

LSB-330-R Fully Automatic Roll Fed Twisted Handle Paper Bag Machine

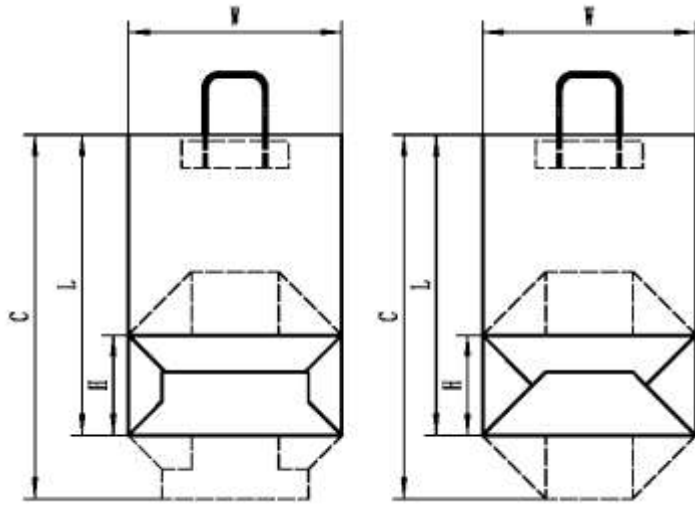


Introduction

This machine is designed to manufacture square bottom paper bags with twisted handle from paper roll, paper patch roll and paper rope. YASKAWA PLC Control system imported from Japan and adjustable dual-moulds structure, ensure that the machine can perform quickly and stably, as well as reduce adjusting time for different bag sizes. Front bags collection platform and counting function, improve packing efficiency of paper bags packing. By implementing steps including handle making, handle application, tube forming, tube cutting, and bottom forming with a fully automatic process. That is especially suitable for foodstuff, clothing and luxury branding products.

Features

1. The human-machine touch screen interface, the work condition can be shown in real- time.
2. Equipped with accurate servo motor drive, it makes the machine run steadily and efficiently.
3. Material loading and unloading adopts pneumatic or hydraulic lifting structure.
4. Automatic constant tension control system. The tension will be just right from beginning to end.
5. Double photoelectric sensor limit automatic correction control system and deviation rectification stability, energy saving, long life.
6. Thumb buttons, appressed bottom cutting device, bag type have many choices.
7. Don't stop machine adjust double bottom structure, the adjustment will become more intuitive, more simple, more time saving.
8. Glue roller air defense coating control, avoid gluing on besmear brushes hub surface directly, reduce unnecessary trouble.
9. Accurate color tracking system, automatic alarm prompt when color is wrong.
10. Adjustable forming mould structure (side sealing is above the forming mould).
11. Handle production unit, paper handle cutting and gluing are all controlled by servo motor



Main Technical Parameter (see picture above)

Type	LSB-330-R	
Bag Width	130-330 mm	
Bottom Size	70-180 mm	
Cutting Length	270-530 mm (No handle)	270-430 mm (With handle)
Bag Length	$L=C-(H \div 2 + 15 \sim 25)$	
Max. Speed	180 pcs/min	
Paper Roll Width	400-1050 mm	
Max. reel weight	600 Kg	
Max.Roll Diameter	1200 mm	
Reel inner diameter	76 mm	
Paper specification	60-170 gsm	
Handle Rope Height	100 mm	
Handle Rope Diameter	4-6 mm	
Paper rope spacing	76.2mm	
Handle Patch Length	152.4mm	
Handle Patch Width	35-50 mm	
Paper Patch Roll Diameter	1200 mm	
Paper Patch Roll Width	70-100 mm	
Paper Patch Thickness	100-150 gsm	
Web edge control system	Double photoelectric automatic correction control system	

Web tension control system	automatic constant tension control system
Air pressure	$\geq 0.12\text{cmm}$, 0.6~1.2Mpa
Driven motor	Seven servo motors
Electric	380V, 50 Hz, 3 phase
Power	27 KW
Weight	13700 Kg
Overall dimension (L×W×H)	12200×5700×2500 mm

Configuration

1. Adopt touch screen and Motion Control System, the work condition can be shown real time. Cooperate with the ultra precise double servo motor, the stability can be guaranteed.
2. The machine has automatic counting system. The user can set a number to count. When bag quantity meets the number, the bag will be jumped out like the picture shows.
3. Adopt Japanese original Yaskawa servo control system to realize high-speed and precise operation control.
4. Independent glue coating system, the glue coating system can be run independently after the machine stops, avoiding the glue drying and not easy to clean. The glue automatic supply system will automatically supply when the glue is insufficient.
5. The compact design of mechanical transmission, ensure that the material is passed stable, accurate, improving mechanical properties, producing paper bags better appearance, neat.



6. Glue roller air defense coating control, avoid gluing on besmear brushes hub surface directly, reduce unnecessary trouble.



7. The integral tube forming adjustment structure can be adjusted at the same time on one side or both sides to improve work efficiency, reduce the scrap rate generated by the adjustment process, and save adjustment time and stability of adjustment.



8. The overall electric adjustment structure of the paper handle pressing wheel, the paper handle pressing conveying and the pressing wheel are adjusted synchronously, saving the cumbersome process of separate adjustment of the paper handle pressing position and the pressing wheel position, and the adjustment position is simple and fast.



9. Width-adjustable paper handle conveying structure can adjust the width according to the paper handle, which makes the paper handle more applicable.



10. Independent servo gluing system, the gluing position of the paper handle can be adjusted arbitrarily, and the gluing position can be adjusted as you like.



11. Gluing automatic clutch control, the machine stops and the glue roller separates automatically, avoiding the continuous working of the glue roller in the stopped state and the glue overflowing.
12. Independent servo pre-cutting system, the pre-cutting position of the paper handle can be adjusted at will, and the pre-cutting position adjustment is very convenient and fast.
13. Precise color mark tracing system can make sure precision of bag printing pattern cutting position. The color mark tracing function can avoid the readjustment after paper reel changing, paper web breaking, or power outage. The machine can stop automatically when the color mark is error. It will save time and reduce the waster rate.
14. Automatic edge control system adopts two photoelectric sensors to detect the edge of paper web. The motor doesn't need to work often so its power consumption is reduced and its life is extended. (User can choose single photoelectric sensor to control edge.)



15. Pneumatic paper reel lifting device make paper reel changing easy. Press one switch and the paper reel will be lifted automatically. Avoid the personal injury. The pneumatic lifting system can make sure the stability of paper web feeding and avoid moving the feeding stand.



16. automatic constant tension control system The tension will be just right from beginning to end.



17. Automatic lubrication system can supply automatically the lubrication oil to every part which needs to be lubricated. The lubricating time and oil quantity can be set by user. Avoid damage of machine because user forgets to lubricate. The maintenance becomes easy!



Parts list of paper bag making machine

Name	QTY	Original/Brand	Remark
Control system			
Motion controller	1	Japan YASKAWA	
I/O module	1	Japan YASKAWA	
Servo motor	7	Japan YASKAWA	
Servo driver	7	Japan YASKAWA	
Touch screen	1	Taiwan WEINVIEW	
Color mark tracking photo-sensor	1	Germany Sick	
detection photo-sensor	8	Japan Omron	
Proximity sensor	5	Japan Omron	
Low-voltage apparatus	16	Japan Omron	
Normal button	16	French Schneider	
Emergency button	3	French Schneider	
Rotation Switch	6	French Schneider	
Edge control and tension control system			
Constant tension controller	1	ORIENTAIDATA	
Magnetic powder brake	3	Zhejiang	
Correction controller	3	ORIENTAIDATA	
Edge control photo-sensor	4	Zhejiang	

Edge control motor	1	Jiangsu	
Limited switch	2	French Schneider	
Constant tension controller	3	ORIENTAIDATA	
Magnetic powder brake	3	Zhejiang	
Correction controller	2	ORIENTAIDATA	
Transmission and lubrication			
Precision planetary gearheads	7	Taiwan fenghua	
Auto lubricating pump	1	Zhejiang	
Synchronous belt	9	Zhejiang	
Synchronous wheel	6	Zhejiang	
Power and appliance			
Three-phase isolation transformer	1	Zhejiang	
Voltage stabilize	1	Taiwan mean well	
Cooling fan	1	Zhejiang	
Mechanical parts			
Inflatable Shaft (Feeding Shaft)	1	Zhejiang	3" Air shaft
Guiding roller	12	Zhejiang	Dynamic balance aluminum guide roller
Transfer belt	2	Zhejiang	High speed transfer belt
Edge line coating way	1	Home-make	Copper gluing wheel
Bottom gluing way	1	Shanghai	Elastic sponge
Besmear brushes way	1	Home-make	corrosion preventive nylon roller

Glue case	2	Home-make	Removable stainless steel glue tank
Replacement parts			
T-shaped Rod	3	Home-make	170、245、320mm
Bottom Closing Nylon Sleeve	10	Home-make	Φ25.4×25、50mm
Paper Pressing Nylon Sleeve	4	Home-make	Φ50×20、80mm
Tooth cutting board	2	Home-make	28×330mm
Flat cutting board	1	Home-make	R60.3×330mm
Big wheels liner	12	Home-make	4°、8°、12° x340mm
Mould keel	4	Home-make	45、80×1710mm
Stainless steel forming board	8 Pair	Home-make	63、73、83、95mm
Accessories (Spare Parts)			
Inflatable Shaft (Feeding Shaft)	1	Zhejiang	Φ76×1418mm
Side Clip	8	Home-make	Big Wheel
Open Side Clip	2	Home-make	Open wheel
Bottom Pressing Scrip	10	Shanghai	30×336、1000mm
Indentation Knife	2	Shanghai	9×340mm
Serrated Blade Knife	2	Zhejiang	30×330mm
Flat knife	2	Zhejiang	29.3×330mm
Circular Arc Knife	2	Zhejiang	R14
Pre-cutting knife	4	Zhejiang	20×32mm
Cutting blade	4	Zhejiang	25×60mm
Roller bearing	2	NSK	CF-1/2-SB

Synchronous Belt	1	Zhejiang	50×1320
Synchronous Belt	1	Zhejiang	30×1880
Synchronous Belt	1	Zhejiang	30×672
Synchronous Belt	1	Zhejiang	40×752
Synchronous Belt	1	Zhejiang	30×1440
Transfer belt	2	Shanghai	15×630
Transfer belt	2	Shanghai	15×700