VARIGATOR

Dear Brent

We thank you for your enquiry and are pleased to submit our quotation on a delivered basis as requested:

ITEM 1. RIPPLE PUMP AS SUPPLIED BY SIDAM

PRICE: R67,392.00 DELIVERED

ITEM 2. VARIGATOR AS SUPPLIED BY SIDAM

PRICE: R26,352.00 DELIVERED

TERMS AND CONDITIONS:

Price Basis:

Prices quoted are Nett delivered to site. Offloading on delivery will be the responsibility of the purchaser.

The prices quoted are subject to Value Added Tax (VAT).

Delivery:

To be discussed.



PARMALAT SA (PTY) LTD

Reg. No. 95/02768/07

ICE CREAM DIVIBION: INCORPORATING AYLESBURY AND DUN ROBIN

40 INDUSTRIA RING ROAD PAROW INDUSTRIA 7499 ☑ 36718, CHEMPET 7441 SOUTH AFRICA ☎ (27) (21) 551 1928 FAX (27) (21) 551 6325

TO/AAN:

Ters Conradie – Stellenbosch Hannes Wagener – Stellenbosch

cc:

Kim Friedrich - Stellenbosch

FROM/VAN:

Danie Schoeman

DATE/DATUM:

21/08/00

RE. CAPITAL EXPENDITURE REQUEST: ROLLO MOULD TABLE

Please find the attached capital expenditure request. With the re-launch of the Aylesbury brand in October 2000 it is required that the quality, skew sticks, of our novelty products / stick line products be improved. The current mould due to its design makes the straight positioning of the sticks virtually impossible. The current mould is in an 8 shape and freezes quicker in the middle where the stick is supposed to be inserted than in the rost of the product. This lead to a stick that follows its own route, the softest channel, and ending up skew.

The original machine has been build by Tetra Pack Hoyer and it is advisable not to bastardize the machine with pirate parts from other suppliers.

Marketing supports this change and believes it will support the change over from the current Dun Robin brand to Aylesbury especially during the launch.

Regards

Danie Schoeman

Manager: Ice Cream Division





DIRECTORS: R Peroni* (Chief Executive Officer), F Di Querano* (Managing Director), F Giuffredi*, S Tanzi* (* Italian)



Quality Assurance Department

The following image quality is poor due to original page quality

<u>www.cleardata.co.uk</u> tel: 01670 356 734 fax: 01670 356 439



PARMALAT SA (PTY) LTD
Reg. No. 95/02768/07
Operation AYLESBURY PARON
T
Address 40 LN SUSTICIA LING CO.
IALON

parr	nalat	YALON						
•	AFRICA							
CAPITAL EX	KPENDITURE REQUEST	Application N	0.					
Budget Rcf.	Description of item	Cost exc. VAT	Budget available					
2	MOULD TABLE OF ROLLD	20 212 764-00	350 000 00					
	SHIPPING COST	30 000-00						
Quote 3: Quote chosen: N	SIDAM EU lo. I Reason: The aphal expenditure: (Plea SEE ATTACI	MACHINE IS HO	212 764-00 729 761-06 0yER ants where applicable)					
Profitable Required Infrastructu Statutory	Planned Personnel reduct Major maintenance Replacement	Number of employ Grading Approximate date	——————————————————————————————————————					
Additional commen	li.	IY EUR = R						
CAPITAL REQUE	ST CHECKED:							
Financial Manager		partiment Head:	SCHOEMAN					
Plant / Codi Manag	CC Date	lc <u>Z1</u>	6/00					
APPROYED BY CAP	ex committee:							
			·					
Date		F O Di Gaetano						
onnita	DIRECT S. Page	FORS;	ivi* OR Zial* (* Italiaa)					





999

PARMALAT OPERATIONS CAPITAL EXPENDITURE BUDGET 2000

OPERATION: Ice Cream Division

DATE: October 1999

NUMBER	DESCRIPTION	JUSTIFICATION	PRIORITY	TYPE	2000	YEAR	2000 BY	QUARTE	ers.	2001	2002
					TOTAL	1	2	3	4	TOTAL	TOTAL
1	Add on equipment to stickline machine	innovation required to positively effect the purchase dicision	Α	PM	125000	125000			Ĭ		
	to produce "funny face" spray on	of our customers in order to grow the novelty / stickline business									
2	Mouldtable for Rollo stickline machine :	The new "max type" mould will allow for new range of stickline products. Improve the appearance of the stickline products (straight sticks) and the overall quality of the product. The product will be smaller in volume but generating a higher price per liter sales. Also used for new Parmalat range 2001	С	PM	350000		350000				
3	1	Required for new Parmalat impuls ice cream products to be launched 2001. This is the target market for Parmalat Ice cream and proofes to be one of the highest growing sectors in the Ice Cream market.	C	PM	0					4000000	
	Investment / partnership with distribution agencies.	In order to extend the distribution to a national basis, distribution centres needs to be setup across the country. A partnership relation must be established with strong frozen chain distributors which have the infrastructure and ability to distribute ice cream as part of their already stable business.	D	PR	0						100000
TOTAL	<u> </u>	<u> </u>	<u> </u>	_	475000	12500X	360000		1 0	4000000	100000

PRIORITY:

D= The business cannot continue without this expenditure

C= The expenditure will within one year contribute to profit and a ROI of at least 20%

B= Equipment that is in use and needs to be replaced

A= Expenditure will contribute to profit in the medium to long term.

TYPES:

PM= Plant and equipment

MV= Vehicles

FE= Office furniture and equipment

MM= Major maintainance

PR= Projects

AYELESBURY STICK LINE: MOULD TABLE

				e						uly				Augu					Septembe				00
D	0	Task Name	Duration	06/04	4 06	3/11	06/18	8 06	/25	07/02	07/09	07/16	07/23		08/06	E1\80	08/20	08/27	09/03	09/10	09/17	09/24	1
1	=	Acquire quotes	7 days															:					
2		Brief Marketing	1 day				7							;				1					
3		Evaluate Competitive Set	1 day				T		:					•				1					:
4		Capital Expenditure Request Ar	2 days						:					:									:
5		Placing Order	1 day				Ī	▶	,					:								•	•
6		Hoyer to manufacter mould tabl	11 wks				ji							· · ·					7				
7		Shipping	1 wk								-							:	İ				-
8		Clearance	3 days															:		Ě	Ą		:
9		Installation	1 day											i I				:			Ė		:
10		Trial	2 days	1														:				T	
11		Production	5 days											:									• •
12	=	Launch	1 day						:														

	Task		Milestone	•	Rolled Up Split	External Tasks	
Project: Project1 Date: Thu 06/22/00	Split	e San Cara Sacas	Summary		Rolled Up Milestone	Project Summary	
	Progress		Rolled Up Task		Rolled Up Progress		

sidam

- Transit insurance.
- Builder's works with materials.
- Water piping work with materials.
- Insulation work of any type and relevant with materials.
- All pipe (air, water, NH3, etc) installations with materials.
- Electrical installations with materials.
- Charge of refrigeration plant with refrigeration and oil when applicable.
- Drain piping between drip tray and sewer.
- Air compressor plant.
- All local personnel, lifting equipment, materials for all installation work.
- All raw materials packaging material or any other material and service necessary for the commissioning of all equipment.

(B) SOLID RING FOR ROLLO 20 AT 6 WIDE

Constructed with following characteristics:

- top plate made of stainless steel
- cups made of stamped nickel in one piece
- welding of cups to the top plate by means of 'plasma'
- 6 cups for each radial row
- 120 radial rows
- model: to be selected

PRICE......EUR. 33.079,=

TOTAL PRICE EX WORKS CORMANO.....EUR.

35.790,=

(C)

NO. 1 SIDAM PUMP SET FOR HOYER FREEZERS

each pump set is composed by: rotor, idle gear and face plate - CIP type

1) Pump set diameter 63 mm. CIP type

SIDAM S.R.L. VIA FABIO FILZI, 37 20032 CORMANO (Milano) ITALY Company in Gram A/S Group Tei. (02) 61554.1 Tetelax (02) 61.50,926 E-meil: mdemonte@aldam.it Internet: www.sidem.it Meco. MI170387 Capitale Sociale 1,000,000,000 i.v. Reg. Imprese Milano 245903 Cod. Fiscale 07807120154 R.E.A. Milanu N. 1184387 Part. IVA IT07807120154

🍂 Tetra Pak Hoyer

Quotation

A011323-3

Dun Robin Products (Pty) Ltd. 40 Industrial Ring Rd Parow 7490 P.O. Box 1021 Parow 7550 SOUTH AFRICA

Yo	ण्याद्यः	Out reli: CHO/DOK	Delo: 14-Jun-00
Item	Qty		DKK
		With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 0102 GB2, which form an integral part of this quotation, we take pleasure in offering you as follows: New Stick Product on the existing Rollo 20, (Serial no. Z312,1411):	
1.	1	Mould Table Consisting of: - 6 mould pockets per row - 120 radial rows Price	
	1	Modification of Production Equipment Price	272,40
2.	<i>:</i>	Equipment for Production of "Filur" Product: The functionality of this Hoyer equipment has recently been upgraded and improved.	

Tetra Pak Hoyer A/8
Sooran Nymarka Vcj. 13. DK-8270 Hoejbjarg, Denmark
Telephone + 48.99.39.39.39, Telex 6.87.70 athey dk, Telefax + 46.88.29.22.00, Telegrams frigohoy austrus
Bankers: Den Danbke Bank A/8, Aarhys Branch, Reg. No.3827, Account No.3288-13389-7
Export VAT No.28348389, Certral Business Register and Import VAT No.41852118
e-mail: hoyer@hoyor.dk, web-site: www.tutrapakhoyer.com

Jun. 14 2000 DZ:48PM PZ

PHONE NO. : 0215550420

EROM : CUMOENTEMCE EDOD SASTEMS



PARMALAT SA (PTY) LTD
Reg. No. 95/02768/07

MEMORANDUM

To:

Martin Neethling

From:

Kim Friedrich

Date:

21 June 2000

RE:

Aylesbury re-launch - new mould for novelties

Dear Martin

Attached please find the capital expenditure request for a new ice-cream mould. This has been budgetted for, and we would like to have this new mould when we re-launch Aylesbury in October 2000.

Our current mould does not do our product justice, as all the sticks are inserted "skew". In addition, the shape of the ice-cream ("spade-shaped") is a little outdated. The mould that we would like is a "tongue-shaped" mould, and allows for a more modern look, and puts us in a different league.

The decision regarding the type of mould to purchase was taken after looking at the competitive set, as well as the proposed range of novelties we are planning to launch.

I would appreciate your approval of this purchase as soon as possible, as we need to allow for delivery and set-up time for the new mould, as well as trials.

Kind regards

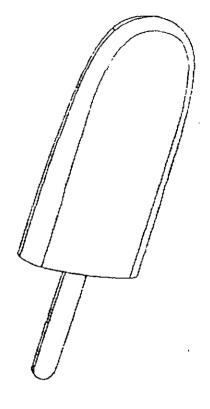
Kim Friedrich PRODUCT MANAGER





DIRECTORS:
R Peroni* (Chief Executive Officer), F Di Gaetano* (Chief Financial Officer)
F Gluffredi *, S Tenzi* (* Italian)

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ROLLO 20	30	Ţ	Ţ					1
ROLLO 27	30		٦į			700 C	oct or	
ROLLO 32	34				ĺ	MOUL	DGE OF D TABLES	ا : رَ
ROLLO 35	34	ļ	ĺ		ļ	•	ار	
		LENGTH - X + Y	8			1: 501 - 1	INSIDE MOULD - Y - 113	



VOLUMENS:

Volume of mould (at L = 105 mm), V_{mould} = 75,0 CC

Estimated volume of ice taken out of mould, Vice - 72.0 CC

Residual (normaly 1-3 CC) and displacement of stick (normaly 1 CQ) influence Vice

Please note: Product drawings, dimensions given refer to the shape of the mould. It must be anticipated, that the final product may differ slightly in volume and shape from the drawing of the stick product.

Freezing mould see drawing:

	Approved by customer	
Sign.:	Dave:	

A Tetra Pak		SI	TICK PRODA	JCT	
a Projet, \$1 dyna Mil.					
"#### 	1 1- A 3	000620	P≥ D≥Q	C04533585	0

<u> /3 _</u>

FAX

from Fax no.: +27 21 555 0467

To

: Parmalat

Attn.

Dannie Schoeman

Brent Claassen

Fax no

021 551 6325, 933 6689

From

: Sam Greenaway

Ref. No.

2029sg

Date

2000-05-31

No. pages

.

(incl, this one)

Subject

New Mould Table

Dear Brent,

I thank you for your valued enquiry and take pleasure in quoting the following for your kind attention.

Mould Table for a Rolo 20 Z312,1411

Price Ex works DKK 272 400,00

An estimate of R 258 780,00 ex works, is due to the exchange rate were any fluctuation will be for your account. This quote is valid for 60 day.

Exchange rate quoted DKK 0,95 = R 1,00. Should you require a fixed exchange rate please feel free to contact me.

Shipping, cleaning, duty costs, Vat : Excluded.

(Estimated total Sea freight costs, Ex VAT, R 15 000-30 000)

Installation: N/A

Payment terms: 50% on receipt of order, and 50% on proof of shipping doc's

-before dispatch.

Kind Regards

Sam

Convenience Food Systems (Pty) Ltd.

P.O. Box 60962, Flamingo Square 7441, Cape Town, South Africa. Visiting address: Unit N5, Centurion Business Park, Bosmansdam Rd, Milnerton. Tel. +27.21.555.0420\21, Fax +27.21.555.0467, http://www.cfs.com

ात वन्तुंते होता चल्लेट रहे अन्तर

DEFOSSSTRØ : TON BNOHA

TEOR : COMMENTENCE EDUC EXELENC



FAX from Fax no.: +27 21 555 0467

To

: Parmalatice cream

Attn.

: Mr Dannie Schoeman

Brent Claassen

Fax no.

551 6325/933 6689

From

: Sam Greensway

Ref. No.

2041sq

Date

2000-06-14

No. pages

Subj**ect**

2000-00-1

, ,

: "Filur" and a new mould table quotation - Revised

Dear Dannie.

We have considered the complete order and the previously related price for the Filur of 1998/9 and have revised the situation. On initial quotation of the filur product it was not establish if a new modified chocolate tank and other modification were necessary on the role 20. However with assistance from the Engineering department the price has been reduce in order for us to meet with your needs.

I hope that the quotation meets with your requirements and we look forward to the order. Please note the 12 weeks delivery time (ex Works.)

Estimated Exchange rate: DKK 0,95 = R 1,00

(Were any Fluctuation will be for your account)

Estimated Total Shipping Costs: R30 000(To be confirmed & charged at cost)

(Shipping, Clearing, Duty, VAT and any other costs are all excluded.)

Convenience Food Systems Terms: 50%, 60%.

Convenience Food Systems (Pty) Ltd.

P.O. Box 60962, Flamingo Square 7441, Cape Town, South Africa.

Visiting address: Unit N5, Centurion Business Park, Bosmansdam Rd, Milnerton.

Tel. +27 21 555 0420\21, Fax +27 21 555 0467, http://www.cfs.com

Jd WAYA:S0 005 41 .nut

PHONE NO. : 0215556420

EROM : COMMENTENCE LOOD SASTEMS

(incl. this one)

00S P04

DUN ROBIN PRODUCTS

700 SS.00 8:00 051 333688

AU113/41-3

14-Jun-00 Dun Robin Products (Pty) Ltd. DKK Item **Qty** The equipment consists among other things of: · Various modification on the Rollo to make room for this equipment - 1 New pump - 1 Set of Nozzles - 1 Frame - 1 Vessel for the water paint, which is a mix of water and colouring. - l Mask - Various electrical components For the principle of this spraying equipment please look at the enclosed engineering drawings no. 128,24223 and 128,24164. Please note: - The accuracy and sharpness of the motive sprayed onto the stick product varies according to the production speed of the Rollo and the spray media. - The price of this spraying equipment is conditioned by placement of an order on the above-mentioned mould table (Item 1). Total Price, Item 2 132.800 405,200 Grand Total Price, Item 1 & 2 The Price: is to be understood F.C.A. (free carrier) Aarhus, Denmark, incl. packing for the transport in question, excl. installation. "INCOTERMS 1990" apply.

A: Tetra Pak Hoyer

Quotation A011323-3

Heal VIV's

Dus	n Rob	oin Products (Pty) Ltd.	14-Jun-0
Iten	Qty		DKI
		Delivery:	
		Approx. 12 working weeks after receipt of order and approved/signed product drawing.	
		The above mentioned time of delivery is to be reckoned from the date all relevant technical information/samples necessary for production of the machine have been received and samples must be sent to Hoyer for comments.	
		In addition, the time of delivery depends on the down payment being paid according to agreed terms of payment.	
		Payment:	
		30 % of the contractual amount to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus Branch, Denmark, not later than 2 weeks after order.	
		70 % of the total amount to be paid before delivery.	

		We hope our quotation is in accordance with your wishes and look forward to receiving your order. Should you have any further questions we are of course at your disposal with further information.	
		Yours faithfully, Tetra Pak Hoyer A/S	
	<	Chris Olsen	
-			

- 3



With reference to the Extrusion line as per our meeting on the 12/06/00

I can confirm as follows;

- 4 weeks are estimated for Installation & commissioning.
- @ Euro 4500 per week, ex flight, Accom.
- Estimated CIF Cape Town Euro 12700, Ex local clearing, Agent fees and Local Transportation.

Should you have any further questions please feel free to contact me.

King Regards

Sam Greenaway.

Page 2 of fax d.d

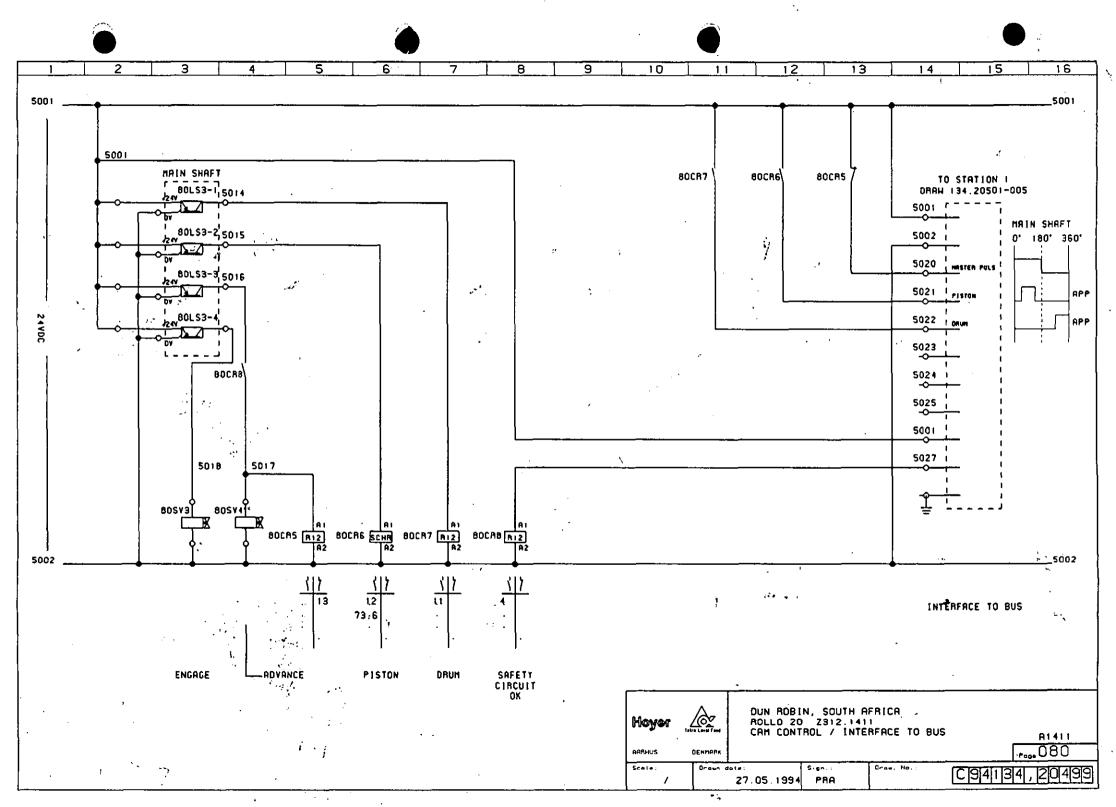
Jun. 14 2000 02:48PM PZ

PHONE 40. : 0215550420

EBOW : COMMENTENCE EDOD SASTEMS

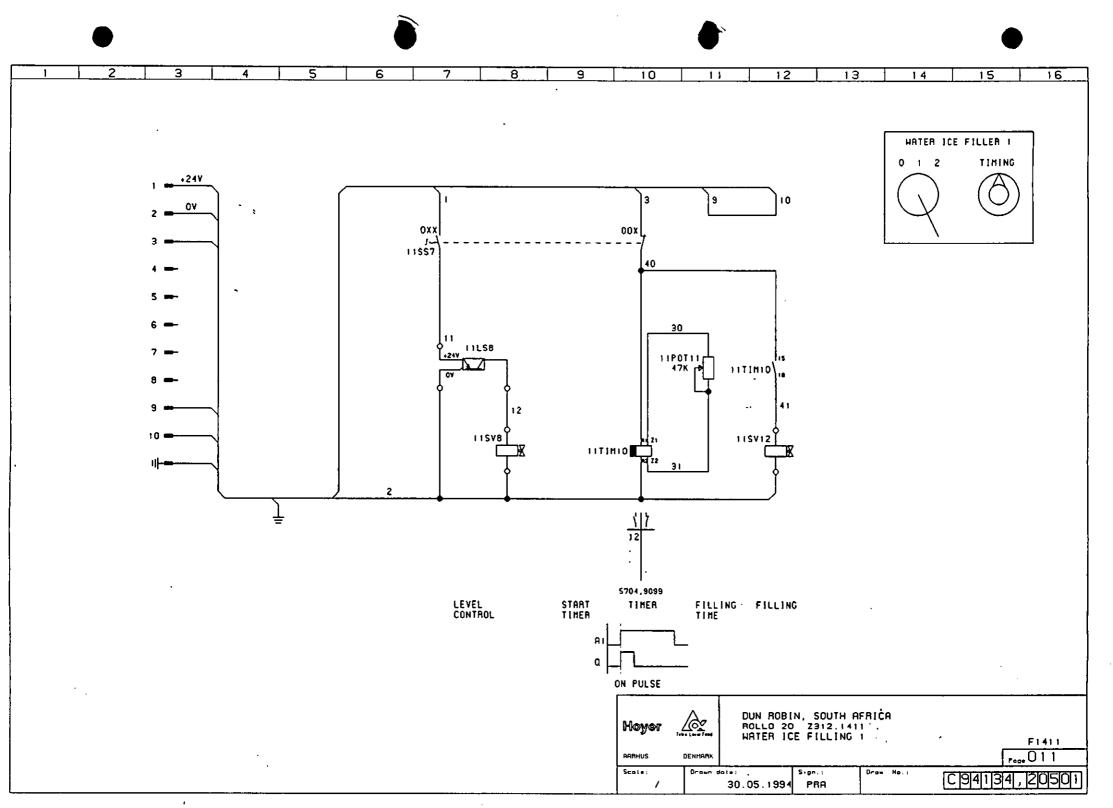
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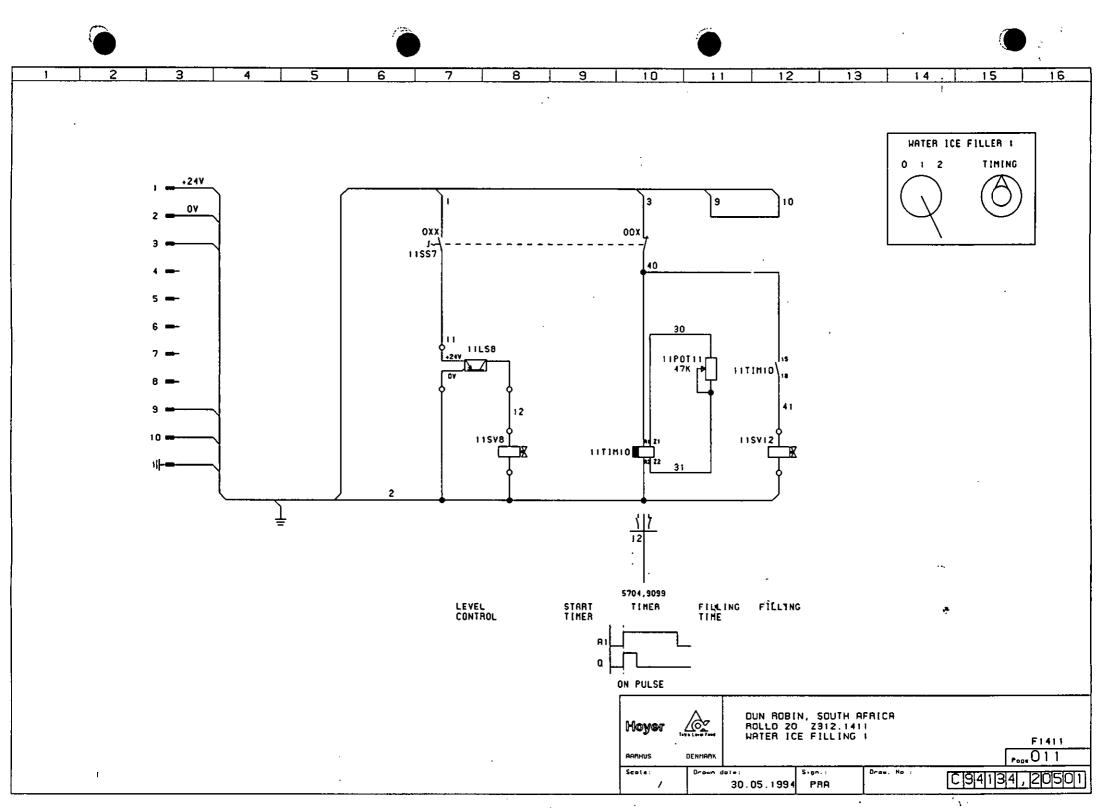
DOM ROBIN PRODUCTS



3 5 8 16 6 9 10 12 13 14 15 5001 5001 5001 MAIN SHAFT 80CR7 60CR6 80CAS TO STATION I 80LS3-1₁₅₀₁₄ DRAW 134.20501-005 5001 r MAIN SHAFT 5002 0, 180, 360, 5020 MASTER PULS 5021 | PISTON APP 5022 i paum APP BOCRB 5024 5025 5001 5027 5018 5017 80573 80574 80CR5 R12 80CR6 SCHR 80CR7 R12 80CR8 B12 5002 5002 12 /INTERFACE TO BUS 73.6 ENGAGE . L_ADVANCE PISTON DRUN SAFETT CIRCUIT DUN AOBIN, SOUTH AFRICA ROLLO 20 Z312.1411 CAH CONTROL / INTERFACE TO BUS **A1411 ,...**080 ARRHUS DENMAAK Scale: Drawn dala: Sign. Oraw. No. 27.05.1994 PAA

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ICEHOY Tetra Pak Hoyer - Bilwinco - Limitech

Fax

To:	Parmalat Ice Cream	From:	Sam Greenaway	
ATT:	Mr Brent Claassens	Pages:	2 page\s including t	his one
Fax:	021 933 6889	Date:	00-08-30	
Ro:	Old mould table drawings	CC:	Mr Danie Schoema	n
□ Urg	ent 🗆 For Review 🗀 Please C	omment	☐ Please Reply	☐ Please Recycle
Dear B	Brent,			
Herew	ith are the old mould table drawings for th	ne Rollo 20.		
If I can	be of any further assistance please feel t	free to conta	at me.	

Kind Regards

Sam.

ICEHOY

P.O. Box 60764, Flamingo Square, 7441, Cape Town, South Africa. 81 Libertas Ave, Table View, 7441, Cape Town, South Africa. Tel: +27 21 557 7205, Fax: +27 21 557 5547, Cell: 083 483 5730.

Email: sammy.g@iafrica.com

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ICEHOY

Tetra Pak Hoyer - Bilwinco - Limitech

To:	Par	malat Ice Cream		From:	Sam Greenaway	-
ATT:	Mr I	Brent Claassens		Pages	2 page\s including	this one
Fax:	021	933 6689		Date:	00-08-30	
Re:	Old mould table drawings		Old mould table drawings CC:	Mr Danie Schoems	an	
🗆 Urge	ent	☐ For Review	□ Piease Com	ment	☐ Please Reply	☐ Please Recycle
·····	<u></u>	·····		<u></u>	***************************************	
Dear Br	rent,					
Herewi	th are	the old mould table	drawings for the F	talia 20.		
If I can	be of	any further assistance	e please feel free	to conta	ct me.	
Kind Re	egard	s				
Sam						

ICEHOY

P.O. Box 60764, Flamingo Square, 7441, Cape Town, South Africa. 81 Libertas Ave, Table View, 7441, Cape Town, South Africa. Tel: +27 21 557 7205, Fax: +27 21 557 5547, Cell: 083 483 5730.

Email: sammy.g@iafrica.com

ICEHOY

Tetra Pak Hoyer - Bilwinco - Limitech

Fax

To:	Par	malat ice cream		Fromi	Sam Greenaway	
ATT:	Mr	Danie Schoeman	*	Pagesi	1 pagels including	this one
Fax:	021	551 6325/ 021 933	6689	Date:	00-08-30	
Re:	a: New agent details - ICEHOY		gent details - ICEHOY CC:		Mr Brent Claassens, Mr Dena Fou	
🗆 Urg	ent	☐ For Review	🗆 Pleas	e Comment	☐ Please Reply	☐ Please Recycle
	-,,-					

Dear Danie,

It is with great pleasure that I can announce ICEHOY as the newly appointed local agent for Tetra Pak Hoyer, with immediate effect. We will strive to improve, solve and serve you our customer, to the best of our ability. ICEHOY will assist Parmalat ice cream with any Tetra Pak Hoyer related enquiry's, quotations, after sales service and general information were applicable.

Any backlog orders from 30/08/00 will be delivery, invoiced and handled by Convenience Food Systems. We hope that this transition period will not inconvenience you in any way and I thank you in advance for your understanding.

ICEHOY also represents Bilwinco and Limitech. Bilwinco have been in the food industry for many years and focus their efforts on automatic weighing systems. Limitech specialise in processing, mainly - Cheese, Yoghurt, Jam, Sauces, Tomato sauce, Case-in products, Soups, Chocolate Mayonnaise, Dressings

If you have any further questions please feel free to contact me.

Kind Regards

Sam Greenaway.

ICEHOY

P.O. Box 60764, Flamingo Square, 7441, Cape Town, South Africa. 81 Libertas Ave, Table View, 7441, Cape Town, South Africa. Tel: +27 21 557 7205, Fax: +27 21 557 5547, Cell: 083 483 5730.

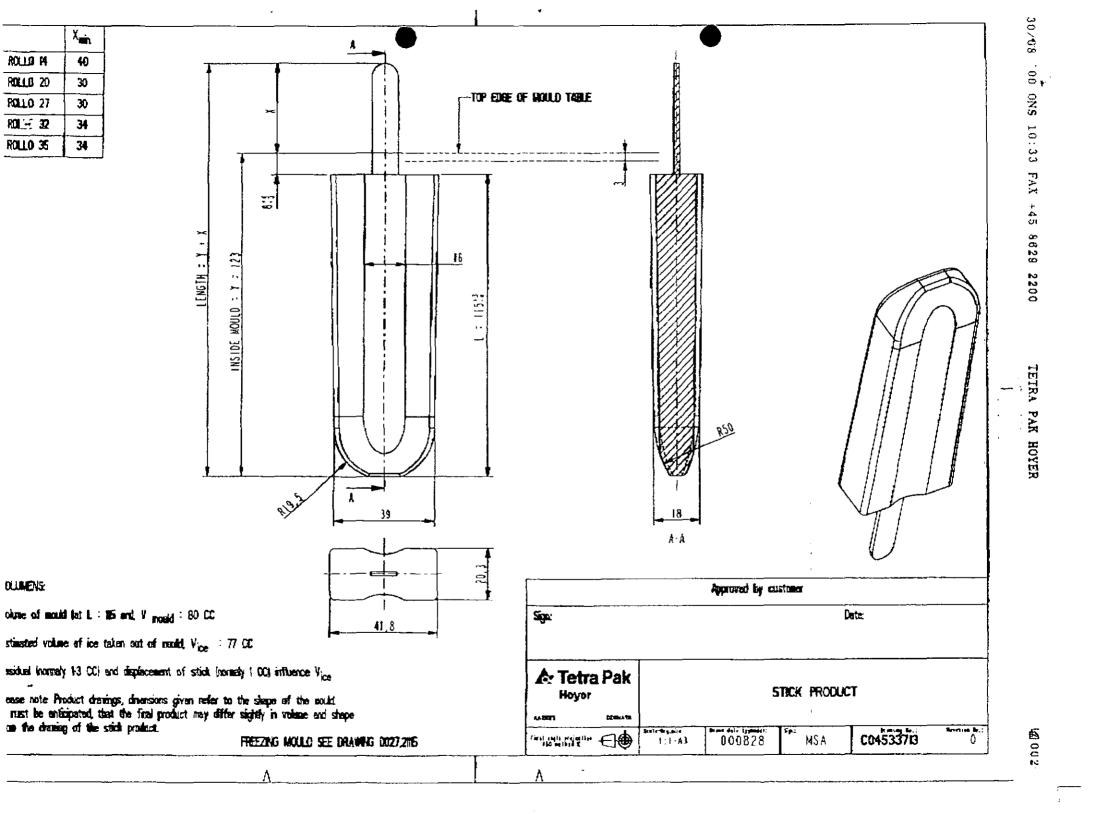
Email: sammy.g@iafrica.com



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FAX

from Fax no.: +27 21 555 0467

To

Parmalat

Attn.

: Dannie Schoeman

Brent Claassen

Fax no.

: 021 551 6325, 933 6689

From

Sam Greenaway

Ref. No

: 2036sg

Date

2000-06-08

No pages

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(incl. this one)

Subject

: Filur product

Dear Brent/Dannie,

I thank you for your valued enquiry and take pleasure in quoting the following for your kind attention. Please note that the prices are in DKK and any variation in the exchange rate will be for your account.

This quotation is also subject to CFS standard terms and conditions should you place any order via CFS SA.

Please feel free to contact me should you have any further questions.

Kind Regards

Sam.

Convenience Food Systems (Pty) Ltd.

P.O. Box 60962, Flamingo Square 7441, Cape Town, South Africa. Visiting address: Unit N5, Centurion Business Park, Bosmansdam Rd, Milnerton. Tel. +27 21 555 0420\21, Fax +27 21 555 0467, http://www.cfs.com

PHONE NO. : 0215550420

Jun. 08 2000 02:55PM P2

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08/06 100 13:14

2386292200

TLF HOYER DK

303 - 43 - 4

Estimate

A011323-1

Dun Robin Products (Pty) Ltd. 40 Industrial Ring Rd Parow 7490 P.O. Box 1021 Parow 7550 SOUTH AFRICA

Your ref.;

Our ref.: CHO/DOK

Date: 08-Jun-00

	CHO/DOK	08-Jun-00
Qty		DKK
	With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 0102 GB2, we are pleased to quote an estimated price as follows:	
	New Stick Product on the existing Rollo 20, (Serial no. Z312,1411):	
	Equipment for production of Filur product:	
	The functionality of this Hoyer equipment has just been upgraded and improved. Therefore, it has not yet been released for selling and I can only send you an estimate.	
	The equipment consists among other things of: 1 New dipping vessel on the Rollo Various modifications on the Rollo to make room for this equipment. 1 New pump 1 Set of Nozzles	
,	- 1 Frame - 1 Vessel for the water paint, which is a mix of water and colouring 1 Mask - Various electrical components	
	For the principle of this spraying equipment please look at the enclosed engineering drawings no. 128,24223 and 128,24164.	
	Estimated Price	362,00

08/06 00 13:14

25 83292200

PHONE NO. : 0215550420

TLF HOYER DK

🌊 Tetra Pak Hoyer

Estimate A011323-1

Dun Robin Products (Pty) Ltd. 08-Jun-00 **Qty** DKK The Price: is an estimated price to be understood F.C.A. (free carrier) Aarhus, Denmark, incl. packing for the transport in question. "INCOTERMS 1990" apply. Delivery: Approx. 12 working weeks after receipt of order and approved/signed product drawing.

> The above mentioned time of delivery is to be reckoned from the date all relevant technical information/samples necessary for production of the machine have been received and samples must be sent to Hoyer for comments.

In addition, the time of delivery depends on the down payment being paid according to agreed terms of payment.

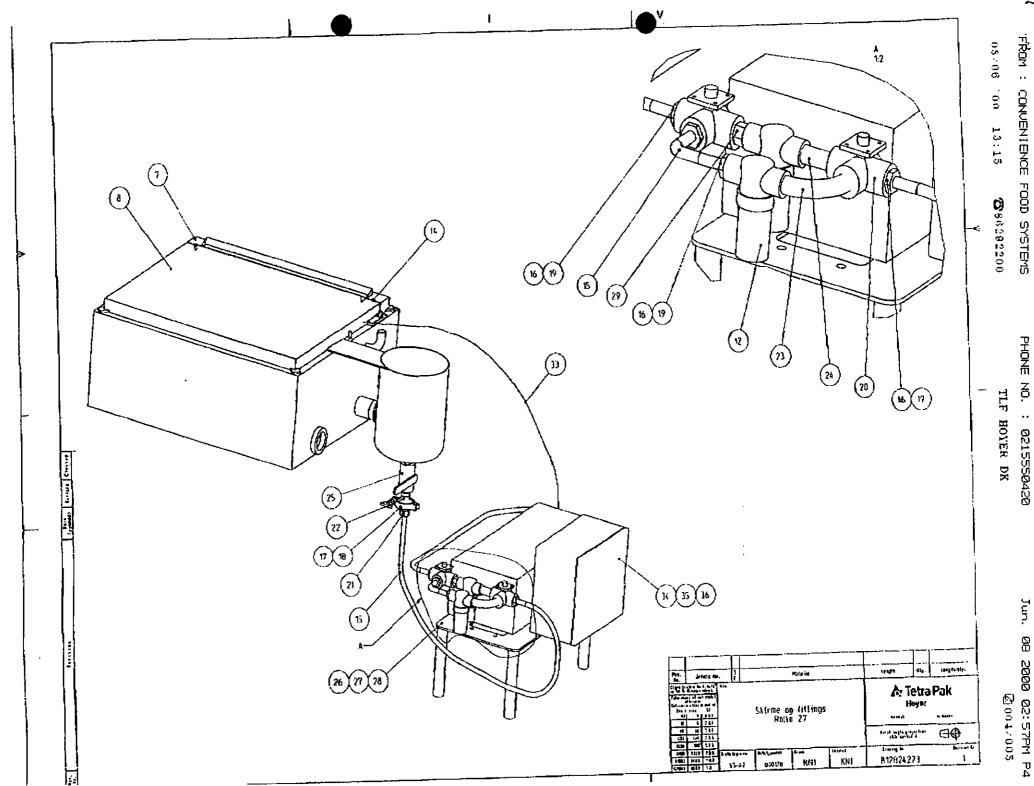
Payment:

30 % of the contractual amount to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus Branch, Denmark, not later than 2 weeks after order.

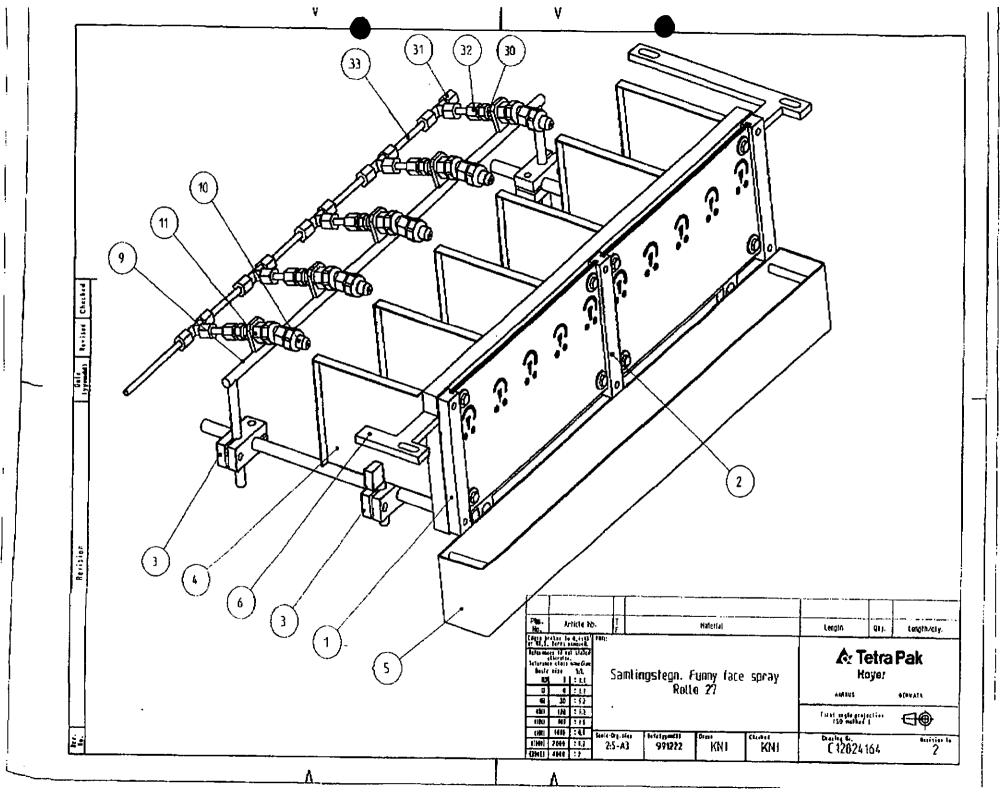
70 % of the total amount to be paid before delivery.

We hope our Estimate is in accordance with your wishes and should be pleased to work out a firm quotation which meets your specific requirements. Looking forward to hearing from you.

Yours faithfully, Tetra Pak Hoyer



8 2000 02:57PM P4



FROM : CONVENIENCE FOOD SYSTEMS

IONE NO. : 0215550420 TLF HOYER DK

Jun. 08 2000 02:57PM P5 @005/005

PRODUCT EXAMPLES	One-coloured ice cream	Two-coloured ice cream vertically divided	Two-coloured ice cream vertically divided »zebra pattern«	Two-coloured ice cream concentric	
EQUIPMENT REQUIRED	*1	1	1	1	
OPTIONAL EQUIPMENT REQUIRED		5	5+6	5+7	
PRODUCT EXAMPLES					
	Two-coloured ice cream horizontally divided	One-coloured water ice	Two-coloured water ice horizontally divided	Three-coloured water ice horizontally divided	Split ice
STANDARD EQUIPMENT REQUIRED	1				
OPTIONAL EQUIPMENT REQUIRED	8	9	9+9	9+9+9	9+10
PRODUCT EXAMPLES	One-coloured water ice, two different colours per radial row	Two-coloured water ice vertically divided (twin type)	Pencil filled ice cream	Chocolate coated bars	Dry coated ice cream
STANDARD EQUIPMENT REQUIRED		1	1	1+2	1+2
OPTIONAL EQUIPMENT REQUIRED	11	12	13	18	15+18

^{*} The numbers in this table refer to list of optional equipment on previous page.

Technical Data

Electrical Power Pipe Co

Main consumption: 10 kW

Connection: 3 x 400 Volts AC, 50/60 Hz

Defrosting Elements (Additional load)

Heating elements max. 15 kW Low pressure steam 30 kg/h

Warm brine, heated either by electricity or by steam. The choice must be made when ordering, otherwise electric heating will be installed as standard.

Brine Quantity 800 litres/ 1,048 kg

(211.5 gall./ 2,311lbs)

Air Consumption 1000 litres/min.

Pipe Connections

Brine in- and outlet: 3 inch (76 mm) clamp connection.

Main inlet for air 15 mm (1/2")Piping dimensions for ice cream not less than the outlet of

the continuous freezer.

Weight

In »ready-to-work« condition

approx. 4,000 kg

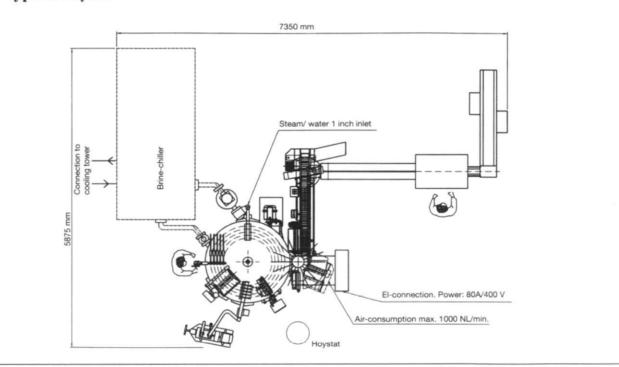
Shipping Data

Net weight3,000 kgGross weight4,000 kgVolume 20 m^3

Main Dimensions

Height of work table above floor 1,100 mm (43.5")

Typical Layout



Tetra Pak Hoyer

Tetra Pak Hoyer A/S, Soeren Nymarks Vej 13, DK-8270 Hoejbjerg, Denmark, Tel.: +45 89 39 39 39, Fax: +45 86 29 22 00, E-mail: hoyer@hoyer.dk
Tetra Pak Hoyer Inc., 753 Geneva Parkway, P.O. Box 280, Lake Geneva, WI 53147-0280, USA, Tel.: +1 262 249 7400, Fax: +1 262 249 7500
Tetra Pak Hoyer SpA, 52 Via Monferrato, I-20098 San Giuliano Milanese (Milan), Italy, Tel.: +39 02 98 2921, Fax: +39 02 9880171
Tetra Pak Hoyer Indústria e Comércio Ltda., Rua Napoleao de Barros 1038, CEP04024-003 Sao Paulo - SP, BRAZIL, Tel.: +55 11 573 9422,

Fax: +55 11 549 5420, E-mail: export@tphoyer.com.br

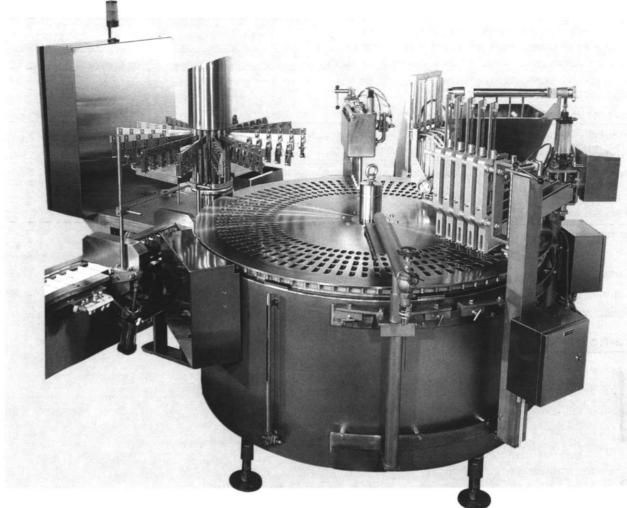
Tetra Pak Hoyer Inc., Ground Floor, Molave Building, 2231 Pasong Tamo Street, Makati, 1231 Metro Manila, Philippines,

Tel.: +63 2 813 2848, Fax: +63 2 813 2866

Tetra Pak Hoyer A/O, 35 A Usacheva str., 119048 Moscow, Russia, Tel.: +7 502 224 2160, Fax: +7 095 931 9762, E-mail: hoyer.moscow@tetrapak.com
Product Description: PD 0515 GB1/03.2000/1000

www.tetrapakhoyer.com





Hoyer Rollo 16

Automatic Ice Cream

Bar Freezer

Application

Automatic, continuous production of ice cream, sherbet, or fruit-juice bars with sticks.

Operating Principle

The production of ice cream bars is carried out in six main stages:

- 1. Filling of ice cream into the moulds.
- 2. Insertions of wooden sticks into the ice cream.

- 3. Freezing of the bars in a cold brine bath at -40° C (-40° F).
- 4. Defrosting of a thin outer layer of the bars in a warm brine bath at +15-25°C (+60-77° F).
- 5. Extraction of the frozen bars from the moulds.
- 6. Lay-off for packing.

Between extraction and lay-off, the bars may be coated with chocolate. Products dipped in chocolate may also subsequently be coated with dry stuffs.

Capacity

The capacity for typical products (see tables) will normally be in the range of 4,500 to 6,000 ice cream bars per hour. Capacities for water ice are lower than for ice cream. Actual capacity depends upon a number of factors, including:

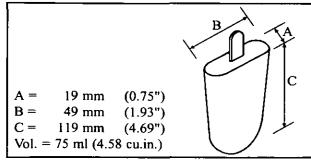
- Number of radial rows.
- Number of products per radial row.
- Product thickness.
- Recipe (e.g. sugar content and total solids content).
- Overrun.
- Viscosity of ice cream mix.
- Brine temperature.
- Ice cream filling temperature.
- Number and types of filling operations.
- Capacity of the packing line.
- Capacity of the refrigeration unit.

Example:

Product width:	49 mm	— (1.93")
Product thickness:	19mm	(0.75")
Number of radial rows:	90	
Number of pockets per row:	5	
Overrun of ice cream:	60%	
Evaporating temperature:	-45°C	(-49°F)
Brine temperature:	-40°C	(-40°F)
Ice cream filling temperature:	−2°C	(+28°F)
Capacity*, approx.:	6,000	per hou
Required refrigeration power:	38 kw	

* The capacity is based on a mix recipe using good quality ingredients as follows:

Fat	10.0%
Skimmed milk powder, fat free	10.5%
Sugar (sucrose)	12.0%
Glucose syrup	5.0%
Auxiliary ingredients	0.5%
Total solids	38.0%
Water	62%
	100%



The number of freezing pockets per radial row depends upon the width of the ice cream bar.

Max. width of product	Pockets per radial row
43 mm *53 mm	6
68 mm	4

For example

The number of radial rows depends on the thickness of the ice cream bar.

Max. thickness of product	Number of radial rows
*Up to 24 mm	
24-28 mm	75

For example:

*Typical products.

Standard Design

Mould Table. The moulds, in which the bars are shaped and frozen, are welded into an annular, rotary table situated on top of the brine tank.

The mould table is made of stainless steel. The number of pockets included in the standard mould table with 5 pockets per radial row is 90 pockets.

Other mould tables with different row and pocket configurations can be supplied (see »Optional Equipment«).

The mould table of a Hoyer Rollo 16 can handle ice cream bars up to 180 mm long. The stick inserted in the ice cream/ water ice bar must protrude at least 30 mm (1.18") above the mould table.

Brine Tank. The double-walled annular tank is welded and insulated. It is made from stainless steel.

Two rails are placed on the outside of the brine tank for mounting the stick dispenser, the cleaning equipment, the filling equipment, etc.

The brine tank is divided into a freezing zone with cold brine and a defrosting zone with warm brine.

The secondary cooling system is a cold brine bath and the cold brine is circulated by a centrifugal pump. The cold brine distribution trough is made of stainless steel. A pump ensures the circulation of the brine from the refrigeration unit to the Hoyer Rollo 16 tank.

An external primary refrigeration system is required. See optional equipment 32/33.

Defrosting System. The warm brine is heated either by electricity or by steam. The choice must be made when

ordering. The brine is sprayed onto the underside of the moulds through a nozzle system.

The defrosting system is equipped with a separate centrifugal pump. A thermostat prevents operation of the extractor if the warm brine temperature is too low.

Main Drive. All functions are pneunatically actuated and PLC controlled.

The speed of the Hoyer Rollo 16 varies between 6 and 20 strokes per minute.

Electric Equipment. The equipment comprises motor starters with thermal overload protection, contactors, electric and thermostatically controlled heating elements for the defrosting system, necessary parts for control functions, limit switches, relays, fuses, etc. This means that the Hoyer Rollo 16 only needs to be connected to the main power supply.

Control Panel. Primary functions are regulated and read from the operator panel. Start/stop and filling times of the equipment are operated individually from a control box mounted on each piece of equipment. The refrigeration unit is controlled seperately.

Filling Equipment. The standard ice cream filler is designed as a drum type volumetric filler for top filling of ice cream and consists of a column and a filling head, on which the interchangeable filling equipment is mounted. The standard machine is equipped with a filler for one-coloured ice cream.

Stick Dispenser. The stick dispenser is mounted on a suspension rack and consists of sections, one for each freezing pocket in the radial row. The activation is pneumatic.

Extractor and Lay-Off Device. This device is equipped with 16 extractor arms each with a complete set of extractor tongs for wooden sticks all made of stainless steel.

The release of the products is actuated by the downward movement of the extracting arm.

Chocolate Coating Equipment. This equipment is mounted beneath the extracting device and comprises a dipping cup and a chocolate vessel with drip scraper. The temperature of the drip tray is thermostatically controlled.

An external chocolate tank and a circulation pump are required, e.g. a Hoystat (see "Optional Equipment" no. 18).

Washing and Sterilizing Apparatus. For cleaningin-place (CIP) and sterilizing, a washing apparatus is supplied for mounting on the supporting rails on the brine tank. The apparatus requires connection to water and steam.

Standard Equipment

- I Filling equipment for one-coloured ice cream.
- Chocolate dipping cup.
- 3 Set of tools.

Optional Equipment

- 5 Filling equipment for two-coloured ice cream, vertically divided.
- 6 Filling equipment for two-coloured ice cream, vertically divided in a »zebra-pattern«.
- 7 Filling equipment for two-coloured ice cream, concentric filling.
- 8 Filling equipment for the filling of twocoloured ice cream, horizontally divided.
- 9 Independent filling unit for one-coloured water ice (required for two-coloured water ice, horizontally divided and for topping-up).
- 10 Filling equipment for shell and core split ice: shell of water ice, core of ice cream.
- 11 Equipment for one-coloured water ice, but two different colours per radial row. (Three and four colours per radial row is also available.)
- 12 Filling equipment for two-coloured water ice, vertically divided (twin-type lolly only).

- 13 Pencil filler with equipment for two strings of ripple mass per bar.
- 15 Dry coating equipment for coating the bars with granulated dry stuff, nuts, candy, etc.
- 18 Hoystat pump station. 100 litre (26.5 gall.) chocolate floor tank with electrically heated and thermostatically controlled water jacket and electrically driven chocolate circulation pump. The floor tank is a separate unit on wheels and with hoses for connection to the dipping cup on the Hoyer Rollo machine.
- 20 Cart for transport and storage of mould table.
- 24 Extended set of spare parts for two years' operation.
- 28 Mould table with alternative pocket and row configurations.

The number of freezing pockets which can be fitted into a Rollo 16 mould table depends on the size and shape of the ice cream bar. Between 4 and 6 freezing pockets per radial row is possible. The number of radial rows will depend on the thickness of the product (see tables under »Capacity« section).

- 31 Hydraulically operated crane for lifting the mould table
- 32. Complete refrigeration unit which is separate from the machine and built on one frame. It consists of a compressor, a driving motor, a condenser, an evaporator (PHE) and a control panel. R22 is used as refrigerant. The evaporator is equipped with oil drain valves. A check valve and a stop valve are mounted in the liquid line. A suction stop valve is also supplied.
- 33 Plate heat evaporator for connection to a central ammoniabased system refrigeration.

Other optional equipment is available and full details can be obtained on request.

All capacities, data, illustrations, photographs, drawings and statements in this publication are for general information only and subject to change without notice. They should not be considered as a warranty or legal obligation of any kind. Any drawing or data contained herein shall remain the property of Tetra Pak Hoyer and unauthorized use thereof is prohibited.

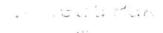


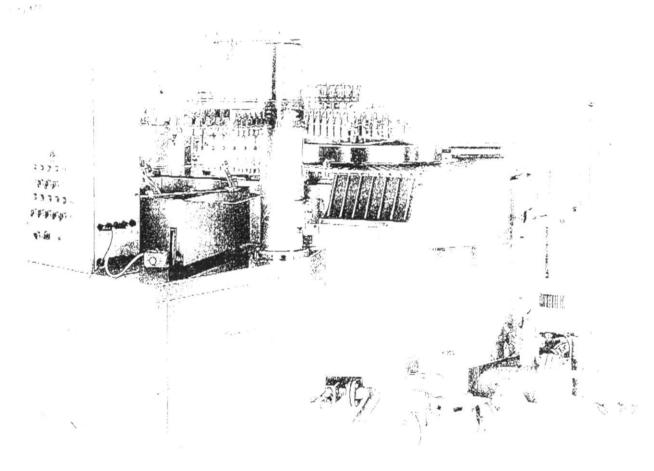
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tel: 01670 356 734 fax: 01670 356 439





Hoyer Rollo 20

Automatic Ice Cream

Bar Freezer

Application

Operating Principle

TO: BRENT DANNIE 933 6689. | 551 6325

Mario SAM

Capacity

The capacity for typical products (see table) will normally be in the range of 7,000 to 10,000 ice cream bars per hour. Capacities for water ice are lower than for ice cream. Actual capacity depends upon a number of factors, including.

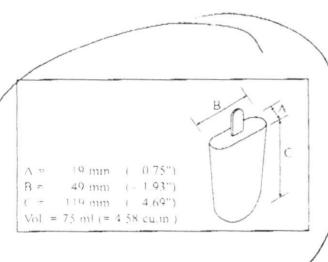
- Number of radial rows
- Number of products per radial row.
- Product thickness
- Recipe (e.g. sugar content and total solids content).
- Overrun.
- Viscosity of ice cream mix
- Brine temperature
 - Ice cream filling temperature
- Number and types of filling operations.
 Capacity of the packing line.

Example:

		ASSESSMENT OF THE PARTY OF THE
Product width:	49 min	(1.93")
Product thickness:	19 mm	(0.75")
Number of radial rows.	120	
Number of pockets per row:	6	
Overrun of ice cream:	60%	
Evaporating temperature.	-45°C	(-49°F)
Brine temperature:	-40°€	(-40°F)
lcc cream filling temperature:	-2°C	(±28°F)
Capacity*, approx.:	9.000	per hour

 The capacity is based on a mix recipe using good quality ingredients as follows:

Fat	12%
Skimmed milk powder, fat free	11%
Sugar (sucrose)	12%
Auxiliary ingredients	1%
Water	64%
	100%



The number of freezing pockets per radial row depends upon the width of the ice cream bar Lor example

Max. width of product	Pockets per radial row
83 mm (3.27")	4
65 mm (2.56")	5
*53 mm (2.09")	6
*44.5 mm (1.75")	7
38 mm (1.50")	8

^{*}Typical products.

The standard number of radial rows is 120 for products with thickness up to 23.5 mm. Above 23.5 mm the number of radial rows or pockets per radial row will be less.

Standard Design

Mould Table. The moulds, in which the bars are shaped and frozen, are welded into an annular, rotary table situated on top of the brine tank

The mould table is made of stainless steel. The number of pockets included in the standard mould table with 6 pockets per radial row is 6 x 120 - 720 pockets.

Other mould tables with different row and pocket configurations can be supplied (see »Optional Equipments).

The mould table of a Hoyer Rollo 20 can handle ice cream bars which are up to 135 mm (5.31") long. The stick inserted in the ice cream/water ice bar must protrude at least 30 mm (1.18") above the mould table.

The Hoyer Rollo 20 is supplied with a crane for lifting and removing the mould table

Brine Tank. The double-walled annular tank is welded and insulated. It is made from stainless steel except for the bottom of the inner tank and the evaporator which are made from milled steel.

Two rails are placed on the outside of the brinc tank for mounting the stick dispenser, the cleaning equipment, the filling equipment, etc.

The brine tank is divided into a freezing zone with cold brine and a defrosting zone with warm brine.

Cooling System. The primary cooling system consists of evaporating coils placed at the bottom of the brine tank. Ammonia is used as refrigerant

The secondary cooling system is a cold brine bath and the cold brine is circulated by a centrifugal pump. The cold brine distribution trough is made of stainless steel.

		7	T	·r-	· · · · · · · · · · · · · · · · · · ·
PRODUCT EXAMPLES				The state of the s	
	One-coloured	Bottomatilled one-coloured ice cream	Two-coloured ice cream vertically divided	Two-coloured ice cream vertically divided *zebra pattern*	Two coloured ice cream concentric
STANDARD EQUIPMENT REQUIRED	*1		1	1	1
OPTIONAL EQUIPMENT REQUIRED		4	5	5+6	5+7
PRODUCT					
	Two-coloured ice cream, horizontally divided	One-coloured water ice	Two-coloured water ice horizontally divided	Three-coloured water rec horizonally divided	Spill ice
STANDARD EQUIPMENT REQUIRED	1				
OPTIONAL EQUIPMENT REQUIRED	8	9	9+9	9+9+9	9+10
PRODUCT EXAMPLES					
	One-coloured water ice, two different colours per radial row	Iwo-coloured water ice vertically divided (twin type)	Pencil filled ice eream	Chocolate coated bars	- Diy coated receream
STANDARD EQUIPMENT REQUIRED		1	1	1+2	1+2
OPTIONAL EQUIPMENT REQUIRED	11	12	13		15

^{*} The numbers in this table refer to list of optional equipment on previous page.

FAX from Fax no.: +27 21 555 0467

To : Parmalat Ice cream

Attn. : Mr Dannie Schoeman

Brent Claassen

Fax no. : 551 6325/933 6689

From : Sam Greenaway

Ref. No : 2041sg

Date : 2000-06-14

No. pages : 5 (incl. this one)

Subject : "Filur" and a new mould table quotation - Revised

Dear Dannie,

We have considered the complete order and the previously related price for the Filur of 1998/9 and have revised the situation. On initial quotation of the filur product it was not establish if a new modified chocolate tank and other modification were necessary on the rolo 20. However with assistance from the Engineering department the price has been reduce in order for us to meet with your needs.

I hope that the quotation meets with your requirements and we look forward to the order. Please note the 12 weeks delivery time (ex Works.)

Estimated Exchange rate : DKK 0,95 = R 1,00 (Were any Fluctuation will be for your account)

Estimated Total Shipping Costs : R30 000(To be confirmed & charged at cost)

(Shipping, Cleaning, Duty, VAT and any other costs are all excluded)

Convenience Food Systems Terms; 50%, 50%.

Convenience Food Systems (Pty) Ltd.

P.O. Box 60962, Flamingo Square 7441, Cape Town, South Africa. Visiting address: Unit N5, Centurion Business Park, Bosmansdam Rd, Milnerton. Tel. +27 21 555 0420\21, Fax +27 21 555 0467, http://www.cfs.com

LEOW : CONNENIENCE LOOD SAZIEWS BHONE NO': 05/2220450 10" IT S000 05:216W BT

quotation, we tak New Stick Pro (Serial no. Z3) 1. 1 Mould Table Consisting of:		011323-3
With reference to Delivery" No. Q1 quotation, we tak New Stick Pro (Serial no. Z3) 1. 1 Mould Table Consisting of:		
With reference to Delivery" No. Q1 quotation, we tak New Stick Pro (Serial no. Z3) 1. 1 Mould Table Consisting of:		Dat 14-Jun-0
Delivery" No. Q1 quotation, we tak New Stick Pro (Serial no. Z3) 1. 1 Mould Table Consisting of:		DKI
Consisting of:	T 0102 GB2, which form an integral part of this see pleasure in offering you as follows: oduct on the existing Rollo 20, 612,1411):	
	DKK 247,400	
	Production Equipment DKK 25,000	
Total Price, Iten	m 1	27

improved.

Tetra Pak Hoyer A/S
Soeren Nymarks Vel 13, DK-8270 Hoejblerg, Denmark
Telephone + 45 89 39 39 39, Telex 6 87 70 alhoy dk, Telefax + 45 86 29 22 00, Telegrams frigohoy aarhus
Bankers: Den Denske Bank A/S, Aarhus Branch, Reg. No 3827, Account No 3258-13389-7
Export VAT No 29348359, Central Business Register and Import VAT No 41852110 e-mail: hoyer@noyer.dk, wcb-site: www.tetrapakhoyer.com

PHONE NO: : 0215550420

Equipment for Production of "Filur" Product:

The functionality of this Hoyer equipment has recently been upgraded and

LEGM : CONCENTENCE LOOD SASTEMS

2.

* A: Tetra Pak Hoyer

Quotation

Dun Robin Products (Pty) Ltd.

4-Jun-00

Item Qty DKK

Delivery:

Approx. 12 working weeks after receipt of order and approved/signed product drawing.

The above mentioned time of delivery is to be reckoned from the date all relevant technical information/samples necessary for production of the machine have been received and samples must be sent to Hoyer for comments.

In addition, the time of delivery depends on the down payment being paid according to agreed terms of payment.

Payment:

30% of the contractual amount to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus Branch, Denmark, not later than 2 weeks after order.

70 % of the total amount to be paid before delivery.

We hope our quotation is in accordance with your wishes and look forward to receiving your order. Should you have any further questions we are of course at your disposal with further information.

Yours faithfully,

Tetra Pak Hoyer A/S

Chris Olsen

- 3

Dun Robin Products (Pty) Ltd.

14-Jun-00

Dun Robin Products (Pty) Ltd.			14-Jun-00
Item	Qty		DKK
		The equipment consists among other things of:	
		- Various modification on the Rollo to make room for this equipment	
		- 1 New pump	
		- 1 Set of Nozzles - 1 Frame	
		- 1 Vessel for the water paint, which is a mix of water and colouring.	
		- 1 Mask	
		- Various electrical components	
		For the principle of this spraying equipment please look at the enclosed engineering drawings no. 128,24223 and 128,24164.	
		Please note:	
		- The accuracy and sharpness of the motive sprayed onto the stick product	
		varies according to the production speed of the Rollo and the spray media.	
		- The price of this spraying equipment is conditioned by placement of an order on the above-mentioned mould table (Item 1).	
		Total Price, Item 2	132,
		Grand Total Price, Item 1 & 2	<u>405.</u>
		The Price:	
	i	is to be understood F.C.A. (free carrier) Aarhus, Denmark, incl. packing for the transport in question, excl. installation.	
	ı	"INCOTERMS 1990" apply,	
		investibility apply,	
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		<u>l</u>	
		· •	
	ĺ		
	}		

PHONE NO. : 0215550420



With reference to the Extrusion line as per our meeting on the 12/06/00

I can confirm as follows;

- 4 weeks are estimated for Installation & commissioning.
- @ Euro 4500 per week, ex flight, Accom.
- Estimated CIF Cape Town Euro 12700, Ex local cleaning, Agent fees and Local Transportation.

Should you have any further questions please feel free to contact me.

King Regards

Sam Greenaway.

Page 2 of fax d.d.

EKOW : COMNÉMIENCE LOOD SASIEWS BHONÉ NO: : 05122220450 19 5000 05:216W 65

FAX from Fax no.: +27 21 555 0467

To

: Parmalat

Attn.

: Dannie Schoeman

Brent Claassen

Fax no.

: 021 551 6325, 933 6689

From

: Sam Greenaway

Ref. No

: 2036sg

Date

2000-06-08

No. pages

. 5

(incl. this one)

Subject

: Filur product

Dear Brent/Dannie,

I thank you for your valued enquiry and take pleasure in quoting the following for your kind attention. Please note that the prices are in DKK and any variation in the exchange rate will be for your account.

This quotation is also subject to CFS standard terms and conditions should you place any order via CFS SA.

Please feel free to contact me should you have any further questions.

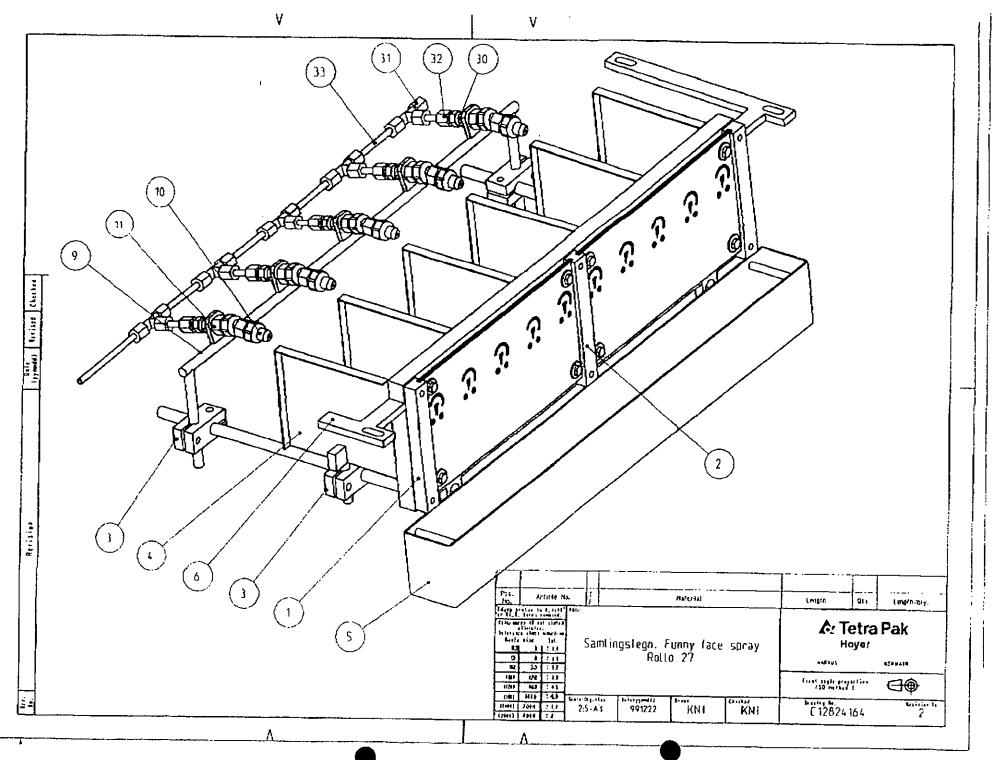
Kind Regards

Sam.

Convenience Food Systems (Pty) Ltd.

P.O. Box 60962, Flamingo Square 7441, Cape Town, South Africa. Visiting address: Unit N5, Centurion Business Park, Bosmansdam Rd, Milnerton. Tel. +27 21 555 0420\21, Fax +27 21 555 0467, http://www.cfs.com

EROM : CONVENTENCE FOOD SYSTEMS PHONE NO. : 0215550420 Jun. 08 2000 02:58PM P1

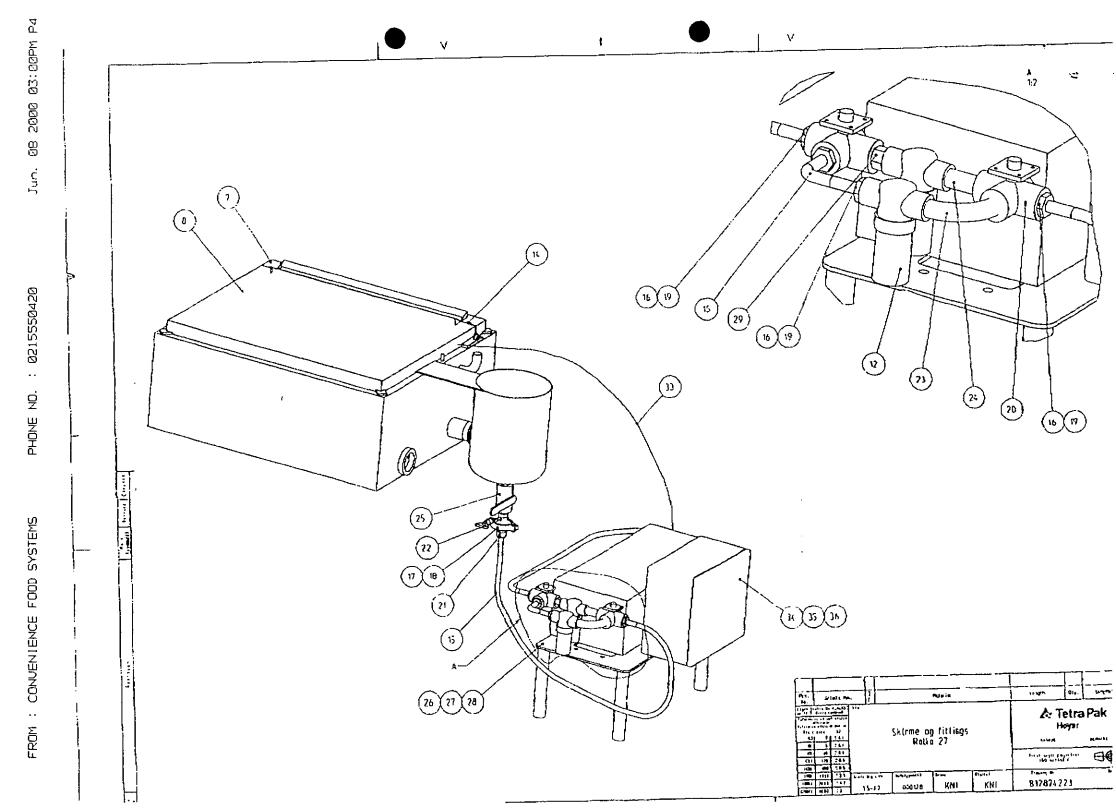


FROM : CONVENIENCE FOOD SYSTEMS 68/08 00 13:15 25:8292200

PHONE NO. : 02155

: 0215550420 LF HOYER DK

Jun. 08 2888 83:88PM P5 @nns:nns



Dun Rol	Dun Robin Products (Pty) Ltd.	
Qty		DKK
	The Price:	
	is an estimated price to be understood F.C.A. (free carrier) Aarhus, Denmark, incl. packing for the transport in question.	
	"INCOTERMS 1990" apply.	
	Delivery:	-
	Approx. 12 working weeks after receipt of order and approved/signed product drawing.	
	The above mentioned time of delivery is to be reckoned from the date all relevant technical information/samples necessary for production of the machine have been received and samples must be sent to Hoyer for comments.	
	In addition, the time of delivery depends on the down payment being paid according to agreed terms of payment.	
	Payment:	
	30% of the contractual amount to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus Branch, Denmark, not later than 2 weeks after order.	
	70 % of the total amount to be paid before delivery.	
	* * * * * * * * * * * * * * * * * * * *	
	We hope our Estimate is in accordance with your wishes and should be pleased to work out a firm quotation which meets your specific requirements. Looking forward to hearing from you.	
	Yours faithfully, Tetra Pak Hoyer	
	File	

A011323-1

Dun Robin Products (Pty) Ltd. 40 Industrial Ring Rd Parow 7490 P.O. Box 1021 Parow 7550 SOUTH AFRICA

Your ref.:

Our ref.: CHO/DOK Date: 08-Jun-00

CHO/DOK		08-Jun-00	
Qty		DKK	
	With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 0102 GB2, we are pleased to quote an estimated price as follows:		
	New Stick Product on the existing Rollo 20, (Serial no. Z312,1411):		
	Equipment for production of Filur product:		
	The functionality of this Hoyer equipment has just been upgraded and improved. Therefore, it has not yet been released for selling and I can only send you an estimate.		
	The equipment consists among other things of: - I New dipping vessel on the Rollo - Various modifications on the Rollo to make room for this equipment. - I New pump - I Set of Nozzles		
	- 1 Frame - 1 Vessel for the water paint, which is a mix of water and colouring 1 Mask - Various electrical components		
	For the principle of this spraying equipment please look at the enclosed engineering drawings no. 128,24223 and 128,24164.		
	Estimated Price	362,00	
		1	

Tetra Pak Hover A/S
Soeran Nymarks Vej 13, DK-8270 Hoejbjerg, Denmark
Telephone + 45 89 39 39 39, Telex 6 87 70 alhoy dk, Telefax + 45 86 29 22 00, Telegrams frigohoy aarhus
Bankers: Den Danske Bank A/S, Aarhus Branch, Reg. No 3627, Account No 3258-13389-7
Export VAT No 29348359, Central Business Register and Import VAT No 41852119
e-mall; hoyer@hoyer.dk, web-site; www.tetrapaknoyer.com



FAX

from Fax no.: +27 21 555 0467

To

: Parmalat

Attn.

Brent Claassen

Fax no.

933 6688

From

Sam Greenaway

Ref no

99026sq

Date

02\03\99

No. pages Subject

: External cooling system.

Dear Brent.

I thank you for your valued inquiry and take pleasure in quoting the following for your kind attention. Due to the fact that the coils are not working sufficiently we would like to propose the follow two options:

- 1. Replace that set of coils or
- 2. Use an external cooling device that will make maintenance and fault finding much simpler. (See attached drawing.)

Option 1.

1pc Coil for NH3-system Unit Price; Dkk 116 100

Option 2

One complete external plate heat exchanger include, pipes, valves, coldbrine pumps for coldbrine circulation between the Rollo and the cooling plate exchanger. The connection to the Rollo will be were the existing pumps are installed. It is recommended that the old coils are removed if the above system is used.

External cooling system Price

Dkk 135 000

(incl. this one)

These prices excl. Installation, VAT, shipping costs and any parts required for connection to your ammonia system. The Dkk price is valid for 30 days only.

Do not hesitate to contact me should you have any further questions.

Kind regards Sam Greenaway

Convenience Food Systems (PTY) LTD

P. O.Box 60962, Flamingo Square 7441, Cape Town, South Africa. Unit N5, Centurion Business Park, Bosmansdam Rd, Milnerton, Cape Town, South Africa. Telephone +27 21 555 0420\21, Fax +27 21 555 0467.

Email: foodsam@iafrica.com

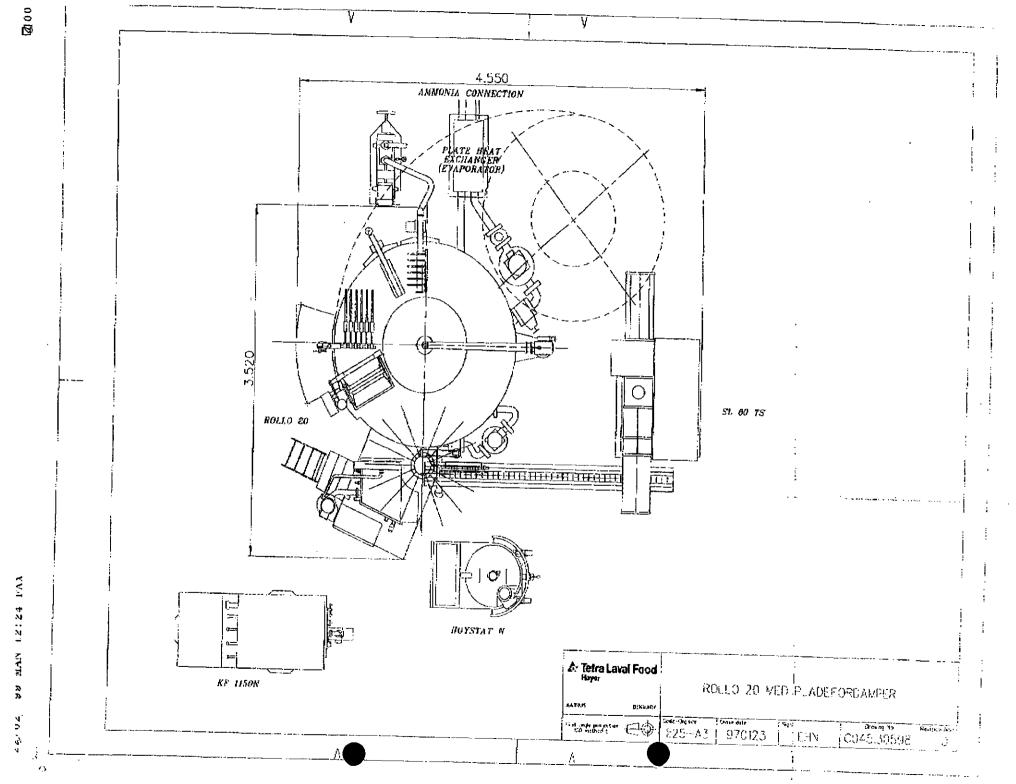
FROM : CONVENTENCE FOOD SYSTEMS PHONE NO.: Ø21 5576316 Mar. 02 1999 04:43PM P1



Quality Assurance Department

The following image quality is poor due to original page quality

<u>www.cleardata.co.uk</u> tel: 01670 356 734 fax: 01670 356 439



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CONVENTENCE

FOOD

ADJUSTMENT OF CROSS SEALING JAWS / KNIVES

Index

1. Components		
2. Adjustment of cross sealing and cutting		
A. Adjustment of cross sealing		
B. Insertion of knife set		
C. Adjustment of sharp knife		
D. Cutting test	and the second s	
E. Corrections, if required		

. 1 *-*

1. Components

- 1. Top knife shaft
- 2. Bottom knife shaft
- 3. Top sealing jaw
- 4. Bottom sealing jaw
- 5. 2 pcs. of compression springs
- 6. Centre guide for top sealing jaw.
- 7. Adjusting screw for sealing pressure.
- 8. 3 pcs. of locking screws for the same.

- 9. Knife counter part.
- 10. Knife
- 11. Locking screws for knife counter part.
- 12. Locking screws for knife.
- 13. 3 pcs. of eccentric bolts for adjustment of knife.
- 14. Lock-nut for eccentric bolt.

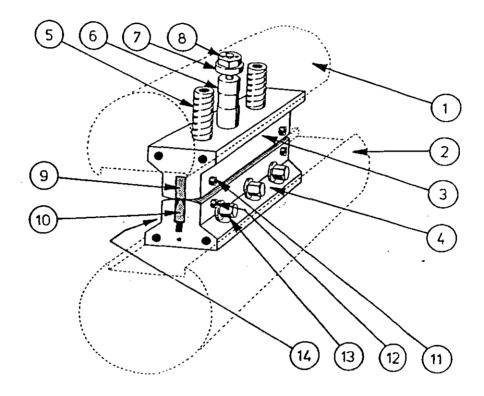


Fig. 1.

2. Adjustment of cross sealing and cutting

Note!

Before adjustment, switch off the main supply to the machine, press emergency stop, if necessary.

Note!

Adjusting the knives should be made at correct operating temperature (sealing temperature).

Procedure for adjustment:

- A Adjust cross sealing
- B Insert anvil/knife
- C Adjust knife
- D Cutting test
- E Correct, if required.

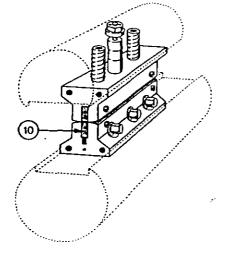
A. Adjustment of cross sealing

Adjust the cross sealing on the springloaded top sealing jaw by tightening/loosening the adjusting screw, pos. 7.

Procedure:

- Take out the knife, pos. 10.
- Loosen the locking screws, pos. 8.

- Place the sealing jaws so as to make them step on the sealing surface.
- Loosen the adjusting screw, pos. 7, by the use of tools, if necessary, until it is completely loose.
- Tighten the adjusting screw, pos. 7, with your fingers as tightly as possible.
- Then tighten the locking screws, pos. 8.



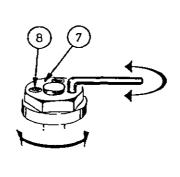




Fig. 2.
B. Insertion of knife set

Set the knife shaft in horizontal position, as shown on the sketch.

Inserting anvil, pos. 9.

- Make sure that the sealing jaw track for the anvil is clean.
- Place the anvil, pos. 9, in the track and check that it bottoms completely.
- Tighten the locking screws, pos. 11.

- Loosen the lock-nuts, pos. 14, and set the eccentric bolts, pos. 13, in bottom position (mark on bolt is to turn towards the knife shaft, see sketch).
- Place the sharp knife, pos. 10, in the track of the lower sealing jaw.
- Tighten the locking screw <u>loosely</u>, pos.
 12, so as to make the knife contact the sealing jaw.

Inserting sharp knife, pos. 10.

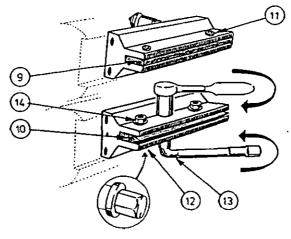


Fig. 3.

C. Adjustment of sharp knife

Adjusting position:

- Turn the knive shafts by means of the handwheel until the knives are in cutting position (anvil in vertical postion above knife, see sketch).

Adjusting height of sharp knife:

- To order to get optimum operational conditions and long lifetime of the knives, it is essential that these are adjusted in such a way that they are touching each other in the middle of the circular movement.
- Lift the sharp knife by turning the middle eccentric bolt, pos. 13, clockwise until the knife is contacting the anvil.

- Tighten the locking screws, pos. 12, while keeping the eccentric bolt tight.
- Place the remaining eccentric bolts in contact with the knife.

Tightening eccentric bolts:

- Set the knives in horizontal position, as shown.
- Tighten the lock-nuts, pos. 14, with a box wrench while counterholding the eccentric bolts, pos. 13, with a face wrench.

IMPORTANT!

- It is important that the eccentric bolt is in contact with the knife while countertightening.
- Retighten strongly!

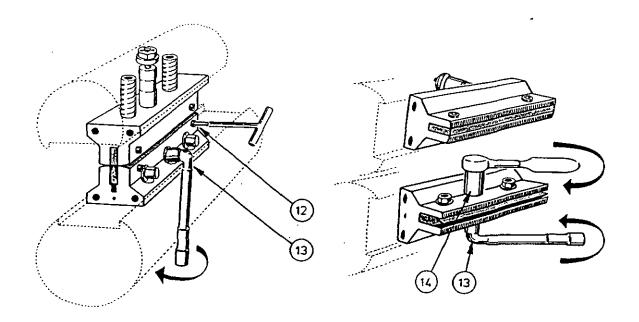


Fig. 4.

D. Cutting test

- The knives are now ready for test of cutting function.
- Place a piece of folded wrapping material between these and then turn round the handwheel.

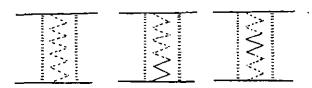


Fig. 5.

E. Corrections, if required

Determination of necessary adjustment:

- The knife is only cutting the wrapping material in the side:
 Raise the knife by means of the eccentric bolt in the side not being cut. (see below).
- The knife is only cutting the wrapping material in the middle: Raise the knife by means of the eccentraic bolt in the middle (see below).
- The knife is not at all cutting over the wrapping material:
 Raise the whole knife by means of all eccentric bolts (see below).

Knife readjustment:

- Place the knives in horizontal position, see sketch.
- Loosen the locking screws, pos. 12.
- Put a wrench on the chosen eccentric bolt, pos. 13, and on the belonging lock-nut, pos. 14.
- Turn the 2 wrenches simultaneously approx. 5° to the right.
- Set the knives in vertical position.
- Tighten the locking screws, pos. 12.
- Carry out cutting test.

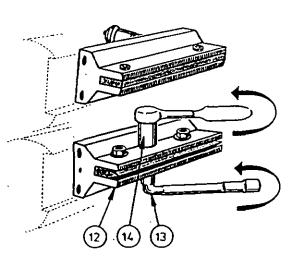
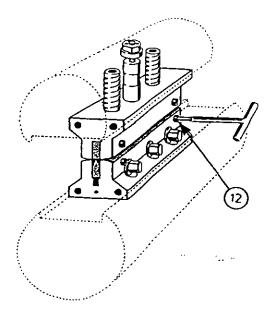


Fig. 6.





Quality Assurance Department

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<u>www.cleardata.co.uk</u> tel: 01670 356 734 fax: 01670 356 439

A∙ Tetra Laval Food

FAX MESSAGE

From Fax No.: + 27 11 974 8153

To:

Dun Robin

Attention

Brent Claasens

Fax No.:

021 933 6688

From

Sam Greenaway

Ref No.:

97171SG

Date:

27th January 1997

No. of pages incl. this: 2 Pages

Dear Brent.

Enclosed please find the drawing for the following hot gas procedure. There are two steps i.e. inlet and outlet.

Weekly defrosting and oil drain,

- 1. Close the liquid value H and the suction value E.
- 2. Open the hotgas magnetic valve 3 oil drain F and G together with PM valve C.

How the liquid is pressed out by the hot gas in to a low pressure separator (customer must install)?

When the Rolo is empty, you close valve C which opens automatically at 4 bar pressure and defrosting and oil drain can be done at the same time.

The modification will be done as follows.

Please also understand that this is only an idea and that we are not sure of the result. If you have any further questions please feel free to contact me.

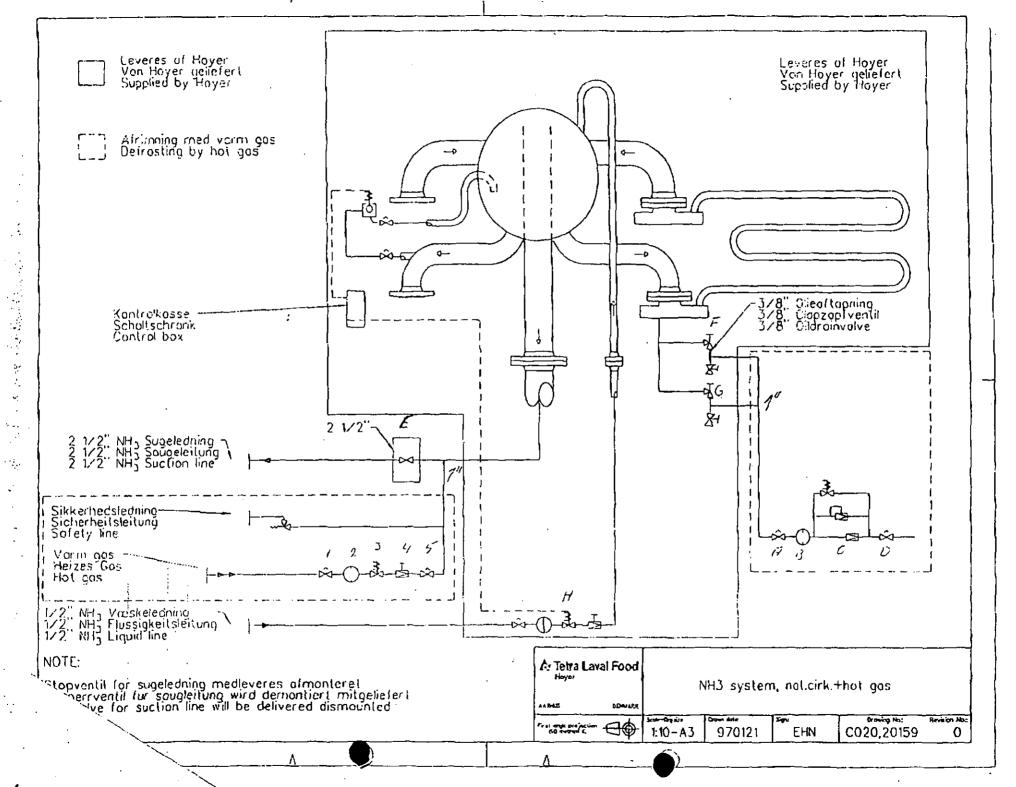
Kinderegards

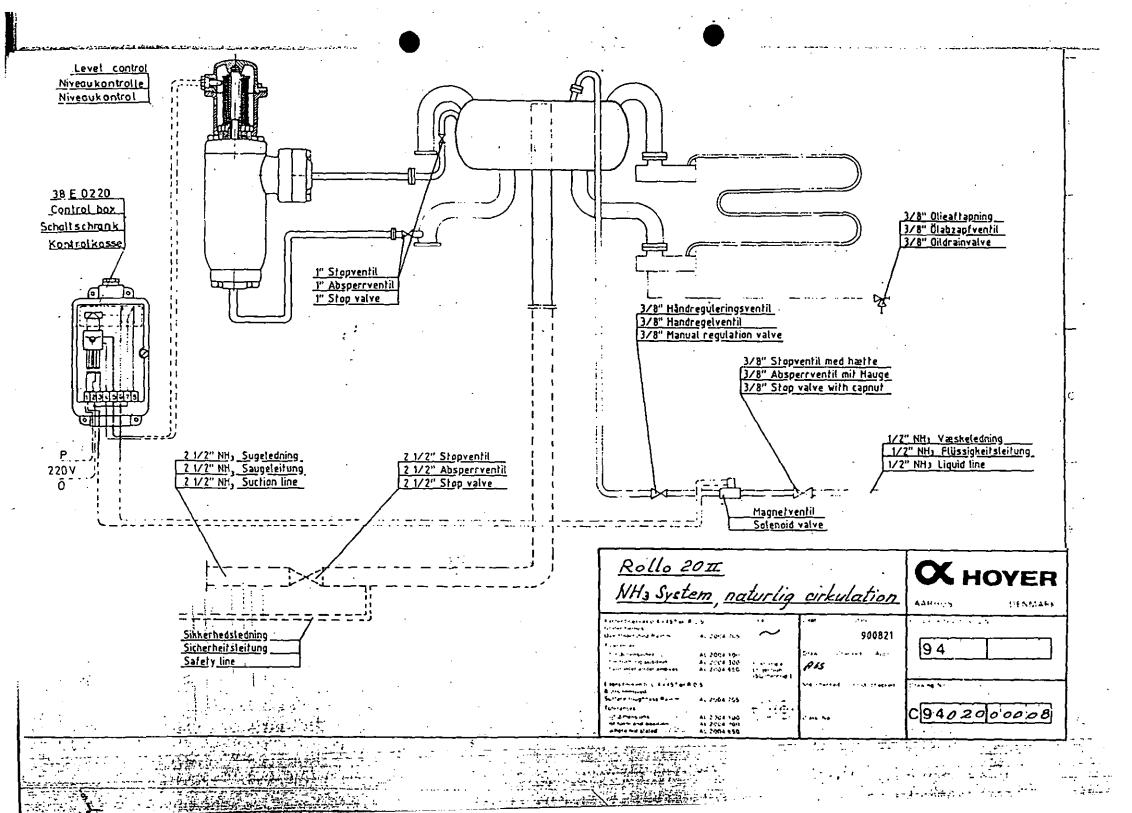
am Greenaway

TETRA LAVAL FOOD

Private Bag X2007, Isando 1600, South Africa 100 Electron Avenue, Isando 1601, Gautene, South Africa Telphone: +27 11 392 4157Telefax: +27 11 974 8153Voicemail: +27 11 392 1616

€0118148110S





↑ Tetra Lava! Food

FAX MESSAGE

From Fax No.: + 27 11 974 8153

To:

Dun Robin

Attention:

Brent Claasens

Fax No.:

021 933 6688

From:

Sam Greenaway

Ref No.:

97171SG

Date:

27th January 1997

No. of pages incl. this: 2 Pages

Dear Brent,

Enclosed please find the drawing for the following hot gas procedure. There are two steps i.e. inlet and outlet.

Weekly defrosting and oil drain.

- 1. Close the liquid value H and the suction value E.
- 2. Open the hotgas magnetic valve 3 oil drain F and G together with PM valve C.

How the liquid is pressed out by the hot gas in to a low pressure separator (customer must install)?

When the Rolo is empty, you close valve C which opens automatically at 4 bar pressure and defrosting and oil drain can be done at the same time.

The modification will be done as follows.

Total price 15 595,78 ex works, which will include 13 valves, pipe and fittings.

Please also understand that this is only an idea and that we are not sure of the result. If you have any further questions please feel free to contact me.

Kind-regards

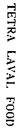
am Greenaway

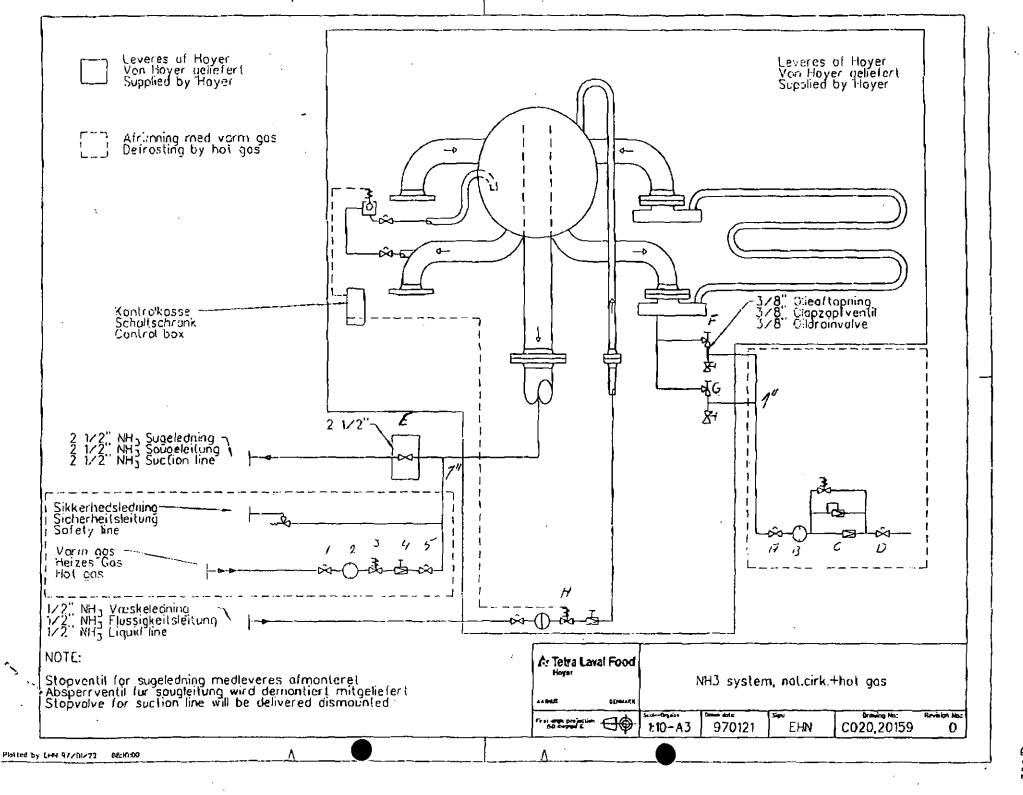
TETRA LAVAL FOOD

Private Bag X2007, Isando 1600, South Africa 100 Electron Avenue, Isando 1601, Gautene, South Africa Telphone: +27 11 392 4157Telefax: +27 11 974 8153Voicemail: +27 11 392 1616

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(a)

Ø 002



Air Treatment and Refrigeration Division

> DUN ROBIN P O BOX 1021 PAROW 7550

Grenco (South Africa) (Pty) Ltd.

Engineering Division

15 Chain Avenue Montague Gardens 7441 Cape Town P.O. Box 36815 Chempet 7442 Republic of South Africa Telephone: (021) 551 - 3950 Telefax: (021) 551 - 4036

Date: 04.09.97

Ref: T1R/ma/12/9/97

Attention: Brent

Our price to install two gauges on your Rollo system will be: R 2 110.00 excluding V.A.T..

This price includes for:

Welder
Assistant
2 x Gauge Valves
2 x Press: ges

Our price cacludes for pumping the unit down which we assume will be done by your i staff.

Should the above be in order, kindly supply our office with an order number.

Assuring you of our best attention at all times.

Yours faithfully

GRENCO S.A. (PTY) LTD

A.LENBOUX MANAGER - UNDUSTRIAL SERVICE DEPARTMENT

DUN ROBIN PRODUCTS



40 Industria Ring Road, Parow 7490 P.O. Box 1021 Parow 7500 TO (021) 933-6670 Fax: (021) 933-6688

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COMPANY:	TO: SAM Greenaway
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FROM: _/3.4	K. Clauseens
COMPANY:	Dan Robin PHONE NO: 011-4336670
FAX NO: 2 2	Post-it FAX PAD 7551

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·RESULT----- G3EOK TRANSMISSION OK

Leitungslängen bei AC

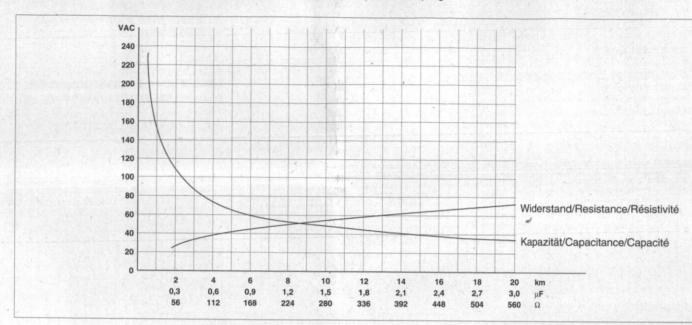
Bei Kabelkapazitäten > 75 nF ist keine sichere Abschaltfunkltion gewährleistet. Beschalten Sie deshalb die NOT-AUS-Taster als Ringleitung.

Cable length AC

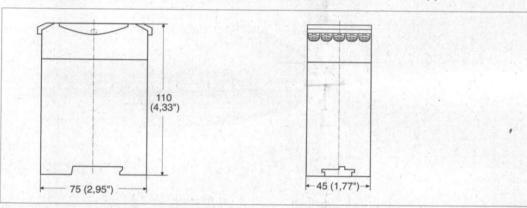
With cable capacitance > 75 nF, deenergisation of the unit is not guaranteed. Please ensure seperation of the Emergency Stop cables to prevent capacitive coupling.

Longueur maxi. câblage AC

Un fonctionnement optimal ne peut être garanti si le câblage a une capacité > 75 nF. Pour cette raison, il est recommandé de câble les AU en boucle



Abmessungen in mm (")/Dimensions in mm (")/Dimensions en mm (")



Pilz GmbH & Co. Pilz Ges.m.b.H. Pilz Belgium Pilz Industrieelektronik AG Pilz Industrieelektronik S.L. Pilz France Electronic Pilz UK Pilz Italia Pilz Nederland Pilz Inc.

Felix-Wankel-Straße 2 Modecenterstraße 14 BC Building, Industriezone III, Industriela Gewerbepark, Postfach 6 Edificio Tilma, Avda. Sant Julià 1 BP 12 Willow House, Medlicott Close Via Castelletto 58 Postbus 186

24850 Drake Road, Farmington Hills

D-73760 Ostfildern A-1030 Wien an 3 B-9320 Erembodeger CH-5506 Mägenwil E-08400 Granollers F-67037 Strasbourg Cedex GB-Corby, Northants NN18 9NF © 0 15 36/46 07 66 I-20030 Palazzolo M. (Mi) NL-4130 ED Vianen USA-Michigan 48335

© 07 11/34 09-0 Fax 07 11/34 09-1 33 © 02 22/7 98 62 63-0 Fax 02 22/7 98 62 64 © 0 53/83 66 70 Fax 0 53/83 89 58 © 0 62/8 89 79 30 Fax 0 62/8 89 79 40 © 93/8 49 74 33 Fax 93/8 49 75 44 © 88 10 40 00 Fax 88 10 80 00 Fax 0 15 36/46 08 66 © 02/99 04 21 85 Fax 02/99 04 30 15 © 03 47/32 04 77 Fax 03 47/32 04 85 © 8 10/4 73-11 33 Fax 8 10/4 73-39 97

Nr. 18 484

Betriebsanleitung

Notice d'utilisation

Operating Instructions

Unfallverhütung vertraut sind.

Schutzmaßnahmen

Gewährleistung.

nen führen

/ Sicherheitsbestimmungen

 Das Gerät darf nur von Personen installiert und in Betrieb genommen werden, die mit

dieser Betriebsanleitung und den gelten-

Beachten Sie die VDE- sowie die örtlichen

trieb mechanische Erschütterungen, die größer als 5g/33 Hz sind (VDE 0160/5.88).

Durch Öffnen des Gehäuses oder eigen-

mächtige Umbauten erlischt jegliche

· Montieren Sie das Gerät in einen Schalt-

schrank; Staub und Feuchtigkeit können sonst zu Beeinträchtigungen der Funktio-

· Sorgen Sie an allen Ausgangskontakten bei kapazitiven und induktiven Lasten für eine

ausreichende Schutzbeschaltung.

Bestimmungsgemäße Verwen-

Das Sicherheitsschaltgerät PNOZ 5 bzw.

PNOZ 5.1 ist bestimmt für den Einsatz in

Sicherheitsstromkreisen nach VDE 0113

Das Gerät ist nicht für die Absicherung von

berührungslosen Verdeckungen geeignet, da

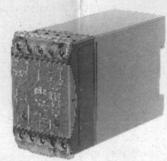
bei beweglichen Verdeckungen)

kein dynamischer Start möglich ist.

Teil 1 (06.93) und EN 60204-1: 1992 (z. B.

Vorschriften, insbesondere hinsichtlich

den Vorschriften über Arbeitssicherheit und



/!\ Safety Regulations

- . The unit may only be installed and operated by personnel who are familiar with both these instructions and the current regulations for safety at work and accident prevention. Follow CEN and local regulations especially as regards
- preventative measures. Avoid mechanical vibrations greater than 5 · Vermeiden Sie beim Transport und im Beg/33 Hz both when transporting and in
 - operation (VDE 0160/5.88). · Any guarantee is void following opening of the housing or unauthorised modifications.
 - . The unit should be panel mounted. otherwise dampness or dust could lead to function impairment.
 - · Adequate fuse protection must be provided on all output contacts with capacitive and inductive loads.

Authorised Applications

The Safety Relay PNOZ 5/5.1 is for use in:

- BG Fachausschuß Elektrotechnik
- SA Schweden

Geräteklassifikation:

TÜV Rheinland

Gerätebeschreibung

NOT-AUS-Einrichtungen

Das Sicherheitsschaltgerät PNOZ 5 bzw. PNOZ 5.1 ist in einem P-75-Gehäuse untergebracht. Es stehen elf Varianten für den Betrieb mit Wechselspannung (nur PNOZ 5) und eine Variante für den Betrieb mit Gleichspannung zur Verfügung. PNOZ 5 und PNOZ 5.1 unterscheiden sich in der Startleistung. PNOZ 5.1 ist für den Start mit kleinen Strömen z. B. durch einen Lichtschrankenausgang (Open Collector)

ausgelegt. Merkmale:

- Relaisausgänge: zwei Sicherheitskontakte (Schließer), zwangsgeführt
- Anschlußmöglichkeit für NOT-AUS-Taster Rückführkreis zur Überwachung externer
- Schütze Das Schaltgerät erfüllt folgende Sicherheits-

anforderungen:

· Schaltung ist redundant mit Selbstüberwachung aufgebaut.

PNOZ 5 **PNOZ 5.1**

/!\ Conseils préliminaires

- La mise en oeuvre de l'appareil doit être effectuée par une personne spécialisée en installations électriques, en tenant compte des prescriptions des différentes normes applicables (NF, EN, VDE..), notamment au niveau des risques encourus en cas de défaillance de l'équipement électrique.
- · Evitez lors du transport et de l'utilisation des chocs supérieurs à 5g/33Hz. (VDE 0160/5.88).
- · L'ouverture du boîtier annule automatiquement la clause de garantie.
- · Installez le relais dans une armoire électrique à l'abri de la poussière et de l'humidité.
- · Assurez-vous du pouvoir de coupure des contacts de sortie en cas de charges inductives ou capacitives

Domaine d'utilisation

Emergency Stop installations.

· Safety Circuits according to EN 60204-1 1992 (e.g. with movable guards). The unit is not suitable for use with non-

contact guards, as a dynamic start is not possible. Approvals:

- TÜV Rheinland
- · BG Fachausschuß Elektrotechnik
- · SUVA
- · SA Sweden

Description The Safety Relay PNOZ 5/5.1 is enclosed in a P-75 housing. There are eleven versions available for AC operation (PNOZ 5 only) and one for DC operation.

The difference between PNOZ 5 and PNOZ 5.1 is the start-up power. PNOZ 5.1 is designed for start-up with low currents e.g. via a light curtain output (Open Collector).

Features:

- · Relay outputs: two safety contacts (N/O), positive-guided.
- · Connections for Emergency Stop Button.

The relay complies with the following safety

. Feedback Control Loop for monitoring of external contactors/relays.

requirements:

· The circuit is redundant with built-in selfmonitoring

Le bloc logique PNOZ 5 (PNOZ 5.1) est spécialement conçu pour :

· les circuits d'arrêt d'urgence

· les circuits de sécurité d'après la norme EN 60204/1: 1992 (par ex. protecteur) L'appareil n'est pas adapté à la surveillance

de barrières immatérielles car une validation dynamique n'est pas possible. Homologations

• I.N.R.S. (logique interne)

 TÜV Rheinland BG Fachausschuß Elektrotechnik

· SUVA SA Schweden

Description de l'appareil

Inséré dans un boîtier P-75, le bloc logique PNOZ 5 (PNOZ 5.1) est disponible en 11 variantes pour les tensions alternatives (unig. PNOZ 5) et une variante pour les tensions continues (24 VDC). Le PNOZ 5.1 est une version dérivée du

PNOZ 5. Son courant d'appel réduit permet une commande directe par des détecteurs de proximité à sortie statique (Open Collector).

Autres caractéristiques :

- · contacts de sortie : 2 contacts à fermeture de sécurité, contacts liés
- · raccordement pour poussoir AU ou capteur · boucle de retour pour l'auto-contrôle des

contacteurs externes Le bloc logique PNOZ 5 (PNOZ 5.1) répond aux exigences suivantes:

· conception redondante avec autosurveillance

- · Sicherheitseinrichtung bleibt auch bei Ausfall eines Bauteils wirksam.
- Bei jedem Ein-Aus-Zyklus der Maschine wird automatisch überprüft, ob die Relais der Sicherheitseinrichtung richtig öffnen und
- AC: Schaltgeräte sind mit kurzschlußfestem Netztransformator ausgestattet. DC: Schaltgeräte besitzen eine elektronische Sicherung.

Funktionsbeschreibung

Das Schaltgeråt PNOZ 5 bzw. PNOZ 5.1 dient dem sicherheitsgerichteten Unterbrechen eines Sicherheitsstromkreises. Voraussetzung: Anlegen der Betriebsspannung über den NOT-AUS-Taster, Brücke zwischen X1 (Y1)-X2 (Y2) und T33 (S33)-T34 (S34)

- · Eingangskreis geschlossen (z. B. NOT-AUS-Taster nicht betätigt) Relais K1 und K2 gehen in Wirkstellung und halten sich selbst. Die Sicherheitskontakte 13-14/23-24 sind geschlossen
- · Eingangskreis wird geöffnet (z. B. NOT-AUS-Taster betätigt) K1 und K2 fallen in die Ruhestellung zurück, Die Sicherheitskontakte 13-14/ 23-24 werden redundant geöffnet

Function Description

proof transformer

The relay PNOZ 5/5.1 provides a safetyoriented interruption of a safety circuit. Operating voltage to be supplied at the E-Stop Button, X1 (Y1) - X2 (Y2) and T33 (S33) - T34 (S34) to be bridged.

The safety function remains effective in

. The correct opening and closing of the

the case of a component failure

safety function relays is tested

automatically in each on-off cycle.

· AC: Units are fitted with a short-circuit

· DC: Units are fitted with an electronic

- · Input circuit closed (e.g. Emergency Stop Button not activated): Relays K1 and K2 energise and latch. The safety contacts (13-14/23-24) are · Input circuit opened (e.g. Emergency
- Stop Button activated): K1 and K2 de-energise. The safety contacts (13-14/23-24) are opened redundantly.

- · fonction de sécurité garantie même en cas de défaillance d'un composant électronique.
- · test cyclique du relais à chaque mise sous tension de la machine.
- les appareils en AC sont équipés de transformateurs protégés contre les c.c., les appariels en DC disposent d'un fusible électronique.

Description du fonctionnement

Le bloc logique PNOZ 5 (PNOZ 5.) assure de facon sure l'ouverture d'un circuit de sécurité. Préalables : tension d'alimentation présente sur poussoir AU, ponts entre X1 (Y1)-X2 (Y2) et T33 (S33)-T34 (S34)

- circuit d'entrée fermé (par ex. poussoir AU. non actionné) Les relais K1 et K2 passe en position travail et s'auto-maintiennent. Les contacts de sécurité 13-14/23-24 se ferment.
- circuit d'entrée s'ouvre (par ex. poussoir AU actionné) K1 et K2 retombent. Les contacts de sécurité 13-14/23-24 s'ouvrent de façon redondante.

Schematisches Schaltbild/ Connection Diagram/ Schéma de principe

- A: Einschaltlogik, zykllischer Test, Steuerlogik : Operating Logic, Cycle Test,
- Control Logic A: logique d'entrée, test cyclique.
- logique de commande
- 1: Kanal 1/Channel 1/ Canal 1
- 2: Kanal 2/Channel 2/Canal 2

T33 T34 (\$33) (\$34)

Retriebsarten:

- Einkanaliger Betrieb: Eingangsbeschaltung nach VDE 0113 und EN 60204, keine Redundanz im Eingangskreis. Erdschlüsse im Tasterkreis werden erkannt.
- · Automatischer Start: Gerät ist aktiv, sobald der Eingangskreis geschlossen ist.
- Manueller Start: Gerät ist erst dann aktiv, wenn ein Starttaster betätigt wird. Dadurch ist ein automatischer Start des Schaltgeräts nach Spannungsausfall und -wiederkehr ausgeschlossen.
- · Kontaktvervielfachung und -verstärkung durch Anschluß von externen Schützen. u.v.a.

Montage

Das Sicherheitsschaltgerät muß in einen Schaltschrank eingebaut werden. Zur Befestigung auf einer Normschiene hat das Gerät ein Rastelement auf der Rückseite.

Inbetriebnahme

Beachten Sie bei der Inbetriebnahme: · Vor die Ausgangskontakte eine Sicherung (6 A flink oder träge) schalten, um das Verschweißen der Kontakte zu

Operating Modes

- Single-channel operation: Input wiring according to VDE 0113 and EN 60204, no redundancy in the input circuit. Earth faults are detected in the emergency stop circuit.
- Automatic reset: Unit is active, as soon as the input circuit is closed.
- · Manual reset: Unit is only active, when a reset button has been pressed. Automatic reset following a loss/return of supply voltage is thereby prevented.
- · Increase in the number of available contacts by connection of external contactors/relays.

Installation

The safety relay must be panel mounted. There is a notch on the rear of the unit for DIN-Rail attachment.

Operation

Please note for operation:

. To prevent a welding together of the contacts, a fuse (6 A quick/slow acting) must be connected before the output contacts.

Mode de fonctionnements :

- · commande par 1 canal : conforme aux prescriptions de la norme EN 60204, pas de redondance dans le circuit d'entrée.La mise à la terre du circuit d'entrée est détectée.
- Réarmement automatique : le relais est activé dès la fermeture du circuit d'entrée.
- Réarmement manuel : le relais n'est activé qu'après une impulsion sur le poussoir de réarmement. Un réarmement automatique du relais après une coupure d'alimentation est ainsi impossible
- Augmentation du nombre de contacts ou du pouvoir de coupure par l'utilisation de contacteurs externes

etc...

Montage

Le relais doit être monté dans l'armoire électrique. Sa face arrière permet un montage rapide sur rail DIN.

Mise en oeuvre

Remarques préléminaires :

· protection des contacts de sortie par des fusibles 6A rapides ou normaux pour éviter leur soudage.

Max. Leitungslängen: DC: 3,5 km Voraussetzungen: 2 x 1.5 mm² Leiterquerschnitt: 150 nF/km Kapazität: 28 Ohm/km Widerstand +25 °C Temperatur: Leitungswiderstand: DC: 100 Ohm Leitungslängen bei AC s. "Technische

- Keine kleinen Ströme (z. B. 12 mA) mit Kontakten schalten, über die zuvor große Ströme geführt wurden.
- Angaben im Kapitel "Technische Daten" unbedingt einhalten.

Ablauf:

Eingangskreis

- Betriebsspannung über NOT-AUS-Taster an Klemmen A1 (+) und A2 (-) anlegen. NOT-AUS-Taster zwischen Klemme A1
- (L+) des PNOZ und die Plusklemme (L+) der Betriebsspannung anschließen. Geerdete Seite der Betriebsspannung mit A2 (L-) verbinden. Rückführkreis schließen
- Brücke an X1 (Y1)-X2 (Y2) oder externe Schütze anschließen
- Aktivierungskreis schließen
- Automatischer Start: T33 (S33)-T34 (S34) brücken.
- Manueller Start: Taster an T33 (S33)-T34 (\$34) anschließen (keine Brücke zw. T33 (S33)-T34 (S34). Die Sicherheitskontakte sind geschlossen.

Das Gerät ist betriebsbereit. Wird der Eingangskreis geöffnet (NOT-AUS-Taster betätigt), öffnen die Sicherheitskontakte 13-14/23-24.

Wieder aktivieren • Eingangskreis schließen

7

tung; manueller Start/

wiring; manual reset/

réarmement manuel

 Bei manuellem Start zusätzlich Taster zwischen T33(S33) und T34 (S34) betätigen

(S33) (Y1)

T33

T34

Eingangskreis einkanalig: NOT-AUS-Beschal-

Single channel input circuit: Emergency Stop

Commande par 1 canal : circuit AU, avec

(S34) (Y2)

Max. cable length DC: 3.5 km 2 x 1.5 mm² Capacitance: 150 nF/km 28 Ohm/km Resistance: Temperature: + 25 °C DC: 100 Ohm Cable resistance: Cable length for AC units - see "Technical . Low currents (e.g. 12 mA) should not be

circuit d'entrée

Préalables

capacité :

résistivité

température :

Mise en oeuvre :

résistivité max.

"caract, techniques"

longueur maxi câblage:

Longueur maxi câblage pour AC voir

Ne pas commuter de faibles intensités

(ex. 12 mA) par des contacts avant au

Respectez les données indiquées dans les

Amener la tension d'alimentation à travers.

potentiel (-) de la tension d'alimentation.

pont entre X1 (Y1)-X2 (Y2)ou câblage des

réarmement automatique : pontage des

poussoir sur T33 (S33)-T34 (S34) (pas

Si le circuit d'entrée est ouvert (AU actionné),

en cas de réamement manuel, appuyer sur

caractéristiques techniques.

Fermer la boucle de retour :

Fermer le circuit de réarmement :

bornes T33 (\$33)-T34 (\$34).

Les contacts de sécurité sont fermés.

le poussoir T33(S33) - T34 (S34).

les contacts 13-14/23-24 s'ouvrent.

réarmement manuel : câblage d'ur

contacts externes

depontage).

Remise en route :

· fermer le circuit d'entrée

préalable commutés des intensités plus

- switched across contacts across which high currents have previously been switched
- Important details in the section "Technical Data* should be noted and adhered to.

To operate:

Input Circuit:

- Supply operating voltage to terminals A1 (+) and A2 (-) via E-Stop Button. Connect the E-Stop Button between
- le poussoir AU sur les bornes A1 (+) et terminal A1 (L+) of the PNOZ and the A2 (-): positive terminal (L+) of the operating câblez le contact du poussoir AU entre les bornes A1 (L+) du PNOZ et le potentiel (L+) Connect terminal A2 (L-) with the earthed de la tension d'alimentation. side of the operating voltage. Relier la borne A2 (L-) du PNOZ au
- Close the feedback control loop Bridge X1 (Y1) - X2 (Y2) or connect external contactors/relays.
- · Close the activation circuit. - Automatic reset: Bridge T33 (S33) -T34 (S34)
- Manual reset: Connect button on T33 (S33) - T34 (S34) (no bridge on T33 (S33) - T34 (S34)).

The safety contacts are closed. The unit is ready for operation. If the input circuit is opened (E-Stop activated), the safety contacts 13-14/23-24

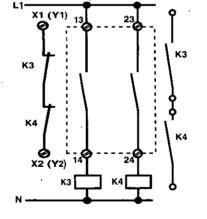
Reactivation

- . Close the input circuit.
- With manual reset, the button between T33 (S33) - T34 (S34) must also be pressed.

Verstärkung (Vervielfältigung) der Kontakte durch externe Schütze; einkanalig/ Increase in the number of available contacts by connection of external contactors/relays; single channel/

X2 (Y2)

Multiplication des contacts à l'aide de contacteurs externes; commande par 1 canal



Verstärkung (Vervielfältigung) der Kontakte durch externe Schütze: zweikanalig/ Increase in the number of available contacts by connection of external contactors/relays; two channel/ Multiplication des contacts à l'aide de contacteurs externes; com. par 2 canaux

DC: 3,5 km

2 x 1,5 mm²

150 nF/km

28 Ohm/km

+25 °C

DC: 100 Ohm

 Kurzschluß bei Geräten für Wechselspannung: die Versorgungsspannung bricht zusammen und die Sicherheitskontakte werden geöffnet.

Fehler - Störungen

- · Kurzschluß bei Geräten für Gleichspannung: Eine elektronische Sicherung bewirkt das Öffnen der Ausgangskontakte bei Fehlströmen ≥1,2 A. Nach Wegfall der Störungsursache und bei Einhalten der Betriebsspannung ist das Gerät nach ca. 1 s wieder betriebsbereit.
- · Fehlfunktionen der Kontakte: Bei verschweißten Kontakten ist nach Öffnen des Eingangskreises keine neue Aktivierung möglich.

Faults/Disturbances

operation after 1 s.

. Short circuit with AC units: The supply voltage fails and the safety contacts open.

welded contacts, no further activation is

possible following an opening of the input

- sortie s'ouvrent. Short circuit with DC units: An electronic Court-circuit sur les relais DC :un fusible fuse causes the output contacts to open électronique entraîne l'ouverture des with fault currents ≥ 1.2 A. Once the cause contacts de sortie si l'intensité est sup. à of the disturbance is removed and the rated 1,2 A. L'appareil est à nouveau prêt à voltage is upheld, the unit is ready for fonctionner env. 1 sec. après la disparition Faulty contact functions: In the case of
 - Défaut d'un contact : en cas de collage d'un contact après ouverture du circuit d'entrée, un nouvel réarmement est impossible.

· Court-circuit sur les relais AC : la tension

d'alimentation s'effondre et les contacts de

Erreurs- Défaillances

Technische Daten/Technical Data/Caractéristiques techniques

Betriebsspannung/Operating Voltage/Tension d'alimentation U _B PNOZ 5	AC: 24, 42, 48, 100, 110, 115, 120, 127, 230, 240, 400 V
Betriebsspannung/Operating Voltage/Tension d'alimentation U _B PNOZ 5, PNOZ 5.1	DC: 24 V
Spannungstoleranz/Voltage Tolerance/Plage de la tension d'alimentation U _B	85 110 % PNOZ 5.1 (55 °C): 90 110 %
Frequenzbereich/Frequency Range/Fréquence	AC: 50 60 Hz
Restwelligkeit/Residual Ripple/Ondulation résiduelle U _B	DC: PNOZ 5: 20 %, PNOZ 5.1: 10 %
Leistungsaufnahme bei/Power Consumption/Consommation U ₈	ca./appx./env. 4 VA/2,5 W
Störspannungsunempfindlichkeit/Noise Voltage Indifference/Tenue aux parasites	IEC 801 Klasse/Class/Classe 3
Ausgangskontakte/Output Contacts/Contacts de sortie	2 Sicherheitskontakte (S)/2 Safety Contacts (N/O)/2 F de sécurité
Kontaktmaterial/Contact material/Matériau contact	AgSnO ₂
Einschaltverzögerung/Delay-on Energisation (aut. reset)/Temps de réarmement	PNOZ 5: ca./appx./env./ 330 ms PNOZ 5.1: 400 ms
Anzugsverzögerung/Delay-on Energisation (man. reset) Temps d'appel	≤105 ms
Rückfallverzögerung/Delay-on De-Energisation/Temps de retombée	PNOZ 5: AC: max. 200 ms/ DC: max. 300 ms PNOZ 5.1: 370 ms
Spannung und Strom/Voltage, Current at/Tension et courant T33 (S33), T34 (S34)	24 V DC/50 mA
Schaltvermögen nach/Switching Capability to/Caractéristiques de commutation d'après AC1, DC1	AC: 250 V/0,1 6 A/1500 VA/cos phi = 1 DC: 24 V/0,1 6A/150 W mit Funkenlö- schung/with spark suppression/avec ext. d'arc
Startstrom/Start-up Current/Courant d'appel PNOZ 5.1	ca./appx./env.100mA
Betriebstemperatur/Operating Temperature/Température d'utilisation	-10+55 °C
Lagertemperatur/Storage Temperature/Température de stockage	-40 +85 °C
Klimabeanspruchung/Airgap Creepage/Conditions climatiques	DIN 40040 Classe F
Luft- und Kriechstrecken/Cheminement et claquage	DIN VDE 0110 Teil 2, 4 kV/3
Kontaktabsicherung extern nach/External Contact Fuse Protection/Protection des contacts de sortie DIN VDE 0660 Teil/Part/Partie 200	6 A flink/quick acting/rapides oder/or/ou 4 A träge/slow acting/normaux
Schutzart/Protection/Degré de protection Einbauraum (z.B. Schaltschrank)/Mounting (min.)/Lieu d'installation Gehäuse/Housing/Boîtier Klemmen/Terminals/Bornes	IP 54 IP 40 IP 20
Gehäusematerial/Housing material/Matériau boîtier	Kunststoff/Plastic/Plastique Thermoplast Noryl SE 100
Anschlußklemmen: max. Querschnitt des Außenleiters/Max. cable cross section/Raccordement	Einzelleiter oder mehrdrähtiger Leiter mit Adernendhülsen/Single and multi-core with crimp connector/conducteur unique ou multi-conducteur avec embout: 2 x 1,5 mm²
Abmessungen H x B xT/Dimensions H x D x W/Dimensions H x P x L	75 x 45 x 110 mm
Gewicht/Weight/Poids	AC: 290 g, DC: 230 g

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FAX from Fax no.: +27 11 974 8153

To : Dun Robin

Attn. : Brent Claassens

Fax no. 021 933 6688

Ref no. : 97396SG

Date : 2nd April 1997

No. pages 1 (incl. this one)

Subject : Confirmation of order

: Sam Greenaway

Dear Brent,

From

Thank you for your order. Below please find description and prices.

Part no.	<u>Description</u>	Quantity	<u>Price</u>
5704,9105	Pils safety switch (Relay)	2	R4042,35

All prices are including delivery but excluding VAT.

Kind regards

∕Sam Greenaway

Convenience Food Systems

Private Bag X2007, Isando 1600, South Africa
100 Electron Avenue, Isando 1601, Gauteng, South Africa
Telephone +27 11 392 4157, Fax +27 11 974 8153, Voicemall:+ 27 11 392 1616

Convenience Food Systems Krämer+Grebe > Koppens > Tiromet > TiroPak

FAX

from Fax no.: +27 11 974 8153

To

: Dun Robin

Attn.

: Brent Claassens

Fax no.

: 021 933 6688

From

: Sam Greenaway

Ref no.

: Level control

Dale

: 19\03\97

No. pages

(incl. this one)

Subject

Dear Brent.

Thank you for your valued inquiry. Below please find our quotation for the level control float valve.

Part no.

Description

Quantity

Total Price

5706,1728

level control

1

R 4778.00

All price are including delivery, but excluding vat and valid for 30 day. We hope that the our quotation meets with your requirements and if you have any further questions please feel free to contact me.

Kind regards

Sam Greenaway

Convenience Food Systems

Private Bag X2007, Isando 1600, South Africa 100 Electron Avenue, Isando 1601, Gauteng, South Africa Telephone +27 11 392 4157, Fax +27 11 974 8153, Voicemail:+ 27 11 392 1616

DUN ROBIN PRODUCTS



40 Industria Ring Road, Parow 7490
P.O. Box 1021 Parow 7500
(021) 933-6670 Fax: (021) 933-6688

	1 (021) 933-6670 Fax: (021)	(1) 93	3- <i>6688</i>	
DU!	N ROBIN			
Datu Date	: Order)	3835
	AT NO: 4640143699 :: 94/2549)07			
Be	stelvorm / Purchase Ordei	r: L		
M	TETRA LAVAL FOOD			
	7			
·••••••	HCCOUNT: 0520			
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	BESKRYWING / DESCRIPTION		R	с
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	2× 03720721 @ RIBI,90 EF			
	X 03721384 @ R148410 EA			
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	ar and a character	1		
	GROOTBOEK ALLOKASIE			
2.	8 X 5911 5001 @ K375,50 EA			
	12 X 59115000 @ R 125, 29 EA			
	1 X 03721255 @ R1652,50 EF	h		
-	GROOTBOEK ALLOKASIE	-		
	1 X 03721256 @ R1432,00 EF			<u> </u>
<i>3</i> .	\wedge D $$			+
	1 X 54020431 @K 570,66 EF	-		-
		<u></u>		
	GROOTBOEK ALLOKASIE	_		
	Sub Totaal / Sub Total			

B.T.W. / V.A.T.

KWIK KOPY PRINTING BELLVILLE

Totaal Verskuldig / Total Due

Post-it Fax Pad 7551	Page: / of /
To: Sam Greenaway	From: B.K. Cluassens
CO. TETRA LAVOL	Co. Dun Robin
Dept.	Phone No. 021-9336670
Fax No. 011-9748153	Fax No. 021-4336688

- 3

等計算		
	L DUN ROBIN PI	RODUCTS
E	40 Industria Ring Road P.O. Box 1021 Par	, Parow 7490 ow 7500
DIII	ROBIN (021) 933-6670 Fax: (0	
) i e	ECREAM	
Datu Date:		¹ Nº ∴ 3835
Reg. no.	AT NO: 46401438999 :04/2549/07	
	stelvorm / Purchase Orde	
M	LETRA LAVAL TOOD	
	HCCOUNT 0520	
		BEDRAG / AMOUNT
	BESKRYWING / DESCRIPTION	R c
1.	2X 03721622 @ KTLA, 46 EA	
	2X 03720721 @ KIBI, 90 EF	
	HX 03721384 @ KIA8410 ED	1 1000000
\	2 X 03721385 @ R2120,75 E	<u> </u>
-	GROOTBOEK ALLOKASIE	
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	And the second s	
	GROOTBOEK ALLOKASIE	
	Sub Totaal / Sub Total	
	B.T.W. / VA.T.	
	Totaal Verskuldig / Total Due	THE KOMPONITING BELLING E
a la la		ONK KOPYPRINTING BELLVILLE

·RESULT----- G3EOK TRANSMISSION OK

FAX MESSAGE

From Fax Nc.: + 27 11 974 8153

To:

Dun Robin

Attention:

Brent Claassens

Fax No.:

021 933 6688

From:

Sam Greenaway

Ref No.:

97208SG

Date:

03\02\97

No. of pages incl. this: 1

Dear Brent.

Thank you for your valued inquiry. The following quotation is as requested:

Part no.	Description	Quantity	Unit price	Total price	
037,21622	brake ring	2	R 769,46	R 1538,92 st	
037,20721	brake lining	2	R 161,90	R 323,80 st	
037,21384	brass plated slip ring	4	R 1484,10	R 5936,40 st	٠
037,21385	silver plated slip ring	2	R 2120,75	R 4241,50 st	
5911,5001	silver brush	8	R 375,50	R 3004,00 st	
5911,5000	bronze brush	12	R 125,29	R 1503,48 st	
037,21255	upper knife	1	R 1652,50	R 1652,50 st	_
037,21256	lower knife	1	R 1432,00	R 1432,00 st	/
5402,0431	check valve	1	R 570,66	R 570,66 st	/
5331,9148	pistons	6	R 1770,94	,	
130,20006	spring	6	R 140,70	R 10 625,64 1wk	
032,20089	tension spring	100	R 140,70	R 844,20 2wk R 900.00 st	
Total delivery ti	me: + 2 2 mosts	· · ·	2,00	R 900,00 st	

Total delivery time: +- 2-3 weeks on confirmation of order.

20203,26

All price are ex works and valid for 30 days only.

I hope that the above meets with your requirements and if you have any further questions please feel free to contact me.

Kind regards

<u>کلمېټونه.</u> Sam Greenaway.

TETRA LAVAL FOOD
Private Bag X2007, Isando 1600, South Africa
100 Electron Avenue, Isando 1601, Gauteng, South Africa
Telphone: +27 11 392 4157Telefax: +27 11 974 8153Voicemail: +27 11 392 1616

Facsimile

To: SAM GREENAWAY

TETRA LAVAL

@Fax: 011-9748153

From: BRENT CLAASSENS

DUN ROBIN

Tel: 021-933 6670

Fax: 021-933 6688

Date: 31 JANUARY 1997 Pages: 1, including this

Following our telephone conversation, can you please give me prizes on the following:

HOY WRAP

PART NO.	DESCRIPTION	QTY	
037,21622	Brake ring	(2)	
037,20721	Brake lining	(2)	
037,21384	Brass plated slip ring Q25	(4)	
037,21385	Silver plated slip ring	(2)	
5911,5001	· Silver brush	(8)	
5911,5000	Bronze brush	(12)	
037,21255	Knifes upper	(1)	
037,21256	Knifes Lower	(1)	
ROLLO 20			
5402,0431 Check Valve		. (1)	
5331,9148	Pistons	(6)	
130,20006	Spring	(6)	
032,20089	Tension spring	(100)	

Yours faithfully.

B.K. CLAASSENS SENIOR PRODUCTION TECHNICIAN ·RESULT----- G3EOK TRANSMISSION OK

MAINTENANCE & REPAIR MANUAL

Guidance of products

Synchronization of pocket conveyor and inlet

By means of a flange of hub, Fig. 11 Pos. A, in the pinion for the pocket conveyor, it is possible to synchronize the pocket conveyor and the inlet conveyor.

The pinion unit with flange of hub is situated behind the sheet at the end of the machine under the pocket conveyor.

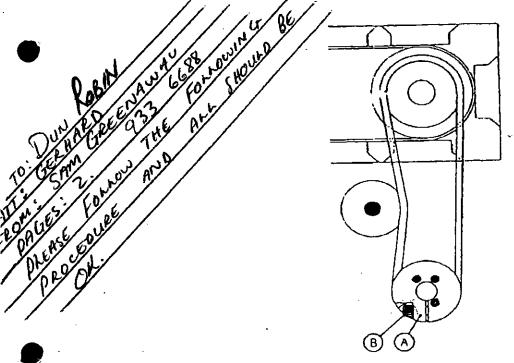


Fig. 11

Procedure:

- Loosen the screw, Fig. 11, Pos. B. Now the connection between the wrapping machine and the pocket conveyor is disconnected.
- Press the JOG-button until one of the register spades is placed in front of the pocket conveyor, Fig. 12, Pos C.
- Pull the pocket conveyor and place a pocket just in front of the register spade as shown, Fig. 12, Pos D.
- Tighten the lock screw, Fig.11, Pos.B. and the connection between the wrapping machine and pocket conveyor is re-established.

417E9408.A09

- 23 -

Tetra Laval Food Hoyer

TELEFAX

ATT .: FRANK MILLIGAN & DERICK PALMER

TO FAX NO: +27 21 93 36 688

COMPANY: DUN ROBIN

FROM: JAN A PEDERSON

FROM FAX NO: +4586 29 2200

DATE: 17/3 1995

REF.:

NO OF PAGES: 4

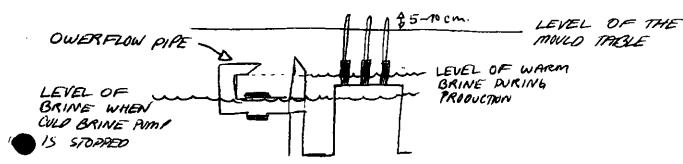
DEAR MR. PALMER

■ PLEASE CHECK THE FOLLOWING, ACCORDING TO YOUR

TROUBLE WITH THE ROLLO 20.

TO ADJUST THE WARM BRINE, IT IS WESSARSERY

TO REMOVE THE MOULD TROLE.



AFTER REMOVAL OF THE MOULD TABLE, ADJUST THE HEIGHT OF THE WARM BRINE TO 5-10 cm
ABOVE NORMAL LEVEL OF THE MOULD TABLE
THE HEIGHT IS ADJUSTED AT THE PRESSURE
SIDE OF THE BRINE PUMP.

Tetra Laval Food Hoyer A/S
Søren Nymarks Vej 13, DK-8270 Aarhus-Højbjerg, Denmark
Telephone + 45 89 39 39 39, Telex 6 87 70 ethoy dk, Telefax + 45 86 29 22 00, Telegrams frigohoy aarhus
Bankers Den Danske Bank A/S, Aarhus Branch, Reg. No 3627, Account No 3258-13389-7, Import VAT No 41852119,
Export VAT No 29348359, A/S Reg. No 38.795



Tetra Laval Food

CY

Tetra Laval Convenience Food

FAX MESSAGE

To:	Dun ROBIN
	gerhand
_	

Fax No:

Date: 200795

No. of pages incl. this:

$\mathcal{N} \mathcal{D}$		· · · · · · · · · · · · · · · · · · ·
Very Important! You!	Nau	e Two THOMASTATES
WHERE Your MAIN Motor is		HEIR TO SEE HE THE .
DANFOSS TEMP CONTROLLERS	<u> </u>	KE SHAT THE COLLECT
SETTING HOTBEINE +205 is	. (5	we +23°c is the other.
IF THE ONE IS SET INCORPECT		
THE MAIN MOTOR LOW STOP		+-30mm from Top
ALDCOUSE FREEZE UP. 18 LOS	11	Then BRINE 13 OK
than + 20°C.	// _r	
CHECK IF BRIME IS	li 1	
CORRECT LEWEL >	(4)	,
5 >	\leq	
PS. CHECK IN Manual for . Co	~ ⊩	1/ratile
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Tetra Laval Convenience Food

1 Bridle Close Woodmead Park Van Reenen Ave Woodmead, 2157 South Africa Fax No:

+27 11 804 6545

Tel:

+27-11 804 6529

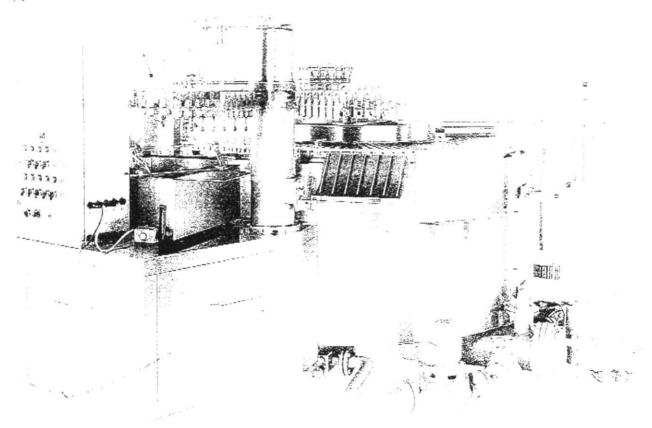


Quality Assurance Department

The following image quality is poor due to original page quality

<u>www.cleardata.co.uk</u> tel: 01670 356 734 fax: 01670 356 439





Hoyer Rollo 20

Automatic Ice Cream

Bar Freezer

Application

attendence a saturaçõe producina os na otivam. seemen on man have nors with sticks

Operating Principle

as around the teathing of slight finance of the months poor, as

- 10 17
- 4. Demostray of a few sec-
- half simultaneous the factors in

to a system for pass offi-

TO: BRENT DANNIE 933 6689. | 551 6325 FROM: SAM

Capacity

The capacity for typical products (see table) will normally be in the range of 7,000 to 10,000 ice cream bars per hour. Capacities for water ice are lower than for ice cream. Actual capacity depends upon a number of factors, including:

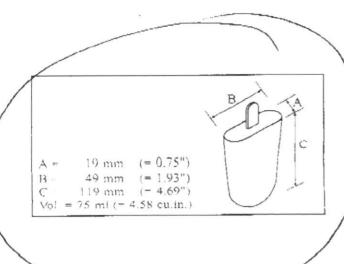
- Number of radial rows.
- Number of products per radial row.
- Product thickness.
- Recipe (e.g. sugar content and total solids content).
- Overrun.
- Viscosity of ice cream mix.
- Brine temperature.
- Ice cream filling temperature.
- Number and types of filling operations.
 Capacity of the packing line.

Example:

	the state of the s	
Product width:	49 mm	(1.93")
Product thickness:	19 mm	(0.75")
Number of radial rows:	120	
Number of pockets per row:	6	
Overrun of ice cream:	60%	
Evaporating temperature:	-45°C	(-49°F)
Brine temperature:	-40°€	(40°F)
ice cream filling temperature:	-2°C	(+28°F)
Capacity*, approx.:	9,000	per hour

* The capacity is based on a mix recipe using good quality ingredients as follows:

ality ingredients as follows.	
Fat	12%
Skimmed milk powder, fat free	11%
Sugar (sucrose)	12%
Auxiliary ingredients	1%
Water	64%
	100%



The number of freezing pockets per radial row depends upon the width of the ice cream bar. For example:

Pockets per radial row
4
5
6
7
8

^{*}Typical products.

The standard number of radial rows is 120 for products with thickness up to 23.5 mm. Above 23.5 mm the number of radial rows or pockets per radial row will be less.

Standard Design

Mould Table. The moulds, in which the bars are shaped and frozen, are welded into an annular, rotary table situated on top of the brine tank.

The mould table is made of stainless steel. The number of pockets included in the standard mould table with 6 pockets per radial row is $6 \times 120 = 720$ pockets.

Other mould tables with different row and pocket configurations can be supplied (see »Optional Equipment«).

The mould table of a Hoyer Rollo 20 can handle ice cream bars which are up to 135 mm (5.31") long. The stick inserted in the ice cream/water ice bar must protrude at least 30 mm (1.18") above the mould table.

The Hoyer Rollo 20 is supplied with a crane for lifting and removing the mould table.

Brine Tank. The double-walled annular tank is welded and insulated. It is made from stainless steel except for the bottom of the inner tank and the evaporator which are made from milled steel.

Two rails are placed on the outside of the brine tank for mounting the stick dispenser, the cleaning equipment, the filling equipment, etc.

The brine tank is divided into a freezing zone with cold brine and a defrosting zone with warm brine.

Cooling System. The primary cooling system consists of evaporating coils placed at the bottom of the brine tank. Ammonia is used as refrigerant.

The secondary cooling system is a cold brine bath and the cold brine is circulated by a contrifugal pump. The cold brine distribution trough is made of stainless steel.

^{*} The numbers in this table refer to list of optional equipment on previous page.

Legth

W-7

75 ml

75 ml

49

8-7 19 mm

19

1-7 192

119

Stidzprotnice 43 mm

Wrapper

W-7 166 mm

2 -7 204/10 mm

•

•

.



FAX from Fax no.: +27 21 555 0467

To : Parmalat Ice cream

Attn. : Mr Dannie Schoeman

Brent Claassen

Fax no. 551 6325/933 6689

From : Sam Greenaway

Ref. No : 2041sg

Date : 2000-06-14

No. pages : 5 (incl. this one)

Subject "Filur" and a new mould table quotation - Revised

Dear Dannie.

We have considered the complete order and the previously related price for the Filur of 1998/9 and have revised the situation. On initial quotation of the filur product it was not establish if a new modified chocolate tank and other modification were necessary on the role 20. However with assistance from the Engineering department the price has been reduce in order for us to meet with your needs.

I hope that the quotation meets with your requirements and we look forward to the order. Please note the 12 weeks delivery time (ex Works.)

Estimated Exchange rate : DKK 0,95 = R 1,00

(Were any Fluctuation will be for your account)

Estimated Total Shipping Costs: R30 000(To be confirmed & charged at cost)

(Shipping, Clearing, Duty, VAT and any other costs are all excluded.)

Convenience Food Systems Terms: 50%, 50%.

Convenience Food Systems (Pty) Ltd.

P.O. Box 60962, Flamingo Square 7441, Cape Town, South Africa. Visiting address: Unit N5, Centurion Business Park, Bosmansdam Rd, Milnerton. Tel. +27 21 555 0420\21, Fax +27 21 555 0467, http://www.cfs.com

LEADM : CONNENIENCE FOOD SYSTEMS PHONE NO. : Ø2155580420 Jul. 14 2000 02:47PM P1



With reference to the Extrusion line as per our meeting on the 12/06/00

I can confirm as follows;

- 4 weeks are estimated for Installation & commissioning.
- @ Euro 4500 per week, ex flight, Accom.
- Estimated CIF Cape Town Euro 12700, Ex local clearing, Agent fees and Local Transportation.

Should you have any further questions please feel free to contact me.

Kind Regards

Sam Greenaway.

Page 2 of fax d.d.

⚠ Tetra Pak Hoyer

Quotation

A011323-3

Dun Robin Products (Pty) Ltd. 40 Industrial Ring Rd Parow 7490 P.O. Box 1021 Parow 7550 SOUTH AFRICA

Our ref.: Your ref.: CHO/DOK

Date: 14-Jun-00

		CHO/DOK	14-3411-00
Item	Qty		DKK
	-	With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 0102 GB2, which form an integral part of this quotation, we take pleasure in offering you as follows:	
		New Stick Product on the existing Rollo 20, (Serial no. Z312,1411):	
1.	1	Mould Table	
		Consisting of: - 6 mould pockets per row - 120 radial rows	
		Price	
)	1	Modification of Production Equipment	
٠		Price DKK 25,000	
		Total Price, Item 1	272,400
2.		Equipment for Production of "Filur" Product:	
		The functionality of this Hoyer equipment has recently been upgraded and improved.	

Tetra Pak Hoyer A/S
Soeren Nymarks Voj 13, DK-8270 Hoejbjerg, Denmark
Telephone + 45 89 39 39 39, Telex 6 87 70 alhoy dk, Telefax + 45 85 29 22 00, Telegrams frigohoy aarhus
Bankers: Den Daniske Bank A/S, Aarhus Branch, Reg. No 3627, Account No 3258-13389-7
Export VAT No 29348359, Central Business Register and Import VAT No 41852119

PHONE NO.: Ø215550420

e-mail: hoyer@hoyer.dk, web-site: www.tetrapakhoyer.com

LKOW: CONNENIENCE LOOD SASIEMS

⚠ Tetra Pak Hoyer

Quotation<u>A011323-</u>3

Dun Ro	Dun Robin Products (Pty) Ltd.	
Item Qty		DKK
	The equipment consists among other things of: Various modification on the Rollo to make room for this equipment I New pump 1 Set of Nozzles 1 Frame 1 Vessel for the water paint, which is a mix of water and colouring. 1 Mask Various electrical components For the principle of this spraying equipment please look at the enclosed engineering drawings no. 128,24223 and 128,24164. Please note: The accuracy and sharpness of the motive sprayed onto the stick product varies according to the production speed of the Rollo and the spray media. The price of this spraying equipment is conditioned by placement of an order on the above-mentioned mould table (Item 1). Total Price, Item 2	132,
	Grand Total Price, Item 1 & 2	405,
	The Price:	
	is to be understood F.C.A. (free carrier) Aarhus, Denmark, incl. packing for the transport in question, excl. installation.	
	"INCOTERMS 1990" apply.	

⚠ Tetra Pak Hoyer

Quotation A011323-3

Dun Robin Products (Ptv) Ltd.

14-Jun-00

Dun Robin Products (Pty) Ltd.		14-Jun-00	
Item	Qty		DKK
		Delivery:	
		Approx. 12 working weeks after receipt of order and approved/signed product drawing.	-
		The above mentioned time of delivery is to be reckoned from the date all relevant technical information/samples necessary for production of the machine have been received and samples must be sent to Hoyer for comments.	
		In addition, the time of delivery depends on the down payment being paid according to agreed terms of payment.	
		Payment:	
		30 % of the contractual amount to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus Branch, Denmark, not later than 2 weeks after order.	
		70 % of the total amount to be paid before delivery.	

•		We hope our quotation is in accordance with your wishes and look forward to receiving your order. Should you have any further questions we are of course at your disposal with further information.	
		Yours faithfully, Tetra Pak Hoyer A/S	
	_		
		Chris Olsen	

FAX from Fax no.: +27 21 555 0467

To : Parmalat

Attn. : Dannie Schoeman

Brent Claassen

Fax no. : 021 551 6325, 933 6689

From : Sam Greenaway

Ref. No : 2029sg

Date : 2000-05-31

No. pages : 1 (incl. this one)

Subject : New Mould Table

Dear Brent,

I thank you for your valued enquiry and take pleasure in quoting the following for your kind attention.

Mould Table for a Rolo 20 Z312,1411

Price Ex works DKK 272 400,00

An estimate of **R 258 780,00 ex works**, is due to the exchange rate were any fluctuation will be for your account. This quote is valid for 60 day.

Exchange rate quoted DKK 0,95 = R 1,00. Should you require a fixed exchange rate please feel free to contact me.

Shipping, clearing, duty costs, Vat : Excluded.

(Estimated total Sea freight costs, Ex VAT. R 15 000-30 000)

Installation: N/A

Payment terms: 50% on receipt of order, and 50% on proof of shipping doc's

before dispatch.

Kind Regards

Sam.

Convenience Food Systems (Pty) Ltd.

P.O. Box 60962, Flamingo Square 7441, Cape Town, South Africa.

Visiting address: Unit N5, Centurion Business Park, Bosmansdam Rd, Milnerton.

Tel. +27 21 555 0420\21, Fax +27 21 555 0467, http://www.cfs.com

EKOW : COMNEMIENCE ŁOOD SKRIEMS - BHOME NO' : BSIZZZBYSB - W9A' 3I SBBB IB:SBBW BI



FAX from Fax no.: +27 21 555 0467

To

: Parmalat

Attn.

: Dannie Schoeman

Brent Claassen

Fax no.

: 021 551 6325, 933 6689

From

: Sam Greenaway

Ref. No

: 2036sg

Date

2000-06-08

No. pages

5

(incl. this one)

Subject

: Filur product

Dear Brent/Dannie,

I thank you for your valued enquiry and take pleasure in quoting the following for your kind attention. Please note that the prices are in DKK and any variation in the exchange rate will be for your account.

This quotation is also subject to CFS standard terms and conditions should you place any order via CFS SA.

Please feel free to contact me should you have any further questions.

Kind Regards

Sam.

Convenience Food Systems (Pty) Ltd.

P.O. Box 60962, Flamingo Square 7441, Cape Town, South Africa. Visiting address: Unit N5, Centurion Business Park, Bosmansdam Rd, Milnerton. Tel. +27 21 555 0420\21, Fax +27 21 555 0467, http://www.cfs.com

FROM : CONVENIENCE FOOD SYSTEMS

586292200

PHONE NO. : 0215550420

TLF HOYER DK

Jun. 08 2000 02:51PM P2 **☑** 002/00

♠ Tetra Pak Hoyer

08/06 100 13:14

Estimate

A011323-1

Dun Robin Products (Pty) Ltd. 40 Industrial Ring Rd Parow 7490 P.O. Box 1021 Parow 7550 SOUTH AFRICA

Your ref.;

Our ref.:

	CHO/DOK	08-Jun - 00
Qty		DKK
·	With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 0102 GB2, we are pleased to quote an estimated price as follows:	
	New Stick Product on the existing Rollo 20, (Serial no. Z312,1411):	
	Equipment for production of Filur product:	
	The functionality of this Hoyer equipment has just been upgraded and improved. Therefore, it has not yet been released for selling and I can only send you an estimate.	
	The equipment consists among other things of: - 1 New dipping vessel on the Rollo - Various modifications on the Rollo to make room for this equipment. - 1 New pump - 1 Set of Nozzles - 1 Frame	
	- 1 Vessel for the water paint, which is a mix of water and colouring 1 Mask - Various electrical components	
•	For the principle of this spraying equipment please look at the enclosed engineering drawings no. 128,24223 and 128,24164.	
	Estimated Price	362,00
	,	

08/06 '00 13:14

☎\$6292200

"INCOTERMS 1990" apply.

TLF HOYER DK

☑0037005

A: Tetra Pak Hoyer

Estimate A011323-1

Dun Robin Products (Pty) Ltd.

08-Jun-00 Qty. DKK The Price: is an estimated price to be understood F.C.A. (free carrier) Aarhus, Denmark, incl. packing for the transport in question.

Delivery:

Approx. 12 working weeks after receipt of order and approved/signed product drawing.

The above mentioned time of delivery is to be reckoned from the date all relevant technical information/samples necessary for production of the machine have been received and samples must be sent to Hoyer for comments.

In addition, the time of delivery depends on the down payment being paid according to agreed terms of payment.

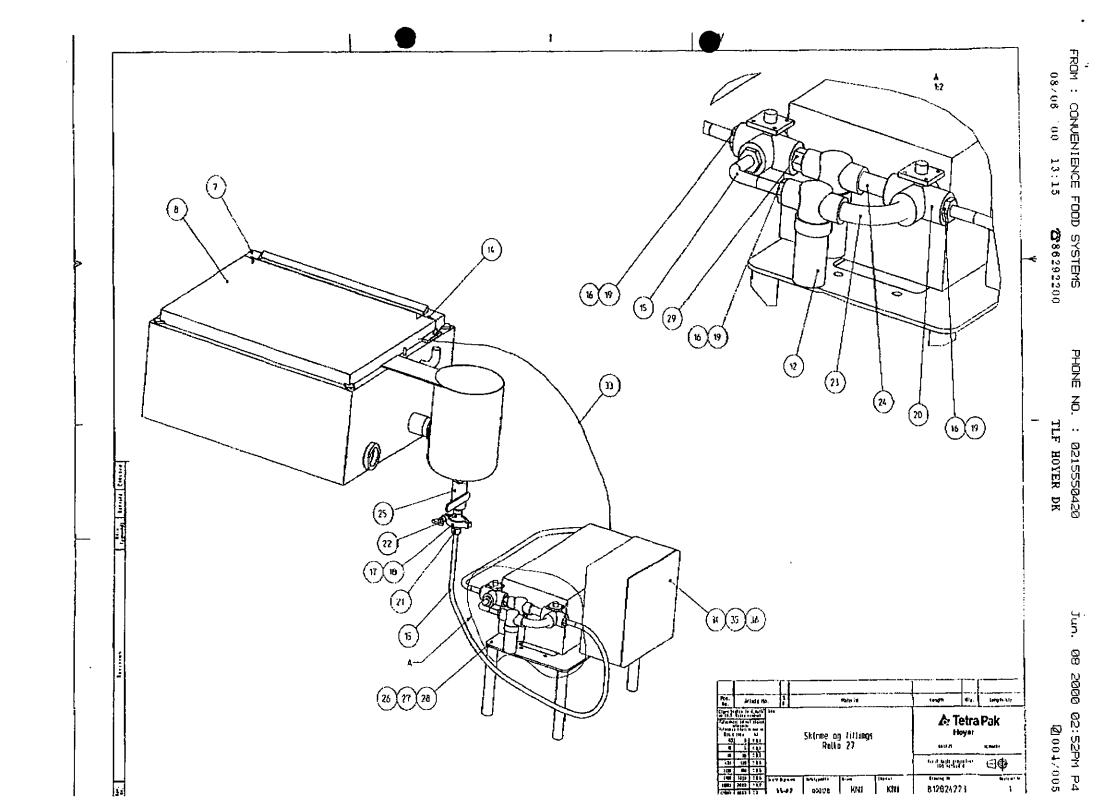
Payment:

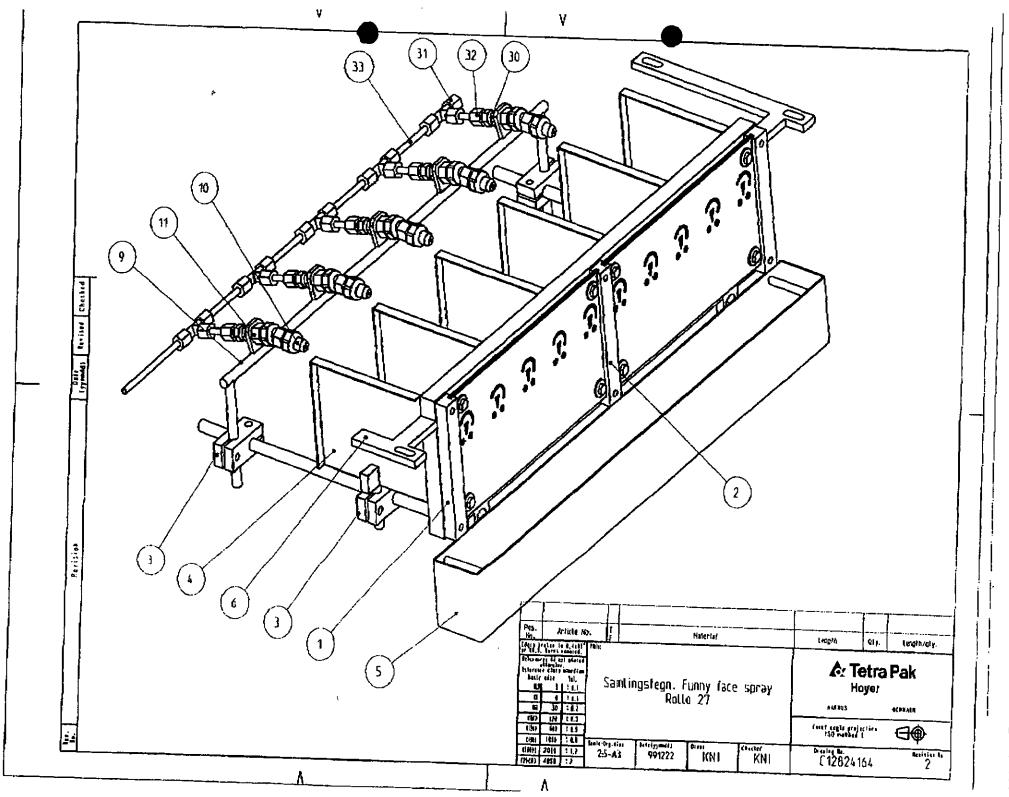
30 % of the contractual amount to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus Branch, Denmark, not later than 2 weeks after order.

70 % of the total amount to be paid before delivery.

We hope our Estimate is in accordance with your wishes and should be pleased to work out a firm quotation which meets your specific requirements. Looking forward to hearing from you.

Yours faithfully, Tetra Pak Hoyer





FROM : CONVENIENCE FOOD SYSTEMS
00.00 00 13:15 \$\mathbf{C}\mathbf{8}88292200

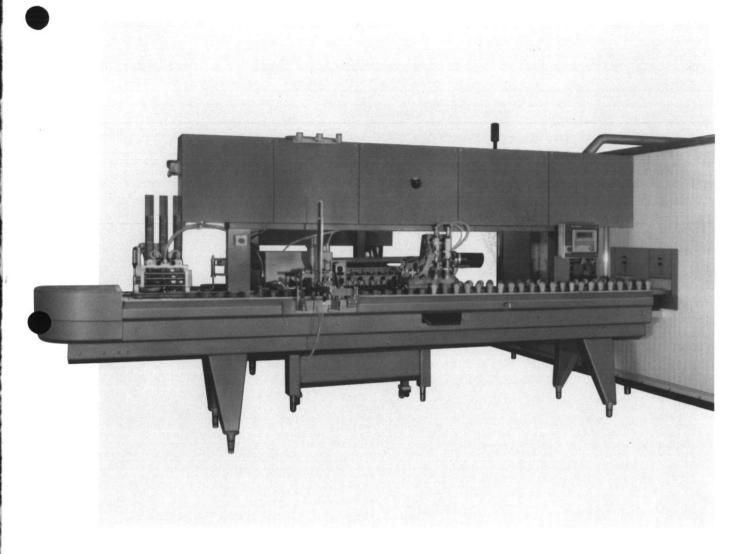
PHONE 0215550420

: 0215550420 TLF HOYER DK

Jup. 8 2000 02:53PM P5

<u>@</u>0057005





Hoyer Straightline 600 C

Tray Tunnel Extrusion System

Application

The Hoyer Straightline 600 C is a complete system for processing and packaging extruded ice cream products, with or without sticks.

Premium chocolate bars, ball-shaped cones, funnyfaces, bonbons, decorated cakes, dessert slices, and sandwiches can all be produced on the Hoyer Straightline 600 C with the aid of different auxiliary equipment.

With its flexible design, change-over from one product to another is quick and efficient.

Description

The basic machine consists of a conveyor chain which transports the product trays and follows a double-spiral path through a hardening tunnel.

At the inlet/outlet end of the tunnel the conveyor chain forms a worktable where extrusion, filling, decorating and product transfer take place.

The production process on the Hoyer Straightline 600 C starts with the extrusion or time-elapse filling of the ice cream onto the product trays, either directly (e.g. stick products, candy bars, slices and cakes), or into pre-inserted cones.

Different operations can be carried out depending on the product to be produced eg. stick insertion, the dispensing of biscuits, cones or chewing gum balls, and decoration with ice cream, caramel, syrup, jam or dry ingredients.

The filled product trays are passed through the hardening tunnel, where the products are efficiently frozen by cold air circulation.

After hardening the products are removed from the trays and can be dipped into chocolate or other ingredients. Alternative transfer systems for different products are available (see Product Transfer section).

Automatic flow wrapping of the products into paper or plastic laminate wraps is carried out on a Hoyer Charta single-lane wrapper.

Standard Design

Drive

The drive for the conveyor chain and for the stations on the worktable is placed inside the hardening tunnel.

Worktable

The worktable is prepared for mounting all the possible stations. The stations are designed for easy interchange.

All exterior surfaces and components on the worktable are produced from stainless steel or stainless materials. The worktable is sloped to facilitate water run-off. The frame is constructed from stainless steel channelling to ensure effective cleaning. Tray change-over is quick and simple. The trays can be lifted off the conveyor chain without the aid of tools.

A tray washing unit is available.

Hardening Tunnel

The Hoyer Straightline 600 C hardening tunnel is delivered pre-assembled in two main parts for quick and easy installation in the factory. The evaporator and high speed fans are positioned at the side of the spiral conveyor.

In the hardening tunnel the conveyor chain follows a double-spiral path around a frame made of stainless steel. All chain supports, sprockets and framing are constructed to facilitate cleaning, servicing and access between the chainway. The vertical distance between the chainways allows for product heights up to 120 mm above the tray and for ball-top cones up to 170 mm.

A built-in chain tightening mechanism allows for temperature variation.

The hardening tunnel is manufactured from polyurethane insulated panels with white PVC coated sheets on both the interior and exterior surfaces. The floor is made from fiberglass with drain channels.

The tunnel is supplied with two entrance doors allowing for effective cleaning and maintenance inside the tunnel.

Control system

All in-line functions, including drive and the filling and decoration equipment are controlled via the PLC from one central control panel.

All production data can be pre-programmed and supervision and adjustment are easy from the control panel.

Different programmes can be stored in the PLC which operates as master when connected to other machines in the line.

Refrigeration

The Hoyer Straightline 600 C is provided with an R22 or ammonia evaporator unit.

Filling and Decorating Equipment

As Hoyer Straightline 600 C is designed for the production of a large number of different ice cream products, the choice of filling and decorating equipment will depend upon the specific product types.

The filling and decorating equipment is designed for easy connection to the sliding carriages on the worktable.

The decorating equipment will be individually supplied to suit customer requirements for product size and shape.

The following equipment is available:

Horizontal extruder

- Candy bars.
- Logs.

Vertical extruder

- Stick novelties.
- Slices.
- Minicakes.
- Bite-sizes.

Vertical Time-elapse Filler

- Cone filling.
- Top decoration.
- Tartufo.
- Bonbons

Other Equipment

- Single or double stick inserter.
- Chewing gum dispenser.
- Biscuit dispenser for sandwiches.
- Cone dispenser.
- Wafer cup dispenser.
- Jam and caramel top decoration.
- Chocolate inpregnation.
- Chocolate tank with pump.
- Pencil filler.
- Ripple equipment.

Product Transfer

According to the products to be produced different transfer systems are available.

- Multi-lane transfer system suitable for stick or stickless products and ball-top cones.

Two different coating systems are available for stick products. One system is for chocolate coating the other for juice coating. The chocolate coating unit is also suitable for coating ball-top cones, and halfsandwiches. Products can be coated with either chocolate or with chocolate containing dry ingredients. Stickless lines require chocolate enrobing equipment. A flatbelt-conveyor system that passes through the hardening tunnel to dry the chocolate is optional. The conveyor system is complete with an automatic infeed and outfeed centering device and speed adjustment is carried out from the central control panel.

- Gripper conveyor for chocolate coating of stick products.
- Logs, bonbons and miniatures must be removed from the trays by hand after hardening.

Product Capacities

The maximun capacity of the Straightline 600 C is up to 7400 novelties per hour with either a multi-lane transfer system or a gripper conveyor.

If other products are produced, like candy bars, ice cream logs or sandwich products, the capacity will depend upon the type, size and design of the product. In each case actual capacity will be determined by the mechanical speed, number of products per tray, freezing capacity of the hardening tunnel and the subsequent transfer and packaging system. Maximum outputs are as follows:

Products discharged automatically

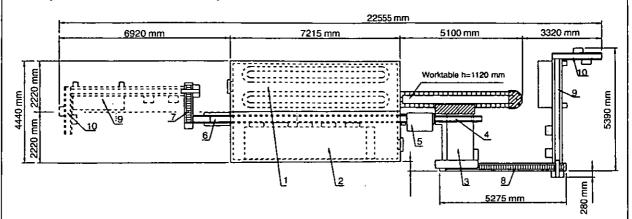
- Stick products: 7400 pcs/hr Three products per tray Distance between the products 100 mm.
- Ball top cones: 7400 pcs/hr Three products per tray Distance between the products 100 mm.
- Candy bars: 9000 pcs/hr Six products per tray Distance between the products 150 mm. Distance between the lanes 70 mm.
- Brickettes/slices: 7400 pcs/hr Three products per tray Distance between the products 100 mm.
- Mini-cakes: 7400 pcs/hr Three products per tray Distance between the products 100 mm.

Products discharged manually .:

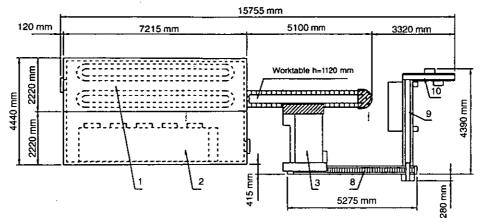
- 14000 pcs/hr Miniaturè/bonbon; Nine products per tray Distance between the products 100 mm. Distance between the lanes 70 mm.
- Logs: One product per tray

Typical Layouts

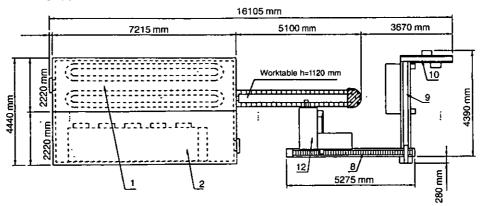
Complete line for sticks, stickless products, cones and sandwiches.



Complete line for sticks and cones.



Complete line with gripper conveyor for sticks.

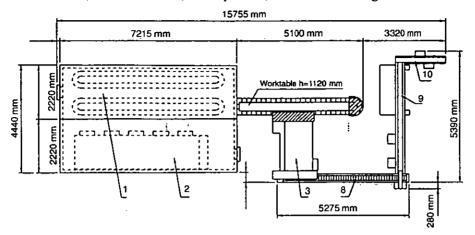


- 1 Straightline 600 C (h=2440)
- 2 Evaporator
- 3 Hoyer Dino-C, Multi-lane transfer system
- 4 Belt conveyor for stickless products
- 5 Chocolate coating machine
- 6 Chocolate drying belt conveyor

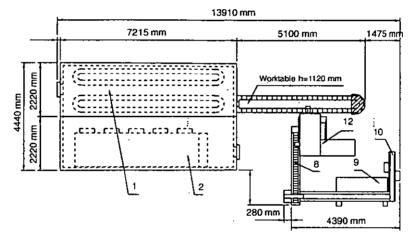
- 7 Stickless products pocket conveyor
- 8 Pocket conveyor
- 9 Single lane wrapping machine (for sandwiches)
- 10 Outlet belt conveyor
- 11 Refrigeration unit R22

(can be placed away from SL 600 C)

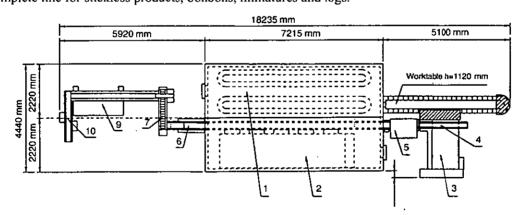
Complete line for sticks, half-sandwiches, ball-top cones, sandwiches and logs.



Complete line for sticks, half sandwiches and logs.



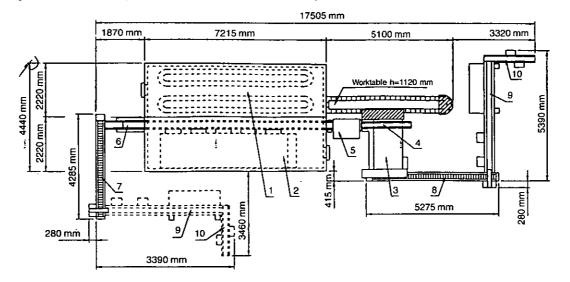
Complete line for stickless products, bonbons, miniatures and logs.



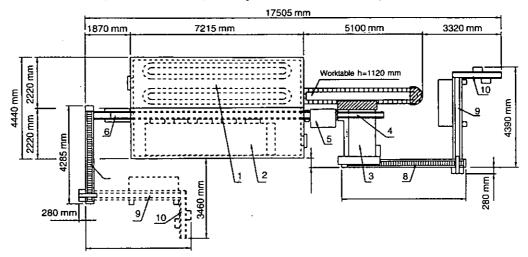
- 1 Straightline 600 C (h=2440)
- 2 Evaporator
- 3 Hoyer Dino-C, Multi-lane transfer system
- 4 Belt conveyor for stickless products
- 5 Chocolate coating machine
- 6 Chocolate drying belt conveyor

- 7 Stickless products pocket conveyor
- 8 Pocket conveyor
- 9 Single lane wrapping machine (for sandwich)
- 10 Outlet belt conveyor
- 11 Refrigeration unit R22 (can be placed away from SL 600 C)

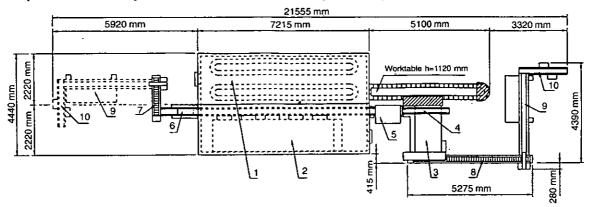
Complete line for stick products, half-sandwiches, ball-top cones, sandwiches, bonbons and miniatures.



Complete line for sticks, half-sandwiches, ball-top cones, bonbons and logs.



Complete line for stick products, half-sandwiches, ball top cones, logs and bonbons.



- 1 Straightline 600 C (h=2440)
- 2 Evaporator
- 3 Hoyer Cino-C Multi-line transfer system
- 4 Belt conveyor for stickless products
- 5 Chocolate coating machine
- 6 Chocolate drying belt conveyor

- 7 Stickless products pocket conveyor
- 8 Pocket conveyor
- 9 Single lane wrapping machine (for sandwich)
- 10 Outlet belt conveyor
- 11 Refrigeration unit R22

(can be placed away from SL 600 C)

Technical Data

Product plates:		
Total no. of trays including worktable:		617
No. of trays inside tunnel:		580
Total tray area inside tunnel:		35 m ²
Chain length:		185 m
Chain pitch:		50 mm
Cooling system:	R22	NH ₃
Max. evaporator capacity:	60 kW	64 kW
Small compressor capacity:	48 kW	
Max. compressor capacity:	58 kW	
Evaporator surface:	510 m ²	506 m ³
Evaporator volume:	310 ltr.	180 ltr.
Suction temp. at evaporator:		–40°C
Air temperature:		−33°C
Air flow:		48 m³/h
Power consumption		
Main drive:		2.2 kW
Fans (5 x 1.1kW):		5.5 kW
Compressor unit:		55 kW
Tray washer:		0.18 kW
Multi-lane main motor:		1 kW
Outfeed conv. for stickless product:		0.5 kW
Chocolate pump:		0.75 kW
Heaters (depending on version):		3 kW
Flatbelt conveyor motor:		1 kW
Compressed air pressure:		6-7 bar.
Total air consumption depending upon		
number and type of equipment:	Max 1 m³/mir	i. including the washing unit.
Connection		
Electricity:		
-Standard:	3x400 volts A	
-Optional:	according to c	eustomer spec.
-Compressed air:	15 mm	

Shipping Data

	net/gross.weight	shipping vol.
-Frame box:	7800kg/10000kg	51 m³
-Evaporator box:	3200kg/4500kg	51 m ³
-Worktable:	3000kg/3300kg	33 m^3
-Gripper conv. for choco:	1200kg/1500kg	7 m³
-Multi lane transfer system:	650kg/900kg	11 m³
-Compressor unit:	2300kg/3000kg	10 m ³

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↑: Tetra PakHoyer

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Tetra Pak Hoyer SpA, 52 Via Monferrato, I-20098 San Giuliano Milanese, (Milan), Italy, Tel.: +39 02 98 2921, Fax: +39 02 9880171

Tetra Pak Hoyer Indústria e Comércio Ltda., Rua Napoleao de Barros, 1038, CEP04024-003 Sao Paulo - SP, BRAZIL, Tel.: +55 11 573 9422, Fax: +55 11 549 5420, E-mail: tphoyermario tplugnet.com.br



Quality Assurance Department

The following image quality is poor due to original page quality

<u>www.cleardata.co.uk</u> tel: 01670 356 734 fax: 01670 356 439

★ Tetra Pak Hoyer

TELEFAX

ATT.:

Mr. Sam Greenaway

FAX NO:

-27 21 555 0467

COMPANY:

Convenience Food Systems (Pty) Ltd.

Cape Town, SOUTH AFRICA

FROM:

Allan Bjerring Andersen

FAX NO:

+45 86 29 22 00

DATE:

31-May-00

REF.:

AA/IN

00043,000 -

PAGES:

16

Dear Sam.

Enclosed please find fax and quotation A011273-1 for Parmalat Ice Cream. Furthermore we enclose draft proposal, indicative example of interest rate and Drawing SLC011

Please present the above to the customer personally and revert with your comments.

Best regards

Tetra Pak Hoyer A/S

Impa de

Ë,

Allan B. Andersen

♠: Tetra Pak Hoyer

Parmalat Ice Cream SOUTH AFRICA Att.: Danie Schoeman

Your ref.:

Our ref.: AA/AA.

Date: 31-May-00

Gentlemen

Quotation for Straightline 400

First of all I would like to thank you for your kind hospitality extended to me during my recent visit to South Africa.

It is as always a pleasure to visit your factory and meet people with visions and ambitions.

As we agreed upon enclosed you will find the following documents:

- 1. Quotation for a Straightline 400
- 2. Leasing agreement for a period of three years
- 3. Layout for the Straightline 400

As we discussed during our meeting the Straightline 400 that we are now quoting includes equipment for the production of one "Magnum" product type and one Funny Face.

The Straightline 400 is equipped with an ammonia evaporator that has to be connected to a central ammonia system at an evaporation temperature of -45°C.

Tetra Pak Hoyer

Page 2

Parmalat Ice Cream

31-May-00

The Straightline 400 can at a later stage be equipped for the production of the following products:

- Ball top cones
- Sandwich products
- Logs

In the following we have given an example of a cost brake down per unit based on the 3 years leasing proposal.

In broad terms the payments are as follows with the example of a three-year lease:

- Down payment Euro 55,725. 1.
- 2. Quarterly instalments of Euro 29,556 for three years.
- Based on a separate agreement at the end of the leasing period the equipment will be 3. acquired for a symbolic amount of e.g. Euro 200.

The calculation, which outlines the saving for a three-year lease, will look as follows:

Leasing per year

Euro 118,224

Deductible company tax (30% of Euro 118,224) - Euro 35,467

Estimated cost of lease per year after tax, year one <u>Euro 82,757</u>

Euro 82,757 equals approximately RAND 512,403.

Estimated production per year:

6 million sticks

Capital cost per stick: RAND 512,403: 6 million = 8.5 cent per stick

As we discussed, and as the numbers show, an investment of this extent should be a sound investment and pay itself back within a short time.

♠: Tetra Pak Hoyer

Page 3

Parmalat Ice Cream

31-May-00

Please check the above assumptions with your local accountant, having knowledge of the exact tax rules in South Africa.

We are at the moment checking the best timing for a visit to Egypt where the line can be inspected.

As soon as we have a video of the line in question we will forward it to you.

We hope that our quotation is in accordance with your expectations and are looking forward to hearing from you.

Best regards

Tetra Pak Hoyel A

Allan Bjerring Andersen

♠: Tetra Pak Hoyer

Quotation

A011273-1

Parmalat Ice Cream

SOUTH AFRICA

Your ref.:

Our ref.: A A/TN _. 30**-**Мау-00

· Our ren.	AA/IN	30-May-00
Qty		EURO
1	With reference to our enclosed "General Conditions of Sale and Delivery" No. QT 0102 GB2, which form an integral part of this quotation, we take pleasure in offering you as follows: Straightline 400	
,	Line for the extrusion, hardening and coating of stick products as described below. Capacity: Up to 4800 stick products per hour The basic machine includes: - Box insulated by means of high density polyurethane 100 mm thick. Floor provided with water drain. Inspection doors. Internal lighting plant - Internal stainless steel frame to support the trays and drive the stainless steel chain - Main drive with a motoreducer suitable for low temperature, placed inside the cold box, with speed regulation by menas of an inverter - Mechanical gear for the motion of the working stations - External worktable to place the working stations - Centralized electrical panel to control and adjust all the devices by means	
	of a PLC and user interface - Internal finned tube evaporator for ammonia with six fans, mounted on top of the frame with defrosting system by water. Evaporation temperature - 45°C. - Electrical and pneumatic plant The unit has to be connected to a suitable power source and to the centralized ammonia system.	

Tetra Pak Hoyer A/S

Soeren Nymarks Vej 13, DK-8270 Hoejbjerg, Denmark
Telephone + 45 89 39 39 39, Telex 6 87 70 alhoy dk, Telefax + 45 86 29 22 00, Telegrams trigohoy aarhus
Bankers: Den Danske Bank A/S, Aarhus Branch, Reg. No 3627, Account No 3258-13389-7
Export VAT No 29348359, Central Business Register and Import VAT No 41852119
e-mail: hoyer@hoyer.dk, web-site: www.tetrapakhoyer.com

⚠: Tetra Pak Hoyer

Quotation A011273-1

Parmalat Ice Cream 30-May-		30-May-00
Qty		EURC
1	Washing brush	
l	Set of 460 flat trays in stainless steel – 200 x 295 mm	
1	Single wire horizontal cutting device including wire drive and extruder support	
1	Vertical extruder - 1 outlet	
1	Vertical extruder 2 flavours 5 outlets	
1	Size change over for single stick inserter	
1	Single stick inserter 95 x 10 mm pneumatically actuated	
1	Single hammer, upper position	
1	Pick-up for sticks – 145 grippers Apparatus for synchronized pick-up and chocolate enrobing of stick products, extruded and hardened by the SL production lines.	
	The device includes: - Stainless steel frame - Chain with 145 articulated pincers - Double jacket chocolate dipping tank, complete with pump, electric heating elements, thermostat. The tank is provided with sheels and can be removed for the cleaning operations. - Product release station - By-pass station - Electric control panel	
1	Pick-pack Wrapping Machine Designed to pack different sizes and shapes of ice cream products and can be used with a variety of wrapping materials, e.g. polyethylen, PVC and polikraft. Both hot and cold sealing can be carried out. Pick-pack is completely built in AISI 304 stainless steel and equipped with double paper roll suspension and an electronic speed variator with progressive start resulting in a faster operation. A friction system centralizes the products in the wrapping material and operates also as a safety device for the product conveyor.	

♠ Tetra Pak Hoyer

Quotation<u>A01127</u>3-1

Parmala	t Ice Cream	30-May-00
Qty		EURO
1	The machine is fitted with a longer inlet conveyor facilitates the manual placement of products. Gearing is built-in, avoiding direct contact with the products. Up to 6,000 products/hour and with photocell, which centralizes the wrapping material so welding and cut are always carried out at the same point in the wrapper design (picture-in-place). Chocolate Tank 100 l Set of recommended spare parts Total price for Straightline 400	371,500
	Delivery: 12 working weeks after receipt of order. The above mentioned time of delivery is to be reckoned from the date all relevant technical information/samples necessary for production of the machine have been received and samples must be sent to Hoyer for comments. In addition, the time of delivery depends on the down payment being paid according to agreed terms of payment. Payment: 50 % down payment to be transferred to our account No. 3258-13389-7 with Den Danske Bank, Aarhus, Denmark, not later than 15 days after the date of the pro forma invoice.	

♠: Tetra Pak Hoyer

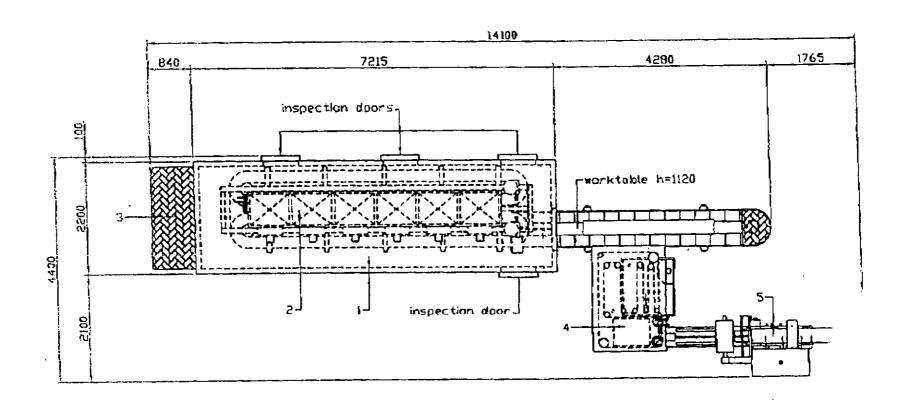
Quotation A011273-1

Parmalat Ice Cream		30-May-00
Qty		EURO
	of the contractual amount to be paid against presentation of shipping documents, or, if, owing to conditions beyond Hoyer's control, shipment cannot take place at the time agreed upon, against warehouse receipt.	
	Or according to enclosed leasing proposal.	-
	The payment must be secured by an irrevocable Letter of Credit to be opened by a first-class bank, and to be payable at sight at the counters of and confirmed by Den Danske Bank, Aarhus, Denmark.	
	The Letter of Credit must be opened one month before estimated delivery and be valid for at least one month after estimated delivery, allowing partial shipment and transhipments.	
	All costs in connection with the confirmation and keeping in force of the Letter of Credit - abroad and in Denmark are for the account of the buyer.	
	2% per month interest fee for late payment will be added to the last invoice amount.	
	Validity:	
	Our quotation is valid for order received not later than 60 days from date of quotation.	
	Exclusions:	
	The TP Hoyer delivery comprises the above specified only, and thus does not include, for example, the following:	
	1. Installation and start-up assistance of any kind.	
ļ	 Electrical work consisting of external conduit runs, wiring, nor the materials or labor to install such equipment. 	
	 Pneumatic work - consisting of external conduit runs, pneumatic tubing, fittings, connections, nor the materials or labor to install such equipment. 	
	4. The main power supply and/or pneumatic supply to the control	

★ Tetra Pak Hoyer

Quotation _A0112**7**3-1

Supply or installation of an enclosed lockable enclosure for storing installation materials, tools, expendables, etc. This is to be customer supplied upon request. Supply or installation of refrigeration equipment required for the system's operation equipment and the Hoyer supplied equipment. Excl. circulation pump, pipes and fittings and insulation. Any building construction modifications or materials which may be required. Supply or installation of any sanitary or CIP piping to or from the Hoyer supplied equipment. Receiving or off loading of the Hoyer supplied equipment. Call of lubricants. Leaflets enclosed serve for informative purposes only, and any special features or optional extras are only included in our delivery if specifically mentioned in this quotation.	rarmaia	at Ice Cream	30-May-00
installation materials, tools, expendables, etc. This is to be customer supplied upon request. 6. Supply or installation of refrigeration equipment required for the system's operation nor the required connections between such refrigeration equipment and the Hoyer supplied equipment. Excl. circulation pump, pipes and fittings and insulation. 7. Any building construction modifications or materials which may be required. 8. Supply or installation of any sanitary or CIP piping to or from the Hoyer supplied equipment. 9. Receiving or off loading of the Hoyer supplied equipment. 10. Oil or lubricants. Leaflets enclosed serve for informative purposes only, and any special features or optional extras are only included in our delivery if specifically mentioned in this quotation. ***********************************	Qty		EURO
features or optional extras are only included in our delivery if specifically mentioned in this quotation. ********** We hope our quotation is in accordance with your wishes and look forward to receiving your order. Should you have any further questions we are of course at your disposal with further information.		 installation materials, tools, expendables, etc. This is to be customer supplied upon request. 6. Supply or installation of refrigeration equipment required for the system's operation nor the required connections between such refrigeration equipment and the Hoyer supplied equipment. Excl. circulation pump, pipes and fittings and insulation. 7. Any building construction modifications or materials which may be required. 8. Supply or installation of any sanitary or CIP piping to or from the Hoyer supplied equipment. 9. Receiving or off loading of the Hoyer supplied equipment. 10. Oil or lubricants. 	
********* We hope our quotation is in accordance with your wishes and look forward to receiving your order. Should you have any further questions we are of course at your disposal with further information.		features or optional extras are only included in our delivery if specifically	
to receiving your order. Should you have any further questions we are of course at your disposal with further information.			
Yours faithfully,		to receiving your order. Should you have any further questions we are of	
•		Yours faithfully,	
· -			



1-Streightline-400 (h=2490)

2-R22 air cooler

3-R22 refrigeration unit

4-Pick-up for sticks

5-Pick-pack wrapping machine

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\$ 7	_	SL400 - DIMENSIONS	SL COII
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INDICATIVE EXAMPLE, INTEREST RATE SUBJECT TO CONFIRMATION

Customer/Kunde/Client: Parmalat, South Africa

31-05-00

Date/Datum/date

3 YEARS Rent

Quarterly payments

Amount/Betrag/Somme		EUR 371.500
C.I.F. cost/kosten/frais		٥
Adv.Paym./VorrausZ/Paym.Anticip:	15%	55.725
To be financed/Finanzier./		315.775

EUR

Currancy/Wart/Cours

Condition:

1)Bank Guarantee from 1st Class Bank

2) Separate Contract

3 Years lease.Quarterly payments

INTEREST RATE:

Security/Sicherneit/Caution:

7,50% p.a. fixed

INIERESI MAIE;	7,50 % p.a.	IIACU	[Payme∩t		
Date/Datum/date	Termin	Instalm/Abz/Mensua	alt Int./Zins/Int.	Arriere Total	Balance Begin	Balance End
01-09-00	1	23.635	5.921	29.556	315.775	292.140
01-12-00	2	24.078	5. 4 78	29.556	292.140	268.062
01-03-01	3	24.530	5.026	29.556	268.062	243.532
01-06-01	4	24.989	4.566	29.556	243.532	218.543
01-09-01	5	25.458	4.098	29.556	218.543	193.085
01-12-01	6	25.935	3.620	29.556	193.085	167.150
01-03-02	7	26.422	3.134	29.556	167.150	140.728
01-06-02	8	26.917	2.639	29.556	140.728	113.811
01-09-02	9	27.422	2.134	29.556	113.811	86.389
01-12-02	10	27.936	1.620	29.556	86.389	58.453
01-03-03	11	28.460	1.096	29.556	58.453	29.993
01-06-03	12	28.993	562	29.556	29.993	1.000
		314.775	39.894	354.669		

* Communing

DKK ± 100000 includig Slight, board, lodging, etc 3 w/s.

* CIF Ctains ex Denas Egipt Isration Late Jely 1 Edy Aug. 00

DRAFT PROPOSAL

Lease Agreement No. S.A. - 2000 - 1001 - 01

1)	This Lease Agreement is an integrated part of orderconfirmation no
١.,	dated 2000. between Tetra Pak Hoye
	A/S, Søren Nymarksvej, 8270 Højbjerg, hereafter referred to as the
	Lessor and

Parmalat Ice Cream - South Africa

in the following referred to as the Lessee.

- 2.) The Lessor will let out and the Lessee will rent the equipment specified in the the above mentioned order confirmation hereafter referred to as "the Equipment" under the terms and conditions laid out herein.

The total price of the Equipment is Euro 371.500,- FCA Aarhus, Denmark (Incoterm 1990), packing included. All other conditions according to contract.

- 4.) The Equipment is rented for use at the address of Lessee only.
- 5.) No costs and charges, taxes, duties of whatsoever nature in connection with import of the Equipment are included in the above amount and shall, if any, be paid directly by the Lessee.
- 6.) The Leasing Period is to be understood from delivery of the Equipment at the Lessee's address, and during the forthcoming 36 months. Delivery is expected to take place week xx 2000. First payment under the lease contract to take place 1 xx 2000.

7.) It has been agreed that Payment will take place as follows:

Down payment:

15% i.e Euro 55,725

12 Quarterly rates of:

Euro 29,556

according to the enclosed

schedule, first time xxx, 1st 2000 and the

succeeding 11 quaters.

Invoices will be presented to the Lessee concerning each payment. The due dates for payments are as mentioned above or the first banking day following immediately after the above-mentioned dates. A penalty fee of 2.0% of the amount due per starting month will be charged in case the payment has not been credited Tetra Pak Hoyer A/S's account No. 3627-3258-133897 with Den Danske Bank, Copenhagen, Holmens Kanal 2-12, 1092 Copenhagen on due date. All payments are to be secured by a bank guarantee from a first Class Bank.

- 8.) All costs in connection with payments of the Rental Fee as e.g. but not limited to taxes, fees, commission, V.A.T., withholding tax and duties are not included in the Rental Fee and are to be paid directly by the Lessee and are of no concern to the Lessor.
- 9.) This lease agreement is a net Lease amount, and by signing this agreement the Lessee gives his consent to pay all Rent. The right of the Lessor or any assignee in and to such Rent is unconditional and not subject to counterclaims, set-offs or the like of whatever nature.
- 10.) The Lessee is obliged at his own cost to keep the Equipment adequately insured, equivalent to the full and new value of the equipment.

Furthermore, the Lessee agrees that the Lessor shall not be liable to the Lessee for any loss, liability or proceedings with respect to any injury or damage of whatsoever nature and whatsoever cause arising out of or in connection with the Equipment or the use thereof.

The Lessee shall take out a Liability Insurance, including product liability according to local law.

The Lessee is obliged to use the Equipment according to the Lessor's instructions.

31-05-00 Page 2 of 5

- 11.) The enclosed "General Conditions of Sale and Delivery" No. QT 80008 E9 shall apply unless anything to the contrary is stated in order, order confirmation or the parties agree to the contrary in writing.
- 12.) The Lessee will at his sole expense keep the Equipment free and clear of all levies, liens and encumbrances. The Equipment shall be equipped with a sign stating that it is the property of Tetra Pak Hoyer A/S. Tetra Pak Hoyer A/S reserves the right to inspect the condition of the equipment at any time and, if necessary, to request a repair at the expense of the Lessee.
- 13.) This Lease Agreement is a valid contract when signed by both Lessor and Lessee, not later than (to be decided !) and when the bank guarantee has been received and accepted by Tetra Pak Hoyer A/S
- 14.) The Lessor has the right to assign, forfait, transport or sell the whole or part of the Bank Guarantee, if any, and the leasing contract to any third party.
- 15.) Together with the down payment the Lessee is obliged to forward documentation stating that all licences and import permits have been obtained and paid, or stating that such permits are not required.
- 16.) The Lessee shall keep the Equipment in good repair, condition and working order at all times during the Lease Term. The Lessee shall, at his own cost and expense, furnish all parts, mechanisms and devices required for proper operation and maintenance of the Equipment. This does not exclude Hoyer's obligations under the 12 months guarantee period, according to the enclosed general conditions of Sale and Delivery.

Maintenance of the Equipment shall be performed by the Lessee in accordance with the directions given by the Lessor as well as any supplementary directions given by the Lessor or by the Lessor's designated agent.

The Lessee shall only permit the Equipment to be repaired by a person or persons approved by the Lessor and to use only spare parts supplied by the Lessor or by an agent designated by the Lessor. The

Lessee shall immediately inform the Lessor of any defect(s) that has appeared on the Equipment.

The Lessee shall not make any alterations or adjustments to the Equipment nor do anything which might affect its proper working without Lessor's prior written consent.

The Lessee agrees to use the Equipment solely for the type of operations originally envisaged unless otherwise has been agreed with the Lessor.

The Lessee shall use the Equipment in a careful and proper manner. In conformity with the Lessor's and/or the manufacturer's instruction manual and shall comply with, and conform to, all federal, state, municipal or other laws, ordinances and regulations in any way relating to the possession, use or maintenance of the Equipment.

The Lessor and/or the Lessor's designated agent shall have the right from time to time during reasonable business hours to enter upon the Lessee's premises or elsewhere for the purpose of inspecting the Equipment, observing its use and operation and making alterations, improvements or additions thereto as the Lessor shall deem desirable.

17.) <u>Title</u>

The Lessee shall have no right, title or interest in the Equipment other than the right of full enjoyment and use of the Equipment for the full Lease Term (including any Additional Lease Term) provided that no Event of Default has occurred.

The Lessor may require labels, plates or other markings to be affixed to or placed on the Equipment, indicating the Lessor as owner of the Equipment, and the Lessee agrees to affix and keep the same prominently displayed on the Equipment.

The Lessor and the Lessee hereby confirm their intent that the Equipment shall always remain and be deemed movable property, even though said Equipment may hereinafter become attached or affixed to real property.

The Lessee further agrees to execute and deliver instruments, documents or other forms necessary and/or desirable by the Lessor to protect the Lessor's ownership in the Equipment.

Lessee guarantees Lessor's free access, including trespassing to the leased equipment.

31-05-00 Page 4 of 5

18.) This Lease Agreement shall, in all respect, be governed and construed in accordance with the laws of the Kingdom of Denmark.

All disputes arising out of or in connection with this Lease Agreement shall be finally settled in Copenhagen, under the Rules of Conciliation and Arbitration of the International Chamber of Commerce by one or more arbitrators appointed in accordance with those rules.

Notwithstanding the foregoing, the Lessor shall have the right at his absolute discretion to refer any dispute to the proper court in the territory where the Lessee has his legal residence.

19.) At the end of the leasing period Lessee has the option to buy the equipment for Euro 200,- or a fair market value, whatever is the cheapest - or to prolong this agreement for 12 months for the amount of Euro 200,- pr month as lease payment for this period. The Lessee is obliged to inform Lessor which of the options he chooses 2 months before the turnover of the original leasing period.

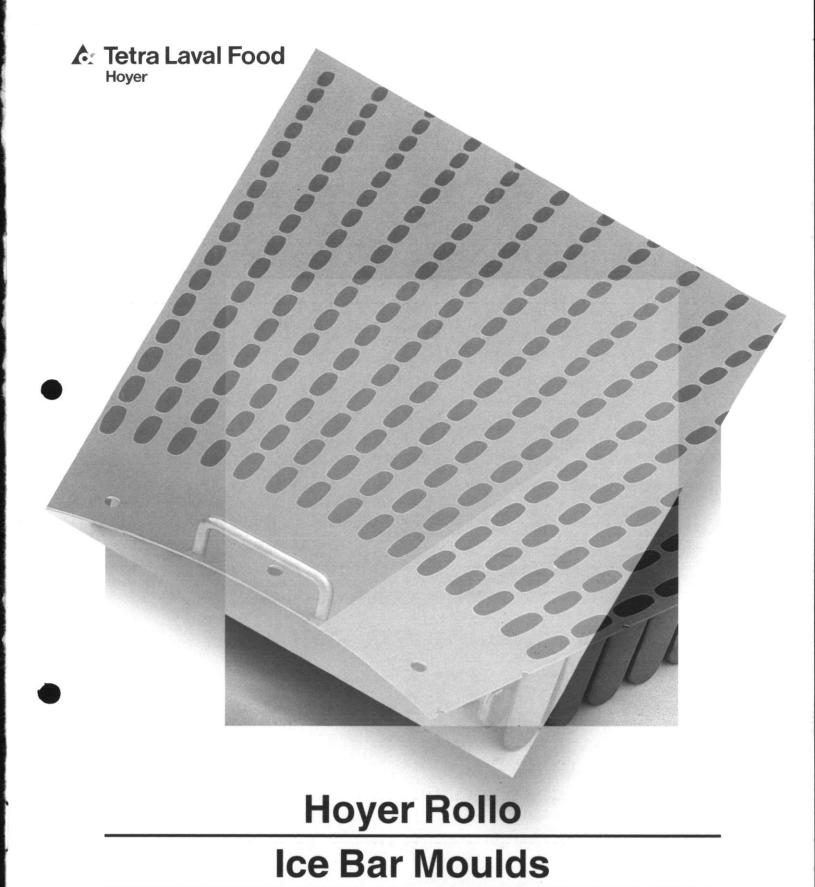
<u>Termination</u> of the contract can take place provided that *Lessee* pays to the *Lessor* the remaining balance and a termination fee of DKK 25.000,- All tax related issues in that connection, and in general is the responsibility of the Lessee and of no concern of the *Lessor*

If the Lessee terminates the Lease Agreement by <u>not paying</u> according to the contract, the Lessee is obliged to dismantle and return the Equipment to Lessor without cost for Lessor and to pay that part of the remaining balance consisting of instalments plus an additional fee of 2% of the same balance.

20.) This contract is made in 2 originals of which the Lessee holds 1, and the Lessor 1.

This edition cancels all previous editions and drafts.

Lessee: Parmalat Ice Cream	Lessor: Tetra Pak Hoyer A/S.
authorised signature	authorised signature
witness to the signature	witness to the signature



Rollo Mould Brochure

Stick Novelty Production

Stick novelties make up a very important part of the ice cream market. In many countries the world over they are still the most sold ice cream novelty, confirming their continued popularity and, not least, their profit potential.

Tetra Laval Food Hoyer has been producing stick novelty processing machines, the well-known Rollo rotary bar freezers, for more than four decades. In cooperation with our customers we have continued to develop new and more efficient models to meet the changing requirements of the industry.

Today, Tetra Laval Food Hoyer offers different Rollo models with capacities ranging from 5,000 to more than 30,000 stick novelties per hour.

Hoyer Rollo Mould Catalogue

In this catalogue we illustrate various types of ice cream moulds. Many other mould designs with a volume of up to approx. 150 ml (5 fl.oz.) can be supplied on request.

Mould Table Production

The Rollo mould table consists of a stainless steel top piate into which the actual moulds are welded. The stainless steel used for producing the top plate is type SS 2353 which has excellent acid and

heat resistance properties. Standard Hoyer mouids are produced from stainless steel type SMO 254 which means that the two main components of the mould table react uniformly to mechanical influences and the constant temperature changes between the hot and cold brine solutions.

Hoyer moulds are normally manufactured from two halves which are welded together. This ensures that the mould wall is of even thickness throughout which inhibits internal tension and provides uniform freezing. However, if desired and if the design of the mould allows, drawn mouids can be supplied. In addition, Hoyer is also abie to supply nickel moulds if these are preferred.

Rollo mould tables are manufactured in our workshop under strict supervision to ensure that they meet the very demanding requirements of stick novelty production. Every mould table is subjected to stringent control before it leaves our factory.

Service

On request, our qualified service personnel can carry out a full service check of your Rollo mould table either at pre-agreed intervals or whenever you feel that a check may be necessary. On the basis of the service visit we will be able to advise you of whatever maintenance or overhaul work is required.

Calculation of Volume

The ice volume of a bar is equal to the net. volume of the ice bar product extracted from the mould.

The net. volume of the product is the total volume of the product including e.g. dry stuff and chocolate coatings.

Volume of the mould is measured from the bottom of the mould to a vertical line in the mould.

Residual from defrosting will always occur and can be calculated to 3% of the total volume as an average value.

All data contained in this publication are related to the ice volume of the bar. If divergations should occur, this will be notified.

For calculating the volume of the pocket, Tetra Laval Food Hoyer uses the following formula: Ice volume of the bar + 1 ml. for the stick + 3% for defrosting.

Before producing the mould table, a drawing or product sample should be approved and returned to Tetra Lavai Food Hoyer.

Smaller diviations between the shape indicated on the drawing and the final product must be anticipated and accepted.

An average distance between the top of the mould table and the filled ice top will typically be between 5 and 12 mm.

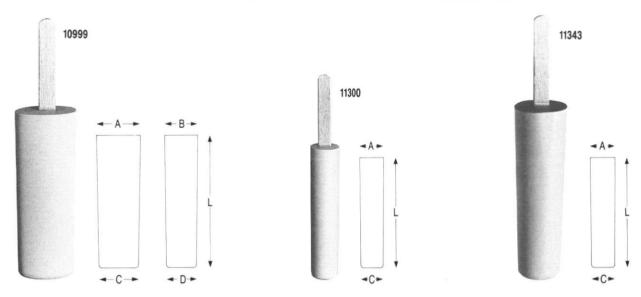
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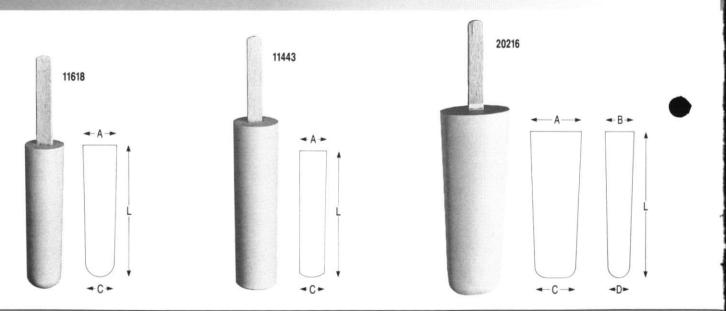
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Oval and Cylindric Moulds



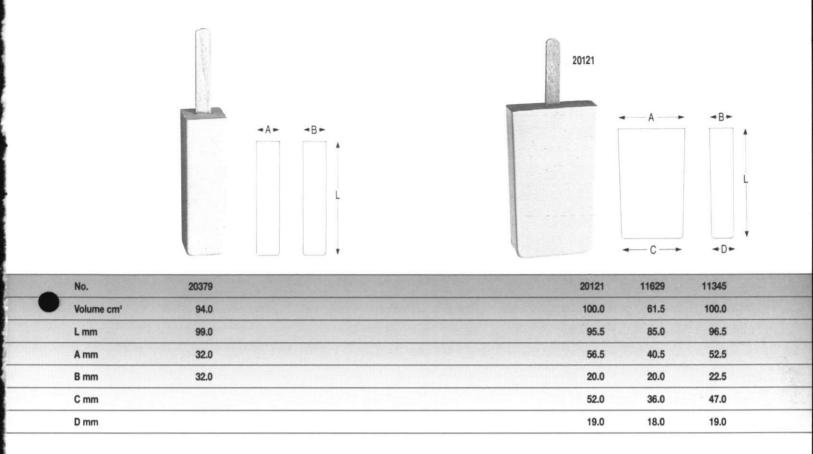
No.	11323	10999	20704	11300	11793	20473	11165	11443	20941	20959	21066	21094	21119	21143	21149	21160	21019	11343	20843	20826
Volume cm ³	78.0	90.0	103.0	31.5	41.0	46.5	32.5	58.5	69.0	104.0	65.0	90.0	78.0	103.0	38.0	103.0	36.5	65.0	6	78.0
L mm	115.0	115.0	144.0	96.0	96.0	104.0	90.0	115.0	116.0	130.0	114.0	134.0	114.0	130.0	107.0	144.0	90.0	114.0	115.0	114.0
A mm	44.0	36.0	31.5	21.0	23.5	25.0	23.0	28.0	29.0	34.0	28.0	30.5	34.6	32.4	23.5	31.5	23.5	28.0	29.0	33.0
B mm	20.0	28.0																		
C mm	40.0	33.0	29.0	20.0	22.0	23.0	20.5	23.5	26.0	30.0	26.0	28.0	27.0	28.4	20.5	29.0	22.0	26.0	26.0	27.0
D mm	18.0	26.0														- 12	11 11			

Oval and Cylindric Moulds



N	0.	20269	11618	20932	20973	21006	21019	11701
Vo	olume cm³	41.0	43.0	37.0	40.0	40.0		68.0
L	mm	108.0	110.0	100.0	108.0	108.0	90.0	118.0
A	mm	23.0	23.0	23.0	23.0	23.4	23.5	41.0
В	mm							25.0
С	mm	21.5	21.5	20.5	21.5	20.5	22.0	31.0
D	mm	en en en en						17.0

Box Shaped Moulds



Box Shaped Moulds



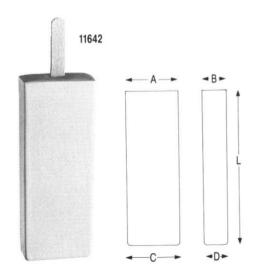
No.	20311	11764	11887	20131	20904	
Volume cm ³	44.0	44.5	57.5	59.5	44.5	
L mm	80.0	73.0	80.0	88.0	73.0	
A mm	37.0	28.0	30.0	35.0	28.0	
B mm	15.0	22.0	24.0	20.0	22.0	
C mm				34.0		
D mm				19.0		

Box Shaped Moulds



No.	11896	11556	11307	11484	
Volume cm ³	60.0	65.0	75.5	81.0	
L mm	100.0	95.0	98.0	90.0	
A mm	35.0	38.0	42.0	50.0	
B mm	20.0	18.0	19.0	18.0	
C mm	31.0				
D mm	16.0				

Box Shaped Moulds



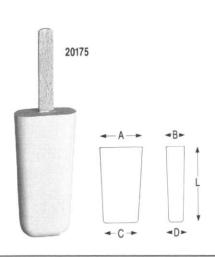
No.	20156	11912	20776	11404	20867	11642	11543	21099	20966	20906	21147	21129	
Volume cm ³	82.0	83.5	92.0	93.0	114.0	122.0	127.0	125.0		78.0	86.0	86.0	
Lmm	92.0	103.0	89.0	100.0	111.0	128.0	135.0	135.0		93.0	98.0	98.0	
A mm	42.0	45.0	41.0	50.0	49.0	47.0	44.5	44.5	45.0	47.0	49.0	49.0	
B mm	22.0	18.0	27.0	19.0	23.0	21.0	22.5	22.5	23.0	19.0	19.5	19.5	
C mm	41.0		39.0		46.0			43.5	43.0	46.0	47.0	47.0	
D mm	21.0		25.0		21.0			21.5	21.0	18.0	18.0	18.0	

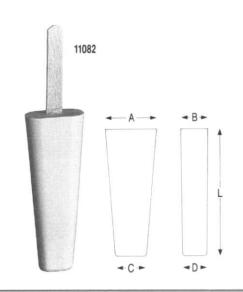
Spade Shaped Moulds



No.	20320	11754	20190	21124
Volume cm ³	65.0	70.0	128.0	128.0
L mm	108.0	107.0	132.0	132.0
A mm	38.0	38.0	49.0	49.0
B mm	20.0	23.0	23.0	23.0
C mm	32.0	31.0	41.0	41.0
D mm	17.0	17.0	21.0	21.0

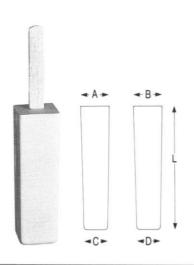
Spade Shaped Moulds





No.	11050	11672	11154	20175	11894	20817	20368	20468	11082	20396	
Volume cm ³	30.0	42.0	44.0	48.0	50.0	50.0	59.0	70.0	68.0	40.0	
L mm	66.0	88.0	81.0	88.0	100.0	96.0	112.0	116.0	111.0	100.0	
A mm	37.0	39.5	44.5	41.5	40.0	40.0	43.0	42.0	43.5	36.0	
B mm	16.5	17.5	18.5	18.5	18.0	18.0	18.0	21.0	23.0	18.0	
C mm	30.0	30.0	34.0	34.0	30.0	34.0	33.5	35.0	26.0	22.0	
D mm	13.0	13.5	14.0	14.5	14.0	14.0	13.0	17.0	22.0	14.0	

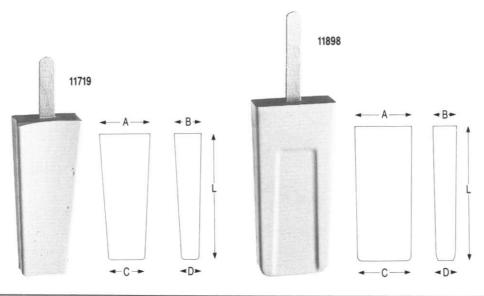
Spade Shaped Moulds





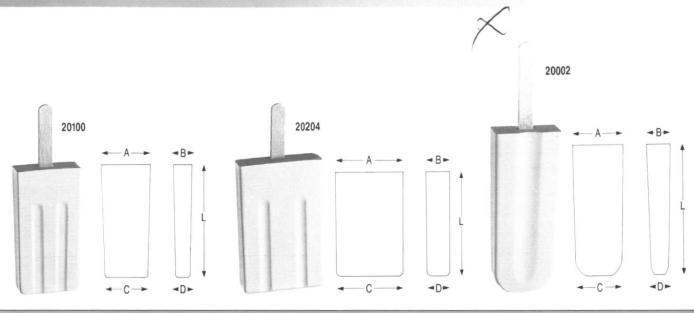
No.	11087	21155	11798	11089	20599	20044	20680	20806	11932	21111	20951	20924	20953	20923	21118	21053	
Volume cm ³	52.0	65.0	50.0	65.0	65.0	68.0	75.0	89.0	123.0	89.0	62.0	65.0	74.0	50.0	50.0	82.	
Lmm	108.0	99.0	100.0	114.0	116.0	94.0	105.0	110.0	115.0	110.0	104.0	100.0	98.0	100.0	100.0	104.0	
A mm	24.0	26.5	36.0	41.5	38.0	46.5	51.5	52.0	65.0	52.0	43.0	35.0	49.0	36.0	36.0	47.0	
B mm	24.0	26.5	18.0	19.0	19.5	20.5	19.0	20.5	23.5	17.5	16.5	20.5	20.0	16.0	18.0	20.5	
C mm	20.0	25.5	31.0	35.5	32.0	42.5	47.0	44.0	55.0	44.0	39.5	34.0	47.0	35.0	31.0	42.5	
D mm	20.0	25.5	15.5	15.5	16.0	15.5	13.0	17.3	18.0	11.3	15.0	19.,5	15.0	15.0	15.4	18.4	

Spade Shaped Moulds



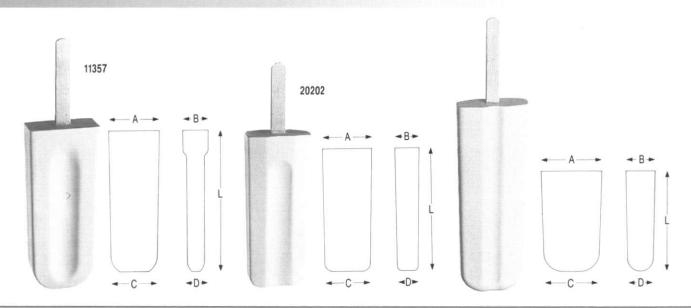
	No. 11	719 1	1898 2	20072	
,	/olume cm³ (65.0	90.0	90.0	
ı	. mm 11	10.0	116.0	118.0	
,	A mm	12.0	50.0	49.0	
E	3 mm	22.5	20.0	20.0	
(C mm	30.0	46.0	46.0	
	O mm	15.0	16.0	16.0	

Spade Shape Moulds



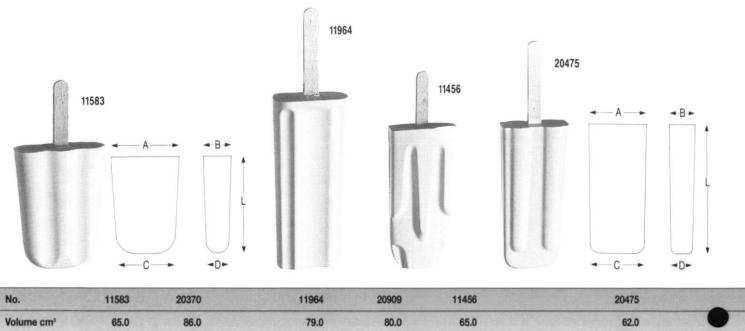
No.	20067	20100	20204	21041	21057	20002	20466	
Volume	cm³ 55.0	67.0	100.0	68.5	75.0	80.0	80.0	
L mm	99.0	90.0	91.5	109.0	116.0	115.0	115.0	
A mm	42.5	44.0	58.0	45.0	45.0	43.0	42.0	
B mm	16.0	19.0	20.0	18.6	18.6	20.0	20.5	
C mm	37.0	42.0	57.0	40.5	40.5	39.0	39.0	
D mm	13.0	17.0	19.0	16.5	16.5	19.6	18.0	- 10

Spade Shape Moulds



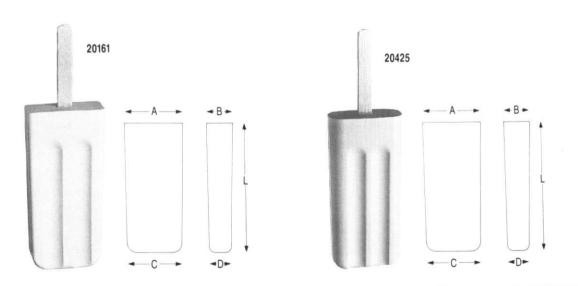
No.	11357	11148	20202	11707	11311	10862	20049	20805	11364	20601	
Volume cm ³	91.0	100.0	70.0	75.0	82.0	90.0	98.0	98.0	100.0	102.0	
L mm	114.0	124.0	108.0	88.0	128.0	104.0	132.0	132.0	110.0	120.0	
A mm	44.0	44.5	42.0	52.0	44.0	49.5	47.5	47.0	53.5	47.5	
B mm	22.5	22.5	20.5	25.0	21.0	25.5	22.5	22.0	26.0	25.5	
C mm	40.0	40.0	38.5	46.0	42.0	42.5	42.5	42.5	46.0	42.5	
D mm	20.5	20.5	17.5	22.0	18.0	22.0	19.0	19.5	22.0	22.0	
											_

Spade Shape Moulds



No.	11583	20370	11964	20909	11456	20475	
Volume cm³	65.0	86.0	79.0	80.0	65.0	62.0	
Lmm	84.0	110.0	118.0	115.0	100.0	100.0	
A mm	57.0	53.0	47.0	50.0	46.0	45.0	
B mm	23.5	23.5	21.5	21.5	21.0	20.0	
C mm	48.0	48.0	42.5	41.0	42.0	40.0	
D mm	19.0	19.0	18.5	15.0	14.0	17.0	

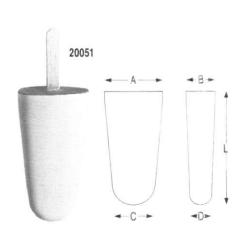
Spade Shape Moulds



No.	20665	20869	20161	21101	21120	21060	21123	21135	21148	21145	20899	20425
Volume cm³	59.2	84.0	96.0	96.0	81.5	118.0	75.0	96.0	89.0	89.0-74.0	96.0	85.0
L mm	92.0	115.0	112.0	115.0	101.0	118.0	107.0	114.0	110.0	104.0-92.0	115.0	106.0
A mm	48.0	49.0	49.0	49.0	49.0	51.5	49.0	49.0	49.0	49.0	49.0	49.0
B mm	20.6	22.0	22.0	22.0	22.0	24.0	20.0	22.0	22.0	22.0	22.0	21.5
C mm	42.0	42.0	46.0	46.0	46.0	48.0	46.3	46.0	46.0	46.0	46.0	46.0
D mm	16.5	15.0	18.5	18.5	18.5	22.0	16.0	18.5	18.5	18.5	18.5	18.5
	Volume cm³ L mm A mm B mm C mm	Volume cm³ 59.2 L mm 92.0 A mm 48.0 B mm 20.6 C mm 42.0	Volume cm³ 59.2 84.0 L mm 92.0 115.0 A mm 48.0 49.0 B mm 20.6 22.0 C mm 42.0 42.0	Volume cm³ 59.2 84.0 96.0 L mm 92.0 115.0 112.0 A mm 48.0 49.0 49.0 B mm 20.6 22.0 22.0 C mm 42.0 42.0 46.0	Volume cm³ 59.2 84.0 96.0 96.0 L mm 92.0 115.0 112.0 115.0 A mm 48.0 49.0 49.0 49.0 B mm 20.6 22.0 22.0 22.0 C mm 42.0 42.0 46.0 46.0	Volume cm³ 59.2 84.0 96.0 96.0 81.5 L mm 92.0 115.0 112.0 115.0 101.0 A mm 48.0 49.0 49.0 49.0 49.0 49.0 B mm 20.6 22.0 22.0 22.0 22.0 C mm 42.0 42.0 46.0 46.0 46.0	Volume cm³ 59.2 84.0 96.0 96.0 81.5 118.0 L mm 92.0 115.0 112.0 115.0 101.0 118.0 A mm 48.0 49.0 49.0 49.0 49.0 51.5 B mm 20.6 22.0 22.0 22.0 22.0 24.0 C mm 42.0 42.0 46.0 46.0 46.0 48.0	Volume cm³ 59.2 84.0 96.0 96.0 81.5 118.0 75.0 L mm 92.0 115.0 112.0 115.0 101.0 118.0 107.0 A mm 48.0 49.0 49.0 49.0 49.0 51.5 49.0 B mm 20.6 22.0 22.0 22.0 22.0 24.0 20.0 C mm 42.0 42.0 46.0 46.0 46.0 48.0 46.3	Volume cm³ 59.2 84.0 96.0 96.0 81.5 118.0 75.0 96.0 L mm 92.0 115.0 112.0 115.0 101.0 118.0 107.0 114.0 A mm 48.0 49.0 49.0 49.0 49.0 51.5 49.0 49.0 B mm 20.6 22.0 22.0 22.0 22.0 24.0 20.0 22.0 C mm 42.0 42.0 46.0 46.0 46.0 48.0 46.3 46.0	Volume cm³ 59.2 84.0 96.0 96.0 81.5 118.0 75.0 96.0 89.0 L mm 92.0 115.0 112.0 115.0 101.0 118.0 107.0 114.0 110.0 A mm 48.0 49.0 49.0 49.0 49.0 51.5 49.0 49.0 49.0 B mm 20.6 22.0 22.0 22.0 22.0 24.0 20.0 22.0 22.0	Volume cm³ 59.2 84.0 96.0 96.0 81.5 118.0 75.0 96.0 89.0 89.0-74.0 mm 92.0 115.0 112.0 115.0 101.0 118.0 107.0 114.0 110.0 104.0-92.0 mm 48.0 49.0 49.0 49.0 49.0 51.5 49.0 49.0 49.0 49.0 49.0 8 mm 20.6 22.0 22.0 22.0 22.0 24.0 20.0 22.0 22.0	Volume cm³ 59.2 84.0 96.0 96.0 81.5 118.0 75.0 96.0 89.0 89.0-74.0 96.0 mm 92.0 115.0 112.0 115.0 101.0 118.0 107.0 114.0 110.0 104.0-92.0 115.0 mm 48.0 49.0 49.0 49.0 49.0 51.5 49.0 49.0 49.0 49.0 49.0 49.0 49.0 8 mm 20.6 22.0 22.0 22.0 22.0 22.0 22.0 22.0

Tongue Shaped Moulds

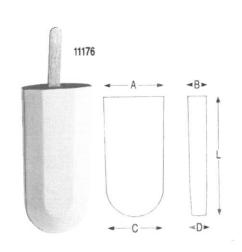




	No.	11748	11406	10644	11253	11344	21040	21028	20925	20948	20974	20982	20051	
疆	Volume cm ³	60.0	60.0	60.0	80.0	100.0	102.0	90.0	90.0	59.0	92.0	80.0	55.5	
	L mm	90.0	92.0	88.0	87.0	108.0	102.0	99.0	96.0	88.0	102.0	120.0	91.0	
	A mm	42.0	44.0	50.0	50.5	52.5	53.0	52.5	51.0	49.8	49.0	42.0	49.0	
	B mm	20.0	18.0	20.5	22.0	21.0	23.0	21.0	22.0	20.5	22.0	20.0	24.0	
	C mm	36.0	40.0	40.0	46.0	46.0	50.0	46.0	48.0	40.0	46.0	36.0	35.0	
	D mm	17.0	15.0	12.0	19.0	19.0	19.0	19.0	19.0	12.0	19.0	17.0	15.0	

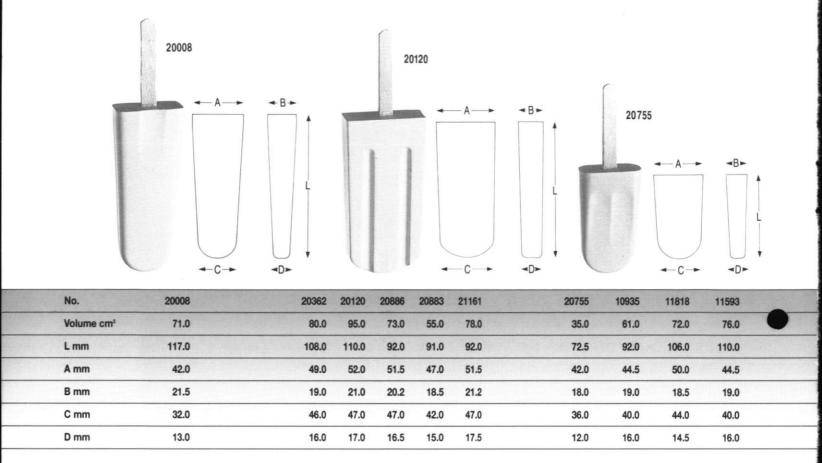
Tongue Shaped Moulds



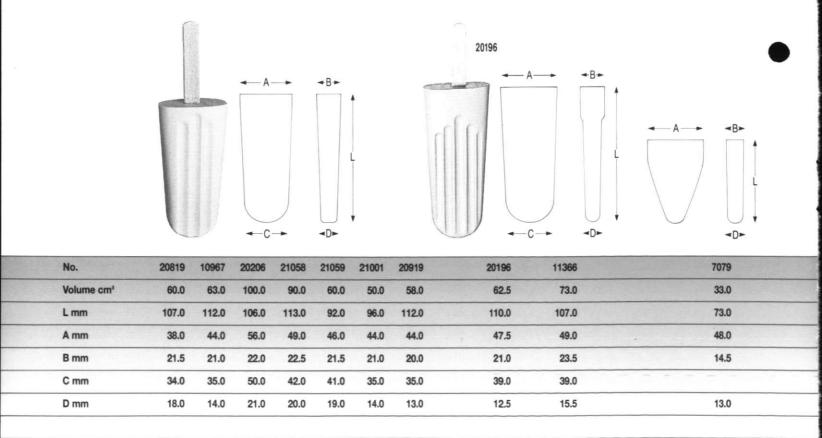


No.	20659	20793	20674	20700	11645	20702	20911	21140	21159	21162	11804	11176	20871	20939	
Volume cm³	62.0	65.0	70.0	75.0	83.0	89.0	54.5	89.0-74.0	89.0	75.0	61.0	61.0	56.0	56.0	
L mm	114.0	100.0	124.0	120.0	111.0	120.0	97.0	121.0-104.0	120.0	12.0	105.0	105.0	98.0	102.0	
A mm	48.0	54.0	52.0	51.0	53.0	51.5	46.7	51.5	51.5	50.7	49.0	51.0	51.0	49.0	
B mm	18.0	18.5	18.0	19.0	21.0	21.0	48.4	21.0	21.0	18.6	16.0	16.0	16.0	16.0	
C mm	40.0	46.0	46.0	42.0	45.0	43.0	40.0	43.5	43.5	42.0	47.0	47.0	47.0	47.0	
D mm	14.0	13.0	14.0	15.0	17.0	17.0	15.0	17.0	17.0	17.0	14.5	14.5	14.5	14.5	

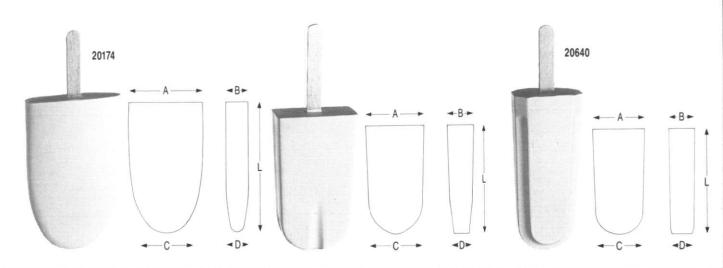
Tongue Shaped Moulds



Tongue Shaped Moulds

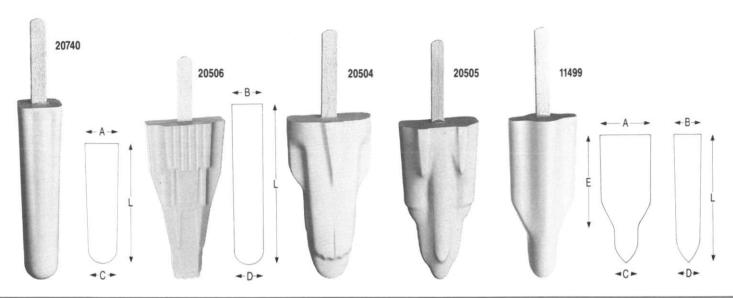


Tongue Shaped Moulds



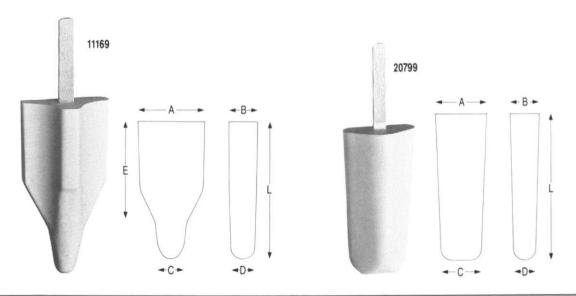
No.	20174	21134	21013	21018	20359	21071	20208	20640	
Volume cm ³	84.0	86.0			89.0	89.0	60.0	75.0	
Lmm	106.0	99.0			98.0	95.0	92.0	112.0	
A mm	63.5	99.0			49.0	51.2	44.0	44.0	
B mm	19.0	59.0	44.0	48.5	22.5	22.5	22.0	22.0	
C mm	44.0	22.0	20.5	20.2	46.0	46.0	39.0	37.0	
D mm	10.0	13.0			13.0	13.0	18.0	18.0	

Special Shapes



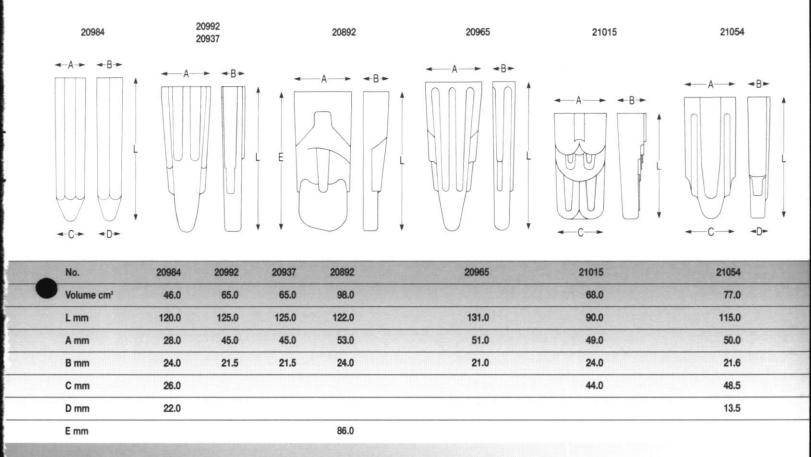
No.	20740	21106	21158	21075	20963	20506	20504	20505	11499	21132	
Volume cm³	60.0	52.0	52.0	45.0	52.0	65.0	65.0	65.0	50.0	50.0	
Lmm	125.0	110.0	113.0	99.0	113.0	110.0	110.0	110.0	112.0	112.0	
A mm	27.5	27.9	27.0	26.0	27.5	53.0	53.0	53.0	44.0	44.0	
B mm	24.5	24.9	24.0	24.0	24.5	23.0	23.0	23.0	23.0	23.0	
C mm	22.0	22.0	22.0	23.3	22.0				20.0	20.0	
D mm									20.0	20.0	
E mm									82.0	89.0	

Special Shapes

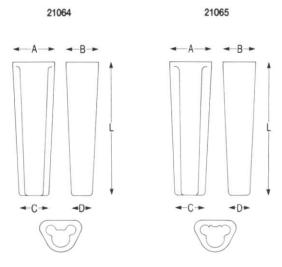


No.	11169	20799	21127
Volume cm³	69.0	74.0	
L mm	120.0	102.0	
A mm	56.0	49.0	53.0
B mm	25.0	24.0	24.0
C mm	22.0	42.0	42.0
D mm	20.0	20.0	19.0
E mm	85.0		

Special Shapes (pockets illustrated)

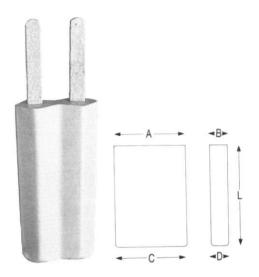


Special Shapes (pockets illustrated)



No.	21064	21065	
Volume cm ³			
L mm	124.0	124.0	
A mm	38.0	38.0	
B mm	29.5	29.5	
C mm	27.0	27.0	
D mm	20.5	19.0	

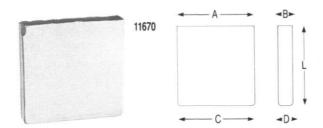
Twin Sticks





No.	20336	20727	20715	21144	20264	20125	21122	
Volume cm³	60.0	75.0	75.0	74.0	80.0	115.0	75.0	
L mm	110.0	106.0	114.0	105.0	98.0	105.0	117.0	
A mm	49.0	51.0	51.0	49.0	54.0	65.0	49.0	
B mm	17.0	24.5	21.5	24.5	22.0	27.0	19.5	
C mm	47.0	45.0	45.0	47.0	50.0	51.0	43.0	
D mm	16.0	22.0	19.0	22.0	19.0	23.0	17.0	

Stickless Products



	No.	11670
O	Volume cm ³	75.0
	L mm	94.0
	A mm	60.0
	B mm	15.0
	C mm	59.0
	D mm	14.0

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PRODUCT EXAMPLES					
	One-coloured ice cream	Bottom filled one-coloured ice cream	Two-coloured ice cream vertically divided	Two-coloured ice cream vertically divided »zebra pattern«	Two-coloured ice cream concentric
STANDARD EQUIPMENT REQUIRED	*1		1	1	1
OPTIONAL EQUIPMENT REQUIRED		4	5	5+6	5+7
PRODUCT EXAMPLES					
	Two-coloured ice cream horizontally divided	One-coloured water ice	Two-coloured water ice horizontally divided	Three-coloured water ice horizontally divided	Split ice
STANDARD EQUIPMENT REQUIRED	1				
OPTIONAL EQUIPMENT REQUIRED	8	9	9+9	9+9+9	9+10
PRODUCT EXAMPLES					
	One-coloured water ice, two different colours per radial row	Two-coloured water ice vertically divided (twin type)	Pencil filled ice cream	Chocolate coated bars	Dry coated ice cream
STANDARD EQUIPMENT REQUIRED		1	1	1+2	1+2
OPTIONAL EQUIPMENT REQUIRED	11	12	13		15

^{*} The numbers in this table refer to list of optional equipment on previous page.

Technical Data

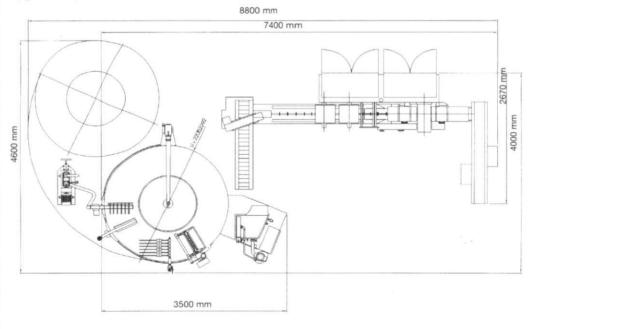
Electrical Power

Electrical Power			Brine Quantity	800 litres/ 1,048 kg			
Main consumption:		10 kW		(211.5 gall./ 2,311lbs)			
Connection:	nection: 3 x 400 Volts AC, 50/60 Hz		Air Consumption	300 litres/min.			
Optional: according to customer specification cable for main drive according to			ions and		79.3 gall./min.		
regulations.				Weight In »ready-to-work« condition			
Defrosting E	lements			approx.	8,500 kg	(18,743 lbs)	
Heating elements max. 18 kW Low pressure steam 36 kg/h		ax. 18 kW 36 kg/h	Shipping Data				
		anteinity or by		Net weight	6,500 kg	(14,330 lbs)	
Warm brine, heated either by electricity or by steam. The choice must be made when ordering, otherwise electric				Gross weight	8,000 kg	(17,640 lbs)	
	be installed as sta		ise electric	Volume	30 m^3	(1,059 cu.ft.)	
Pipe Connect				Main Dimensions Height of work table above flo	oor 1,100) mm (43.5")	
recirculation	iic, giavity	15 mm	(1/2")				
NH3 liquid li	ne, pump						



of the continuous freezer.

recirculation NH3 suction line Main inlet for air



(1/2")

15 mm

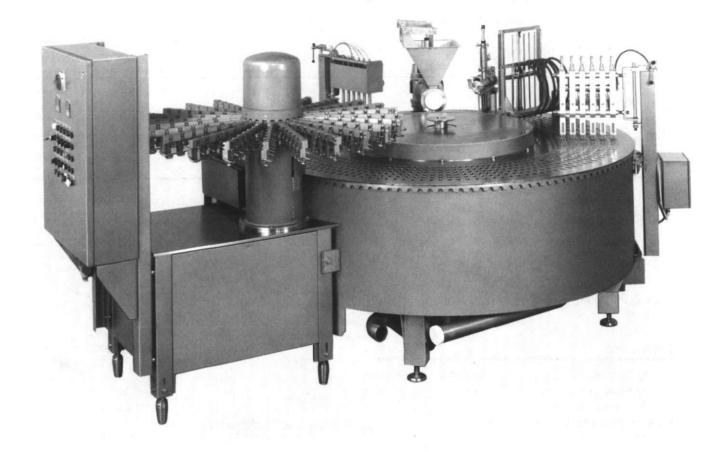
Piping dimensions for ice cream not less than the outlet

↑ Tetra Pak Hoyer

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Product Description 0553 GB2/98.07/1000





Hoyer Rollo 23

Automatic Ice Cream

Bar Freezer

Application

Automatic, continuous production of ice cream, sherbet, or fruit-juice bars with sticks.

Operating Principle

The production of ice cream bars is carried out in six

- 1. Filling of ice cream into the moulds.
- 2. Insertions of wooden sticks into the ice cream.

- 3. Freezing of the bars in a cold brine bath at -40° C 4. Defrosting of a thin outer layer of the bars in a
- warm brine bath at +15-25°C (+60-77° F).
- 5. Extraction of the frozen bars from the moulds.
- 6. Lay-off for packing.

Between extraction and lay-off, the bars may be coated with chocolate. Products dipped in chocolate may also subsequently be coated with dry stuffs.

Capacity

The capacity for typical products (see tables) will normally be in the range of 8,000 to 12,000 ice cream bars per hour. Capacities for water ice are lower than for ice cream. Actual capacity depends upon a number of factors, including:

- Number of radial rows.
- Number of products per radial row.
- Product thickness.

- Overrun.

- Recipe (e.g. sugar content and total solids content).
- Viscosity of ice cream mix.
- Brine temperature.
- Ice cream filling temperature.
- Number and types of filling operations.
- Capacity of the packing line.
- Capacity of the refrigeration unit.

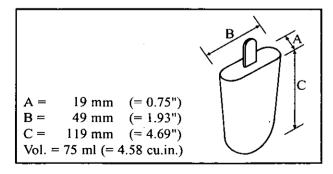
Example:

Product width:	49 mm	(1.93")
Product thickness:	19 mm	(0.75")
Number of radial rows:	120	
Number of pockets per row:	7	
Overrun of ice cream:	60%	
Evaporating temperature:	-45°C	(-49°F)
Brine temperature:	-40°C	$(-40^{\circ}F)$
Ice cream filling temperature:	−2°C	(+28°F)
Capacity*, approx.:	10,900	per hour
* The capacity is based on a mi	x recipe u	sing

good quality ingredients as follows:

Fat 12%
Skimmed milk powder, fat free 11%
Sugar (sucrose) 12%
Auxiliary ingredients 1%
Water 64%

100%



The number of freezing pockets per radial row depends upon the width of the ice cream bar. For example:

Max. width of product	Pockets per radial row
65 mm (2.56")	6 .
*53 mm (2.09")	7
29 mm (1.14")	11

The number of radial rows depends on the thickness of the ice cream bar.

For example:

Max. thickness of product	Number of radial rows
*Up to 20 mm (0.79")	138
*20-23.5 mm (0.79"-0.93")	120

*Typical products.

If you require equipment compatability with an existing Rollo 20 the number of pockets per radial row will be reduced to coincide with that of your Rollo 20. In this case capacity will be reduced.

Standard Design

Mould Table. The moulds, in which the bars are shaped and frozen, are welded into an annular, rotary table situated on top of the brine tank.

The mould table is made of stainless steel. The number of pockets included in the standard mould table with 6 pockets per radial row is $7 \times 120 = 840$ pockets.

Other mould tables with different row and pocket configurations can be supplied (see »Optional Equipment«).

The mould table of a Hoyer Rollo 23 can handle ice cream bars up to 140 mm (5.51") long, optional up to 180 mm (7.09"). The stick inserted in the ice cream/water ice bar must protrude at least 30 mm (1.18") above the mould table.

Brine Tank. The double-walled annular tank is welded and insulated. It is made from stainless steel.

Two rails are placed on the outside of the brine tank for mounting the stick dispenser, the cleaning equipment, the filling equipment, etc.

The brine tank is divided into a freezing zone with cold brine and a defrosting zone with warm brine.

Cooling System. The primary cooling system is a complete refrigeration unit which is separate from the machine and built on one frame. It consists of a compressor, a driving motor, a condenser, an evaporator (PHE) and a control panel. R22 is used as refrigerant. The evaporator is equipped with oil drain valves. A check valve and a stop valve are mounted in the liquid line. A suction stop valve is also supplied. A pump ensures the circulation of the brine from the refrigeration unit to the Rollo 23 tank.

Ammonia systems for pump recirculation as well as gravity recirculation can be supplied.

The secondary cooling system is a cold brine bath and the cold brine is circulated by a centrifugal pump. The cold brine distribution trough is made of stainless steel.

Defrosting System. The warm brine is heated either by electricity or by steam. The choice must be made when ordering. The brine is sprayed onto the underside of the moulds through a nozzle system.

The defrosting system is equipped with a separate centrifugal pump. A thermostat prevents operation of the extractor if the warm brine temperature is too low.

Main Drive. All main functions are mechanically actuated and controlled through cams. The auxiliary functions and other functions with limited power demands are controlled and actuated pneumatically.

The speed of the Hoyer Rollo 23 varies between 6 and 25 strokes per minute.

Electric Equipment. The equipment comprises motor starters with thermal overload protection, contactors, electric and thermostatically controlled heating elements for the defrosting system, necessary parts for control functions, limit switches, relays, fuses, etc. This means that the Hoyer Rollo 23 only needs to be connected to the main power supply.

Control Panel. All functions are operated from one control panel located on the machine. The refrigeration unit is controlled seperately.

Filling Equipment. The standard ice cream filler is designed as a drum type volumetric filler for top filling of ice cream and consists of a column and a filling head, on which the interchangeable filling equipment is mounted. The standard machine is equipped with a filler for one-coloured ice cream.

Stick Dispenser. The stick dispenser is mounted on a suspension rack and consists of sections, one for each freezing pocket in the radial row. The activation is pneumatic.

Extractor and Lay-Off Device. This device is equipped with 24 extractor arms each with a complete set of extractor tongs for wooden sticks all made of stainless steel.

The release of the products is actuated by the downward movement of the extracting arm.

Chocolate Coating Equipment. This equipment is mounted beneath the extracting device and comprises a dipping cup and a chocolate vessel with drip scraper. The height of the dip cup can be adjusted according to the level of "dip" required.

The chocolate vessel is equipped with an electrically heated water jacket.

The temperature is thermostatically controlled and indicated on a thermometer.

Washing and Sterilizing Apparatus. For cleaning-in-place (CIP) and sterilizing, a washing apparatus is supplied for mounting on the supporting rails on the brine tank. The apparatus requires connection to water and steam.

Standard Equipment

- 1 Filling equipment for one-coloured ice cream.
- Chocolate coating equipment.
- 3 Set of tools.
- 4 Set of normal spares.

Optional Equipment

- 4 Bottom filling machine for one-coloured ice cream.
- 5 Filling equipment for two-coloured ice cream, vertically divided.
- 6 Filling equipment for two-coloured ice cream, vertically divided in a »zebra-pattern«:
- 7 Filling equipment for two-coloured ice cream, concentric filling.
- 8 Filling equipment for the filling of twocoloured ice cream, horizontally divided.
- 9 Independent filling unit for one-coloured water ice (required for two-coloured water ice, horizontally divided and for topping-up).
- 10 Filling equipment for shell and core split ice: shell of water ice, core of ice cream.
- 11 Equipment for one-coloured water ice, but two different colours per radial row. (Three and four colours per radial row is also available.)

- 12 Filling equipment for two-coloured water ice, vertically divided (twin-type lolly only).
- 13 Pencil filler with equipment for two strings of ripple mass per bar.
- 15 Dry coating equipment for coating the bars with granulated dry stuff, nuts, candy, etc.
- 18 Hoystat pump station. 100 litre (26.5 gall.) chocolate floor tank with electrically heated and thermostatically controlled water jacket and electrically driven chocolate circulation pump. The floor tank is a separate unit on wheels and with hoses for connection to the dipping cup on the Hoyer Rollo machine.
- 20 Cart for transport and storage of mould table.
- 24 Extended set of spare parts for two years' operation.
- 28 Mould table with alternative pocket and row configurations.
- The number of freezing pockets which can be fitted into a Rollo 23 mould table depends on the size and shape of the ice cream bar. Between 6 and 11 freezing pockets per radial row is possible. The number of radial rows will depend on the thickness of the product (see tables under »Capacity« section).
- 31 Hydro-pneumatically operated crane for lifting the mould table.

Other optional equipment is available and full details can be obtained on request.

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INDÚSTRIA DE FRIO

CONGELAÇÃO DOMÉSTICA E INDÚSTRIAL

VILA DO CONDE, June 15th, 2000

Dear Sirs.

We introduce ourselves as a leading producer of ice-cream freezers with a 20 year experience that we would like to share with You.

We are exclusive suppliers for Nestlé Camy Portugal, Nordwik, Menorquina, KTC (Spain) and Ijsboerke in Portugal and Belgium.

We join some leaflets of our products that somehow can catch Yr. interest.

At this moment we maintain commercial contacts with some companies in South Africa such as "Zero Appliances".

Yr. comments will be highly appreciated

Best regards

MARTINS & AZEVEDO, LDA

MARTINS E AZEVEDO, Lda.

COFFII
Telef. 02.928772) - Fdx (1.9237729)
Rua Nova del desidente Martines

4480 VILA DO CONDE



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INDÚSTRIA DE FRIO

CONGELAÇÃO DOMÉSTICA



CHGTV290 ABS FRAME - 1000 X 620 X 920

CHGTV420 ABS FRAME - 1260

- 1260 X 620 X 920

dupo



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INDÚSTRIA DE FRIO

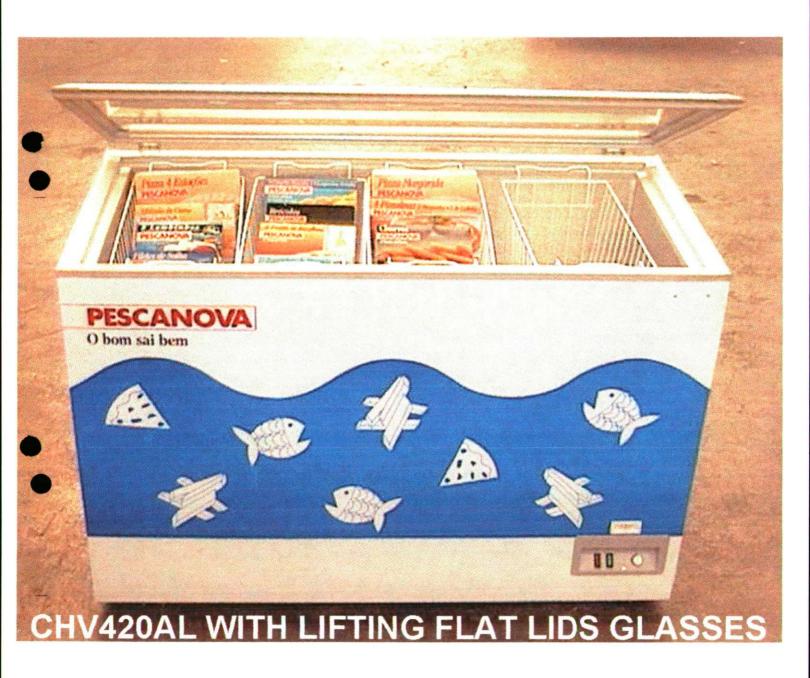




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INDÚSTRIA DE FRIO

CONGELAÇÃO DOMÉSTICA E INDÚSTRIAL



Lutus



Indústria de frio, congelação doméstica e comercial Industria de frio, congelación domestica y comercial Cold storage industry, domestic and commercial freezing Industrie du froid, congelation domestique et commerciale

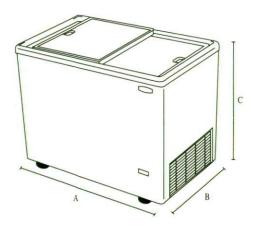


MODELOS CHG — CONGELADORES DE GELADOS

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MODELS CHG — ICE-CREAM FREEZERS

MODÈLES CHG — CONSERVATEURS DE CRÈME GLACÉE



COFRI — qualidade e tecnologia em refrigeração

COFRI — cualidad y tecnología en refrigeración

COFRI — quality and technology in refrigeration

COFRI — qualité et technologie en réfrigération



- · Perfil em PVC
- · Marco en PVC
- · Profile in PVC
- · Profil en PVC

- · Cuba exterior em chapa zincada dupla face lacada a branco.
- · Cuba interior em alumínio stucco / chapa zincada lacada a branco.
- Evaporador estático.
- · Condensador estático / estático + ventilado.
- · Isolamento de poliuretano injectado.
- · Termostato.
- Tampas de correr em vidro especial temperado / tampas de correr isoladas por poliuretano.
- · Perfil superior em alumínio anodizado / perfil em PVC.
- · Termómetro.
- · Rodapés de reforço.
- · Rodas reforçadas ø 50 mm.
- · Cuba exterior en chapa zincada doble cara lacada a blanco.
- · Cuba interior en alumínio stucco / chapa zincada lacada a blanco.
- · Evaporador estático.
- · Condensador estático / estático + ventilado.
- · Aislamiento en poliuretano inyectado.
- · Termostato.
- Tapas correderas de cristal especial temperado / tapas correderas aisladas por poliuretano.
- · Marco superior en alumínio anodizado / marco superior en PVC.
- · Termómetro.
- · Rodapiés de refuerzo.
- · Ruedas reforzadas ø 50 mm.
- · Outside in zinc double face plate white lacquered.
- · Inside in stucco aluminium / zinc plate white lacquered.
- · Static evaporator.
- Skin condenser / skin condenser + ventilated.
- · Injected polyurethane isolation.
- · Thermostate.
- · Glass sliding lids in special tempered glass / injected polyurethane isolated sliding doors.
- · Upper profile in aluminium / upper profile in PVC.
- Thermometer.
- · Reenforced skirting boards.
- · Reenforced wheels ø 50 mm.
- · Cuve extérieure en tôle zinquée double face laquée en blanc.
- · Cuve intérieure en aluminium stucco / tôle zinquée laquée en blanc.
- Évaporateur statique.
- Condensateur statique / statique + ventilé.
- · Isolement en polyurethane injecté.
- · Thermostat.
- Couvercles glissantes en verre special trempé / couvercles glissantes isolées en polyurethane.
- Profil supérieur en aluminium / profil supérieur en PVC.
- · Thermomètre.
- · Lambris pour renforcement.
- Roulettes renforcées ø 50 mm.



Mod.	Dim. exterior / Ext. dim. A x B x C (mm)	Compress. (HP)	V / Hz	Refrig. (gas)	Temp. (C°)	Capac. (Lts)
CHG 160	650 X 650 X 860	1/8	220 / 50	R 134 a	-20 a -25	160
CHG 220	800 X 580 X 900	1/6	220 / 50	R 134 a	-20 a -25	220
CHG 290	1000 X 620 X 920	1/5	220 / 50	R 134 a	-20 a -25	295
CHG 420	1260 X 620 X 920	1/4	220 / 50	R 134 a	-20 a -25	391
CHG 520	1500 X 620 X 920	1/3	220 / 50	R 134 a	-20 a -25	490

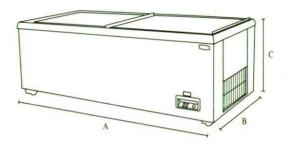


MODELOS CHV e IL — CONGELADORES TAMPOS DE VIDRO DE CORRER

MODELOS CHV y IL — CONGELADORES TAPAS CORREDERAS DE CRISTAL

MODELS CHV and IL — GLASS SLIDING COVER FREEZERS

MODÈLES CHV et IL — CONGELATEURS COUVERCLE GLISSANT EN VERRE



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- · Interior IL 2000
- · Intérieur IL 2000

- · Cuba exterior em chapa zincada dupla face lacada a branco.
- Cuba interior em aço inox / chapa zincada lacada a branco.
 - modelos IL 1500 e IL 2000, chapa lacada
- · Evaporador estático.
- · Condensador estático / ventilado.
 - modelos CH 650, IL 1500 e IL 2000, ventilado
- · Isolamento em poliuretano injectado.
- · Painel de comandos:
 - termostato; sinalizador alarme; sinalizador corrente.
- · Termómetro.
- · Tampas de correr em vidro especial temperado.
- · Divisórias / cestos opção.
- Cuba exterior en chapa zincada doble cara lacada a blanco.
- Cuba interior en acero inox / chapa zincada lacada a blanco.
 - modelos IL 1500 e IL 2000, chapa lacada a blanco
- · Evaporador estático.
- · Condensador estático / ventilado.
 - modelos CH 650, IL 1500 e IL 2000, ventilado
- · Aislamiento en poliuretano inyectado.
- · Panel de comandos:
 - termostato; señal de alarma; señal de corriente.
- · Termometro.
- · Tapas correderas en cristal especial temperado.
- · Divisorias / cestillos opción.
- · Outside in double face zinc plate white lacquered.
- Inside in stainless steel / zinc plate white lacquered.
 - models IL 1500 and IL 2000, zinc plate white lacquered
- · Static evaporator.
- · Skin condenser / ventilated condenser.
 - models CH 650, IL 1500 and IL 2000, ventilated condenser
- · Injected polyurethane isolation.
- · Control panel
 - thermostate; alarm light; power light.
- Thermometer.
- · Tempered glass sliding lids.
- · Dividers / baskets option.
- · Cuve extérieure en tôle zinquée double face laquée en blanc.
- · Cuve intérieure en acier inox / tôle zinquée laquée en blanc.
 - modèles IL 1500 et IL 2000, tôle laquée en blanc
- Évaporateur statique.
- · Condensateur statique / ventillé.
 - modèles CH 650, IL 1500 et IL 2000, ventillé
- · Isolement en polyurethane injecté.
- · Boîte de contrôle
 - thermostat; signal alarm; signal courant.
- · Thermomètre.
- · Couverclées glissantes en verre trempé.
- · Cloison / panters option.



Mod.	Dim. exterior / Ext. dim. A × B × C (mm)	Compress. (HP)	V / Hz	Refrig. (gas)	Temp. (C°)	Capac. (Lts)
CHV 290	1000 X 620 X 920	1/4	220 / 50	R 134 a	-20 a -25	295
CHV 420	1260 X 620 X 920	1/4 +	220 / 50	R 134 a	-20 a -25	391
CHV 520	1500 X 620 X 920	1/3	220 / 50	R 134 a	-20 a -25	490
CHV 650	1700 X 720 X 960	1/3 +	220 / 50	R 134 a	-20 a -25	650
IL 1500	1500 X 910 X 800	1/2	220 / 50	R 22	-20 a -25	570
IL 2000	2000 X 910 X 800	3/4	220 / 50	R 22	-20 a -25	700