



Wenzhou Xinlei Machinery Co., Ltd

Add: No. 1555 Huaming Road, Feiyun Street, Ruian City, Wenzhou City,
Zhejiang Province, China

Tel: +86-13566213908 Email: xinlei02@xyymachine.com Website: <https://www.wzxlachinery.com/>

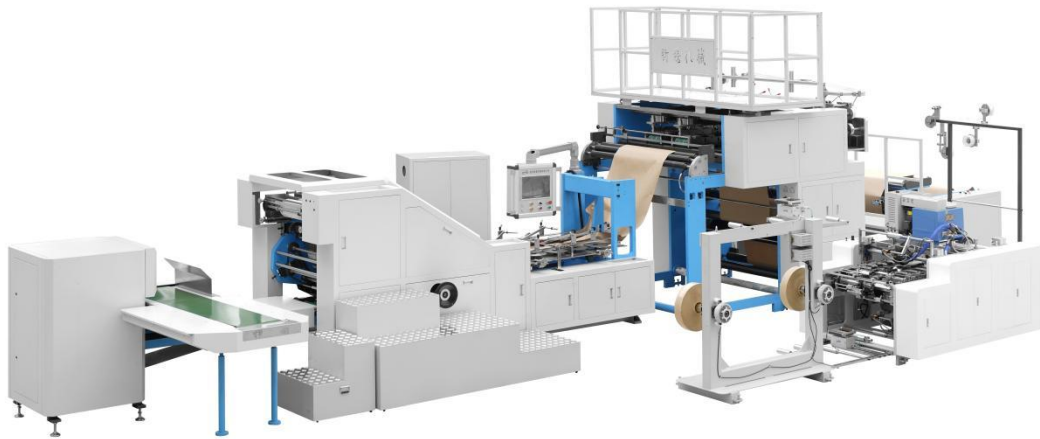
型号 Model: XL-FD330T/450T

全自动方底圆绳手提纸袋机（圆绳）

Fully Automatic Square Bottom

Handle Paper Bag Making Machine (Round Rope)

机器图片 Machine Pictures



样品图片 Sample Pictures:





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性能与用途 Performance and Use:

全自动方底纸袋机，用于生产带手挽的手提纸袋。本机特别适用于食品和服装等行业的购物装批量生产。该机由手挽机将卷绳和纸片卷筒制做成手挽，通过输送系统将手挽送至贴把机组再将原色或印刷好的卷筒纸进行纸绳位预点断、贴片位涂胶、自动粘贴手挽，再由主机将贴有手挽的纸张进行涂边胶。成筒，切断，压痕、底部涂胶、袋底成型并输送出袋，整个过程一次性同步完成。本机采用德国原装进口高速运动控制器(CPU)，通过高速总线控制伺服的运行，保证运动稳定，运动曲线平滑，是广大印刷包装厂家首选的全自动手提方底纸袋设备。

Fully automatic square bottom paper bag machine is used to produce hand-held paper bags with hand handles. This machine is especially suitable for the bulk production of shopping bags in food and clothing industries. The machine by hand holding machine will roll of rope and paper roll system arm in arm, arm in arm through the transmission system to put the unit will be primary or printed roll paper twine again a preliminary point break, patch glue, automatic paste hand wan, again by the host with a hand holding the paper to the edge glue, into the bottom of the cone, cutting, creasing, glue, bag forming and piped out of the bag, The whole process is done simultaneously at once. This machine adopts Japanese Mitsubishi imported high speed motion controller (CPU), through the high speed bus control servo operation, to ensure stable movement, smooth motion curve, is the majority of printing and packaging manufacturers preferred automatic portable square bottom paper bag equipment.

主要特点 Main Feature:

1. 采用威纶触摸屏人机界面，操作功能一目了然。便于掌控。
 2. 采用日本原装三菱运动控制器(PC),通过与光纤一体化。保证高速运行稳定。
 3. 采用日本三菱伺服电机搭配德国施克色标电眼修正。精确跟踪印刷袋尺寸。
 4. 原料装卸采用液压升降结构，放卷采用全自动恒张力控制。
 5. 原料纠偏采用无刷伺服电机，降低纸卷对位调整时间。
1. Using Weinview touch screen man-machine interface, the operation function is clear at a glance. Easy to control.
 2. Adopt original Japanese Mitsubishi motion controller (PC), integrated with optical fiber. Ensure stable high-speed operation.
 3. Use Japanese Mitsubishi private server motor with German original SICK photoelectric eye correction. Accurately track the printed bag size.
 4. The material loading and unloading adopts hydraulic lifting structure, and the unwinding adopts automatic constant tension control.
 5. The raw material is rectified by non-brush servo motor, which reduces the time for roll registration adjustment.



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技术参数 Technical Parameters:

机器型号 Model	XL-ZD350T
纸袋裁切长度 Cutting Length	270-530mm
纸袋裁切长度 (全) Cutting Length (total)	270-430mm
纸袋宽度 Paper Bag Width	120-350mm
纸袋宽度 (全) Paper Bag Width (total)	200-350mm
袋底宽度 Bottom Width	60-180mm
纸袋克重 Paper gsm	60-150g/m ²
纸袋克重 (全) Paper gsm (total)	80-150g/m ²
纸卷宽度 Material Width	380-1050mm
纸卷宽度 (全) Material Width (total)	570-1050mm
纸料直径 Paper Material Diameter	1300mm
纸芯内径 Paper Core Inner Diameter	76mm
手把贴片长度 Handle Patch Length	152mm
手把贴片宽度 Handle Patch Width	50mm
纸绳间距 Paper Rope Spacing	75mm
手把纸绳直径 Paper Handle Rope Diameter	3-5mm
手把贴片纸卷宽度 Handle Patch Paper Roll Width	100mm
手把纸卷直径 Handle Paper Roll Diameter	1200mm
手把贴片纸克重 Handle Patch Paper Weight	100-135g/m ²
机械速度 Mechanical Speed	30-200pcs/min
纸袋速度 Paper Bag Production Speed	30-180pcs/min
带手提速度 Handle Speed	30-150pcs/min
裁切刀具方式 Cutter Method	锯齿裁切 Pinking
总机功率 Total Power	380V/ 3Phase 4Line 41.5kw
整机重量 Total Weight	15000Kg
整机尺寸 Machine Overall Dimension	14000*6000*2400mm



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机器型号 Model	XL-ZD450T
纸袋裁切长度 Cutting Length	270-530mm
纸袋裁切长度 (全) Cutting Length (total)	270-430mm
纸袋宽度 Paper Bag Width	220-450mm
纸袋宽度 (全) Paper Bag Width (total)	240-450mm
袋底宽度 Bottom Width	90-180mm
纸袋克重 Paper gsm	80-150g/m ²
纸袋克重 (全) Paper gsm (total)	80-150g/m ²
纸卷宽度 Material Width	650-1290mm
纸卷宽度 (全) Material Width (total)	650-1290mm
纸料直径 Paper Material Diameter	1200mm
纸芯内径 Paper Core Inner Diameter	76mm
手把贴片长度 Handle Patch Length	190mm
手把贴片宽度 Handle Patch Width	50mm
纸绳间距 Paper Rope Spacing	95mm
手把纸绳直径 Paper Handle Rope Diameter	3-5mm
手把贴片纸卷宽度 Handle Patch Paper Roll Width	100mm
手把纸卷直径 Handle Paper Roll Diameter	1200mm
手把贴片纸克重 Handle Patch Paper Weight	100-135g/m ²
机械速度 Mechanical Speed	30-180pcs/min
纸袋速度 Paper Bag Production Speed	30-150pcsmmin
带手提速度 Handle Speed	30-130pcs/min
裁切刀具方式 Cutter Method	锯齿裁切 Pinking
总机功率 Total Power	380V/ 3Phase 4Line 41.5kw
整机重量 Total Weight	15500Kg
整机尺寸 Machine Overall Dimension	14000*6000*2400mm



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机器配置 Machine Configuration :

控制系统 Control System			
名称 Name	数量 Qty	产地 Original	品牌 Brand
CPU 编程控制器 CPU Program Controller	1	日本 Japan	三菱 Mitsubishi
人机界面触摸屏 Human-computer Touch Screen	1	中国 China	繁易 Flexem
印刷跟踪光电眼 Printing Tracking Photoelectric Eye	2	德国 Germany	西客 Sick
低压电器 Low Voltage Apparatus	4	法国 French	施耐德 Schneider
光电传感器 Photoelectric Sensor	10	日本 Japan	松下 Panasonic
气动元件 Pneumatic Component	18	中国台湾 Taiwan	亚德客 AirTAC
自动润滑油 Auto Lubricating	1	中国 China	
配电柜带自动恒温空调柜 Electric Control Box with Air Conditioner	1	中国 China	
电源滤波器 Main Power Filter	1	中国 China	
电机变频器 Motor Frequency Converter	2	瑞士 Switzerland	ABB
伺服驱动器 Servo Motor	7	日本 Japan	三菱 Mitsubishi



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伺服电源 Servo Power	7	日本 Japan	三菱 Mitsubishi
伺服电机减速机 Servo Motor Reducer	5	日本 Japan	三菱 Mitsubishi
手把机伺服 Handle Servo	1	日本 Japan	三菱 Mitsubishi
贴把机伺服 Sticking Servo	1	日本 Japan	三菱 Mitsubishi
主机伺服 Main Server	1	日本 Japan	三菱 Mitsubishi
牵引伺服 Traction Servo	1	日本 Japan	三菱 Mitsubishi
辅助牵引伺服 Auxiliary Traction Servo	1	日本 Japan	三菱 Mitsubishi
上胶伺服 Gluing Servo	1	日本 Japan	三菱 Mitsubishi
预刺伺服 Prediction Servo	1	日本 Japan	三菱 Mitsubishi
收袋三相异步电机 Bag Collecting 3 Phase Asynchronous Motor	1	中国 China	
放卷 纠偏、张力控制系统 Deviation, Correction and Tension Control System			
名 称 Name	数 量 Qty	产 地 Original	品 牌 Brand
纠偏控制器 Rectifying Controller	3	中国 China	恩瑞斯 Emreis
伺服纠偏电机 Servo Rectifying Motor	3	中国 China	恩瑞斯 Emreis



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超声波感应器 Ultrasonic Sensor	3	中国 China	恩瑞斯 Emreis
磁粉制动器 Magnetic Powder Brake	3	中国 China	中倍 Zhongbei
磁粉自动张力系统 Magnetic Powder Automatic Tension System	3	中国 China	中倍 Zhongbei
自动液压上料电机 Automatic Hydraulic Feeding Motor	1	中国 China	顶铭 Dingming
上料液压油缸 Feeding Hydraulic Cylinder	2	中国 China	顶铭 Dingming
传动 Transmission			
名 称 Name	数量 Qty	产地 Original	品牌 Brand
同步带 Synchronous Belt	10	中国 China	巨隆 Julong
同步轮 Synchronous Wheel	13	中国 China	巨隆 Julong
轴承 Bearing	489	日本	NSK
导辊 Guide Roller	29	中国 China	BAIXIAO
齿轮 Gear	76	中国 China	
胶水部位 Glue Position			
名 称 Name	数量 Qty	产地 Original	品牌 Brand
底部胶（糊底白乳胶） Bottom Glue (Bottom-sealing White latex)	2	中国 China	



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底部匀胶电机 Bottom Glue Evening Motor	1	中国 China	
自动气动灌胶阀 Pneumatic Auto Glue Filling Valve	1	中国 China	
边胶 Side Glue	1	中国 China	
底胶胶位检测 Bottom Glue Position Detection	1	中国 China	
中锋水性喷胶枪 Center Sealing Water Spraying Gun	1	中国 China	
水性白乳胶高压喷胶桶 Waterborne White Latex High-pressure Glue Bucket	1	中国 China	

流程图 Flow Chart:

