

# Sack Making Equipment



Allbest Creative Development Ltd. (ALLBEST)

# **Sack Making Line**

(HC Series)

# Full-automatic Pasting Line for Paper and Plastic-woven Sacks (QDHC702B)

## Main Features:

- Suitable for serve the needs of sacks made of thin, light, soft, thick, weighty and firm materials;
- Easy adjustment for changing the machine to serve the needs of paper sacks, compound materials sacks and plastic woven sacks;
- Equipped with a two-tier pasting unit and two sets of pasting channels as a versatile model;
- Wide range of big width, length and bottom through the feature of Flexible adjustment of dimensions;
- Applicable for various industries, such as packing cement, chemical fertilizer, foodstuffs, raw chemical materials, feedstuff, starch, asphalt, coating and other particle, grain, slice, wadding and pasted shaped substances;
- Effective anti-stickiness measures adopted for the pollution by glue in making plastic woven bag;
- Complete machine under computerized control with a mechanical-electrical integration;
- Automatic alarming and immediate shut-down in case of bag blocking or other fault; automated sorting and discarding in case of different specifications on the upper and lower ends of a sack.
- Automatic rejection of valve-port patch and attaching of bottom patch in case no bag fed in;
- Automatic separation of glue Applying rollers at all positions from the working area and automated gluing in case of temporary shut-down;
- Automatic control of temperature in the drying passageway;
- Automatic switching of hot air into the non-working area in case of temporary shut-down;
- Automatic counting, coding and bag out-loading;
- Through the advanced planet gear vacuum adsorb auto feed pattern, the feeding problems of pliable and smooth non-strength material shall be settled by auto-feeding technology.
- The positioning technology ensures correct coordinate of every bag in the whole production line.
- Unique "Manipulator" turning on base technology and finger-shaped proofreading structure makes every bag in right shape and accurate size.

## Specification:

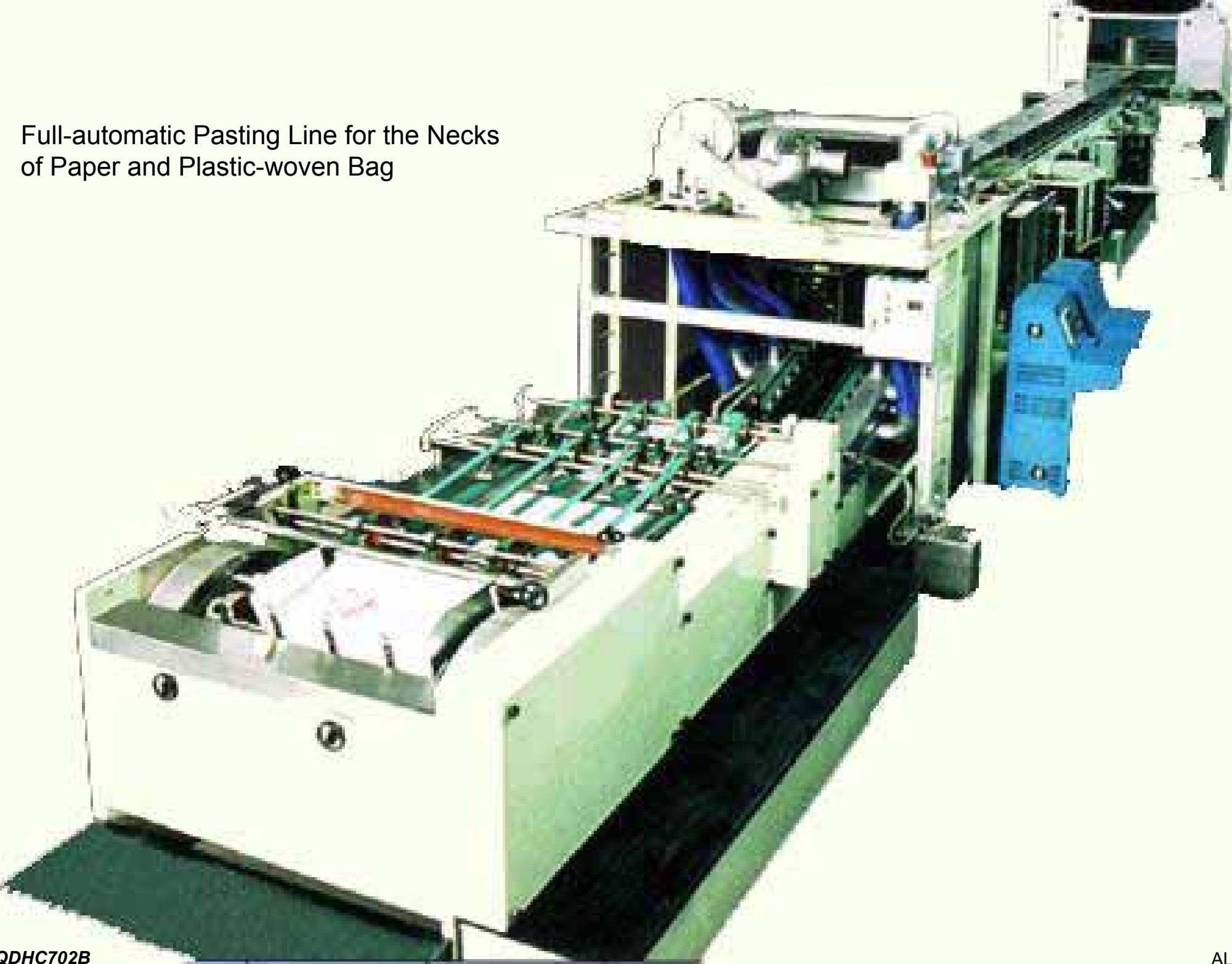
- Capacity: 50-80 bags /minute;
- Total installed power: 76-95kw
- Dimension of the unit: 28 L x 3.8 W x 3.5 H M
- Bag Types: bags with unsealed (open) neck or sealed (valve-port) neck; The bottom with or without the added layer (bottom paste)
- Size of the bags: 660-1020mm long, freely regulated; 450-700mm and 90-180mm wide, freely regulated. Bottom width of bag: 90-180 mm
- Materials of the bags: Clip paper, cover yarn paper, and extending paper bag paper. OR, polypropylene weaving fabric (PP) and polythene film( PE).
- Material weight:: single-layer clip paper of 160-260g/m<sup>2</sup>, double-layer clip paper of 100-140 G/m<sup>2</sup>, multilayer extending paper three-layer of 60 G/m<sup>2</sup> or above (3-5 layer); OR Polypropylene weaving fabric (PP) ≥ 90g/ m<sup>2</sup>, polypropylene film in thickness 0.02mm or above or other plastic bag-manufacturing material
- Printing: 4-6 colors chromaticity printing, flexible resin edition, pneumatic net roller rising and falling, printing ink automatic cycle, photoelectric auto error correction.
- Operation staff: 4-6

## Process:

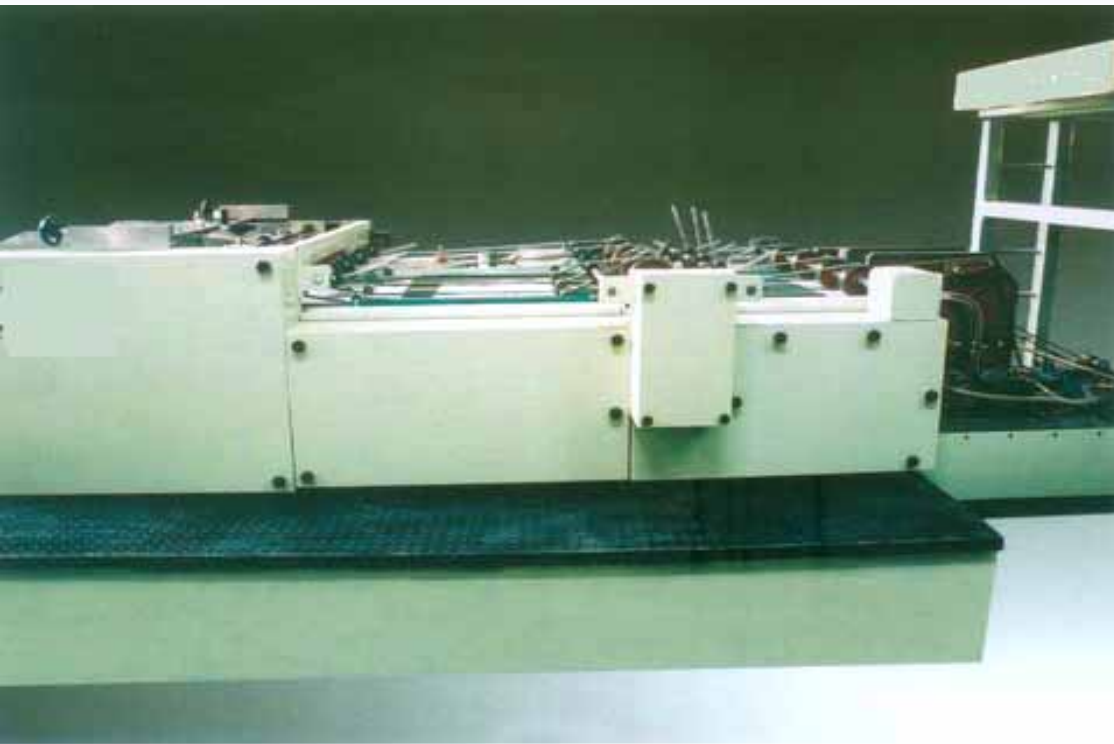
Materials → coil on the stand → 4-6 colors printing → sticking the joint → cut off (computer handled or by M hem device) → auto feed → front positioning → turn on at base → calibrate → glue → paste the valve rim → forming → second glue → paste at the attached base → fold in reverse → stack yard.

Note: The unit can be designed for paper pasting bag unit, or plastic-woven pasting bag unit separately according to the requirement of the client.

Full-automatic Pasting Line for the Necks of Paper and Plastic-woven Bag

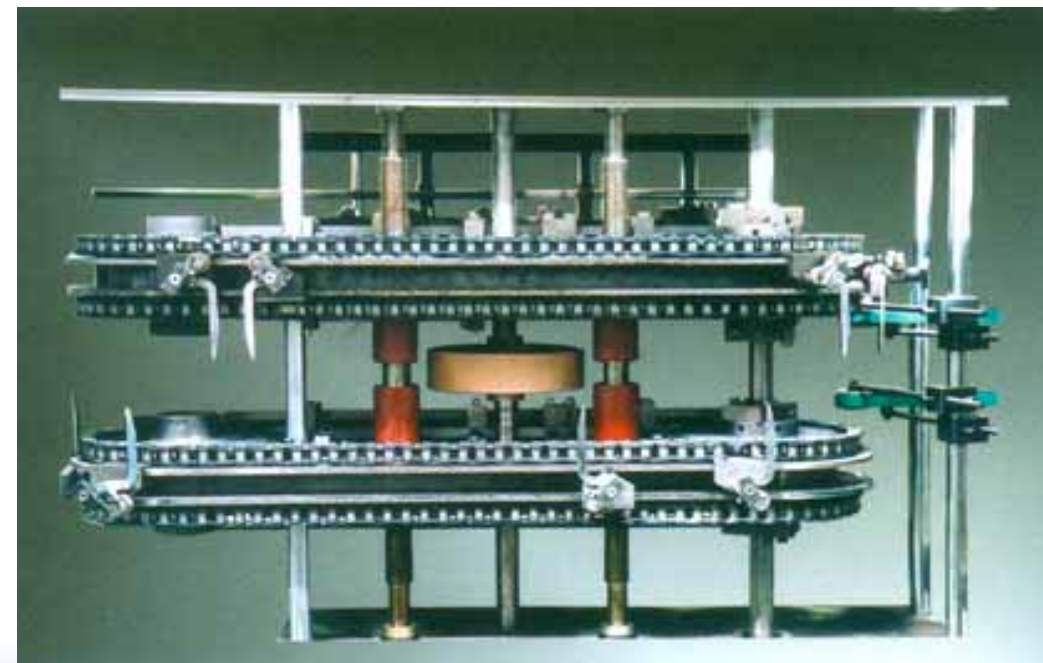


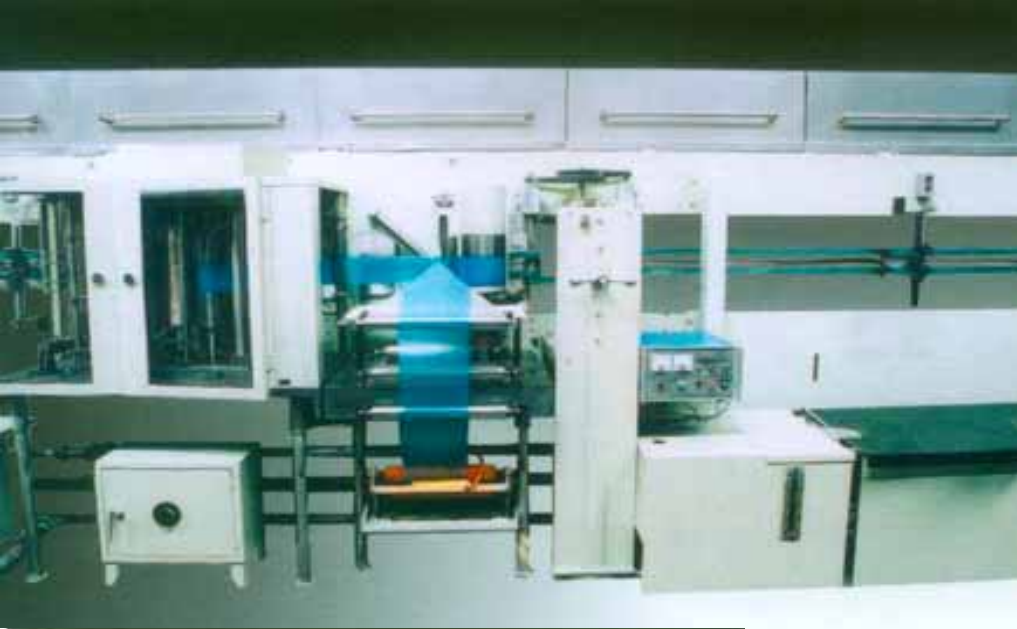




Differential type front edge positioning unit is able to position each of the bags of diverse dimensions sent in by the absorbing and feeding unit along the front edge and side edge accurately.

Finger shaped fork type bag neck correction unit is able to correct the front and rear corners of the neck of a bag already opened, thus to allow the bag bottom to be opened in a duly symmetrical way. The drum type valve port patch unit is able to produce patches made of multiple materials and of different shapes and dimensions, and allows hang wheel type length adjustment.





- The drum valve port patch mechanism can deal with patches of various kinds of materials, shapes and dimensions. Hang wheel type length adjustment available;
- Bag bottom secondary creasing unit is especially designed for thick weighty and firm materials
- Inclined planed type bag bottom fold molding unit is able to adjust the dimensions of bag bottom at any time;
- A vertical conveyance belt is supplied to facilitate the flowing of bags;
- Bag bottom double glue applying unit is especially designed for thick and weighty materials.

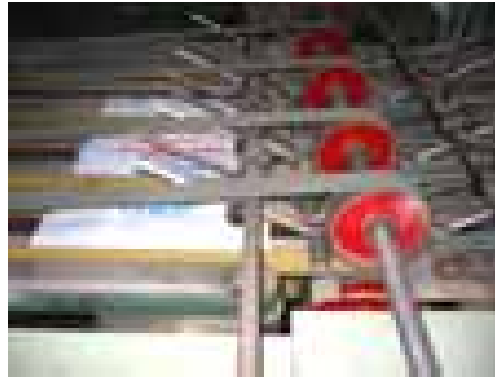


Continuous type added bottom patch unit is suitable for production of multiple kinds of materials.

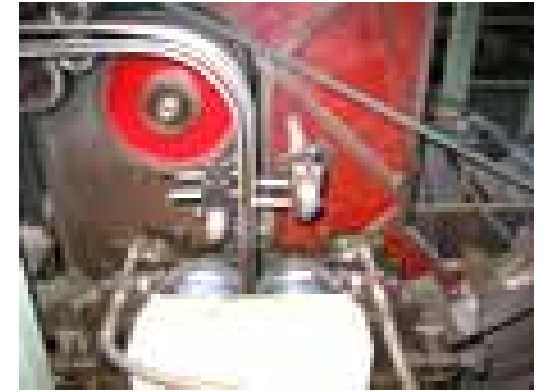
- Inbuilt with a controllable vacuum shifting type drum attached with reinforcing bottom patch;
- Non-circular gear wheel speed adjustment false cutting type cutter;
- Perforated belt based vacuum conveyance of bottom patch
- Vertical drying passageway set up for production of plastic woven bags makes the production techniques and flow more rational;
- Hot air switching;
- Hang wheel type length adjustment
- Automatic gluing in case of temporary shut-down
- Rolling lead screw for automatic rectification of deviations



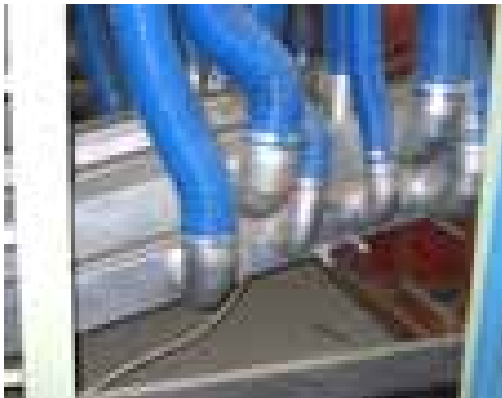
Auto feeding



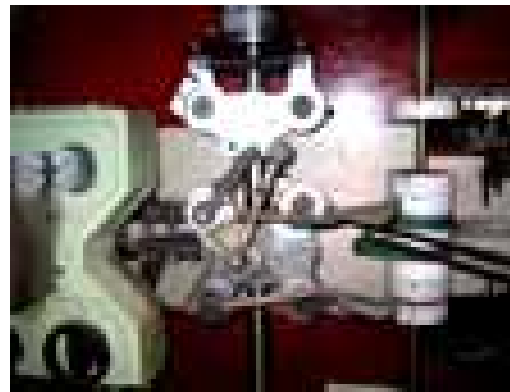
Front positioning



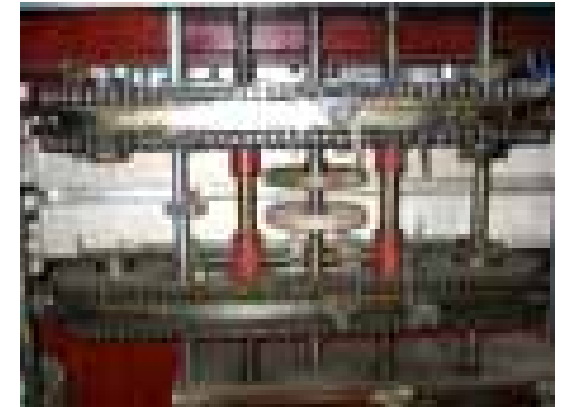
gluing



Drying



Bottom open



Adjusting bottom of bag



Pasting valve port



Forming bag bottom



Pasting added layer

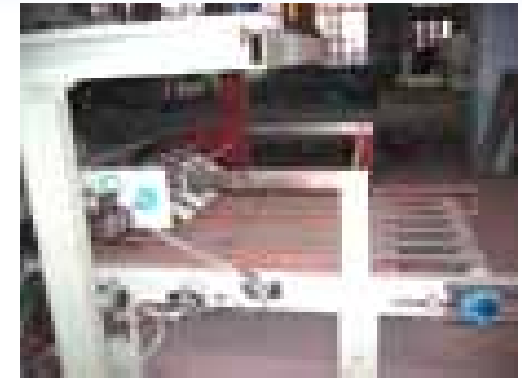




Folding



Bottom pasting corona



Stacking



Control at the rear section



PLC control cabinet



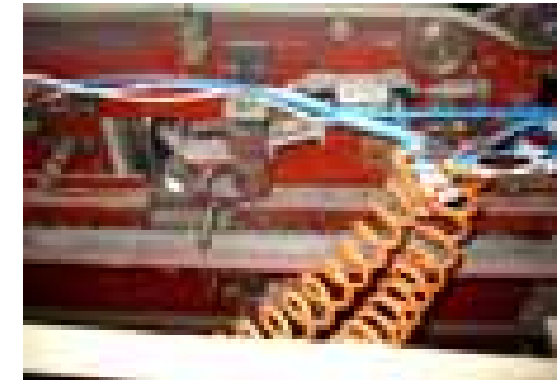
Gluing bottom



Auto correcting deviation



Vacuum pump and heating



Pneumatic pressing

# Samples of Sacks



# Plastic-woven drum cloth automatic printing and bag cutting machine (YCZ)

This machine is equipped with 4-colored complete winding drum cloth for continuous printing purpose, heated spinning for continuous cutting operation, and finely perforated roller and M-shaped molding device

The speed value has a direct relation to printing ink. Therefore, the speed depends on the quick drying performance of printing ink.

The machine adopts a frequency conversion type speed adjustment mechanism, and furnished with face 2-6 four-colored printing machine and reverse 2-4 colored printing machine, which is a lapped type. This print adopts flexographic printing (or offset printing) mechanism, and employs anilox roller for ink transfer purpose. Its edges include an evenly distributed quantity of ink, ink saving, clear-cut and vivid printing effects. Besides, the machine is supplied with an over-run clutch avoid printing ink from scaling off incurred by shut-down, and prevent uneven distribution of printing ink, and hence to prevent inferior products from arising. Its supplied “printing plate roller oil pressure enhancement system” makes it sure to enhance the printing plate roller in case of shut-down, thus to allow the roller to get away from the base cloth being printed, so to avoid pollution on the printing plate incurred by shut-down, and further prevent inferior products from arising. This printing machine delivers a high precision of chromatograph edition, allows horizontal& vertical plate-checking and fine control of chromatograph position, etc., thus to guarantee the accuracy of chromatograph edition and improve the printing results to a higher level.

The cutting device is furnished with a planet differential gear system, which is able to adjust those errors (accumulated in the printing shut-down operations) in the normal operation process, so as to guarantee the print pattern of the bag surface. The supplied electro-thermal cutting knife and cut the bag off neatly in an instant, with no sticking or erose edge left.

## Specification:

Capacity: 40-80 bags/min for compound bag; 30-50 for non-compound bag

Standard of bag length: 787 mm

Width of bag: 380-650 mm

Length of bag: 400-1250 mm

Width of flexure: 80-120 mm

Max. dimension of basic material:  $\text{Ø}1200 \times 800$  mm

Total installed power: 15 kw for driving; 30 kw for heating

Weight: 18 tons

Dimension: 15 x 1.5 x 1.85 M



# Tuber (ZT)

This tuber is for the efficient production of the 2-5 layers flat-end tube sacks, trapezoid-end tube sacks and gusset tube sacks. It consists of 12 components

## Specification:

Tube cut-off length: 650-1050 mm

Tube width: 400-620 mm

Space between tape steps: 20 mm

Paper roll diameter: (Max. 1300 mm)

Double or four colors chromatic printing.

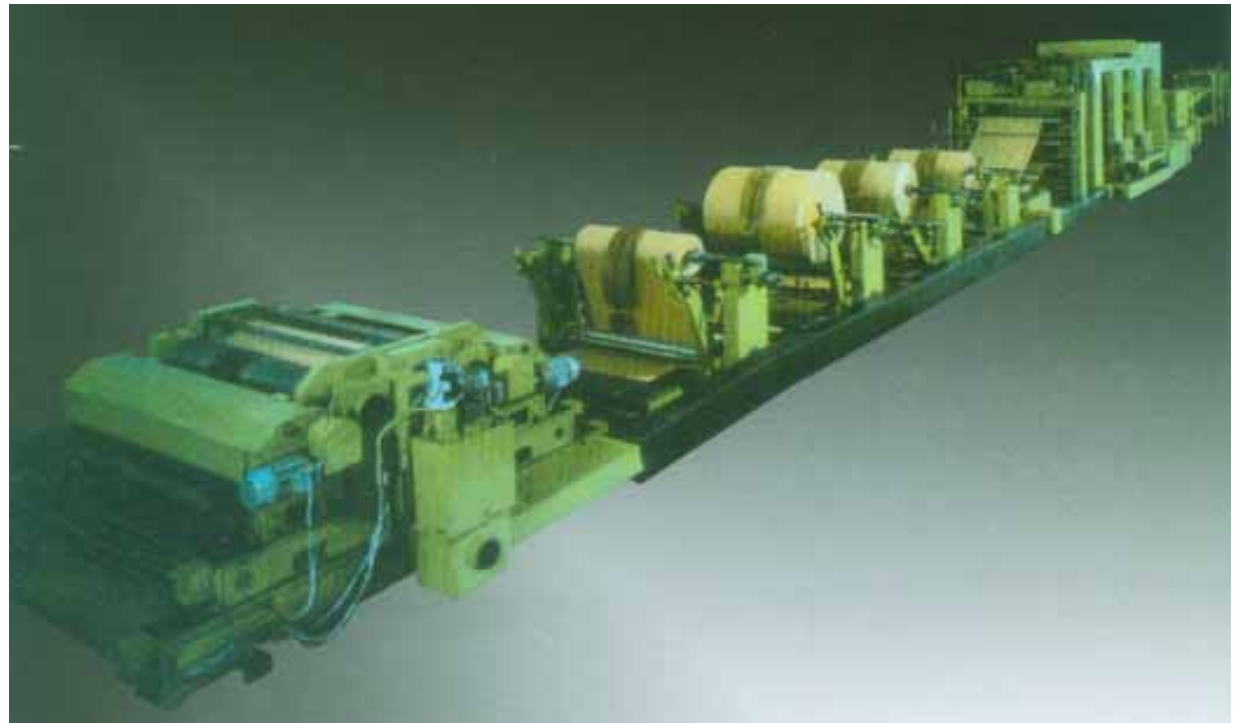
Printing width: 0-1300 mm

Output: up to 180 tubes/min.

Dimension of the unit: 34\*2.4\*2.7 M

Total weight: 34 tons

Main power: 18 kW





# **Sack Making Line**

**(XK Series)**

# Paper Bag Machine (B320/520-6A)

This machine is to produce bottom pasted bag for packing cement and chemical materials. The machine can produce paper bag with 2-5 layers

## Specification:

Capacity: 120-140 bag/min

Bag length: 722-1000 mm

Bag width: 420-520 mm

Total power: 22 kW

Weight: 18 tons

Dimension: 22\*1.6\*1.8 M



## Bottom Pasted Paper Bag Machine (HD100/130A)

This machine is to produce the bottom pasted paper bag, and by using computer program control. It can be used with Model HT500-1 Sack Machine together to produce the bottom pasted paper bag.

### Specification:

Capacity: 80-120 bags/min

Length of sack: 520-900 mm

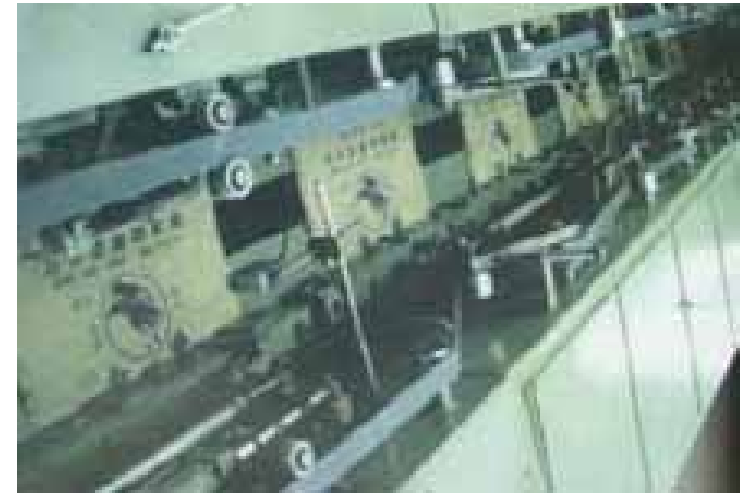
Bottom pasted width: 420-550 mm

Bag pasted bottom width: 90-140 mm

Total power: 32 kW

Weight: 18 tons

Dimension: 22\*1.8\*1.8 M



# Paper Tube Machine (HT500-1)

This machine used to produce the bottom pasted tube sack with ladder-shaped end. The whole machine uses computer program control. It can produce cement bag, starch bag, tea bag, etc.

## Specification:

Capacity: 100-120 bags/min

Bag length: 700-1050 mm

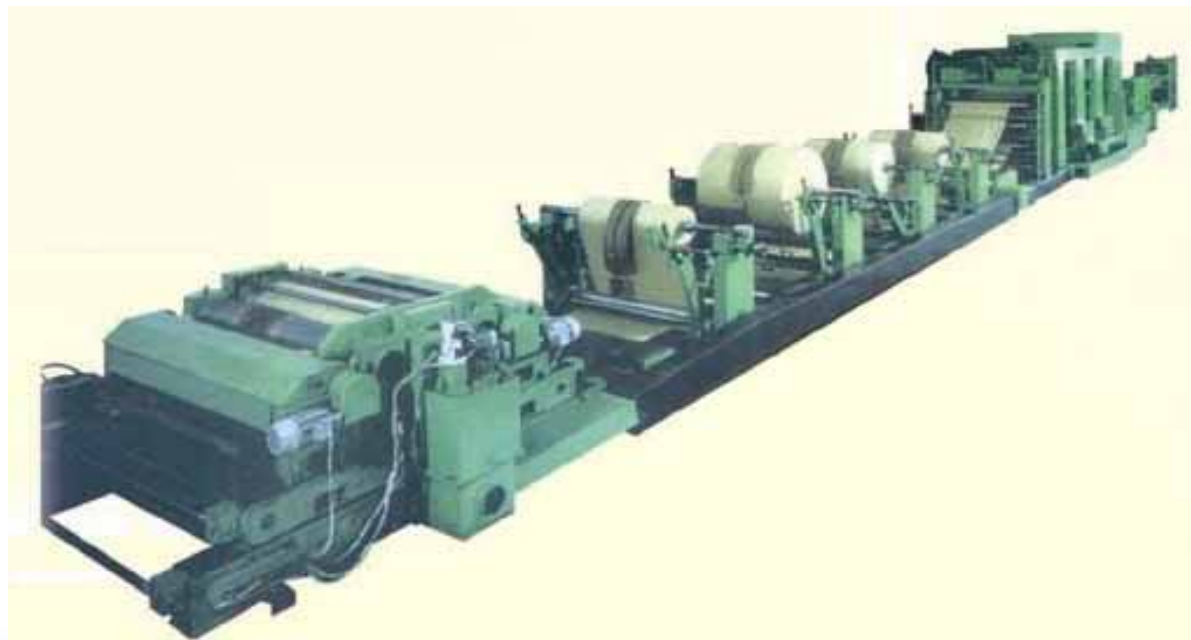
Bag width: 420-600 mm, printed in both 6 surfaces.

Bag layer: 2-4 layers

Total power: 30.9 kW

Weight: 32 tons

Dimensions: 34\*2.4\*2.7 M



# Paper and Plastic Shaped Bag Machine (B320/520-6B)

Plastic weaving and compound bag features lightproof, waterproof, tough , bearing rolling over, wear-resisting, corrosion-resistant, light weight, easy printing, etc, which is applied for packing chemical, sugar, cement, minerals, food, etc.

## Main specification:

Capacity: 30-70 bags/min (paper and plastic compound);  $\leq 50$  bags/min (plastic weaving bag)

Bag length: 650-880 mm

Bag width: 420-550 mm

Hem width:  $\leq 140$  mm (the size of lunch)

Total power: 18.5 kW

Print width: 1220 mm

The platform of center seam takes shape; the device is equipped with cold and hot on the head of machine





# Spreads Plastic Compound Machine (STF-1500)

The machine make the high-pressured polyethylene, the polypropylene become melting form then push from the head of machine out of the membrane and spreads it on the base material evenly which waiting compounded, through the complex device, make it and paper (cow skin paper, container bag paper) compound.

### Main Specification:

Diameter of screw rod: 95 mm

Speed of screw rod: 10-90 m/min

Main power: 18.5 kW

Heating power: 45 kW

Horizontal move distance of head: 2 M

Compound line speed: 10-40 m/min

Effective width of compound: 450-1500 mm

Layer thickness of compound: 0.02-0.4 mm

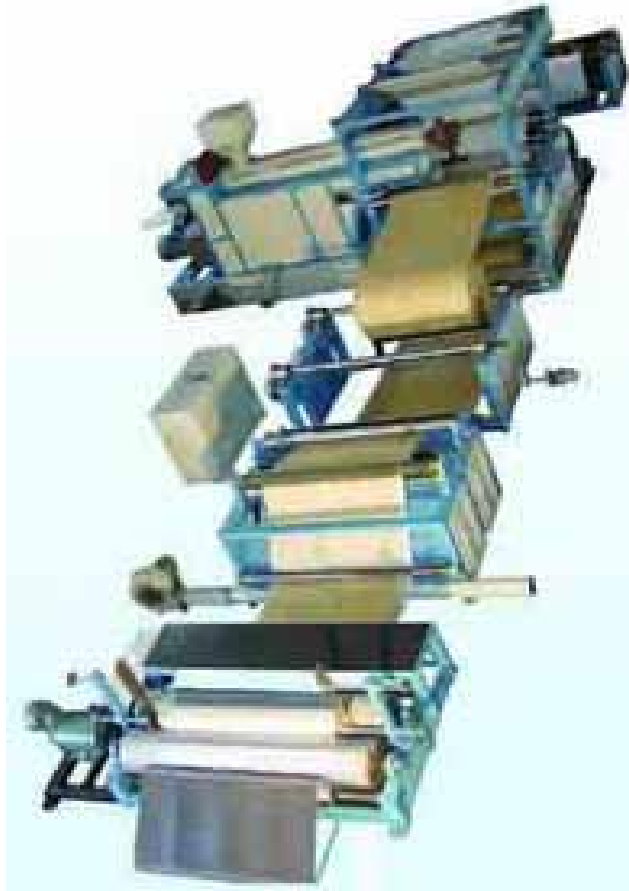
Speed adjust motor for compound: 4 kW



Automatic magnetism powder rises the control device of strength



Drench the pushing out of machine of membrane, compounding machine





Cutting machine



Folding machine



Pressing and punching machine



3 colors printer



Packing machine



On paper frame



Electrical control cabinet



Coiling machine



Double location base paper broadcasting machine



Double location base cloth broadcasting machine

**The bags produced by Sack Tuber(HT500-1) and Bottom Pasting Machine (HD100/130-A):**

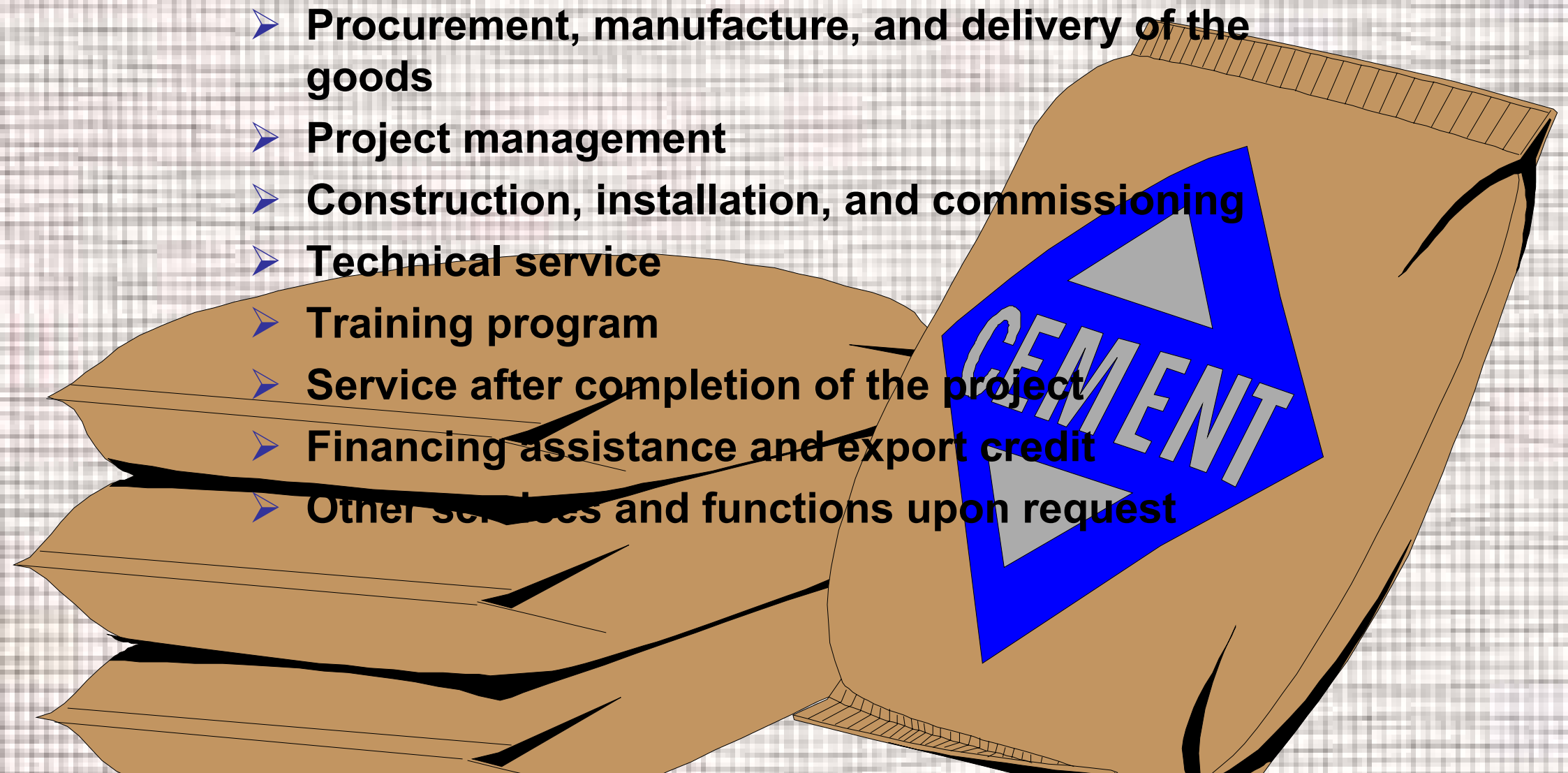
1. Cement bag, chemical bag, sewed bag and pasted bag;
2. Trapezoidal end bags with M side, both sides can be painted with hot melt glue
3. Reinforced paper tape bag and the paper tape can printed
4. Lengthened sack sheep bag
5. Special standard paper bag
6. M side paper bag is with on side flat opening and other trapezoidal staggered opening.





# Service

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- **Procurement, manufacture, and delivery of the goods**
- **Project management**
- **Construction, installation, and commissioning**
- **Technical service**
- **Training program**
- **Service after completion of the project**
- **Financing assistance and export credit**
- **Other services and functions upon request**



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