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**CHAMPION**  
MACHINERY



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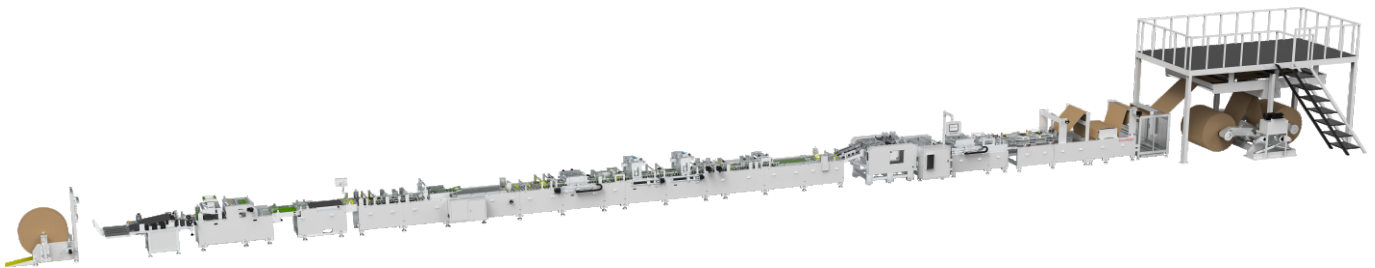
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## CMBM-600WP-R-00

Leak Proof Square Bottom Paper Bag Production Line

防漏水方底纸袋全自动生产线

## 目录

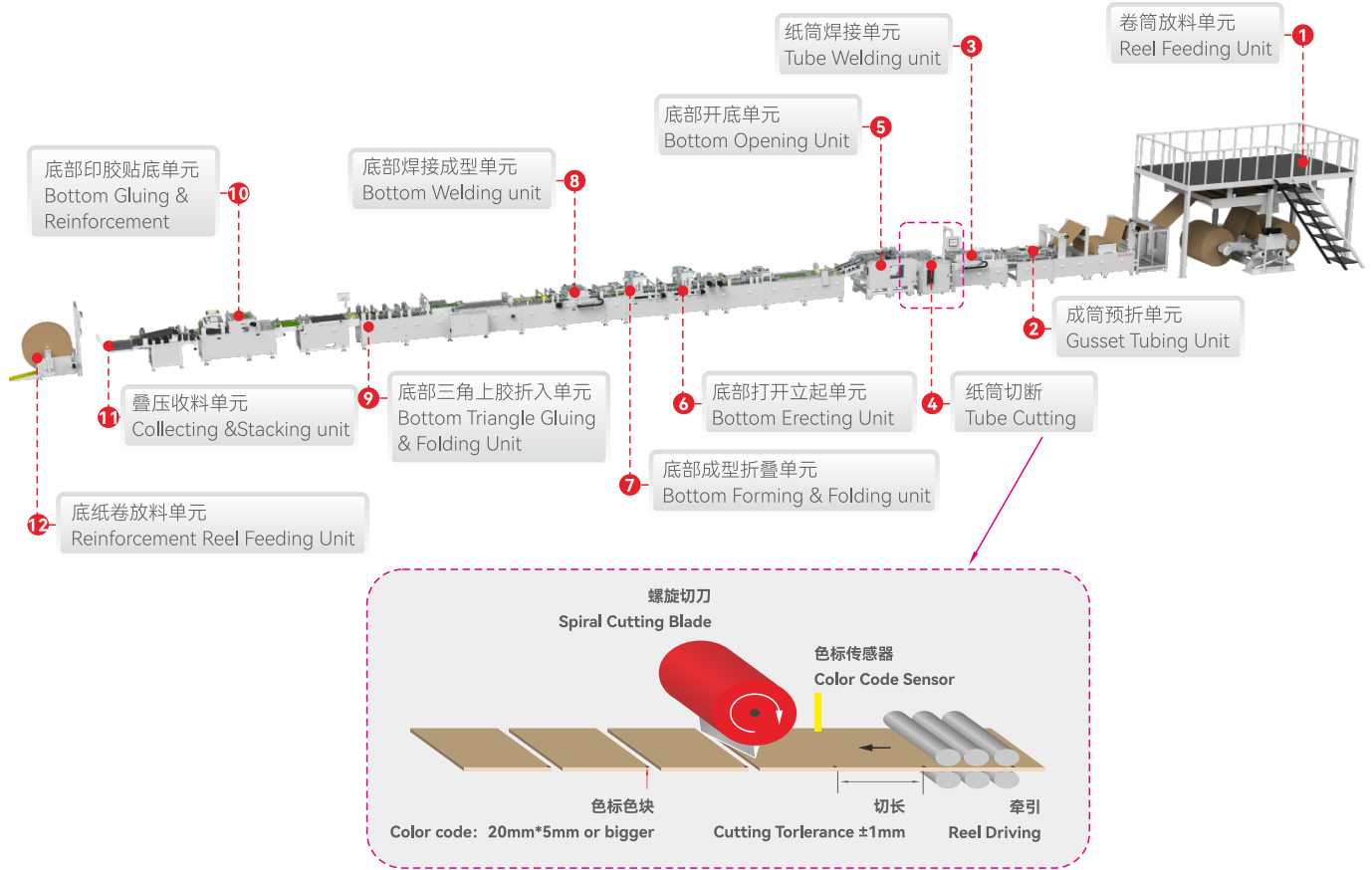
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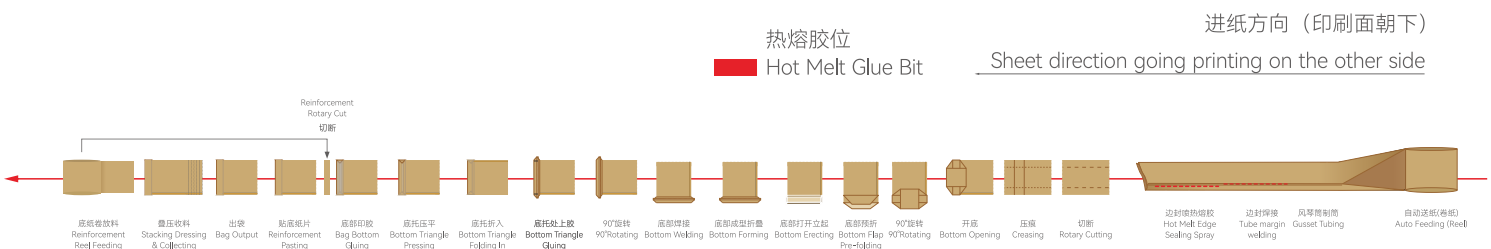
# CMBM-600WP-R-00

## Leak Proof Square Bottom Paper Bag Production Line

### 防漏水方底纸袋全自动生产线



### 工艺流程图 Process Flowchart





## 机器说明 Machine Description

### 袋底成型模块

**吹气开底机构:** 电磁阀控制前后吹气装置, 高压气体精准撑开袋底, 为折底工序预制六边形态。

**热烫密封单元:** 瞬时高温压合覆膜层, 形成密封边线, 防水防漏。

### 智能控制系统

**人机交互界面:** 触摸屏集中控制, 实时显示故障警报及参数微调 (如温度、速度)。

**PLC+光电检测:** 光电传感器联动伺服电机, 实现无料停机、夹袋检测等功能。

### 多功能执行组件

**夹持系统:** 折口夹持板与袋口夹持板协同固定袋体, 振动装置压实内容物, 减少袋内空气。

**阀口贴条机构:** 自动粘贴加强底纸, 提升承重能力。

### Bag Bottom Forming Module

**Blowing Bottom Opening Mechanism:** Solenoid valves control the front and rear air blowing mechanisms. High-pressure air precisely opens the bag bottom, performing a hexagonal shape for the bottom folding process.

**Hot Sealing Unit:** Instantaneous high-temperature lamination creates a sealed edge, ensuring water and leak resistance.

### Intelligent Control System

**Human-Machine Interface:** A touchscreen provides centralized control, displaying real-time fault alerts and allowing fine-tuning of parameters (such as temperature and speed).

**PLC + Photoelectric Detection:** A photoelectric sensor coupled to a servo motor enables functions such as no-material shutdown and bag clamping detection.

### Multifunctional Actuator

**Clamping System:** The folding and bag opening clamping plates work together to secure the bag. A vibration mechanism compacts the contents and reduces air in the bag.

**Valve Tape Mechanism:** Automatically applies reinforced liner paper to improve load-bearing capacity.



## 机器特点 Machine Features

**无缝生产链:** 集成上料、翻边、成筒、热烫密封、切断、开底、折底、贴底等工序, 减少人工干预, 大幅提升效率。

**六边形袋底成型:** 前后高压吹气装置精准开底, 使袋底呈六边形结构, 结合热烫压合技术, 实现物理防漏。

**动态调节机构:** 折口夹持板配备间隙/高度调节模块 (限位块+伸缩杆), 兼容不同克重纸张。

吹气角度可旋转调节 (旋转杆+链轮传动), 避免气流偏移导致袋形歪斜。

**节能设计:** 自动润滑系统降低能耗, 变频电机牵引上料减少空转损耗。

**覆膜纸袋专用:** 支持覆膜牛皮纸、医用纸等防水材料, 热压覆膜层增强防渗性。

**无胶水工艺:** 替代传统胶粘侧边, 采用热烫成型, 杜绝侧边开裂风险。

**Seamless production chain:** Integrates loading, flanging, tube forming, hot-stamping and sealing, cutting, bottom opening, bottom folding, and bottom lamination, reducing manual intervention and significantly improving efficiency.

**Hexagonal bottom forming:** Front and rear high-pressure air blowers precisely open the bottom, creating a hexagonal structure. Combined with hot-stamping technology, this system provides physical leak prevention.

**Dynamic adjustment mechanism:** The folding clamping plate is equipped with a gap/height adjustment module (limiting blocks + telescopic rod) to accommodate different paper weights.

The air blow angle is adjustable (rotating rod + sprocket drive) to prevent airflow deviation and bag shape distortion.

**Energy-saving design:** An automatic lubrication system reduces energy consumption, and a variable-frequency motor drives the material feeding process to reduce idling losses.

**Specialized for laminated paper bags:** Compatible with waterproof materials such as laminated kraft paper and medical paper, the hot-stamped lamination layer enhances impermeability.

**Glue-free process:** Instead of traditional gluing of the sides, hot-stamping is used to form the sides, eliminating the risk of cracking.



纸袋简介 / Brief Description

材料 Material

1. 淋膜纸 PE/PLA/CPP/PBCA Coated Paper
2. 涂层纸 Water Based Coating Paper
3. 材料厚度 Material Thickness  
 纸基厚度 Paper Thickness: 50~100gsm  
 涂层/淋膜厚度 Coating Thickness: 10~30um
4. 放卷宽度 Reel Feeding Width: 560~1200mm
5. 纸袋尺寸 bag Sizes  
 袋宽 Bag Width: 150~420mm  
 袋高 Bag Height: 200~500mm  
 风琴 Gusset: 65-160mm  
 边封尺寸 Side Welding Margin: 15~30mm  
 底封尺寸 Bottom Welding Margin: 20~35mm
6. 适用胶水: Non-glue, Water Glue, Hotmelt Glue, Pur Glue



上机物料要求 / Machine Description

- 分切精度:  $\pm 1\text{mm}$ 。  
 色标色块: 20mm\*5mm, 色标与相近印刷色图案须纵向大于20mm  
 涂层/淋膜厚度均匀性: 均匀性误差须小于 $\pm 3\mu\text{m}$   
 焊接熔化温度: 90~260°C
- Cutting tolerance:  $\pm 1\text{mm}$ .  
 Color code: 20mm\*5mm or bigger, vertical distance from similar pattern printing to color-code must be longer than 20mm.  
 Coating thickness uniform: tolerance must be less than  $\pm 3\mu\text{m}$   
 Welding temperature: 90~260°C



Plastic Free



Glue, Paper, Inks are 100% Compostible



Plant-Based Non-GMO Lining Leak Resistant



Sturdy Bag Stands up on its own

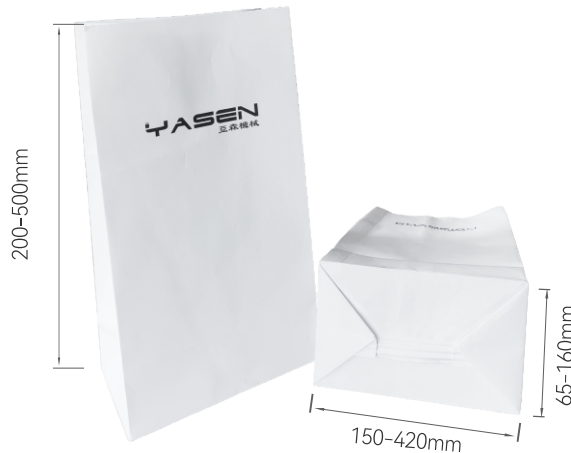


D400 certified

D6868 certified



SUSTAINABLE FORESTRY INITIATIVE  
Made in Canada



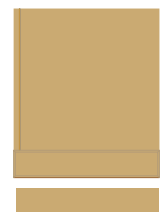
**100% Compos Table Paper Bag Used For Kitchen Organic Waste**



原材料卷纸  
Paper Reel



底部无贴底纸  
Bottom Shape Without  
Reinforcement



底部贴底纸  
Bottom Shape With  
Reinforcement



原材料底纸卷纸  
Reinforcement Paper Reel



**主要技术参数 TechnicalData**

袋型	Bag Type	方底袋 Square Bottom Bag
卷材宽幅度	Reel Width	400-760mm
卷材厚度	Reel Thickness	50-140gsm
放卷直径	Unwinding Diameter	最大Max. 1200mm
成品高度	Bag Height	200-500mm
成品宽度 (底长)	Bag Width (Bottom Length)	150-420mm
风琴位尺寸 (底宽)	Gusset Size (bottom Width)	65-160mm
粘接位宽度	Glue Margin Width	20-50mm
速度	Speed	限速至 85 pcs/min (注: 速度和工人的操作, 纸张材质、胶水有关)
机器尺寸	Machine Size	40000x1700x1600mm
机器重量	Machine Weight	约 15T
适用胶水	Applicable Glue	Non-glue, Water Glue, Hotmelt Glue, PUR Glue



核心配件 Core Accessories



**SynMatic**

运动控制系统  
伺服电机/伺服驱动/变频器  
SIMOTION  
Servo motor/servo drive/frequency converter

安驰 中国  
SynMatic China



**KEYENCE**

总线控制  
BUS CONTROL

基恩士 日本  
Keyence Nippon



**Honeywell**

编码器/接近开关  
热过载继电器接触器  
ENCODER/PROXIMITY SWITCH  
Thermal overload relay contactor

霍尼韦尔 美国  
Honeywell US



**KEYENCE**

主光电眼/光纤  
MAIN OPTICAL EYE/FIBER

基恩士 日本  
Keyence Nippon



触摸屏  
TOUCH SCREEN

威伦 台湾  
WEINVIEW Taiwan



电磁阀  
SOLENOID VALVE

MAC 美国  
MAC US



**CPG**

减速机马达  
REDUCER MOTOR

晟邦 台湾  
Shengbang CPG Taiwan



**SIEMENS**

主马达  
MAIN MOTOR

西门子贝德 德国  
Siemens Bader Germany



**ORION**

真空泵  
VACUUM PUMP

好利旺 日本  
ORION Japan