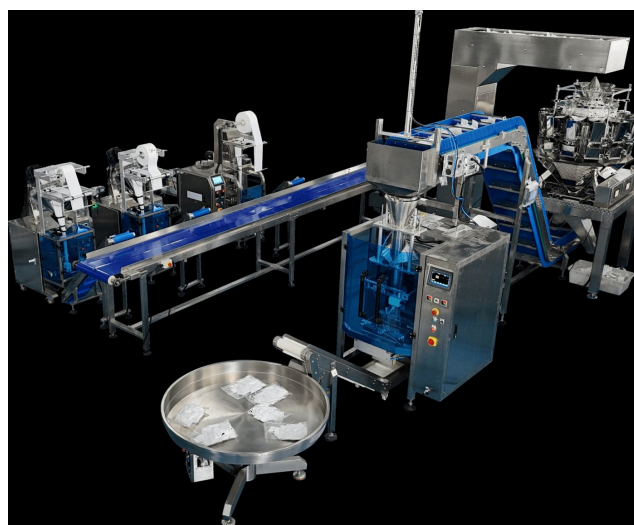


**PACKAGING**

Oil Sachet Packing & Counting Line

30 ml oil sachets filled, counted by a twelve-head weigher and packed 50 to a PE bag with a handle hole — 30 – 45 sachets/min, 5 – 10 bags/min.

**30 – 45 bags/min**

SACHET OUTPUT

5 – 10 bags/min

PE BAG OUTPUT

50

SACHETS PER PE BAG

100%

COUNTING ACCURACY

The line fills 30 ml oil sachets, counts them into groups of 50, and packs each group into a PE bag with a handle hole. Three small vertical packing machines fill and seal the sachets on three-side-seal film. Their output conveyors feed a five-metre collecting conveyor, which carries the sachets to a Z conveyor and up into a twelve-head weigher.

The weigher counts the sachets by weight and releases groups of 50. If a group does not hold the correct number, a forced discharge hopper diverts it away from the bag machine, so no incorrectly counted bag is made. A bucket large-angle conveyor carries each counted group up to the PE bag machine.

Each small packing machine uses a servo-driven magnetic pump, which stops the oil splashing back and leaking during filling, keeps the seal clean and leaves no product at the cut point. Each is supplied with one bag former for the 30 ml sachet, a ribbon date printer and a protective shield, and is built in 304 stainless steel.

The large packing machine forms the PE bag from reel film, punches the handle hole, fills it with the counted group, seals it and prints the date. An encoder tracks bag length so the print and the seal stay in register at speed. Finished bags leave on a corner output conveyor onto a rotary sorting table for collection.

APPLICATION

Products packed	Oil sachet, three-side seal · PE bag with handle hole holding 50 sachets
Filling volume	Sachet 30 ml · PE bag 50 sachets
Sachet size	Width 30 – 150 mm, length 30 – 230 mm
PE bag size	Width 270 mm, length 450 mm
Film width	Sachet machine max. 320 mm · PE bag machine max. 650 mm
Packing speed	Sachet 30 – 45 bags/min · PE bag 5 – 10 bags/min
Tolerance	Sachet $\leq \pm 1$ ml · PE bag 100% correct sachet count

LINE COMPOSITION

Small vertical packing machine, 320 mm film	3 units
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Protective shield for small packing machine	3 units
Output conveyor	3 units
Long collecting conveyor, 5 m	1 unit
Z conveyor	1 unit
Twelve-head weigher, 2.5 L hoppers	1 unit
Forced discharge hopper, 6.7 L	1 unit
Platform for weigher	1 unit
Bucket large-angle conveyor	1 unit
Large packing machine, 650 mm film	1 unit
Ribbon date printer	1 unit
Encoder for bag length tracking	1 unit
PE film device with hole punching structure	1 unit
Output conveyor with corner	1 unit
Rotary sorting table, Ø 1,200 mm	1 unit

SMALL VERTICAL PACKING MACHINE · 3 UNITS

Film width	max. 320 mm
Bag width	30 – 150 mm (bag former change required)
Bag length	60 – 230 mm
Packing speed	20 – 50 bags/min
Air consumption	0.3 m³/min at 1.0 MPa
Power	220 V, 50/60 Hz, 3 kW
Machine size (L×W×H)	1,100 × 900 × 1,800 mm
Machine weight	200 kg

OUTPUT CONVEYOR · 3 UNITS

Belt material	Food grade PP
Frame material	304 stainless steel
Speed	80 m/min
Power	220 V, 50/60 Hz, 0.55 kW
Size (L×W×H)	1,850 × 550 × 1,230 mm
Weight	40 kg

LONG COLLECTING CONVEYOR

Length	5 m
Speed	20 m/min, variable frequency drive
Power	220 V, 50/60 Hz, 0.55 kW

Size (L×W×H)	5,000 × 400 × 1,000 mm
Weight	100 kg

TWELVE-HEAD WEIGHER

Number of hoppers	12
Hopper volume	2.5 L
Weighing range	10 – 60 bags (10 – 1,500 g)
Accuracy	≤ ± 1%
Speed	up to 120 weighings/min
Power	220 V, 50/60 Hz, 10 A / 2,000 W
Size (L×W×H)	1,700 × 1,100 × 1,265 mm
Weight	490 kg
Construction	304 stainless steel, mirror finish, Japanese load cells

Z CONVEYOR

Hopper	1.8 L
Power	220 V, 50/60 Hz, 0.75 kW
Gross weight	280 kg
Size	Made to the line layout

BUCKET LARGE-ANGLE CONVEYOR

Material	304 stainless steel and PP
Power	220 V, 50/60 Hz, 1.5 kW
Gross weight	280 kg
Size	Made to the line layout

PLATFORM FOR WEIGHER

Load capacity	1 t
Material	304 stainless steel
Size (L×W×H)	1,200 × 1,200 × 1,000 mm
Weight	150 kg

FORCED DISCHARGE HOPPER

Hopper volume	6.7 L
Function	Diverts any group with an incorrect sachet count away from the bag machine

LARGE PACKING MACHINE

Film width	max. 650 mm
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Bag width	80 – 315 mm (bag former change required)
Bag length	60 – 450 mm
Packing speed	5 – 30 bags/min
Air consumption	0.3 m ³ /min at 1.0 MPa
Power	220 V, 50/60 Hz, 3 kW
Machine size (L×W×H)	1,471 × 950 × 1,510 mm
Machine weight	500 kg
Construction	304 stainless steel, one bag former supplied

BAG FORMING AND PRINTING

PE film device with hole punching structure	Forms the PE bag from reel film and punches the handle hole
Ribbon date printer	Numbers and letters, 3 lines of 12 characters each
Encoder for bag length tracking	Keeps print and seal in register as bag length changes

OUTPUT CONVEYOR WITH CORNER

Belt material	Food grade PP
Frame material	304 stainless steel
Speed	80 m/min
Power	220 V, 50/60 Hz, 0.55 kW
Size (L×W×H)	1,850 × 550 × 1,230 mm
Weight	40 kg

ROTARY SORTING TABLE

Diameter	Ø 1,200 mm
Frame material	304 stainless steel
Speed	Variable frequency drive
Power	220 V, 50/60 Hz, 0.55 kW
Weight	40 kg

BRAND SPECIFICATION

Touch screen, 7 in	Delta, Taiwan
PLC	Delta, Taiwan
Servo motor	Delta, Taiwan
Servo drive	Delta, Taiwan
Inverter	Delta, Taiwan
Pneumatic devices	AirTAC, Taiwan
Solenoid valves	AirTAC, Taiwan

Solid state relays	Omron, Japan
Intermediate relays	Omron, Japan
Temperature controllers	Omron, Japan
Power supply	Schneider, France
Power switch	Schneider, France
Servo system for 30 ml oil metering	XINJE, China

COMPRESSED AIR — NOT IN THE SCOPE OF SUPPLY UNLESS ORDERED

Piston air compressor	7.5 kW, with a 500 L air receiver
Screw air compressor	7.5 kW — quieter and longer lasting than the piston type

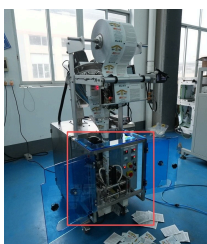
KEY FEATURES

- Counting by weight on a twelve-head weigher — every PE bag holds exactly 50 sachets.
- A forced discharge hopper diverts any wrongly counted group before it is bagged.
- Servo-driven magnetic pump on each sachet machine: no splash-back or leaking, a clean seal, no product at the cut point.
- The PE bag is formed from reel film with its handle hole punched in line.
- An encoder tracks bag length so print and seal stay in register at speed.
- Ribbon date printing on the sachets and on the PE bags.
- Food-grade PP belts and 304 stainless steel frames throughout.

OPTIONAL

- Additional bag former — required to change the bag width
- Gusset bag device — produces gusseted bags
- Thermal transfer printer, 55 mm — higher quality coding than the ribbon printer
- Nitrogen generator, 5 m³/h — nitrogen flushing of the bag
- Weight checker, up to 2 kg — checks the weight of each finished bag
- Labelling machine — flat labelling of the finished bag

PHOTOGRAPHS



Small vertical packing machine



Twelve-head weigher in operation

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.

