

10 TPD Toilet Paper Production Line #519



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1. Summary

- Machine manufactured in 2020
- Production line installed and operated for only 2 months before production stopped
- Production stopped as business strategy changed
- All the equipment in like-new condition

2. Production Process

The production line includes four main operations.

- Automatic Production Line
- Jumbo Roll Slitting Machine
- Paper Core Machine
- End Sealing and Bagging

3. Specifications of Automatic Production Line

3.1 Automatic Rewinding Machine

This machine is an automatic rewinder for trimming, sealing, embossing and perforating. It has PLC control and LCD touch panel for variable speed adjustment and electronic braking.

Parameters:

Max width of raw paper	2600 mm
Design speed	200 m/min
Operation speed	180 m/min
Max outer diameter of raw paper core	1100mm, other sizes to be specified
Inner diameter of raw paper core	3", 76mm, other sizes to be specified
Outer diameter of finished product	90-200mm, other sizes to be specified
Outer diameter of raw paper core	25-55mm, other sizes to be specified
Power	5.5~22 KW variable frequency speed regulating
Parameter setting	HMI (can be equipped with touch screen operation panel)
Control system	PLC
Brake	Electronic & pneumatic control
Mechanical transmission	CVT gearbox, guarantee the
Pneumatic system	3HP air compressor, which the min pressure is 5kg/cm ² pa (supplied by user)
Perforating blade	4 pcs spiral blades
Perforating Size	90-160mm (+/-2mm)
*Options	
*Adjustable perforating size	4 blades: 90-140 mm 2 blades: 200-350 mm 1 blade: 200-500 mm (+/- 3 mm), to be specified
*paper stand	1~3 ply (plies)
*Embossing	single embossing, double embossing, steel to steel (point to point/convex to plane), steel to felted, steel to paper woolen, steel to rubber, pneumatic

*Edge-embossing

Independent pneumatic, steel to steel

3.2 Automatic Toilet Roll Log Saw Machine

Functions and features

Automatic blade sharpening unit complete with lubrication system.

Automatic trim eliminating device.

Automatic approach of grinding wheels to cutting blade based on the blade wear.

Two clamping systems for toilet rolls and kitchen towels.

Main Technical Parameter of the log saw:

Log length: 1500mm~2700mm

Log outside diameter: 90mm~150mm (standard size 110+5mm)

Cutting length: variable

Machine speed: 80cuts/min, 1 rolls/cut

Operation speed: 75cuts/min, 1 rolls/cut

Blade outside diameter: 610mm

Installed power: Alternating Current: 5 Horses per Machine

Frequency Conversation: 5 Horses per Machine, AC motor 5 Horses

Parameters

Design speed	30 bags/min
Stable speed	18-22 bags/min
Plastic bags Loading way	Hanging way Both sides
Max store bags NO.	< 600 Pieces
Bags Length size	< 850mm
Bags width size	< 280mm
Bags high size	< 160mm
Bundling format	2x3/2x4/2x5/2x6
Single roll size	Length 90-160mm diameter 90-125mm
Machine size	5020 x 2000 x 1800
Machine weight	2500 KG
Packing film	CPP, PE
Air pressure	< 0.6 MPA / >300L/min
Motor power	11 KW
Heat power	1.2 KW
Voltage variation	+/-10%
I/O Input (VDC)	24 VDC
I/O Output (VDC)	24 VDC

3.3 Automatic Toilet Roll Single Roll Packing Machine

Parameters

Design speed	0 - 240 rolls/min
Speed of product with core	180 rolls/min

Speed of product without Core	120 rolls/min
Packing film put away	90mm-120mm
Length of with core product	90-150mm
Length of without Core product	90-170mm
Forming unit	2 sets Suitable for 90-120mm diameter
Machine size	6645 mm * 2839mm * 1550mm
Weight of machine	1700 KG
Packing film material	BOPP, SPP
Packing film material	BOPP, SPP
Thickness of packing film (with core)	0.018 mm - 0.03 mm
Thickness of packing film Without core)	0.02mm - 0.03 mm
Max diameter of packing film	380mm
Packing film's ID	70-76mm
Max width of packing film	430mm
Air needed	Pressure > 5MPA, flow < 150L/min
Voltage	220V/50HZ
Total power	2.885 KW
Heating power	5.1 KW
Voltage range	+/-10%
I/O input (VDC)	24 VDC
I/O output (VDC)	24 VDC
Machine moving system	Three axis servo motion, axial
The electronic CAM motion	Positioning control, curve
Transmission mode	Timing belt + chain + gear
Machine color and craft	Electrostatic spraying the lacqu
That bake process	RAL 7032
Packing type	Back sealing, Paper towel hot, Sealing on both ends is flat and level

For more details or to discuss this plant, contact:

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