

**BAG MAKING**

Garbage Bag on Roll Making Machine — Double Line

Two lines making flat-top, star-sealed garbage bags on a perforated roll, fully automatic from film to finished roll — 60 – 205 bags/min per line.

**60 – 205 bags/min × 2**

SPEED

80 – 300 mm

BAG WIDTH

115 m/min

FILM LINE SPEED

approx. 19.5 kW

INSTALLED POWER

A fully automatic two-line machine that turns film into flat-top garbage bags on a continuous, perforated roll, in one pass from the film roll to the finished roll. Each line makes 60 – 205 bags a minute, bag width 80 – 300 mm and length 100 – 1,200 mm, on film from 0.005 to 0.02 mm.

Bag length is held by servo motors with photocell tracking, accurate and steady at speed. A combined sealing and cutting knife with four-zone intelligent temperature control makes a firm, flat seal. Counting is automatic with a settable count alarm, and the left and right rewinds count independently.

The unwind, the traction and the rewind each run on their own inverters, the rewind under PLC control. A photocell stops the machine when the film breaks or runs out — it also works with black film. Two web-guide systems are standard.

TECHNICAL PARAMETERS

Bag making width	80 – 300 mm
Bag making length	100 – 1,200 mm
Bag making speed	60 – 205 bags/min × 2 lines
Max. film line speed	115 m/min
Film thickness	0.005 – 0.02 mm
Bag type	Flat-top bags on a continuous roll, star sealed (eight-fold)
Installed power	approx. 19.5 kW
Actual consumption	approx. 6 kWh
Machine weight	2,200 kg
Dimensions (L×W×H)	6,200 × 2,200 × 1,900 mm

MAIN MACHINE

Frame	12 mm steel plate
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Main motor	1.5 kW, 220 V AC — non-brake motor with an external 15 N·m DC 99 V brake, easy to maintain
Machine control	PLC with 7 in touch screen; 24 V switching power supply
Main motor control	1.5 kW, 220 V inverter
Bag length control	3 kW servo motor × 2; rubber roller Ø 65 × 410 mm
Tracking photocell	× 2
Temperature control	4 zones, solid-state heating, high/low temperature alarm
Temperature precision	± 2 °C
Heating power	Copper knife heating rods, 1.2 kW × 2
Sealing knife	Copper, forged and heat treated, 410 mm long
Perforating blade	410 mm long
Unwind stand	Independent

UNWIND

Driven unwind	550 W aluminium-housing geared motor × 2
Unwind motor control	0.75 kW inverter × 2, speed set by linear potentiometer (analogue)
Film-break stop	Through-beam photocell × 2 (works with black film); 40 × 20 mm thin cylinders hold the film × 2
Loading	Pneumatic, two 100 × 250 mm cylinders, hand valve; air shaft loading with pneumatic brake
Unwind rubber roller	Ø 65 × 410 mm

TRACTION

Traction motors	550 W horizontal AC motor × 2
Traction control	0.75 kW inverter, speed by photoelectric switch × 2
Traction rubber roller	Ø 65 × 410 mm
Web guide	2 sets, standard

REWIND

Rewind control	PLC with 7 in touch screen; 24 V, 100 W switching power supply
Rewind motors	550 W AC motor × 4
Rewind motor control	0.75 kW inverter × 4, speed set by linear potentiometer (analogue)
Roll changeover	Servo controlled × 2 — left and right separate, counted independently

BRAND SPECIFICATION

Inverters and servo motors	Inovance
Tracking and film-break photocells	Panasonic, Japan
Rewind PLC	XINJE (3U3232MT)
Rewind power supply	Mean Well, Taiwan

Main motor	Taiwan brand
Contactors	Schneider
Intermediate relays	Schneider
Solenoid and air-blow valves	AirTAC, Taiwan
Bearings	NSK, Japan

SUPPLIED WITH THE MACHINE

Tool kit	1 set
Thermocouple	1
Push-button switches	2
Unwind springs	100
Relay	1
Solenoid valve	1
Hall sensor	1

KEY FEATURES

- Computer control with automatic counting and a settable count alarm — high output, less labour.
- Fully automatic in one pass, from the film roll to the finished roll of bags.
- Servo length control with photocell tracking — accurate and stable; photocell-controlled feeding.
- Combined sealing and cutting knife with intelligent temperature control, for a firm, flat seal.
- Main drive speed set by inverter; unwind by inverter; rewind under PLC control.
- Left and right rewinds change rolls and count independently.
- Film-break stop that also works with black film.
- Two web-guide systems as standard.

PHOTOGRAPHS



Pneumatic unwind, analogue speed control



Sealing and cutting knife in one unit



Web guide (edge correction)



Automatic rewinding unit

WARRANTY & AFTER-SALES SERVICE

Every machine carries a warranty of one (1) year from the date of commissioning, covering the repair or replacement of parts in case of manufacturing defects. It does not cover malfunctions resulting from misuse, neglect or external factors such as unstable power, accidents, tampering or force majeure, nor wearing parts consumed in normal operation — sealing knives and cutting blades, Teflon tape, heaters, filters and screens.

Installation, commissioning and operator training are arranged by Miroplastic, and an operating manual is supplied with each machine. Technical support is available by telephone and email during the warranty period and thereafter. Spare parts and consumables are available from Miroplastic.

Photographs are for reference only. Miroplastic reserves the right to improve the specification of its machines without prior notice. Actual output depends on the material, width and thickness run.

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