



**温州市新磊机械有限公司**  
Wenzhou Xinlei Machinery Co., Ltd.

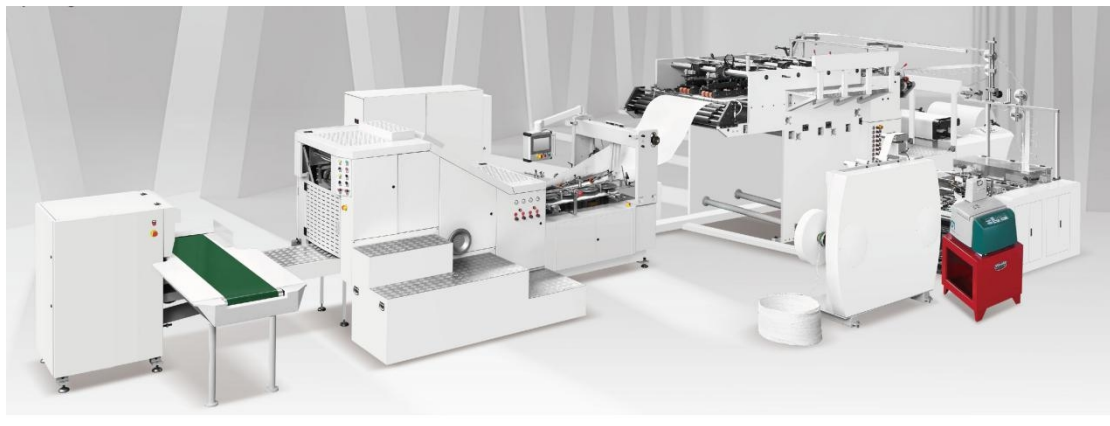
型号：XL-ZD330T/450T

全自动方底圆绳手提纸袋机

**Automatic square bottom round rope portable paper bag machine**

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。Automatic square bottom paper bag machine, used to produce hand-held paper bags. This



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machine is especially suitable for mass production of shopping clothes in food and clothing industries. In this machine, the winding rope and the paper roll are made into a hand-held by a hand-held machine, and the hand-held is sent to the paster unit through a conveying system, and then the primary color or printed roll paper is pre-broken at the paper rope position, glued at the paster position, and automatically pasted with the hand-held, and then the paper with the hand-held is coated with edge glue by the host computer. Tube forming, cutting, indentation, bottom gluing, bag bottom forming and conveying out of the bag, and the whole process is completed synchronously at one time. This machine adopts high-speed motion controller (CPU) imported from Germany, which controls the servo operation through high-speed bus to ensure stable motion and smooth motion curve. It is the preferred automatic portable square-bottom paper bag equipment for printing and packaging manufacturers.

### **主要特点 main feature:**

- 1 采用法国 SCHNEIDER 触摸屏人机界面，操作功能一目了然，便于掌控
- 2 采用德国原装 LENZE 运动控制器(PC)，通过与光纤一体化，保证高速运行稳定
- 3 采用德国原装 LENZE 伺服电机搭配德国原装 SICK 光电眼修正，精确跟踪印刷袋尺寸

4 原料装卸采用液压自动升降结构，放卷采用全自动恒张力控制。5 原料纠偏采用意大利 SELECTRA，降低纸卷对位调整时间。

- 1 Using French SCHNEIDER touch screen man-machine interface, the operation function is clear and easy to control
- 2 Using German original LENZE motion controller (PC) to ensure high-speed operation stability through integration with optical fiber
- 3 Using German original LENZE servo motor with German original SICK photoelectric eye correction, accurate tracking printing bag size
- 4 The loading and unloading of raw materials adopts hydraulic white lifting structure, and the unwinding adopts automatic constant tension control. 5 raw material correction using Italian SELECTRA, to reduce paper roll alignment adjustment time.



**技术参数 technical parameters:**

机器型号 Model	<b>XL-ZD330T</b>
纸袋裁切长度 Cutting Length	270-530mm
纸袋裁切长度（全） Cutting Length (handle)	270-430mm
纸袋宽度 Paper Bag Width	120-330mm
纸袋宽度（全） Paper Bag Width (handle)	200-330mm
袋底宽度 Bottom width	60-180mm
纸袋克重 Paper bag grams	60-150g/m <sup>2</sup>
纸袋克重（全） Paper bag grams (handle)	80-150g/m <sup>2</sup>
纸卷宽度 Wrap width	380-1050mm
纸卷宽度（全） Wrap width (handle)	570-1050mm
纸料直径 Diameter of paper	1300mm
纸芯内径 Inner diameter of paper core	76mm
手把贴片长度 Length of patch by hand	152mm
手把贴片宽度 Hand patch width	50mm
纸绳间距 Paper rope spacing	75mm
手把纸绳直径 Paper rope diameter by hand	3-5mm
手把贴片纸卷宽度 Width of patch paper roll by hand	100mm
手把纸卷直径 Paper roll diameter by hand	1200mm
手把贴片纸克重 Hand patch paper weight	100-135g/m <sup>2</sup>
机械速度 Mechanical speed	30-200bags/min
纸袋速度 Paper bag speed	30-180bags/min
带手提速度 Handheld speed	30-150bags/min
裁切刀具方式 Cutting Tool Mode	锯齿裁切 serrated cutting
总机功率 Switchboard power	380V/ 3phase 4line 41.5kw
整机重量 Total weight	15000kg
整机尺寸 Machine size	14000*6000*2400mm



机器型号 Model	<b>XL-ZD450T</b>
纸袋裁切长度 Cutting Length	270-530mm
纸袋裁切长度（全） Cutting Length (handle)	270-430mm
纸袋宽度 Paper Bag Width	220-450mm
纸袋宽度（全） Paper Bag Width (handle)	240-450mm
袋底宽度 Bottom width	90-180mm
纸袋克重 Paper bag grams	80-150g/m <sup>2</sup>
纸袋克重（全） Paper bag grams (handle)	80-150g/m <sup>2</sup>
纸卷宽度 Wrap width	650-1290mm
纸卷宽度（全） Wrap width (handle)	690-1290mm
纸料直径 Diameter of paper	1200mm
纸芯内径 Inner diameter of paper core	76mm
手把贴片长度 Length of patch by hand	190mm
手把贴片宽度 Hand patch width	50mm
纸绳间距 Paper rope spacing	95mm
手把纸绳直径 Paper rope diameter by hand	3-5mm
手把贴片纸卷宽度 Width of patch paper roll by hand	100mm
手把纸卷直径 Paper roll diameter by hand	1200mm
手把贴片纸克重 Hand patch paper weight	100-135g/m <sup>2</sup>
机械速度 Mechanical speed	30-180bags/min
纸袋速度 Paper bag speed	30-150bags/min
带手提速度 Handheld speed	30-130bags/min
裁切刀具方式 Cutting Tool Mode	锯齿裁切 serrated cutting
总机功率 Switchboard power	380V/ 3phase 4line 41.5kw
整机重量 Total weight	15500kg
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三菱 8 伺服全伺服方底（带手把）配置

品牌 Brand	产品名称 Name	规格 specification	单位 unit	数量 quantity
威伦 Willen	Touch screen10寸	MT8102IE	只	1
日本三菱 Mitsubishi Japan	伺服电机 servo motor	FX5-80SSC-S	件	1
日本三菱 Mitsubishi Japan	可编程控制器 Programmable Controllers	FX5U-80MR/ES	件	1
日本三菱 Mitsubishi Japan	可编程控制器 Programmable Controllers	FX5-16EX/ES	件	3
日本三菱 Mitsubishi Japan	伺服电机 servo motor	HG-SR702J	件	1
日本三菱 Mitsubishi Japan	伺服驱动器 server Driver	MR-J4-700B	件	1
日本三菱 Mitsubishi Japan	伺服电机 servo motor	HG-SR502J	件	3
日本三菱 Mitsubishi Japan	伺服驱动器 server Driver	MR-J4-500B	件	3
日本三菱 Mitsubishi Japan	伺服电机 servo motor	HG-SN202J-S100	件	3
日本三菱 Mitsubishi Japan	伺服驱动器 server Driver	MR-JE-200B	件	3
日本三菱 Mitsubishi Japan	伺服电机 servo motor	HG-SN302J-S100	件	1
日本三菱 Mitsubishi Japan	伺服驱动器 server Driver	MR-JE-300B	件	1
日本三菱 Mitsubishi Japan	编码器电缆 Encoder cable	MR-J3ENSCBL10M-L	件	8



日本三菱 Mitsubishi Japan	动力电缆 Power cable	MR-PWCNS3 10M(8平方)	件	1
日本三菱 Mitsubishi Japan	动力电缆 Power cable	MR-PWCNS5 10M(6平方)	件	3
日本三菱 Mitsubishi Japan	动力电缆 Power cable	MR-PWCNS4 10M(2.5平方)	件	3
日本三菱 Mitsubishi Japan	动力电缆 Power cable	MR-PWCNS5 10M(4平方)	件	1
日本三菱	伺服配件	MR-J3BUS1M	件	1
日本三菱 Mitsubishi Japan	伺服配件 Servo accessories	MR-J3BUS03M	件	7
德国施克 German Schke	色标电眼 Color code electric eye	KT4S-WS4114		2
韩国奥托尼克 斯 Autonics Korea	传感器 sensor	PR12-4DN		12
法国施耐德 France Schneider	开关/低压 Switch/low voltage			

**流程图 flow chart:**

