



GX-SF-24 FLAT BOTTOM POUCH MAKING MACHINE

PROPOSAL BY:
STAR FLEXI FILMS

■ What We Do?

Star Flexi Films, established in 2009, specializes in importing high-quality China pouching machines that incorporate advanced European components. These machines offer cutting-edge technology and performance as leading international brands.

Star Flexi Films provides end-to-end support, including expert installation, backed by a robust warranty*. The company is dedicated to delivering exceptional service, from initial setup to ongoing maintenance, ensuring peak performance and long-term reliability. With their deep expertise, Star Flexi Films stands out as a trusted partner for businesses looking to invest in advanced packaging technologies.



■ Features

This machine processing and assembly is superior, shape is beautiful and structure is reasonable. The whole machine can run smoothly with low noise. It is easy to adjust zipper. Bag hole can be punched accurately. The speed is fast. The machine adopts PLC three servo traction control, temperature centralized control, reducing electricity consume. The feeding system adopts constant tension control, and ensures the smoothness of the material and the accuracy of the control. Middle tension floating roller adopts dynamic compensation mode, to make the process of pulling material fluctuates slightly. Tension control is stably. The creasing overlaps and stability of horizontal and arc heating knife are good.

■ Technical Parameter:

Function: Four blank bag, single out square bottom bags with zipper, single out four pressure side zippered pockets.

Main Electric Device: Ten Servo Motor, Panasonic PLC, AC motor master drive, Panasonic frequency converter, Temperature control, Tension control unwinding.

Base material: BOPP, PET, CPP, PE, nylon, aluminum foil, and paper are used to create two-layer or multi-layer structures.

Max working speed: 60 pouches/min

Max unwinding line speed: ≤ 30 meter/min (subject to base material)

Making bag size: length (400mm), (Max times to send is six)

Max width of bag: 600mm

Max size of roll material: $\phi 600 \times 1250 \text{mm}$ (Diameter $\times$ Width)

Location precise: $\leq \pm 0.5 \text{mm}$

Heating sealing knife quantity: 2 groups of the upper and lower longitudinal sealing using heating, cooling down

Vertical chain with 4 groups warming up and down, up and down the cooling

5 groups of the upper and lower transverse seal using heating, cooling down the two groups.

Bottom material hot pressed using two groups on heating, a set of cooling

Four hot foil stamping blank plastic material is heated using two groups

Four blank material fixed hot pressure using a set of heated

Temperature range: $0 \sim 300^{\circ}\text{C}$

Total Power: 72Kw (Starting power is about 55kw, in condition of keeping warm, power is about 45kw)

Overall dimension: $19000 \times 3500 \times 1950 \text{mm}$ (L $\times$ W $\times$ H)

Net weight: About 9000 kg.

Machine steel plate thickness: 10mm (Made by Baosteel)

Control system Model: Japan Panasonic PLC Laminating Film High speed bag making machine control system.

■ Equipment and Parameter

1) Unwinding device

A. Structural form: horizontal type level station (formed of magnetic powder brake, air cylinder, swing roller, pulling roller sensor and control system)

B. Unwinding bearing: air shaft and pneumatic-lock device.

2) Unwinding tension

A. Control system: computer control, magnetic powder brake, Compensation potentiometer, rotary encoder, tension system.

B. Adjust drive: PID adjust, PWM drive.

C. Detection mode: Detection by Compensation potentiometer and rotary encoder together.

3) Edge control device

- A. Structure:** K type frame vertical translation, adjustment by screw rod.
- B. Drive:** solid-state relay drive and low speed synchronous motor
- C. Transmission:** coupling connect
- D. Control form:** Double photoelectric sensor computer control
- E. Detection mode:** reflecting type photoelectric sensor detection
- F. Tracking accuracy:** $\leq 0.5\text{mm}$
- G. Adjustment range:** 0-100 mm

4) Opposite side

- A. Structure:** centre and both way, rotary type adjust structure.
- B. Form:** manual adjustment (adjusting handle)

5) Perfect register up and down

- A. Structure:** single roller adjustment up and down.
- B. Form:** manual adjustment (adjusting handle)

6) Longitudinal sealing device

- A. Structure:** combined type bridge structure, 5 sets heating & cooling up and down
- B. Heating knife length:** 800mm cooling knife length: 400mm

7) Transverse sealing device

- A. Structure:** crossbeam type heating and pressing
- B. Quantity:** transverse heating: 3 sets, length: 640mm
- C. Cooling :** 2 sets, length: 640mm
- D. Zipper head** adopts ultrasonic welding

8) Film Pulling

- A. Structure:** pneumatic type glue roller pressing and clash type
- B. Drive:** Inertia in the digital type AC servo system
(Panasonic or Mitsubishi servo motor: 1Kw、 1.5Kw 2000r/m)
- C. Transmission:** M type Synchronous belt round transmission:
speed ratio: 1: 2.4
- D. Control Form:** computer concentrate control
- E. Detection mode:** photoelectric sensor, nearby switch.

9) Middle tension

- A. Structure:** vapour-pressure type float tension roller
- B. Control form:** computer control, Dynamic exercise compensation
- C. Detection mode:** non contacting approach switch
- D. Float tension roller adjustment range:** 0~0.6Mpa

10) Main transmission device

- A. Structure:** The crank rocker push-pull type four bar mechanism
- B. Drive:** Panasonic 5.5Kw converter drive, 3kw phase asynchronous motor
- C. Transmission:** Main transmission motor with 1: 10 reduction gears
- D. Control form:** computer control
- E. Mode of exercise:** Main motor exercise brings frame vertical motion up and down.

11) Automatically location device

- A. Type:** a) Computer automatically fixed length control type: accuracy: $\leq 0.5\text{mm}$
b) reflecting type photoelectric sensor detection : accuracy: $\leq 0.5\text{mm}$
- B.** Photoelectric search range: 0~10 mm(range is set by computer, automatically search)
- C. Correct compensate range:** $\pm 1 \sim \pm 5 \text{ mm}$
- D. Location correct type:** photoelectricity and servo motor coder feedback computer control

12) Temperature control device

- A. Detection mode:** thermocouple Detection E type
- B. Control type:** computer control, solid-state relay drive PID adjustment
- C. Temperature range:** 0~300°C
- D. Detection temperature spot:** Middle in electric heating piece

13) Cutting knife

- A. Structure:** up cutting knife+ adjustment device + fixed down cutting knife
- B. Transmission:** eccentric shaft motive power
- C. Adjustment:** level moving, pulling handle adjust the angle of cutting.

14) Zipper device

- A. Longitudinal cold wave:** combination type bridge structure, 2 sets heating and cooling up and down.
- B. Heating knife:** 640mm
- C. Cooling knife:** 330mm
- D. Zipper move towards:** left, middle, right guide plate Longitudinal arrange

15) Standing bag illustration device

- A. Structure:** horizontal type level station(formed of magnetic powder brake, air cylinder, swing roller, pulling roller sensor and control system)
- B. Illustration pulling:** main motor pulling drive illustration together
- C. Unwinding:** swinging arm control unwinding motor
- D. Control form:** sensor and rotary encoder
- E. Transmission:** coupling connection.
- F. Opposite side:** screw rod structure, manual adjustment
- G. Tension:** unwinding constant-tension
- H. Unwinding bearing:** air shaft
- I. Punch hole:** photoelectricity tracking, Main computer control, pneumatic punch. Punch hole location is adjusted manually.

16) Waste collector

- A. Structure:** horizontal type Reciprocating screw collecting waste material.
- B. Drive:** AC motor
- C. Control:** sensor

17) Punch device

- A. Structure:** Bow type pneumatic type punch mould
- B. Control form:** computer control
- C. Drive:** electronic switch drive magnetic valve (DC24V)
- D. Punch hole seat:** guide rail type support bow type manual level adjustment.
- E. Moulds:** Ling form hole 2×4 (1 sets) round hole $\phi 6$ (1 sets) $\phi 15$ (2 sets) Euro hole(1set)

18) Times to send device

- A. Structure:** pneumatic type cushion and nonsynchronous heat protection type
- B. Control form:** computer control
- C. Drive:** electronic switch drive magnetic valve (DC24V)
- D. Motion type:** 5 sets transverse heating knife, 2 sets cooling knife, nonsynchronous motion.
- E. Quantity of times to send:** from 2-6 times(it is set in computer)

19) Automatically carry device

- A. Structure:** O type lever station
- B. Drive:** solid-state relay drive, gear reduction speed single phase motor
- C. Transmission:** helical gear transmission
- D. Carry range and quantity:** set in computer freely
- E. Control form:** computer control

■ The motion control servo motor means

1. The main servo: Panasonic A5 Series 3.0KW servo motor and drive a set;
2. Traction servo: A5 series 1.5KW/2.0KW Panasonic servo motor and drive 2 sets / 1 set;
3. The cutter servo: Panasonic servo A5 series 0.75KW 1 set;
4. The lateral traction: Panasonic servo A5 series 0.75KW 1 set;
5. Lateral positioning: Panasonic servo A5 series 0.75KW 1 set;
6. On the edge material Servo: Panasonic servo A5 series 0.75KW 1 set;
7. The support plate servo: Panasonic servo A5 Series 0.2KW 1 set;
8. A small cutter servo: Panasonic A5 series 0.75KW servo 1 set.

■ 4 Supporting facility (offered by the user)

- A. Power:** three phase 380V $\pm$ 10 % 50Hz air switch 150A
With zero wire, earth wire (R.S.T.E)
- B. Capacity:** $\geq$ 65Kw
- C. Air source:** 35 L/min (0.6Mpa)
- D. Cooling water:** 15 L/min

■ Optional: (not including the price)

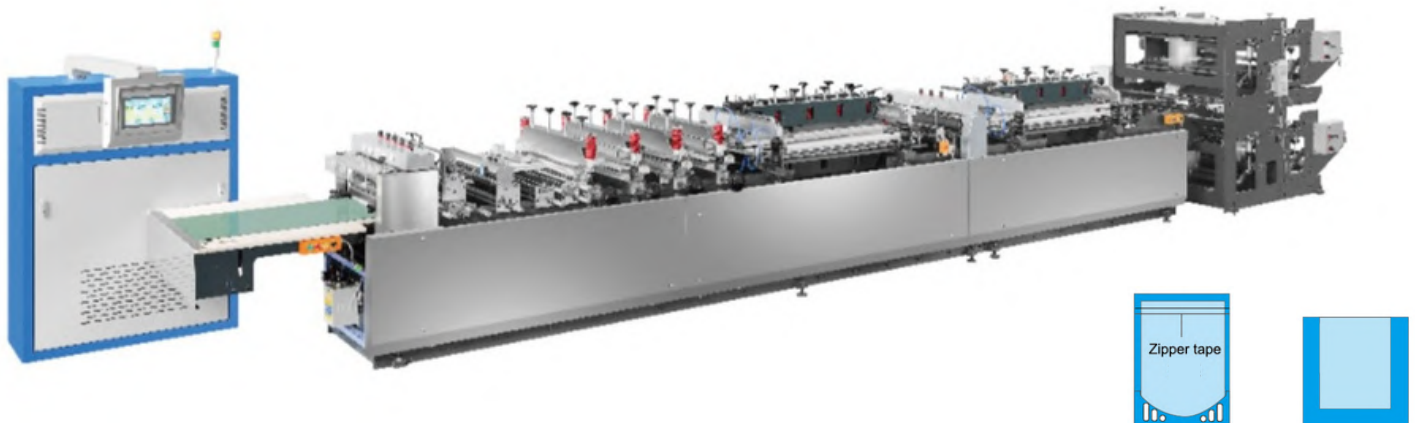
- A.** Adding punch hole it must be statement More than the basic punching configuration
- B.** Abnormal shape sealing knife it can be made especially according to the user's request.

■ Key Parts List

Position name	Parts name	Model	Quantity	Supplier
Pulling	Pulling motor	0.75KW/1KW/1 set /1.5KW/2 sets/ 3.0KW/1 set	10 sets	Panasonic
	Pneumatic part			Airtac, Taiwan
Feeding	Transducer	0.75KW	2 sets	Panasonic
Vertical feeding	Black motor	0.12KW	2 sets	China
Control part	PLC		1 set	Panasonic
	Touch screen	10.4inch Color	1 set	Weinview, Taiwan
	Solid relay		28 pcs	Shanghai
	Magnetic powder brake	0.6/2 sets、2.5/2 sets	4 sets	China
	Edge controller	Double sensor	1 set	China
	Off way controller	PPK-II	1 set	China
Bearing	Oscillating bearing			South Korean
	Drive bearing			Harbin
Detecting part	Photo electric senso		3 pcs	Italy

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Accessories List



Mechanism

Position name	Parts name	Model	Quantity	Remark
Heating knife	Longitudinal knife	5mm	2 pcs	Wuxi
		10mm	3 pcs	Wuxi
		20mm	3 pcs	Wuxi
	Longitudinal chain knife	Groove width: 3mm	4 pcs	Wuxi
	Transverse knife	5	2 pcs	Wuxi
		10	5 pcs	Wuxi
		20	5 pcs	Wuxi
		30	2 pcs	Wuxi
	Stand bag arc knife		2 pcs	Made by client requirement
	Zipper core plate	Double	1 pcs	
		Single	2 pcs	
	Flat knife		2 set	
	Common edge machine		1 set	
Remark: the parts above include parts which come with machine.				

■ Content of Plastic Kit

Tool name	Specification	Quantity	Remark
Solid wrench	8-10	1	
	12-14	1	
	17-19	1	
	22-24	1	
Allen wrench	3	1	
	4	1	
	5	1	
	6	1	
	8	1	
	10	1	
	12	1	
T Allen wrench	5	1	
Monkey wrench	10	1	
Hook spanner	38-42	1	
	48-52	1	
Cross screwdriver	10	1	

Flathead screwdriver	10	1	
Test pencil	6	1	
Small knife		1 box (盒)	
Internal circlip pliers		1	
External circlip pliers		1	
Oil gun		1	
502 Glue		1	
Air gun for air shaft		1	
Rubber pad for 110 motor		1	
Foot		32	
Insulation sleeve for elbows		6	
Seal tape		1	
Black insulating tape		1	
Scotch tape		1	



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