STM GROUP

BOTTLING & CANNING

CASE STUDIES



WWW.STM-PACK.COM

ESTABLISHED IN
STM 1981

PLANT AREA
6000 m2

EMPLOEES
220 persons

ENGINEERS
30 people

MANAGEMENT
29 people

MACHINING
32 people

INSTALATION
70 people

ADMINISTRATION
25 people

ELECTRICAL ENGINEERING
6 persons

CNC
30 items

PLOT AREA
4,5 ha

IMPLEMENTED PROJECTS
about 50 every year

COUNTRIES WHERE OUR MACHINES ARE INSTALLED



Algeria
Angola
Antigua and Barbuda
Armenia
Austria
Azerbaijan
Belarus
Benin
Burkina Faso
Canada
Central African Republic
Chad
Croatia
Cyprus
Czech Republic
Democratic Republic of the Congo
Djibouti
Egypt
Eritrea
Estonia
Germany
Guatemala
Guinea
Hungary
Iceland
India
Iran
Iraq
Israel
Ivory Coast
Jordan
Kazakhstan
Kyrgyzstan
Latvia
Liberia
Libya
Lithuania
Mali
Mauritania
Netherlands
Nigeria
Oman
Poland
Romania
Russia
Senegal
Sierra Leone
South Africa
South Korea
Sudan
Switzerland
Tajikistan
Tanzania
Togo
Tunisia
Turkey
Turkmenistan
Ukraine
United
Kingdom
USA
Uzbekistan

COMPLETE FILLING LINE FOR MINERAL WATER BASED ON SYNCHROBLOCK
MASSPOL, POLAND



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About the Client

Masspol mineral bottling plant (manufacturing and water intake) is located in the town of Zubrzyk in Beskid Sadecki region of Poprad Landscape Park. The company offers mineral and spring water packed in 500, 700, 100, 1500 and 5000 ml bottles, manufactured as part of implementing product, process and eco-innovations.

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Project Requirements

It’s yet another STM Group realization for this client. After delivering two blow molding machines, a time has come to make another profitable development. This time, our client needed an energy-saving technology for PET production to be eligible for receiving EU funds. The project involved manufacturing a complete turnkey filling line for PET bottles.

- Product: still mineral water
- Packaging: PET bottle (5000 ml)
- Capacity: 4000 bph
- Solution: Increasing the number of bottles on the pallet – from 108 to 162!





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Implementation

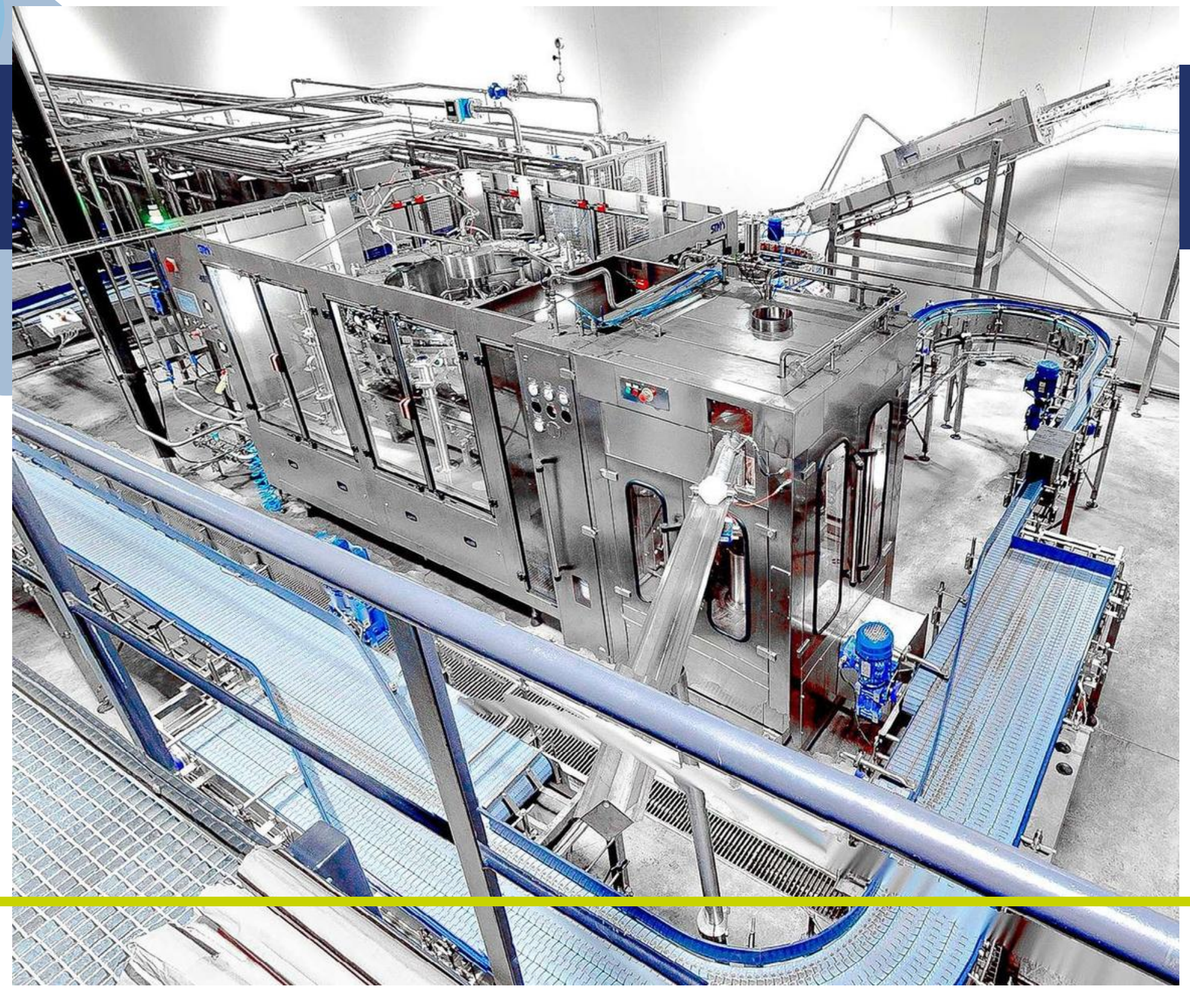
- Suggested solution: Synchroblok Combifill 4/16/6 FlowMatic BIG. The machine features 4 molding cavities, 16 filling nozzles and 6 capping heads
- Low energy consumption: 13W/5l bottle
- Innovative system for recovering compressed air, delivering air (up to 10,5 bar) to all peripheral devices in both, STM line and an adjacent line for 1,5l bottles at 18 000 bph
- Original bottle design – taller and slimmer than the classic model - for higher packing efficiency
- Dedicated palletizing system with 2 rotating plate pallet wrappers at the stacking places – wrapping occurs without pallet transfer
- Palletizing capacity – up to 25 pallets per hour
- Project was co-financed with funds from the Intelligent Development Programme 2014-2020





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COMPLETE FILLING LINE FOR BEER BOTTLING AND CANNING
DARUVAR BREWERY, CROATIA



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CAN FILLING LINE

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CLICK BUTTON
PALLETIZING SYSTEM

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CLICK BUTTON
PET BOTTLE FILLING LINE

CHECK 3D TRIP
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About the Client

In the very center of the Croatian town of Daruvar, there is a brewery of the same name. Founded in 1840, it is the second oldest brewery in the country. As the only one outside of the Czech Republic, it produces beer according to traditional Czech technology, which makes it unique in this field. In addition to beer in glass bottles, the company also offers it in PET bottles and cans, produced as part of the EU project ”Improving the competitiveness of Pivovar Daruvar d.o.o. through investments in digital and green transformation.”

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Project Requirements

Modernizing the production of Daruvar Brewery required designing a system that would take into account the existing line for bottling beer in returnable glass bottles, as well as all the piping and media connections that had evolved over the years of the brewery’s operation. The project included the construction of two complete canning and PET bottling lines as a turnkey solution.

- Product: beer
- Packaging: aluminum can (330 ml + 500 ml) + PET bottle (2000 ml)
- Capacity: 15 000 cph + 3 000 bph
- Solution: Installation of two bottling lines without interfering with the existing system
- Solution: Adapting a new palletizing and depalletizing system forthe existing glass bottle filling line – process automation





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Implementation - Can Filling Line

- Suggested solution: Arrow CAN 40/6 ISO. The machine features 40 iso- baric filling nozzles and 6-head seamer
- Low oxygen pickup - about 35 PPB
- Efficient pasteurization thanks to dynamic pasteurizing unit which adjusts the conveyor speed and temperature
- Water recovery system
- Quick change of can format - from 500 ml to 330 ml
- Packing system adapted to 3 formats: 6x4 items on a tray with foil or 3x2 and 2x2 packs wrapped in foil only- up to 30 packages per minute





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Implementation - Palletizing System

- Complex palletizing system based on two robots - maximum efficiency up to 59 pallets/hour
- Can line works independently, while second robot works on either PET or glass line
- Palletizing cans with the capacity of 15000 CPH
- Palletizing PET bottles with the capacity of 3000 BPH
- Depalletizing crates with empty returnable glass bottles with the capacity of 20000 BPH
- Palletizing crates with full returnable glass bottles with the capacity of 20000 BPH
- Project co-financed with European Funds as part of the Recovery Assistance for Cohesion and the Territories of Europe - REACT- EU

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Implementation - PET Bottle Filling Line

- Suggested solution: Arrow PET 20/40/8 ISO Beer. The machine features 20 rinsers, 40 isobaric filler nozzles i 8 capping heads
- Innovative system for recovering compressed air (up to 10,5 bar) to be reused by the blow molding machine Blueline 3 Standard
- Double evacuation of oxygen before filling
- Low energy consumption: 6W for a 2-liter bottle





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The particular goal of this investment was to become independent of external services for beer bottling and canning, and to increase production efficiency by using green and digital technologies as well as innovative business processes, resulting in:

- reducing energy consumption by 5.93% kWh/hl
- reducing beer loss in production by 22.96 l/hl
- reducing the sewage load by 0.094m³/hl
- maintaining the existing 53 employees and employing 15 new ones
- increasing revenue from sales and exports by 26%

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COMPLETE OIL FILLING LINE
WILMAR, POLAND



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About the Client

Wilmar is a Polish company in the food industry, locat- ed in Lower Silesia. Founded in 1990, it specializes in rape- seed processing. The company combines the exceptional and versatile properties of this plant with action for sustainable devel- opment. Wilmar delivers products developed within its own re- search department and with technologies created from scratch. The quality of Wilmar's food products is guaranteed with the im- plementation and certification of the FSSC 22000 quality control system. This confirms that thanks to the cooperation with STM Group, oil packaging meets the most demanding safety criteria.

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Project Requirements

This ambitious project involved designing and manufacturing bottling lines for glass and PET containers in 9 different formats! Moreover, the energy-efficient solutions implemented in the project, paved the way for the company to obtain EU funding.

- Product: rapeseed oil
- Packaging: PET bottle (500ml, 1l, 2l, 3l, 5l, 10l) + glass bottle (0,5l, 0,75l, 1l)
- Capacity: 8000 bph for 1-litre bottles
- Greenfield Project: system implemented from the ground up





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Implementation

- 2 Blow molding machines
  - Blueline 6 Hitech (500ml – 2l bottles) - capacity up to 10 500bph
  - Blueline 1 BIG MAX (3l – 10l bottles) - capacity up to 1100bph

- Innovative system for recovering compressed air, delivering air (up to 10,5 bar) to all peripheral devices on the manufacturing site.

- 2 Monoblocks
  - Arrow PET/Glass UNIV 20/6 Weightmatic (500ml – 2l bottles) featuring 20 filler nozzles and 6 capping heads - capacity up to 8100 bph
  - Arrow PET 9/3 Weightmatic BIG (3l – 10l bottles) featuring 9 filler nozzles and 3 capping heads - capacity up to 1100 bph





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Implementation

- 3 Labelling machines:
  - For application of “wrap-around,” self-adhesive labels
  - For application of self-adhesive labels on square containers
  - For “hot glue” application of paper labes
- Carton packaging using the “wrap around” method - up to 15 packs per minute
- Automatic palletizing based on a robot with a universal gripper for both cardboard boxes and PET bottles + pallet wrapper with a rotating arm
- EURO and DHP pallet handling
- Additional module for covering the pallet with film from above
- The project was co-financed from the Rural Development Program for 2014-2020.

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COMPLETE FILLING LINE FOR WATER AND CARBONATED BEVERAGES

URGA WATER, LATVIA



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About the Client

Thefounders of the 885 water brand (obtained from a depth of 885 feet/170m) set themselves the goal of following European Union guidelines: “bottled at the source.” The Latvian company started operating in 2021 and currently produces carbonated and still mineral water in 500 and 1000 ml bottles.

STM GROUP
BOTTLING & CANNING

Project Requirements

The main goal of the project was to achieve maximum process automation to reduce service costs. It involved building a complete PET bottling line as a turnkey solution in a completely new production hall.

- Product: water & soft drinks
- Packaging: PET/ BIO PET/ R PET bottles (500 ml + 1 500 ml) with a Sport Cap
- Capacity: 6000 bph
- Greenfield Project: system implemented from the ground up





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Implementation

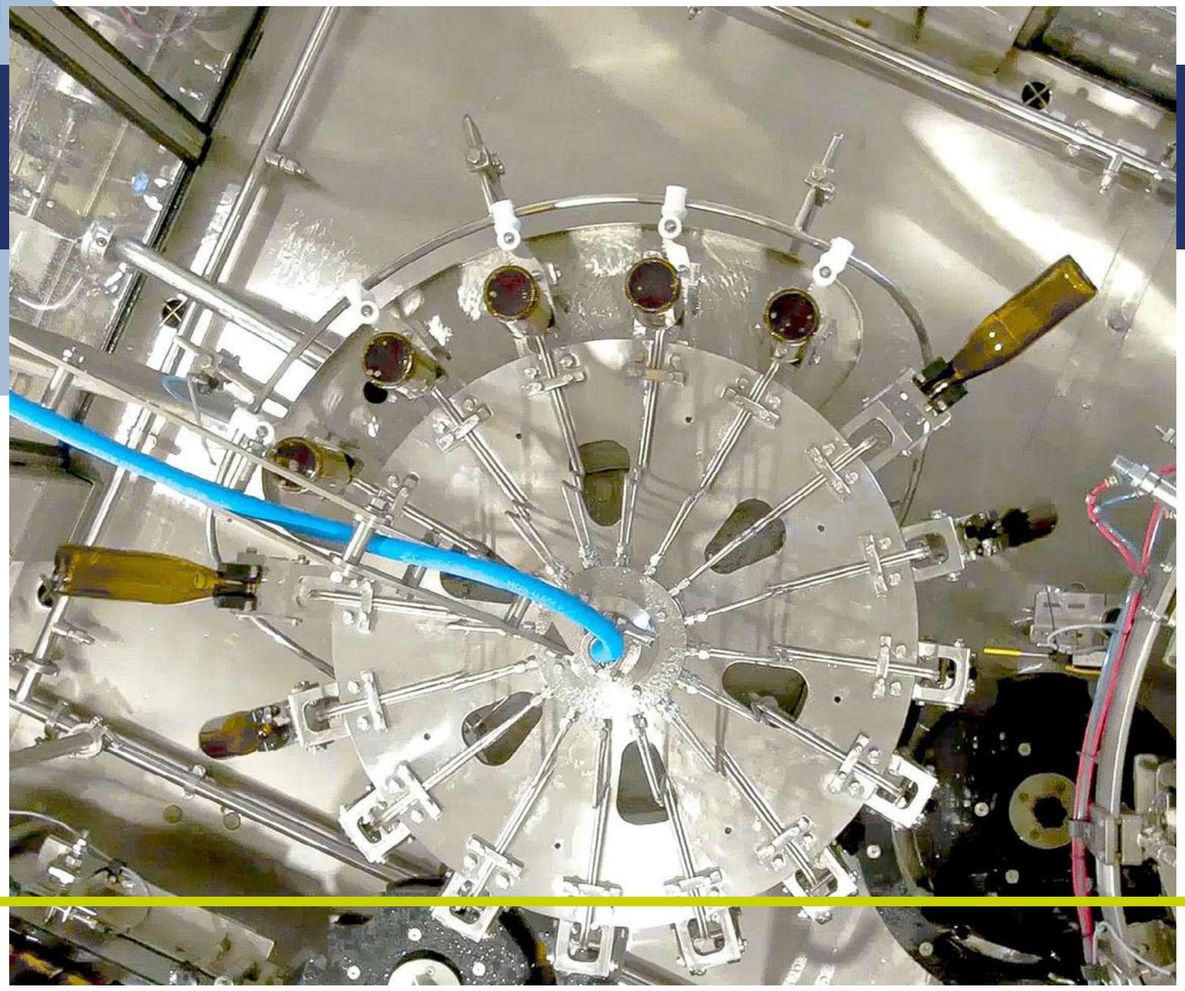
- Suggested solution: Blow molding machine Blueline 4 STD +Triblock Arrow PET 20/40/8 ISO. Machines feature 4 blowmold cavities + 20 rinsers, 40 filler nozzles and 8 capping heads
- Automatic process control control in the blow molding machine, allowing for remote machine diagnostics
- STM JG6 Flowmix mixer with a capacity of up to 9,000 l/h
- STM Mega Roll 9T labeling machine with a capacity of up to 10,000 bph
- Eco-friendly label adhesion
- Packaging system adapted for 2 formats: 3x4 and 3x2 packages wrapped in foil - up to 30 packages/min
- Bottle made of 25% recycled plastic
- Downsizing line operation to 3 people





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BOTTLING & CANNING

COMPLETE HYBRID LINE FOR BEER CANNING AND PET BOTTLING
BROWAR ZAMKOWY, POLAND



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About the Client

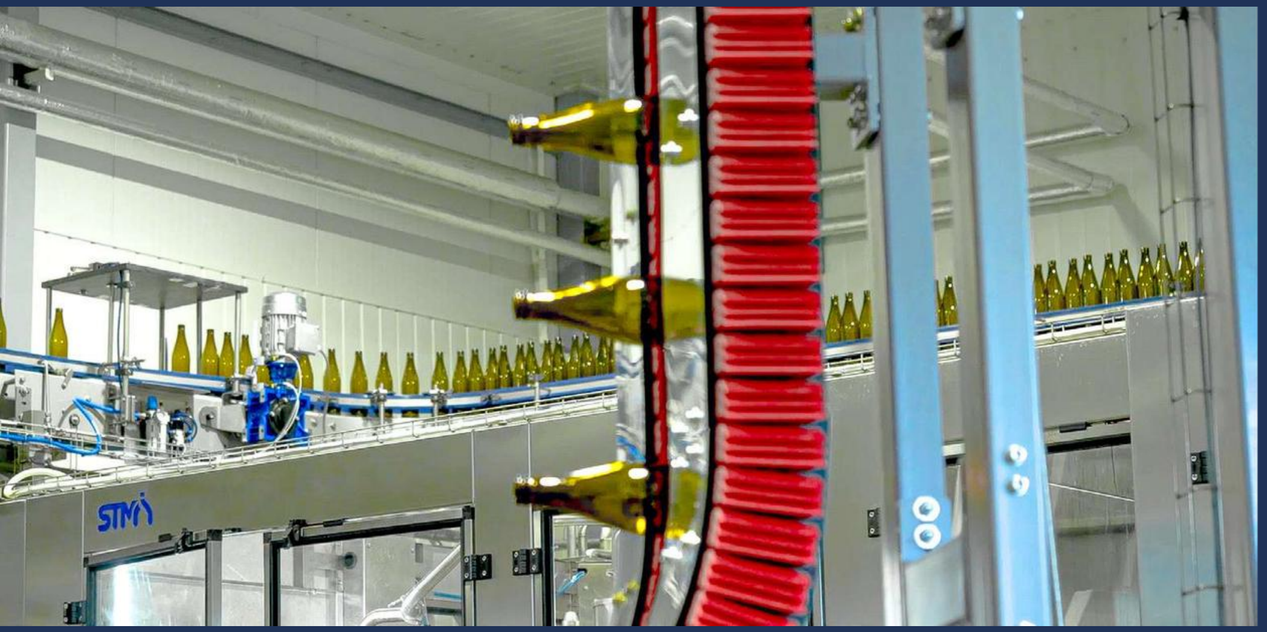
Browar Zamkowyisone of the oldest breweries in Poland, founded in 1567 on the castle hill in Raciborz. With an annual production capacity of 60,000 hl, this historic brewery is constantly expanding its operations, opening two new bottling lines in 2021. In order to meet the demands of consumers and grocery store chains, the facility, which until then had specialized in producing beer in returnable glass bottles, has undergone another stage of evolution.

STM GROUP
BOTTLING & CANNING

- Product: beer
- Packaging: glass bottle (330 + 500 ml) & aluminum can (500 ml)
- Capacity: 4500 bph + 3500 bph & 6000 cph
- Solution: designing as many shared stages for both filling processes as possible

Project Requirements

Designing two production lines on a 230 m2 space was asignificant challenge. To meet the customer's expectations, we proposed the installation of hybrid equipment. We opted for universal machines that would be able to handle various packaging formats, thus taking up less space.





STM GROUP
BOTTLING & CANNING

Implementation

- Suggested solution for glass bottles: Arrow Glass ISO Beer 16/16/4. Triblock featuring 16 rinsers, 16 isobaric fillers and 4 capping heads
- Suggested solution for aluminum cans: Arrow Can 16/2 ISO Beer. Machine featuring 16 isobaric fillers and 2 seamers

- 4 universal devices for both lines: depalletizers, filling level inspector, air knives and labelling machines

- Flash pasteurizer with a capacity of 3000 l/h to minimize the use of space

- Conveyors installed at 3 meters high to fully utilize the space above
- Innovative system for dosing nitrogen in the cans before seaming
- Minimizing oxygen pickup in bottled beer down to 100 ppb thanks to double oxygen evacuation before filling





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FILLING LINE FOR THE BEST MINERAL WATER MILA MUSZYNA

MUSZYNA, POLAND



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INTERVIEW

About the Client

MILA MUSZYNA is a new brand of premium mineral water which has been extracted from the Milusia borehole in Muszyna since 1936. It comes from healing water deposits located at a depth of 176 m. The water has been ranked first in NutriRank mineral water quality among 197 brands for 15 years. The ranking of mineral waters is calculated taking into account the mineral content of the water in question in relation to the body's daily mineral require- ments. The recommended amount of calcium in the water should exceed 150 mg, and magnesium 50 mg per liter, otherwise 0.05 for each such component is subtracted from the NutriRank value.

STM GROUP
BOTTLING & CANNING

- Product: mineral water
- Packaging: PET bottles (500 ml + 1000 ml)
- Capacity: 4500 bph
- Solution: Implement PET bottle filling line

Project Requirements

The project contents the design of PET bottle filling line with a capacity of 4,500 bottles per hour for MILA - MUSZYNA brand. This is a significant contribution by STM GROUP to the development of the premium mineral water segment in the domestic market.





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Implementation

- A set of plate conveyors
- Saturator STM mod. JS6 for carbonated water production
- Newtek labeling system with optical orientation using cameras and embossing recognition system
- Triblock STM mod. ArrowPet 16/24/6 ISO for bottling carbonated or non-carbonated beverages
- Mobile CIP station





STM GROUP
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COMPLETE FILLING LINE FOR BEER BOTTLING
FABRICA GRIVITA BREWERY, ROMANIA



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About the Client

Intheheart of Romania - Bucharest there is located the most modern craft brewery Fabrica Grivita. The brewery's history dates back to 1869 when a German entrepreneur opened the first brewery in Bucharest and made it famous throughout the country. However, since 2019 Fabrica has been operating as an independent brewery as well as a tap-room. Their beers are available on taps and filled into glass bottles in a wide range of locations across the country, from craft beer bars and specialist shops to several online platforms.

STM GROUP
BOTTLING & CANNING

- Product: beer
- Packaging: glass bottles (330 + 500 ml)
- Capacity: 6000 bph – 7000 bph
- Solution: Comprehensive fully automatic beer bottling line from depalletizing to palletizing

Project Requirements

The project required us to take a comprehensive approach to a modern bottling line in a craft brewery. Current times are setting the trend for fully automatic lines, even small and medium outputs. This project confirmed this trend of robotization and process automation.





STM GROUP
BOTTLING & CANNING

Implementation

- Full-Height, Fully Automatic Depalletizer: The TES STM DPL-S- GLASS-6 depalletizer by TES STM GROUP ensures a streamlined start to the beer bottling line, reducing the need for extensive manual labor. This depalletizer is seamlessly integrated with a vertical conveyor, transporting bottles efficiently from a high level to the beer bottling machine’s conveyors.

- Beer bottling machine for beer in glass bottles – STM ArrowGlass 24/24/6 ISO BEER: Designed for precision and efficiency, this glass bottle filler employs double pre-evacuation using a vacuum pump, high-pressure hot water fobber, a proportional main product valv and carbon dioxide modulation valves. The system fills each bottle with beer, maintaining a smooth and efficient production process while minimizing oxygen pick-up for the highest product quality.

- Quality Control Mechanisms: Advanced quality control measures include a fill level inspector for accurate product quantity verification and a checkweigher for full box inspection. These automated processes ensure that each bottle and box meet stringent quality standards.





STM GROUP
BOTTLING & CANNING





Implementation

- Air Knives for Drying: After the beer bottling and fill level checks, containers pass through TES STM GROUP’s air knives, efficiently drying the containers before label application.
- Cutting-Edge Labeling Technology: Integrated with the beer bottling line, Newtec’s state-of-the-art labeling technology provides accuracy and reliability. A 3-head self-adhesive labeler applies up to three labels per bottle—front, back, and neck label.
- Wrap-Around Cartoning Machine: Atlanta Packaging’s Rafaello wrap-around cartoning machine expertly packs beer bottles into cardboard boxes at a stable speed of up to 15ppm.
- Palletizing System – TES STM GROUP’s PAL0: This system, although it is our simplest palletizing system, it is based on a gripper of our production and a robot. This system is compact and allows palletizing at one of two storage locations, where the second location is operated by an operator at the time (taking a full pallet, bringing an empty pallet).

STM GROUP
BOTTLING & CANNING

COMPLETE FILLING LINE FOR BEER BOTTLING
TARNOBRZEG BREWERY, POLAND



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About the Client

Tarnobrzeg Brewery is the first new-wave brewery in Poland, rebuilt in the premises of the old Tarnobrzeg brewery, which operated for 120 years until its closure in 1979. The passion, talent and commitment of the founders contributed to the reactivation of beer production in a new, refreshed form in line with the philosophy of boiling beer with natural methods from the best ingredients. Currently, Brewery Tarnobrzeg's beers are available in more than 30 locations across Poland.

STM GROUP
BOTTLING & CANNING

- Product: beer
- Packaging: glass bottles (330 + 500 ml)
- Capacity: 4200 bph
- Solution: Comprehensive fully automatic beer bottling line from depalletizing to palletizing

Project Requirements

The project involved reactivating the Tarnobrzeg Brewery through a major technological upgrade. The main driving force was the implementation of a complete filling line for beer bottling with a capacity of 4,200 bottles per hour. A joint project between STM GROUP and ZipTech allowed the brewery's production capacity to be significantly increased, which currently stands at around 20,000 hectolitres per year, placing the Tarnobrzeg Brewery at the forefront of Polish craft breweries in terms of modern technology and production capabilities.





STM GROUP
BOTTLING & CANNING

Implementation

- Triblock 16/16/4 ISO EPV BEER
- Semi-Automatic Depalletizer
- Self-Adhesive Labeller UNO ADE PRO
- Data Printer
- Flat Conveyors XPP
- Infeed Table for empty bottles
- Collection Table for finished product
- The whole system allows for the production of the highest quality beers at a volume of 20,000 hectolitres per year and places the Tarnobrzeg Brewery among the leaders of Polish craft breweries in terms of modern technology and production capabilities





STM GROUP
BOTTLING & CANNING

COMPLETE EDIBLE OIL BOTTLING LINE
BIELMAR, POLAND



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About the Client

Bielmar is a Polish company owned by its current and former employees, rapeseed suppliers and its product distributors. The company has existed since 1994, while the plant began its operations in 1945. Bielmar is the Polish market leader in the production of edible oils and margarines. The production plant in Bielsko-Biała has undergone a number of changes since its establishment. Today, the company boasts rapeseed storage facilities, a modern oil pressing plant, a refinery and a margarine plant, as well as a logistics base.

STM GROUP
BOTTLING & CANNING

- Product: edible oil
- Packaging: PET bottles (500 ml, 1000 ml)
- Capacity: 9000 bph
- Solution: Comprehensive fully automatic bottling line from blow moulding machine to palletizing

Project Requirements

The project involved the implementation of state-of-the-art technologies to im- prove the processes of bottling rapeseed oil. The main driving force was introduc- ing a complete bottling line for oil with a capacity of 9,000 bottles per hour. Thanks to the automated bottling line, the company can not only increase productivity, but also maintain the high quality of its products. High-end equipment, advanced auto- mation systems and ecological solutions are the foundation for the future-oriented strategies of Polish production facilities.





STM GROUP
BOTTLING & CANNING

Implementation

- TES STM Blueline 6 Standard blow moulding machine, which produces 500ml and 1000ml PET bottles
- STM Arrow Pet 24/8 filling machine from the WeightMatic series equipped with 24 fillers and 8 capping heads
- STM labelling machine MegaRoll 9 applies OPP labels using Hot Melt method
- Wrap-Around machine, which specialises in packaging in carton boxes
- An automatic palletising system based on Kawasaki robot





STM GROUP
BOTTLING & CANNING

COMPLETE FILLING LINE FOR BEER BOTTLING IN GLASS
ZA MIASTEM BREWERY, POLAND



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About the Client

Za Miastem Brewery was established in 2017, initially operating as a contract brewery, brewing its beers at friendly breweries. A turning point for the company was the opening of its own brewhouse in 2022. The new location in Rumianek allowed the brewery to have full control over the production process, which translated into even higher quality and uniqueness of the beers on offer.
Their range includes classic styles such as pilsner, wheat beers and stouts, as well as new-wave varieties such as IPA and black IPA, which correspond to the latest brewing trends.

STM GROUP
BOTTLING & CANNING

- Product: beer
- Packaging: glass bottles (500 ml)
- Capacity: 4200 bph
- Solution: Comprehensive fully automatic beer bottling line from depalletizing to packing

Project Requirements

The project included the implementation of a 4,200 bph bottling line, which has become a significant step in the brewery's development. The advanced technology has streamlined the entire production process - from start to finish, making it more efficient. The implementation of this type of solution allowed the brewery not only to increase productivity, but also to further improve the quality of its beers.





STM GROUP
BOTTLING & CANNING

Implementation

- Triblock 16/16/4 ISO BEER
- Self - Adhesive Labeller UNO ADE
- Data Printer
- Flat Conveyors XPP
- Infeed Table for empty bottles
- Collection Table for finished product





STM GROUP
BOTTLING & CANNING

COMPLETE FILLING LINE FOR BEER GLASS BOTTLE FILLING & CANNING
PINTA, POLAND



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About the Client

PINTA Brewery is a pioneer of craft beer in Poland, having started operations in 2011. Today, PINTA Brewery is the largest craft brewery in Poland and is constantly developing its offer, including through the production of canned beers. In 2023, it released almost 700,000 cans of beer, an increase of 175,000 compared to the previous year. Canned beer is growing in popularity both at home and abroad, with PINTA exporting its products to 27 countries.

STM GROUP
BOTTLING & CANNING

- Product: beer
- Packaging: glass bottles (330 + 500 ml) + aluminium cans (330 + 500 ml)
- Capacity: 6000-7000 bph + 4000 cph
- Solution: Comprehensive fully automatic beer bottling & canning line from depalletizing

Project Requirements

The project involved the addition of a 4000 cph beer canning line to anexisting glass bottle beer bottling line without relocation or interruption to itsoperation. The combination of the two lines was achieved by mounting awrap-around carton packaging machine.





STM GROUP
BOTTLING & CANNING

Implementation

- Capacity – 6500 bph Triblock 24/24/6 ISO Beer
- Self-adhesive labeler unoade
- Data printer
- Flat conveyors XPP
- Infeed table for empty bottles
- Collection table for finished product
- Automatic dapelletisation with cans rinser
- Microcan CL10 filling machine
- Self-adhesive labeller uno ade pro
- Case packer
- The whole system allows for the production of the highest quality beers which has volume of 50 000 hectolitres per year and places the Pinta Brewery no. 1 of Polish craft breweries in terms of modern technology and production capabilities.





STM GROUP
BOTTLING & CANNING

COMPLETE ALUMINIUM CAN FILLING LINE
BARTEX BARTOL, POLAND



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About the Client

Bartex Bartol is Polish dompany and has been run for three generations by the family of Mr. and Mrs. Bartol, and took its first steps on the alcohol market in 1990. Over the last 35 years, Bartex Bartol has become one of the largest producers and importers of spirits in Poland – from wines and ciders to spirits. Production goes to more than 30 countries around the world. High quality, flexible production and a responsible approach to business are the pillars on which Bartex builds its position and credibility.

STM GROUP
BOTTLING & CANNING

- Product: carbonated soft drinks, RTD
- Packaging: aluminum cans (330+500 ml)
- Capacity: 12000 cph
- Solution: Comprehensive CSD canning line from depalletizing

Project Requirements

The project involved the addition of a 4000 cph beer canning line to an existing glass bottle beer bottling line without relocation or interruption to it’s operation. The combination of the two lines was achieved by mounting a wrap-around carton packaging machine





STM GROUP
BOTTLING & CANNING

Implementation

- Automatic depaletizer
- Monoblock filling machine Arrow Can 24/4 ISO
- EPV Mobile CIP station
- Air Knifes
- Labeller STM Uno Ade PRO
- Flat conveyors XPP
- Filltec X-ray uderfill and lid presence inspector
- Collection table

Soon will be added: second labeller, case packer, connection to universal robot palletizing system delivered earlier as a part of a previous customer project:

Four coupled palletizing systems for full bottles in boxes for 4 filling lines working with speed up to 12000 bph, in each of the 4 cells:

- A plotter that positions cartons in any of dozens of carton formats to prepare a full layer
- The layer is then picked up by a roller gripper and placed on a pallet
- Pallet is then moved to the rotary arm wrapping machine and logistics label print & apply labeler.





STM GROUP
BOTTLING & CANNING

COMPLETE SOFT DRINK CAN FILLING LINE
EUROPEAN DRINKS, ROMANIA



About the Client

European Drinks is a Romanian food and beverage company that produces and distributes soft drinks, alcoholic beverages, mineral water and agricultural products. It owns popular brands such as Frutti Fresh, Bürger and Adria.

STM GROUP
BOTTLING & CANNING

Product: carbonated and still soft drinks, energy drinks, still and carbonated water and other beverages

Packaging: aluminum cans (250 ml, 330 ml, 500 ml

Capacity: 17000 cph

Solution: The new line was designed and delivered on a turnkey basis – from an automatic depalletiser to robotic palletising with a KUKA robot.

Project Requirements

The client was looking for a modern, fully automated filling line that would combine high efficiency with maximum flexibility.
The new installation was entirely designed, manufactured, and delivered by STM Group as a turnkey solution – from the automatic depalletiser to robotic palletising with a KUKA robot.
The system handles three can volumes (250 ml, 330 ml, and 500 ml) in slim, sleek, and standard formats, and supports two lid types: 200 and 202, ensuring adaptability to different product and packaging standards.





STM GROUP
BOTTLING & CANNING

Implementation

- Automatic depalletiser with extended platform and integrated empty can inspector (ECI)
- Can twist-rinser
- STM 36/4 filling monoblock – 36 filling valves with EPV technology and a 4-head seamer
- Bubble breaker
- CO2 injection under the lid
- Proportional valves and product pump
- System enabling filling at higher temperatures without quality loss

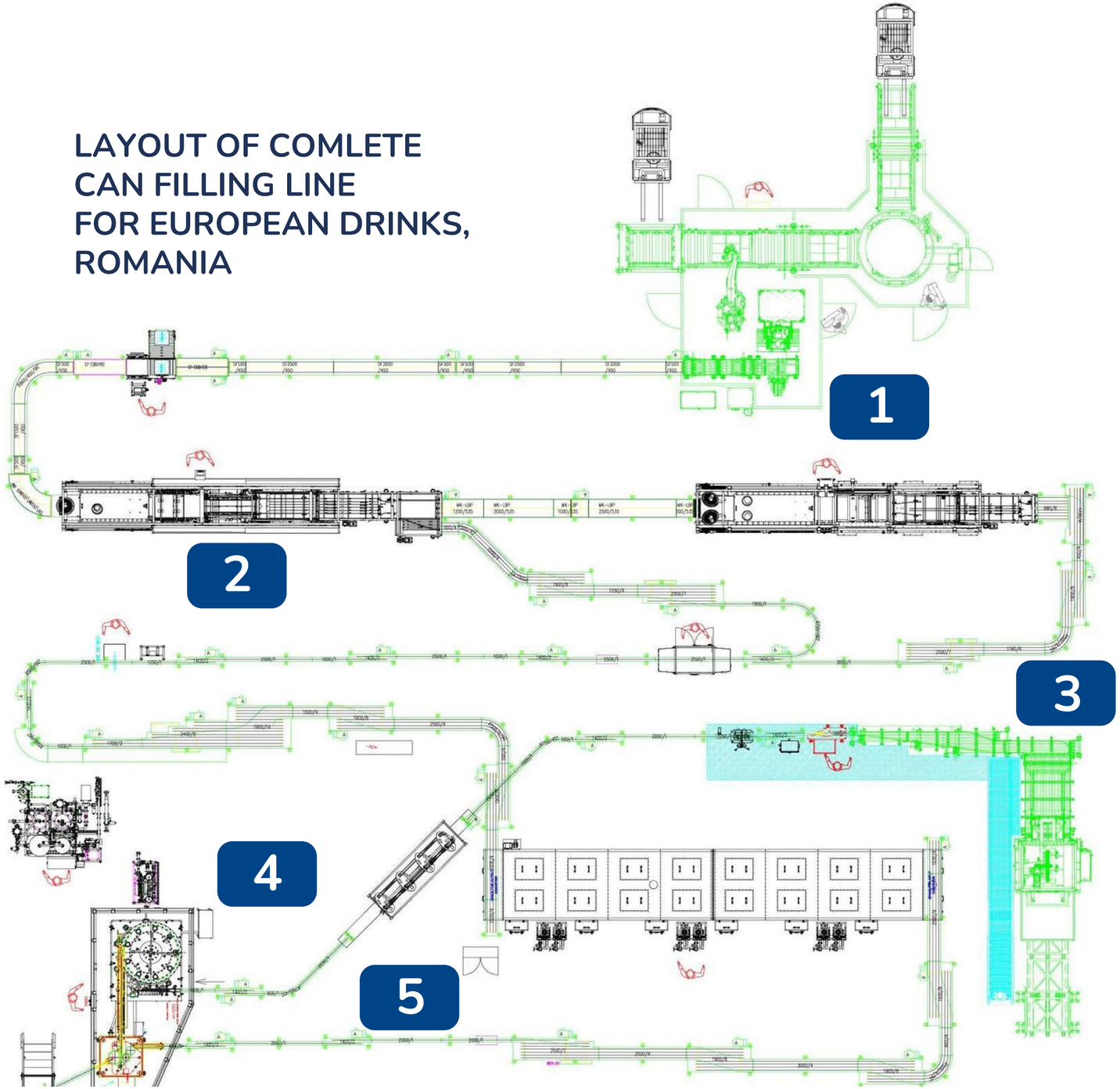
After the filling process, the cans are delivered to the STM pasteuriser. The product then passes through an X-ray fill level inspector, air knives and a double secondary packaging system, which allows for the creation of various multipack configurations (2×2, 3×2, 4×2) and collective packaging (tray + film).
Depending on customer requirements, the line also allows the multipack stage to be bypassed and direct packaging in a 6×4 tray plus film configuration.





STM GROUP
BOTTLING & CANNING

LAYOUT OF COMLETE CAN FILLING LINE FOR EUROPEAN DRINKS, ROMANIA



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STM GROUP
BOTTLING & CANNING

COMPLETE STILL AND CARBONATED WATER BOTTLE FILLING LINES
KELECHEK, KYRGYZSTAN



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About the Client

ZAO "Kelechek" is a leading mineral water producer in Kyrgyzstan, dedicated to providing consumers with premium-quality bottled water. To support its growth and maintain high production standards, the company continuously invests in modern and efficient manufacturing solutions.

STM GROUP
BOTTLING & CANNING

Product: carbonated and still water

Packaging: PET bottles (500ml; 1000ml & 1500ml)

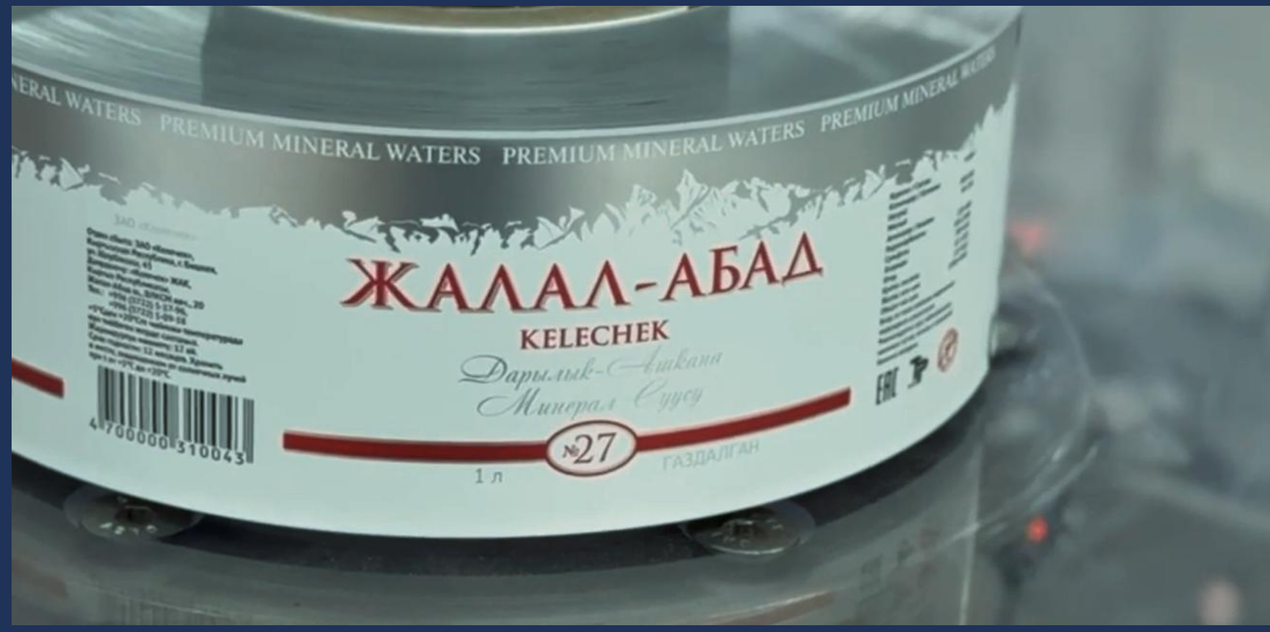
Capacity: 9000 BPH @ 1L & 9000 BPH @ 1,5L

Solution: Comprehensive automatic water bottling lines from stretch blow molding to packaging

Project Requirements

The client required a flexible and efficient PET bottling line capable of handling multiple bottle formats while maintaining high production performance. STM Group delivered a complete turnkey solution, integrating PET bottle production, filling, labelling, coding, and secondary packaging into one automated line. The installation processes PET bottles from 0.5 L to 1.5 L at speeds of up to 9,000 bottles per hour and includes blow moulding, carbonated beverage filling, OPP labelling, shrink wrapping, laser coding, and integrated quality control systems.





STM GROUP
BOTTLING & CANNING

Implementation

- STM Blueline 6 PET blow moulding machine
- STM ARROW PET 32/54/8 ISO triblock combining rinsing, ISO EPV filling and capping operations
- Automatic cap feeding and application system
  Fill level and cap presence inspection system
- OPP hot-melt labelling machine with format changeover parts
- Laser coding system for product traceability
- Shrink-wrapping machine for secondary packaging
- Automatic CIP system for hygienic cleaning and maintenance
- Remote diagnostics and monitoring via STM Site Manager

Following the filling process, bottles pass through automatic inspection systems for cap presence and fill level control before entering the labelling stage. The products are then labelled, laser coded, and packed using a shrink-wrapping system capable of handling various multipack configurations. Finished packs are automatically prepared for logistics and distribution, ensuring efficient end-of-line operation.

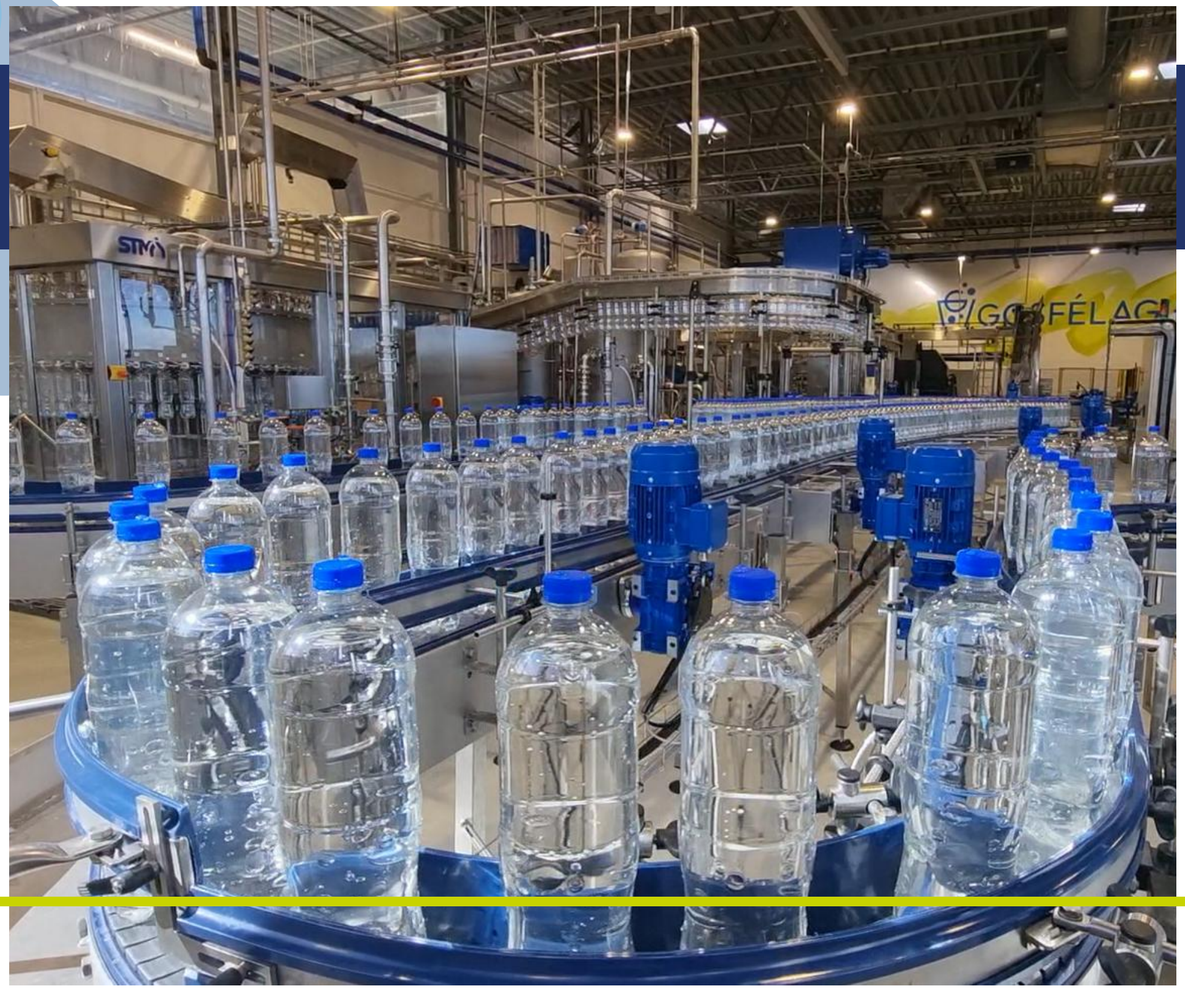




STM GROUP
BOTTLING & CANNING

PET BOTTLE WATER LINE & ALUMINUM CANNINING LINE

PLASTCO, ICELAND



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About the Client

Founded in 1988, Plastco hf. is a leading Icelandic supplier of industrial machinery, packaging, and automation solutions. The company supports food and beverage manufacturers with engineering expertise, equipment integration, installation, and service. With over three decades of industry experience, Plastco is a trusted partner for modern production and packaging projects across Iceland.

STM GROUP
BOTTLING & CANNING

Product: still water & carbonated drink

Packaging: aluminum cans & PET bottles

Capacity: 12 000BPH & 12 000CPH

Solution: Comprehensive automatic water bottling line from stretch blow molding to packaging as well as carbonated soft drink can filling line from depalletising to cardboard packaging.

Project Requirements

The client was looking for two, high-performance beverage production lines capable of processing both PET bottles and aluminum cans at a capacity of 12,000 units per hour. We delivered turnkey lines covering all key production stages, including PET bottle blow moulding, filling, inspection, labelling, coding, packaging, and palletising, as well as automated can depalletising, filling, X-ray inspection, carton packaging, and palletising.

Shared utilities such as a JG 12 premix system, a fully automated CIP station (3×1000 l), checkweigher, and central conveyor control, ensured efficient operation, reliable product quality, and flexibility for various beverage applications.





STM GROUP
BOTTLING & CANNING

Implementation - PET bottle line

- Automatic blow molding machine model BlueLine 6 HiTech
- Hydraulic lift for cartons/basket for preforms
- Blow molding machine and mold chiller
- Compressor set by Ateliers François
- ARROW PET 24/48/8 ISO EPV filling machine
- Air conveyors
- Air knives
- STM MegaRoll 12 rotary labelling machine
- Filtec bottle inspector
- CIJ printer Hitachi
- Shrink wrapping machine Atlanta model Ambra S
- Flat conveyors XPP
- Control cabinet for conveyors steering
- Checkweigher
- Fully automatic palletizing system PAL 1
- Premix Machine model JG 12
- CIP station 3x1000l with automatic control





STM GROUP
BOTTLING & CANNING





Implementation - Aluminum can line

- Fully automatic cans depalletizing unit model TES STM DPL-S CAN-15
- Vertical conveyor (lowerator)
- Monoblock (FS) ARROW CAN 24/4 ISO EPV
- Lid feeding system CSW Lowered V-Chute-LVC
- Air Knives
- CIJ printer Hitachi
- X-Ray filling level inspector
- Wrap around carton box packaging machine ATLANTA GIOTTO
- Alup Largo compressor
- Control cabinet for conveyors steering
- Checkweigher
- Fully automatic palletizing system PAL 1
- Premix Machine model JG 12
- CIP station 3x1000l with automatic control

STM GROUP
BOTTLING & CANNING

COMPLETE BOTTLING FOR CARBONATED WATER, SOFT DRINKS, STILL WATER & SYRUP LINES

SHORO, KYRGYZSTAN



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About the Client

Shoro Company is a leading Kyrgyz beverage producer specializing in traditional drinks, natural spring water, and mineral water. Established in 1992, the company is recognized for combining local heritage with modern production standards.

STM GROUP
BOTTLING & CANNING

Product: carbonated water; still water; carbonated soft drinks

Packaging: PET bottles (from 300ml up to 5,000ml)

Capacity: Ranging from 2200 BPH up to 12 000 BPH

Solution: STM Group supplied and commissioned eight production lines with capacities ranging from 2,200 BPH to 12,000 BPH, providing scalable solutions tailored to the client’s growing production requirements.

Project Requirements

The client was looking for modern, fully automated bottling lines that would combine high efficiency with maximum flexibility. The new installations were entirely designed, manufactured, and delivered by STM Group - from the blow moulding machines and water preparation to the triblock filler and final shrink-wrapping machines. The systems handles multiple container formats and volumes (ranging from 0.33 L to 5 L cylindrical PET bottles) and supports various packaging and capping standards, ensuring full adaptability to different product requirements.





STM GROUP
BOTTLING & CANNING

Implementation - PET bottle CSD filling line

- Blow molder Blueline 6 Standard
- Chiller
- Air conveyors XPPO
- Electric cabinet
- Triblock Arrow Pet 32/54/8 ISO at 1.5l
- Equipment - change over parts for 0.5l, 1.0l, 1.5l
- Waterfall caps feeder BCF1
- Flat conveyors XPP + central lubrication system
- Carbonator JS16
- OPP labeling machine Mega Roll 9T + modem
- Air knives
- Shrink wrapping machine DIMAC StarOne F + modem + 3 formats
- Cap, level and label control FT system + ejector

Line capacity of 10 000 BPH at 1,5l + modem





STM GROUP
BOTTLING & CANNING





Implementation - PET bottle CSD filling line

- PET blow molding machine Blueline 8 HiTech
- Blow molder chiller
- Set of compressor Ateliers François
- Air conveyors XPPO
- Triblock Arrow Pet 40/60/10 ISO
- Caps feeder BCF1
- Flat conveyors XPP
- Premix JG20 Flow Mix
- OPP labeling machine Mega Roll 12T
- Laser printer VIDEO JET
- Shrink-wrapping machine Atlanta Opale F
- Filling level and cap presence inspector
- Line capacity of 12 000 BPH at 1,5L

STM GROUP
BOTTLING & CANNING

Implementation - PET bottle still water line

- PET blow molding machine Blueline 2 Standard BIG
- Blow molder chiller
- Set of compressor Ateliers François
- Air conveyors XPPO
- Triblock Arrow Pet 32/54/8 ISO
- Caps feeder BCF1
- Flat conveyors XPP
- Self-adhesive labeling machine Uno Ade
- OPP Labelling Machine Uno Roll
- Bottle divider DV 150
- Shrink-wrapping machine Dimac Star One F
- Line capacity of 2200BPH at 5L





STM GROUP
BOTTLING & CANNING

Implementation - Syrup line

- Crystal sugar syrup room 12 000 LPH
- Syrup preparation station
- Syrup pasteurizer
- Beverage preparation station
- Beverage pasteurizer
- Nitrogen generator





STM GROUP
BOTTLING & CANNING

Implementation - PET bottle carbonated water filling line

- BlueLine 8 HiTech
- Chiller
- Compressor
- Filling triblock Arrow Pet 40/60/10 ISO
- Premix JG20
- OPP labeller Mega Roll 12T
- Videojet 3210 laser date printer
- Filtec fill level, caps and labell control with rejector
- Flat conveyors XPP
- Packing machine Opale F
- Line capacity of 12 000 BPH





STM GROUP
BOTTLING & CANNING





Implementation - PET bottle carbonated water filling line

- Blow moulding machine TES Blueline 4 HiTech
- Compressor
- Chiller
- Air conveyors
- QuadraBlock 32/40/40/8
- UNO ROLL labelling machine
- Saturator JS9
- Packing machine XP650 ALX
- Flat conveyors XPP
- Line capacity of 6000 BPH

STM GROUP
BOTTLING & CANNING

Implementation - PET bottle filling line

- Blow molding machine mod. BlueLine 6 Standard
- Chiller MTA
- Air conveyors system mod. XPPO
- Triblock mod. ARROW PET 32/54/8 ISO EPV
- Labelling machine mod. MEGA ROLL 9T
- Fill level controller with bottle rejector
- Flat conveyors XPP
- Shrink wrapping machine ATLANTA mod. AMBRA S
- Laser dater VIDEOJET
- Line capacity of 12 000 BPH





STM GROUP
BOTTLING & CANNING

COMPLETE BOTTLING FOR CARBONATED WATER AND STILL WATER LINES

PENTAROM, ROMANIA



About the Client

Pentarom is a Romanian manufacturer of industrial packaging solutions, specializing in cardboard and wooden packaging for the automotive and manufacturing industries. Established in 1992, the company is recognized for its high-quality products, modern production facilities, and customized packaging solutions. The client was looking to diversify their business.

STM GROUP
BOTTLING & CANNING

Product: carbonated water & still water

Packaging: PET bottles (500ml; 6000ml)

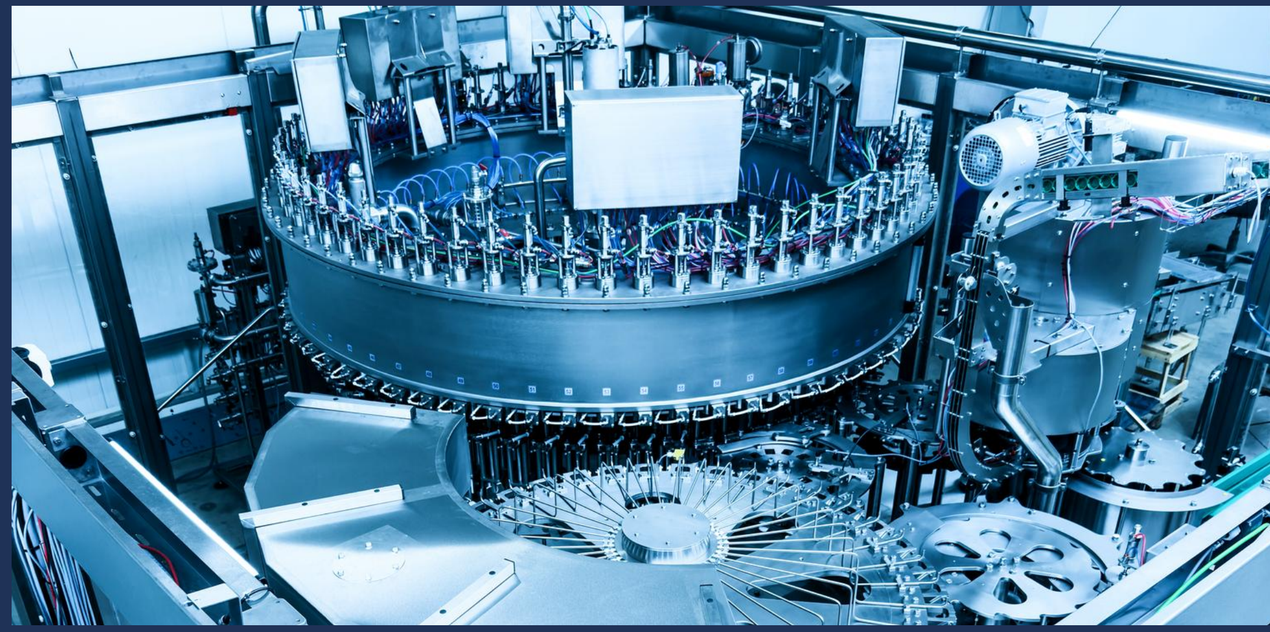
Capacity: 2000 BPH @ 6L & 14 000 BPH @ 0,5L

Solution: As part of its ongoing business diversification strategy, Pentarom expanded into the beverage sector, where STM Group supported this growth by supplying complete beverage production line tailored to the company's new manufacturing ambitions.

Project Requirements

The client was looking for a reliable and scalable water bottling lines capable of producing standard single-serve and large-format PET bottles. The project required dedicated filling lines for 500ml and 6,000ml bottles, while maintaining high product quality, efficient production flow and fully automated end-of-line handling. The solution included a high-speed 14,000 BPH line equipped with an STM ARROW PET EPV filling monoblock, saturator, CIP system, and conveyor network, complemented by a 2,000 BPH line dedicated to large 6 L bottles with integrated palletising capabilities. Together, the two systems provided the flexibility to serve multiple market segments and production requirements.





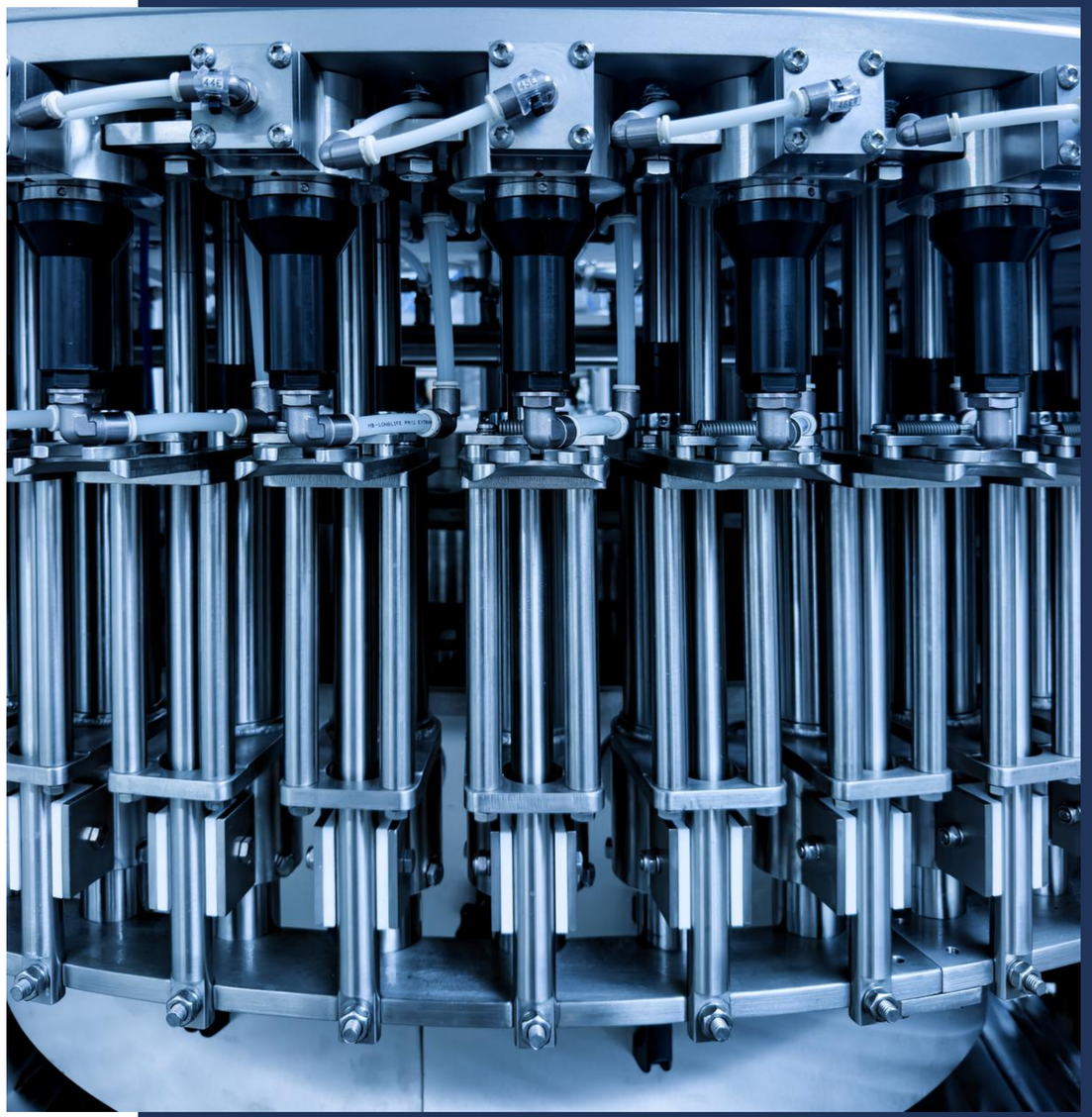
STM GROUP
BOTTLING & CANNING

Implementation - Carbonated water line

- Filling machine STM Arrow PET EPV 40/64/10 ISO
- Saturator machine STM JG 20
- Electric CIP station 2x500l
- Flat conveyors XPP
- Line capacity of 6000 BPH at 0,5L format

Implementation - Still water line

- Filling machine STM Arrow PET 16/16/6 NC BIG
- Complete conveyor system
- STM PAL2 BIG
- Line capacity of 2000 BPH at 6L format



STM GROUP
BOTTLING & CANNING

COMPLETE FILLING ALUMINUM CANS FOR COLD BREW COFFEE LINE

B-HAVEN, SOUTH KOREA



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About the Client

B-Haven is a South Korean innovator specializing in specialty cold brew coffee production and beverage technology. The company combines advanced manufacturing capabilities with in-house developed brewing solutions, supporting both beverage production and process innovation.

STM GROUP
BOTTLING & CANNING

- Product: cold brew coffee
- Packaging: aluminum cans (330ml)
- Capacity: 6,000 CPH
- Solution: Efficient aluminum can filling line

Project Requirements

Compact and efficient can filling solution tailored to specialty cold brew coffee production, with a strong focus on product quality, process reliability, and future scalability. STM Group delivered a fully integrated 6,000 CPH canning line featuring automatic can depalletising, gentle container handling, precise filling with the ARROW CAN ISO EPV monoblock, air knife drying, and a complete conveyor system. The solution was designed to support B-Haven's growing beverage portfolio while ensuring consistent production performance and operational efficiency.





STM GROUP
BOTTLING & CANNING

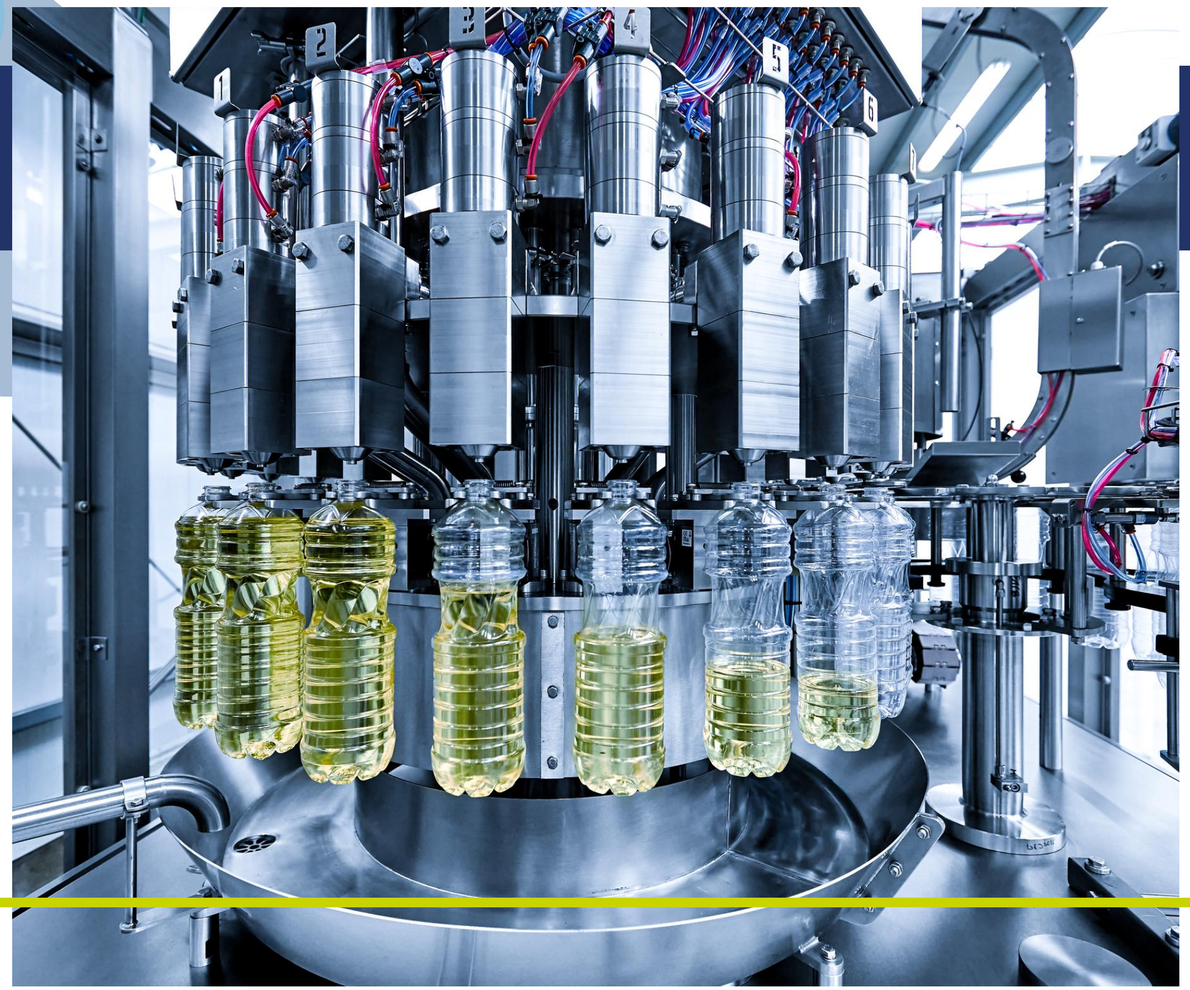
Implementation

- Automatic depalletizer model STM DPL-S-CAN-6
- Overturning vertical conveyor (lowerator)
- Monoblock (FS) ARROW CAN 14/2 ISO EPV
- Air knives
- Flat conveyors XPP



STM GROUP
BOTTLING & CANNING

TWO COMPLETE EDIBLE OIL LINES
TOPOIL, UZBEKISTAN



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About the Client

TopOil JV LLC is a leading edible oil and fat processing enterprise based in Uzbekistan, operating under the renowned Milter trademark. The company specializes in the production of high-quality refined sunflower oil, margarines, spreads, mayonnaise, sauces, and confectionery products, adhering strictly to Halal and ISO quality standards. To meet rapidly growing domestic and regional market demand across Central Asia, Milter continuously modernizes its manufacturing infrastructure through large-scale investments in advanced automation and high-capacity production lines.

STM GROUP
BOTTLING & CANNING

Product: edible oil

Packaging: Cylindrical PET bottles 1l; 2L; 3L; 5L

Capacity: 2,400BPH at 5L and 10,000BPH at 1L

Solution: STM Group delivered two turnkey PET bottling lines with automated net-weight filling to maximize production capacity and operational efficiency.

Project Requirements

As part of a major production expansion, Miltar required two complete, fully automated PET bottling lines dedicated to edible oil packaging. STM Group engineered and delivered a comprehensive turnkey solution comprising Line 1 (2,400 BPH for 2L, 3L, and up to 5L PET bottles) featuring a BlueLine 2 BIG blow moulder and Weight-Matic BIG monoblock filler/capper, and Line 2 (10,000 BPH for high-volume 1L retail packs) equipped with a Blue Line 6 stretch moulder, Weight-Matic 24/8 load-cell net-weight filling, and Atlanta wrap-around packaging. Both lines integrate advanced labelling, date coding (laser and CIJ), and end-of-line carton closing and palletizing to ensure maximum throughput and operational flexibility.



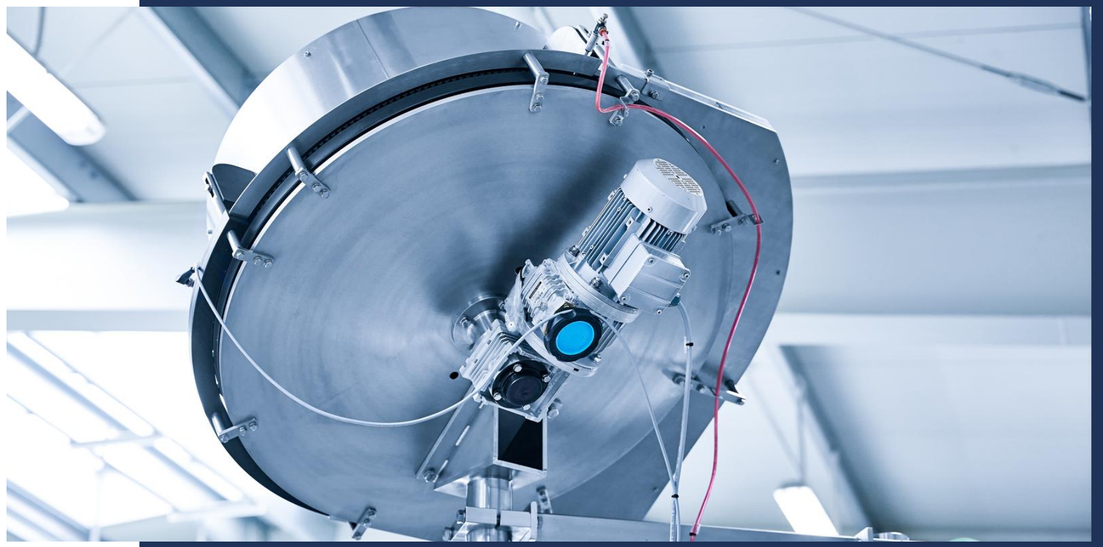


STM GROUP
BOTTLING & CANNING

Implementation - LINE 1

2,400 BPH AT MAX 5L

- BlueLine 2 BIG blow moulding machine + chiller
- Monoblock AP 16/4 Weight-Matic BIG filler/capper
- Labelling, carton forming and loading, laser date coding
- Automatic american carton closing and palletizing



Implementation - LINE 2

10,000 BPH AT 1L

- Blue Line 6 standard stretch blow molder
- Weight-Matic 24/8 monoblock Load-cell net-weight filling and capping
- MegaRoll 9 roll-fed labeller
- Atlanta wrap-around packaging
- HITACHI CIJ ink-jet date codin



STM GROUP
BOTTLING & CANNING

COMPLETE ALCOHOL FILLING LINE IN ALUMINUM CANS

LIVIKO, ESTONIA



About the Client

Liviko is one of the Baltic region's leading producers and distributors of premium alcoholic beverages, with a portfolio that includes internationally recognized brands such as Vana Tallinn, Crafter's Gin, and Viru Valge. The company combines long-standing craftsmanship with advanced production technologies and exports its products to more than 60 markets worldwide.

STM GROUP
BOTTLING & CANNING

Product: alcohol

Packaging: Aluminum cans

Capacity: 6,000 CPH

Solution: STM Group delivered a complete aluminum can filling line with automated can depalletizer to maximize operational efficiency.

Project Requirements

The client required a complete can filling solution for premium alcoholic beverages, combining high product quality, reliable process control, and attractive retail-ready packaging. The installation needed to support efficient production of canned alcoholic drinks while meeting the quality standards expected from a leading international beverage brand. We delivered a fully integrated 6,000 CPH aluminum can line featuring automated depalletising, precise filling with the ARROW CAN ISO EPV monoblock, beverage preparation through a JG 3 Flow Mix premix system, automated CIP cleaning, product inspection, labelling, coding, and secondary packaging. The solution provides Liviko with a flexible and efficient platform for producing and packaging a wide range of premium canned beverages.





STM GROUP
BOTTLING & CANNING

Implementation

- Automatic depalletizer model STM DPL-S-CAN-6
- Overturning vertical conveyor (lowerator)
- Monoblock (FS) ARROW CAN 14/2 ISO EPV
- Warming tunnel
- Air knives
- Automatic checkweigher
- Labelling machine STM PRO ADE
- CIJ type marking system, inkjet printer
- Combined solution Autopack 60CUH25 Tray Packer plus 60SLNM25 shrink wrapper
- Flat conveyors XPP
- CIP station 3x500l with automatic control
- Premix Machine model JG 3 Flow Mix

  Line capacity of 6,000 CPH





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