

Automatic Filter Bag Sewing Line



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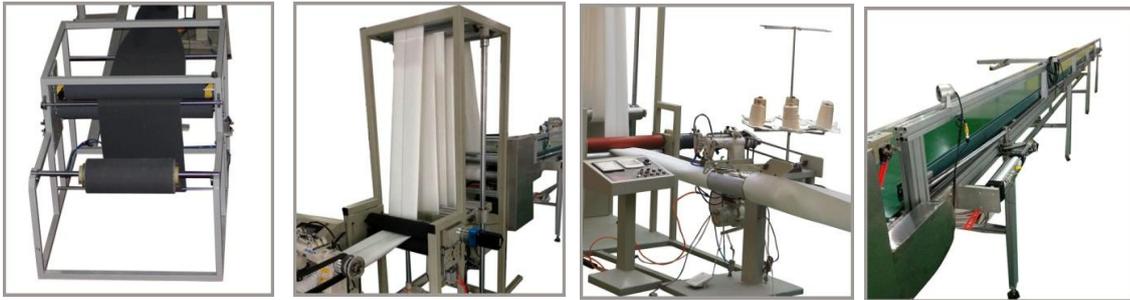
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Usage And Advantages

Images:



Usage And Advantages:

1. Special for air dust filter bag tube
2. Widely used for sewing woven fiberglass, fiberglass felt, meta-aramid felt, PPS felt, polyester felt filter bag, much better to sew high cost mem felt.
3. The size of filter bags can be controlled more accurately.
4. Improve work efficiency and cut down the labor cost.
5. Customizable outline and size according to your requirement.

Filter Bags Can Be Produced:



Working Environment And Maintenance

1. Space Requirement

The complete production line is professional for filter bag making. To make the line work well, we suggest safety working space as below:

1. standard space: 17m(length)*4m(width)
2. loose space: 20m*5m;
3. compact: 16m*2.8m
4. flat surface of working ground.

2. Power Distribution And Lighting

Power: 220-380V/55-80HZ, 2-3 phase outlet. Less than 2000kw.

Lighting: 220W LED daylife lamp

3. Peripherals

Air compressor: pressure not less than 8 bar.

Screws: To fix the machines on ground surface according to your request.

4. Maintain

1. Don't use wet object to touch the electrical parts or damage the parts;
2. To avoid make damage to the any electrical parts or equipments, don't cut off the power suddenly.
3. Don't use force to move the tape forward or backward.
4. Clean equipments and part regularly.
5. Please check and make sure all parts are ready before starting up the line.
6. Please have the machines oiled once per week or not longer than 15 days. The machines need to have oiled are: sewing machine, motor shaft, cylinder and other rotation shaft.



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Main Part List

Main Part List :

1. Feeding part 2. Sewing part 3. Storage part 4. Cross cutting part 5. PLC Controller

Standard Measurement:

1. Complete Line: 16m(length)*2.5m(width)*2.4m(height)

2. Front Part(feeding part+sewing part+storage part):
5.960~6.5m(length)*2.5(width)*2.4m(height)

3. Back Part(cutting part+table+camera+sensor):9.46~10.15m(length)*0.85
~0.98m(width)*1.68~1.74m(height)

4. Storage Table:9.46~10.15m(length)*0.85 ~0.98m(width)*1.68~1.74m(height)



feeding part



sewing part



storage part and cutting part



long table



PLC

Feeding Part

Images:



Main Part List :

1. Frame

2. Shaft

Advantages:

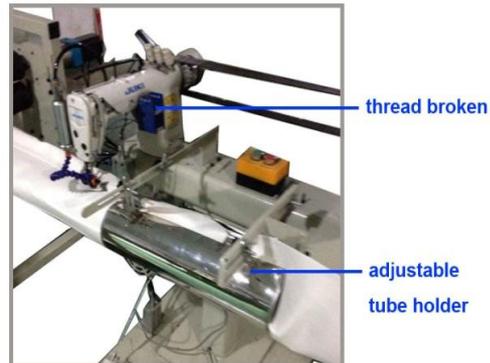
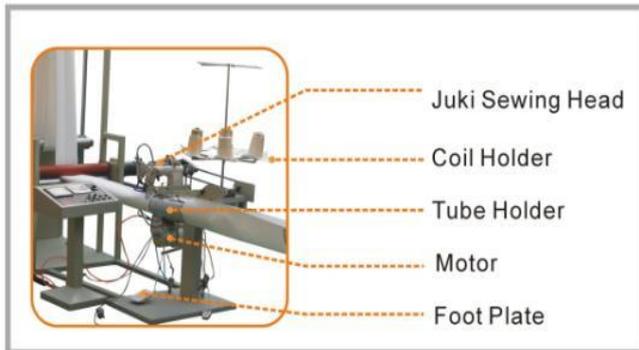
1. Shaft: is for inside paper roll of standard fabric rolls.

2. Fabric pressure: prevent fabric from free feeding.

3. Roller: the width of fabric cloth on the roller can be changed according to client's needs

Sewing Part

Images:



Main Part List :

1. Juki Sewing Part 2. Coil Holder 3. Tube Holder 4. Motor

Functions and advantages:

1. Juki sewing head

It uses Japan Juki Union Special Ms 1261 and we modify it as the main sewing machine, three needle, sewing speed is adjustable for different types of cloth and sewing threads. Sewing speed can be 7-12 meter per minute. It also includes parts as following: needle cold air blowing unit, pneumatic presser foot device, and nonwoven guiding unit.

This product line can also carry out automatic sewing woven fabric, for which complete set of special accessories for wove fabric is used.

It suit for sewing thickness material and the structure is precise. We modify juki 1261 specially for protecting sewing head, such as avoiding needle, feed dog broken etc.

2. We add thread broken sensor on the sewing head, when thread broken, the whole tube line will stop immediately automatically.

3. Coil holder

It is mainly for supporting sewing thread.

4. Tuber holder

It is mainly for rolling the fabric into tube, so that the sewing head can sew fabric into tube.

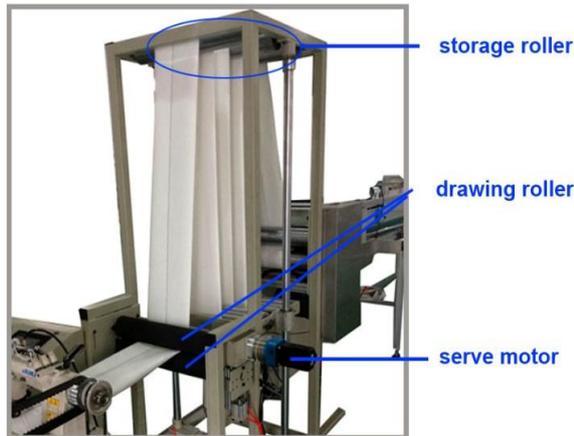
The length of tube holder is 350mm. We supply one adjustable tube holder: 120-200mm. From 120-200mm diameter bags one tube holder is enough.

5. Motor

Normally, we can offer you 220V/50/Single or 380V/60/Single, we also can offer you

Storage Part

Images:



Main Part List :

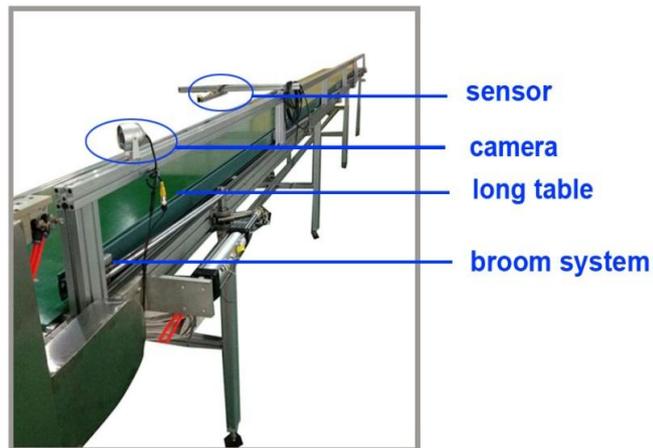
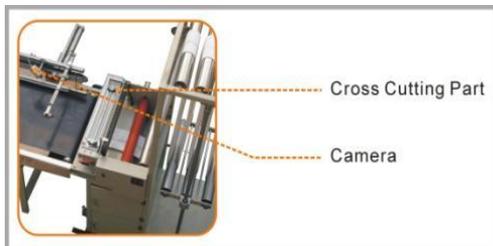
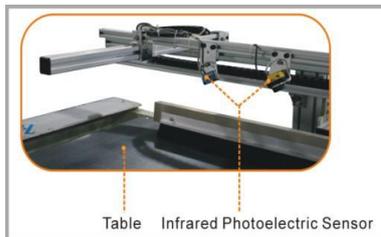
1.Storage roller 2. drawing roller 3.serve motor

Advantages:

1. This part used to keep enough fabric for the next step of cutting.
2. Smooth roller, the roller is polish very well to avoid the PTFE membrane material broken. It can save enough fabric for even 15m long filter bag.
3. Serve motor is used to ensure the sewing speed and drawing roller running speed are synchronuous. After receiving the signal from sewing machine, the PLC control the serve motor and control the drawing roller speed. Sewing speed and drawing roller running speed are synchronuous exactly.

Cutting Part

Images:



Main Part List :

1. Cross cutting knife 2. Camera 3. Infrared photoelectric sensor 4. Table 5. broom system

Advantages:

1. Cross cutting knife

The sharp knife is directly driven by air compressor, anti-friction and durable.

2. Camera

It monitor cross cutting part and transmit to the display of main control unit..

3. Table

Normal length: 10m or as per your request

4. Broom system: after cutting, the broom will sweep the bag body down automatically. Our broom bar is made of metal, after long time using, its shape is still stable.

PLC Controller

Images:



Main Part List :

1. Screen 2. Buttons

Advantages:

Chinese and English language