

CHAMPION
MACHINERY

MACHINERY MANUFACTURER OF **LUXURY PAPER BAGS**

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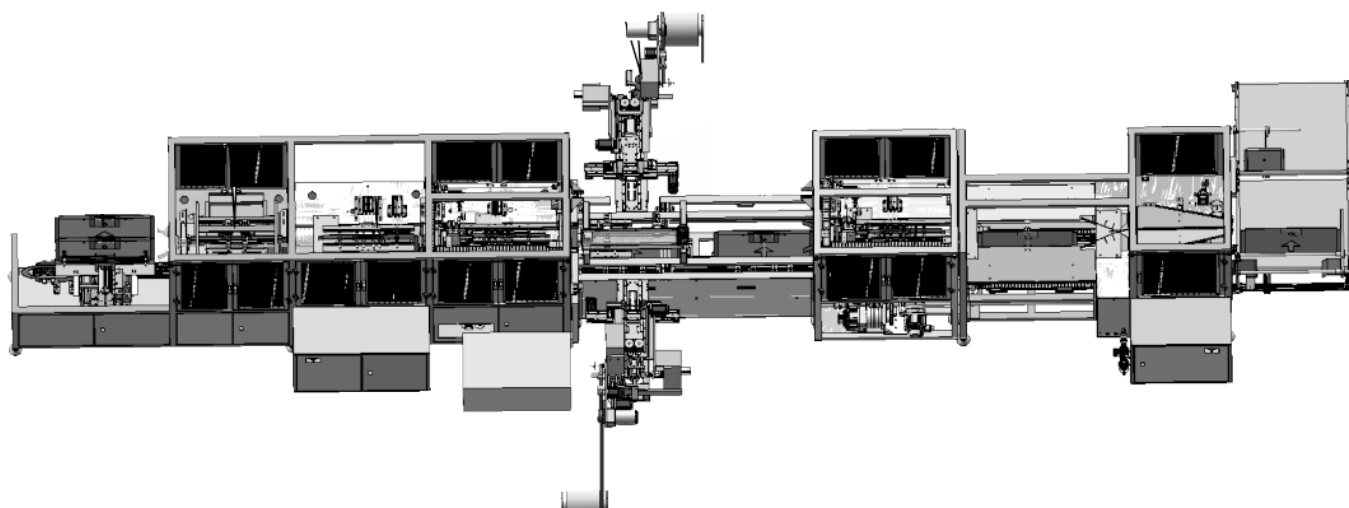


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CMRD-550R

Fully Automatic Paper Bag Drawstring Machine (for Ribbons)

全自动纸袋穿绳机(丝带)



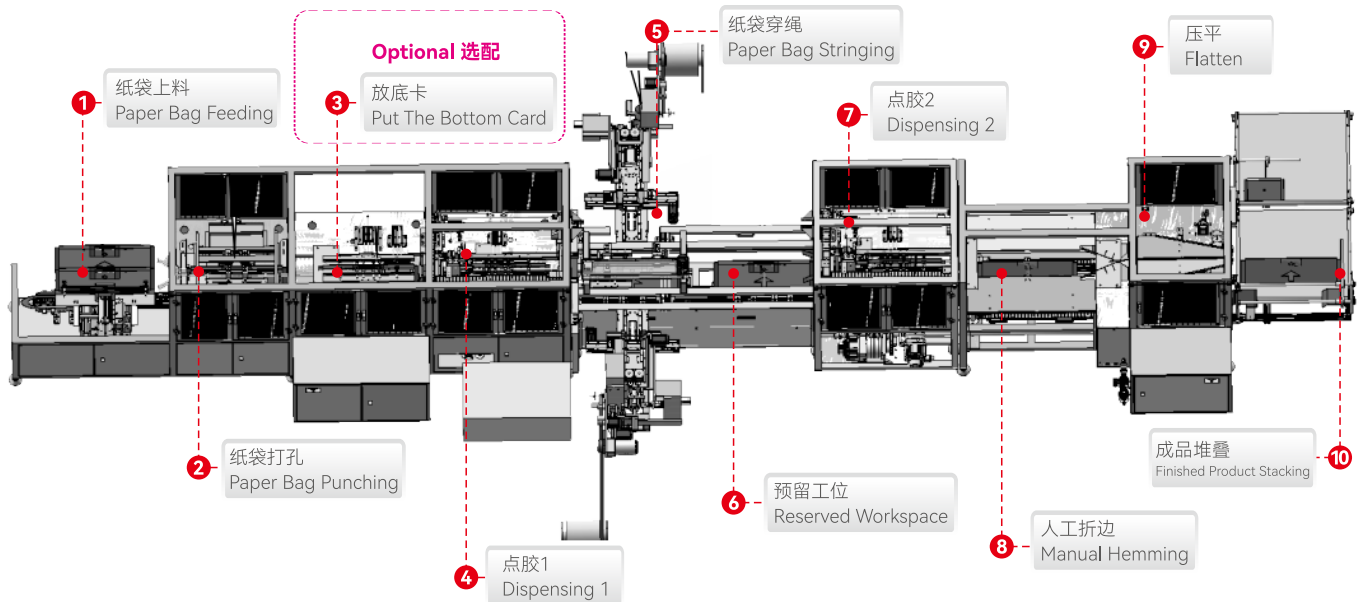
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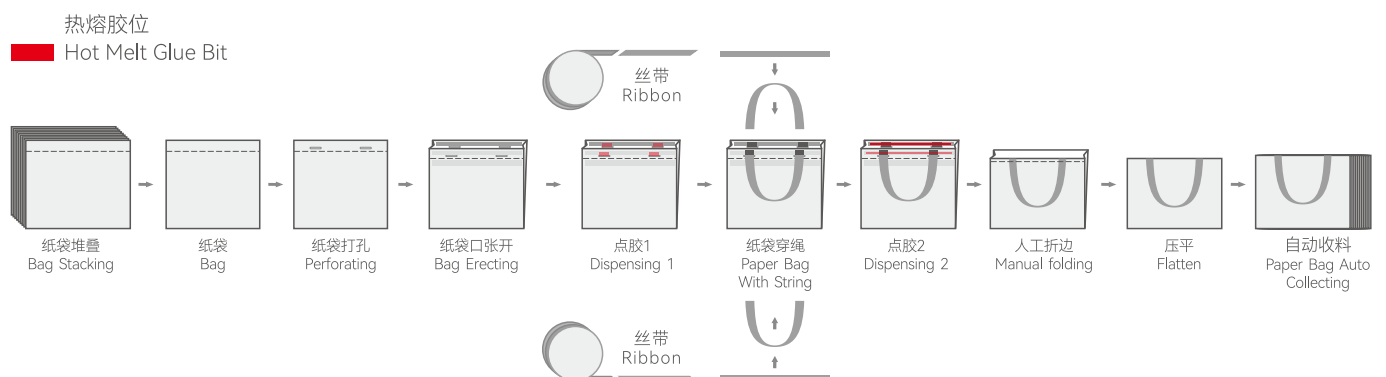
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工艺流程图 Process Flowchart





机器说明 Machine Description

针对人工穿丝带作业中存在的效率低下、质量波动大等痛点，我们全新研发推出纸袋穿丝带机。该设备深度融合“全自动化智能控制、多功能一体集成、毫米级高精度贴合”三大核心技术优势，构建起覆盖原料处理到成品输出的全流程智能化生产体系。

设备较传统工艺生产效率明显提升，同时通过自动定位系统与自适应张力控制技术，将产品良率稳定控制在95%以上。其模块化设计支持快速切换不同规格纸袋生产，完美适配奢侈品包装、高端零售等领域的个性化定制需求，可为企业降本增效，助力实现从“制造”到“智造”的跨越式升级。

特别说明：为了设备的使用寿命和人员的生产安全，生产过程中不宜频繁按下暂停键，前期生产可将设备速率调低，待工人操作熟练后再调高设备速率，提高生产效率。

In response to the pain points in manual ribbon threading operations, such as low efficiency and significant quality fluctuations, we have newly developed and launched a paper bag ribbon threading machine. This equipment integrates three core technological advantages—"fully automated intelligent control, multifunctional integrated design, and high-precision millimeter-level alignment"—establishing a fully intelligent production system that covers everything from raw material handling to finished product output. Compared to traditional processes, the equipment significantly improves production efficiency. Through its automatic positioning system and adaptive tension control technology, it consistently maintains a product yield rate of over 95%. Its modular design supports quick switching between different specifications of paper bag production, making it perfectly suitable for personalized customization needs in fields such as luxury packaging and high-end retail. This helps enterprises reduce costs and improve efficiency, facilitating a leapfrog upgrade from "manufacturing" to "intelligent manufacturing." Special note: To extend the lifespan of the equipment and ensure the safety of personnel, the pause button should not be pressed frequently during production. In the early stages of production, the equipment speed can be reduced, and the speed can be increased after the workers have become proficient in operating the equipment to improve production efficiency.



操作流程与对应事项 Operating Procedures And Corresponding Matters

1、上料：操作员人工将纸袋放到输送带上，输送带自动将纸袋向前推送，吸盘将纸袋取放到步距式传送线上；为了不影响后续工位的定位以及产品的加工，同一款产品的宽度误差控制在2毫米以内，高度误差控制在1毫米以内。

2、打孔：打孔工位在纸袋相应位置打宝盖头孔，孔的尺寸根据客户提供模具(需要更换模具) 模具外形固定尺寸必须相同，孔尺寸比绳宽单边最少4.5MM;孔离袋口15-25可调。打孔误差控制在±3mm内。

3、穿绳要求：绳宽范围15-25MM内;绳长350-720MM内；材质：客户提供样板，穿绳后成品误差±3MM(绳的变型要在2MM以内)；穿绳粘接长度单边尺寸为15-25MM;超声波功率3.5KW，切刀为损耗品，需要更换，穿绳舌头，在更换不同宽度绳带时，需要人工更换不同尺寸舌头。

4、点胶：人工穿完绳后，此工位进行第二次点胶，点胶方式为在边卡上进行长条涂胶，使后续折边粘贴，由于使用同一款旋转式喷枪头，涂胶深度与第一次点胶深度相同；纸袋内部侧边会有一小段距离涂不到胶，到边距离15mm-20mm涂不到胶。

5、人工折边：工人将涂好胶的反口向内折，并用手预压，方便后续压紧工序压紧。为了生产安全，此工序也装有暂停按钮或脚踏开关保证操作员的安全。

6、压实：皮带与滚轮对上一工序折好反口的纸袋进行压实操作，使胶水粘贴更牢固。

7、出料：出料输送带将纸袋输送出来再人工收料，可单个输送，可计数分批输送。

1. Feeding: The operator manually places the paper bags onto the conveyor belt, which automatically pushes the bags forward. Suction cups pick up the bags and place them onto the step-type conveyor line. To avoid affecting the positioning of subsequent stations and product processing, the width error of the same product is controlled within 2 mm, and the height error within 1 mm.

2. Punching: The punching station punches holes for the cap at the corresponding positions on the paper bags. The hole size is based on the mold provided by the customer (mold replacement is required). The mold's fixed dimensions must be identical. The hole size must be at least 4.5 mm wider than the rope on each side. The distance between the hole and the bag opening is adjustable from 15-25 mm. The punching error is controlled within ±3 mm.

3. Rope Threading Requirements: Rope width 15-25mm; rope length 350-720mm; material: customer-provided sample; finished product error ±3mm after threading (rope deformation within 2mm); rope bonding length per side 15-25mm; ultrasonic power 3.5KW; the cutter is a consumable and needs replacement; the rope threading tongue needs to be manually replaced with a different size when changing to different width ropes.

4. Glue Application: After manual rope threading, a second glue application is performed at this station. The glue is applied in a long strip on the edge card to facilitate subsequent edge folding and bonding. Since the same rotary spray gun head is used, the glue depth is the same as the first application. There will be a small section of the inner side of the paper bag that is not glued, approximately 15mm-20mm from the edge.

5. Manual Edge Folding: The worker folds the glued edge inwards and pre-presses it by hand to facilitate subsequent pressing. For production safety, this process is also equipped with a pause button or foot switch to ensure operator safety.

6. Compacting: The belt and rollers compact the folded and reversed paper bags from the previous process, making the glue adhere more firmly.

7. Discharging: The discharge conveyor belt transports the paper bags out for manual collection. It can transport them individually or by counting and batching.

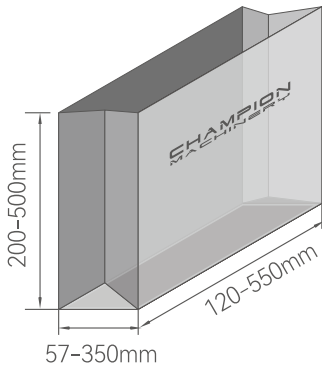


主要技术参数 TechnicalData

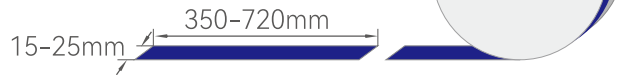
纸袋尺寸 Paper Bag Size		
纸袋宽度范围	Paper Bag Width	120-550mm
纸袋长度范围	Paper Bag Length	200-500mm
风琴尺寸	Paper Bag Gusset	57-350mm
折袋口尺寸	Paper Bag Top Folder Depth	35-66mm
孔位 Hole position		
孔位到绳单边尺寸	Hole Position To Rope Single Side Dimension	≥ 4.5mm
孔位到袋口尺寸	Hole Position To Bag Opening Size	15-25mm
绳子 Rope		
绳宽范围	Rope Width Range	15-25mm
绳长范围	Rope Length Range	350-720mm
穿绳粘接长度单边尺寸	Single-sided Dimension Of Rope Bonding Length	15-25mm
运行 Running		
速度	Speed	0-15 pcs/min



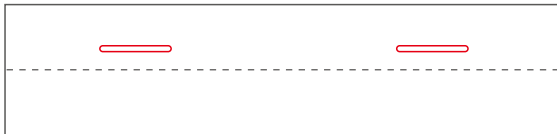
纸袋和丝带尺寸范围 Paper Bag And Ribbon Size Range



织带宽度: 15-25mm
织带长度: 350-720mm
Handle Width: 15-25mm
Handle Length: 350-720mm

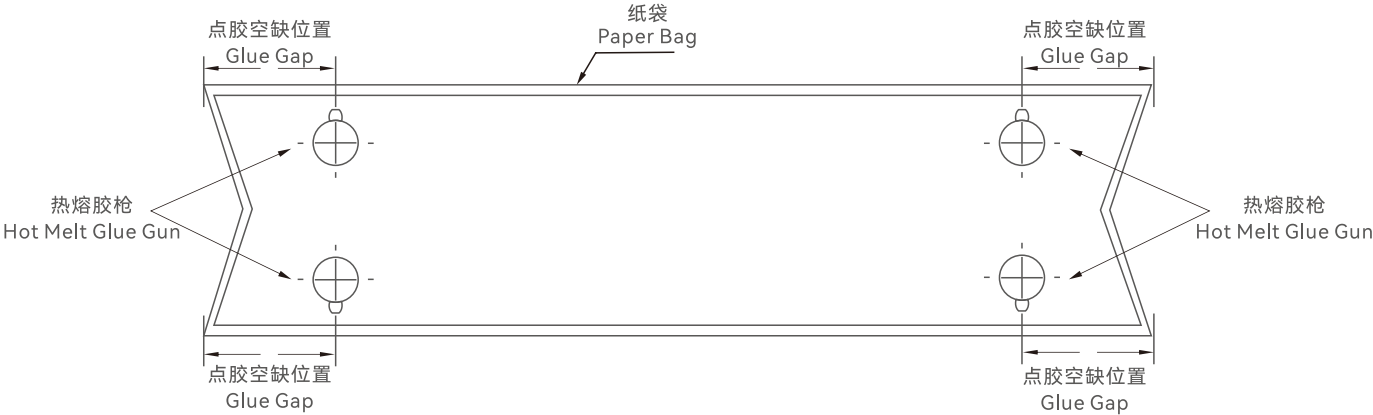


袋头打孔样式 Bag Head Punching Style





点胶示意图 Dispensing Diagram





丝带样式 Ribbon Style

