



# M80 Gummy Production System FAQ's

CATEGORY	SUBJECT	QUESTION	ANSWER
COMPANY	Turnkey System from CapPlus	Why use CapPlus?	Fully integrated at factory with testing of all components. On site Training, engineering and technical support
COMPANY	Why buy from CapPlus	Why is it important to buy machine from CapPlus	With each purchase goes a recipe for Pectin and Gelatin. Reduce R & D labor time and work with proven formulas developed by industry veterans. Reduces production ramp up time.
COMPANY	Training	What machine training is offered?	Capplus Engineers On site training and technical support. Immediate response time & no language barrier & time zone issues when ordering in North America.
COOK	In line Static Mixers	What is the function of In-line Static Mixers?	Combines flavors with incoming gelatin or pectin & quickly mixes colors & flavors for even distribution and product quality.
COOK	Auto Color/Flavor Dosing System	What is the function of the Auto Color/Flavor Dosing System?	Automatically provides consistent, accurate doses. Applicable in a continuous process. Not applicable in batch process
COOK	Water Supply	What kind of Water Supply is required?	Cold filtered water is used.
COOK	Sugar Free	Can the machine be used for sugarless applications?	Yes, but we don't have a formula yet.
COOK	Cooking	How long does it take to cook a batch of Pectin? Gelatin?	Pectin 60 minutes. Gelatin 45 minutes.
COOK	Batch Size	What size batches can be produced on this equipment?	Machine is capable of producing batches from 50-80 Kg.
COOL	Efficient Hygienic Cooling Tunnel	How is cold air produced?	A separate cooling system is provided. It can be placed on top of the cooling tunnel or in a separate room to minimize heat production in the room.
COOL	Compressor	Can the compressor be mounted in adjacent room to mitigate heat in environment?	Yes
COOL	Ejection Pin for Molds	How are the gummies ejected from the molds?	The Oil that is sprayed into the molds reduces friction between the mold and the gummy. Final removal is done by Ejector Pins, Stripper Rollers and Compressed Air.
COOL	Cooling Tunnel	What type of final belt is used?	A Food Grade, Anti Stick FDA approved Polyurethane cooling belt.
COOL	Stripper Brushes	Can the stripper brushes over the transfer belt in the cooling tunnel be removed?	Yes.
COOL	Cooling Tunnels	Do side panels grant access to the cooling tunnel?	Yes all stainless side panels are latched for easy opening.
COOL	Cooling Tunnel	What is the temperature range of cooling tunnel?	0-20 Centigrade
COOL	Cooling Tunnel	How big is the chilling system?	It is a 5 HP unit.

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DEPOSIT	High Definition Molds	Can molds be built that will apply Character Images and Branding?	Yes
DEPOSIT	Product Contact Parts	What are the product contact parts in the Deposit area?	316 SS and Bronze
DEPOSIT	Twin Hoppers	Are hoppers heated?	Yes, Evenly heats and self drains increasing product flow. Minimizes waste, cleaning time and has low retention time which Minimizes process inversion, Two colors can be dispensed in each hopper.
DEPOSIT	Dosators-Servo Drive Control	Why are Servo Driven Dosators important?	Provides greater dosing accuracy.
DEPOSIT	Automatic Oil Spraying System	What does the oil spraying system do?	Sprays a mist of oil on the molds to facilitate easy gummy removal.
DEPOSIT	Fill volume Range	What is the fill volume range.	1-30 Grams
DEPOSIT	Teflon Coated Aluminum Molds	Why are Teflon™ coated aluminum molds better?	Teflon coated Aluminum molds are more durable.
DEPOSIT	Depositor Pistons	What are the pistons made of?	We use stainless Steel plunger and bronze barrels. Stainless steel barrels available at added cost.
DEPOSIT	Dosator Servo Drive Adjustment	How easy is the volume adjustment ?	Operator inputs a Number or value for the servo position from the touch screen. An easy way to change fill volume
DEPOSIT	Dosator Fill Accuracy	What is dosator fill accuracy?	Plus or Minus 10mg
DEPOSIT	Hoppers	What is the hopper capacity?	15 Liters X 2
DEPOSIT	Hoppers	What is the Hopper temperature range	0-140 Degrees Centigrade
DEPOSIT	Hoppers	What are the hoppers made of?	316 SS
DEPOSIT	Dosators	How many dosator nozzles?	20, 10 per hopper
DEPOSIT	Method of dosing	What method is used for determining dosing rates for auto color and flavor system	A dosing pump controls the volume of colorant or flavor being added during continuous processing.
DEPOSIT	Mold Re-Coating	How often do the molds need re coating for Teflon?	2 years or as needed if you see some pitting
COOK	Static Mixing System	Does the Static Mixing System Tanks have a port for adding colors and flavors?	Static Mixing System has a port for adding color and flavors after the cooling process.
DEPOSIT	Tooling	What is the cost for an additional set of tooling?	Approximately \$7,800 for a set of quick release tooling.
DEPOSIT	Liquid Filled Centers Kit	What does the " Liquid filled Centers" kit cost?	Approximately \$37,500
DEPOSIT	Active Ingredients	Where do we add the active ingredients?	In a batch process they will be added to the storage tank.
DEPOSIT	2 Color Gummies	How are two color gummies made?	The hopper is bifurcated. One color goes in one side, the other color goes into the other side. Gummies can be two colors on each gummy or the machine can be set up to make one row of a color and the next row of another color.
DEPOSIT	Packaging	How can I oil coat or wax gummies?	Oil to aid releasing, can be sprayed into the molds. Additional oil can be applied with oil coating drum. "Wax" is term for oil/wax blend that is applied to gummies.
DRY	Drying Starch vs Starchless	How does the drying process differ Starch vs Starchless?	Infrastructure for drying starch gummies is more expensive & the room conditions are different.
DRY	Drying Times Pectin	What are the drying time/conditions for Pectin Gummies?	Drying times Pectin 28-29C, 20-30% RH for 24-48 hours. Values will vary depending on the formula & process conditions
DRY	Drying Times Gelatin	What are the drying time/conditions for Gelatin Gummies?	Drying times Gelatin 25-26 C , RH, 20-30% , 48 Hours. Depends on the formula and process conditions
DRY	Drying Room	How Big should the drying room be?	Size depends on output and gummy size. Assuming 6hrs/day run time, at 20,000 gummies / hr. a drying room of about 200 sq./ ft. should be adequate.
DRY	Transfer Conveyor	How are the gummies brought from floor level & integrated into inspection & drying?	A 6' conveyor catches the gummies as they exit the cooling tunnel & moves them to table height.
DRY	Moisture Analysis	What tools are used for final Moisture content?	A Water Activity Meter is used.
DRY	Drying	How many gummies can I get onto a drying tray?	Approximately 2,000 to 3,000 depending on size and layers

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GENERAL	Length	What is the length of the complete system?	The Pectin System with optional 6' cleated conveyor is 37' long. Add 4' for the Gelatin version.
GENERAL	Mold Removal	How easy is it to change the molds.	Mold removal is easy. No tools required. Reduces labor & changeover time.
GENERAL	Small Footprint	What is the advantage of a small footprint?	Reduces production and energy costs compared to traditional starch molding processes. Ideal for established & new manufacturers of gummies
GENERAL	Starch Free	Why is starchless better?	By avoiding the need to form molds out of starch, you realize the benefits of: Reduced Processing, Less Mess & the equipment occupies a Smaller Space.
GENERAL	Servo Drive Conveyor	Why is it important to have a servo drive conveyor?	Because it perfectly Synchronizes with Dosing station, Fill Station & Pneumatic Mold Lifting. Improves efficiency & accuracy
GENERAL	Quick Release Tooling & SS Chain	Why is quick release tooling important?	Industry's first quick release tooling option for small gummy system. Increases speed on changeover, allows for nimble production of different shaped products. Huge advantage for contract mfg. Stainless steel long term GMP compliance advantage.
GENERAL	Metal Detection	How are customers detecting Non ferrous metals in gummies now?	Metal detection is usually done between production & packaging.
GENERAL	Complete packaging Line	Is a counting-type packaging line available for gummies?	In April 2020 CPT will be introducing a new counter especially for gummies. Allows for pairing production line with suitable packaging line. Congruent, smooth transition and full turnkey line capabilities with one company.
GENERAL	Spare Parts Package	What is included in the Spare Parts Package?	A comprehensive list will be provided.
GENERAL	Sugar Coating Drum Available	Is a Sugar Coater Available?	Yes.
GENERAL	Inspection Tools	What is a refractometer?	Used to determine 'solids' content.
GENERAL	Downtime for cleaning	Downtime for cleaning & Changeover?	Minimum of 2 hours. All of molds need to come off for cleaning. Quick connect can become very valuable. 360 screws on a set of molding.
GENERAL	People needed	How many people are needed on the line?	3 people min, 4 people max if QC & lab inspection is ongoing.
GENERAL	Air Requirements	What are the compressed air requirements for the Depositor?	0.4-0.6MPa 6-8 PSI
GENERAL	Power Supply	What are the power requirements?	75KW/H 220V 3PH 60 Hz
GENERAL	Floor Drain	Is a floor drain required.	No, But its really nice for cleaning and ease of disposal during cleaning tank residue deposits
GENERAL	Type of Gummies	What type of gummies will it make?	One or two color. 1 D, 2D or 3D. There are a plethora of molds to choose from. Gelatin or Pectin
GENERAL	Production Rates	What are the production rates?	Speed depends on type of process, batch or continuous & size of product. Maximum operating speed is 45-50 deposits per minute. Maximum batch size: 50-80kg/hr.
GENERAL	Cleaning	What is the process for cleaning the machine?	Run water into cooking tanks. Heat, mix and circulate thru machine until clean.
GENERAL	Packaging	How do you keep gummies for sticking together during packaging?	Use a food grade tumbler, introduce powdered starch, coat gummies then transport to packaging after tumbling.
GENERAL	Packaging	How many Bulk gummies can you fit in a bag for packaging later?	As few as necessary to mitigate bricking. Not to exceed 5kg
GENERAL	Ingredients	How should I store and transfer my bulk ingredients?	Put them on a skid for transfer (separate room if needed) sugars, syrups are in bulk containers.
GENERAL	Recipe	What is the recipe for Pectin and Gelatin?	After purchasing a machine, CapPlus provides with a proven formulation for each.