

**CHAMPION
MACHINERY**

MACHINERY MANUFACTURER OF **LUXURY PAPER BAGS**
CHAMPION MACHINERY MANUFACTURING CO.,LTD.



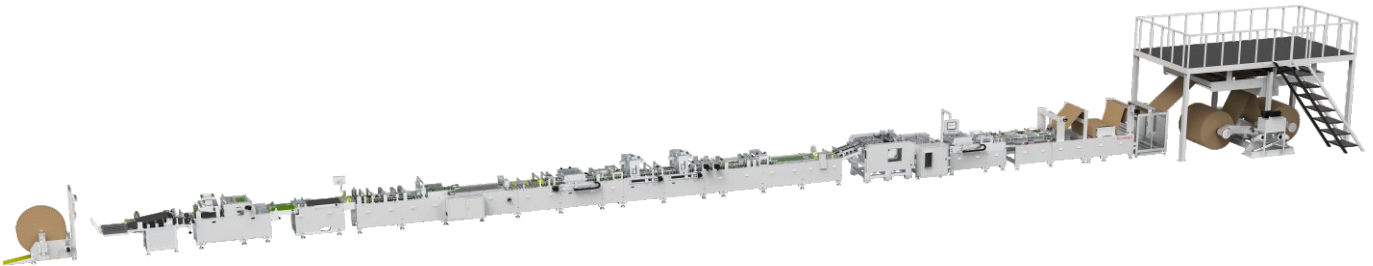
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CMBM-600WP-R-00

Leak Proof Square Bottom Paper Bag Production Line

防漏水方底纸袋全自动生产线

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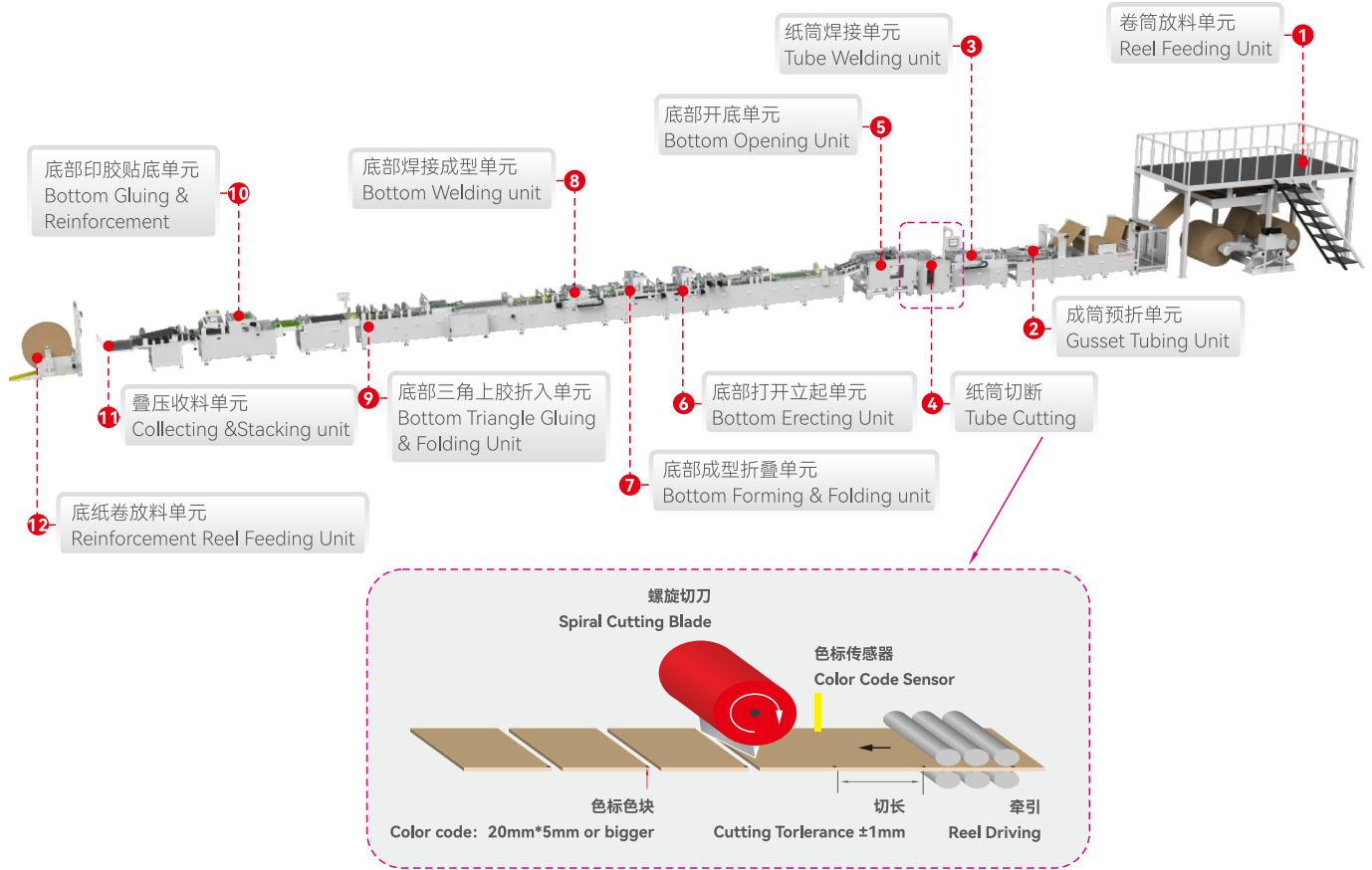
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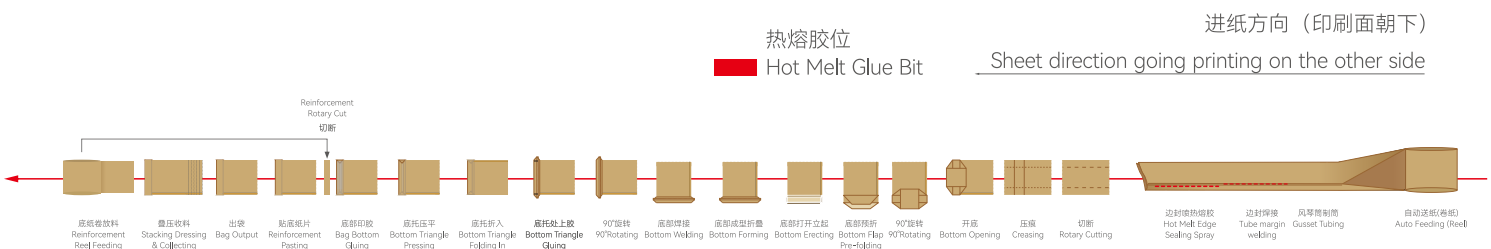
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Leak Proof Square Bottom Paper Bag Production Line

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% Compostable



Plant-Based Non-GMO Lining Leak Resistant



Sturdy Bag Stands up on its own



D400 certified

D6868 certified



SUSTAINABLE FORESTRY INITIATIVE
Made in Canada



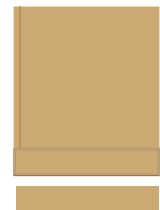
100% Compos Table Paper Bag Used For Kitchen Organic Waste



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



SynMatic

总线控制
BUS CONTROL

安驰 中国
SynMatic China



FOTEK

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

阳明 台湾
FOTEK Taiwan



KEYENCE

主光电眼/光纤
MAIN OPTICAL EYE/FIBER

基恩士 日本
Keyence Japan



繁易
FLEXEM

触摸屏
TOUCH SCREEN

繁易 中国
FLEXEM China



亞德客
AirTAC

电磁阀
SOLENOID VALVE

亚德客 台湾
AirTAC Taiwan



CPG

减速机马达
REDUCER MOTOR

晟邦 台湾
Shengbang CPG Taiwan



SIEMENS

主马达
MAIN MOTOR

茵梦达 德国
Innomotics Germany



ORION

真空泵
VACUUM PUMP

好利旺 日本
ORION Japan