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## **TECHNICAL SPECIFICATION BAG CLOSING MACHINERY AND EQUIPMENT**

## **Portable Bag Closing Machines 2200 Series**



### **Common Specification:**

Built-in thread chain cutter.

Housing for electric motor and handle made of fiberglass- reinforced break-resistant polyamide.

Combined top and bottom feed for greater power grips both sides of the bag.

Standard needle: 9854G200/080.

Heavy duty version for all bag materials.

Weight: 11 pounds (5 kg).

Style	Description	
<b>2200A</b>	Two-thread, 220-240 V, 50/60 Hz, protection class I (with ground wire)	
<b>2200AE</b>	Same as 2200A, designed to comply with ATEX directive 94/9/EC, group II 3 D T125°C for zone 22, non-conductive dust	
<b>2200AS</b>	Two-thread, 220-240 V, 50/60 Hz, protection class II (protective insulation)	
<b>2200AA</b>	Single-thread, 220-240 V, 50/60 Hz, protection class I (with ground wire)	
<b>2200AAE</b>	Same as 2200AA, designed to comply with ATEX directive 94/9/EC, group II 3 D T125°C for zone 22, non-conductive dust	
<b>2200AAS</b>	Single-thread, 220-240 V, 50/60 Hz, protection class II (protective insulation)	
<b>2200AT</b>	Two-thread, 220-240 V, 50/60 Hz, start-stop controlled by a feeler, protection class I (with ground wire)	
<b>2200B</b>	Two-thread, 110-125 V, 50/60 Hz, protection class I (with ground wire)	
<b>2200BA</b>	Single-thread, 110-125 V, 50/60 Hz, protection class I (with ground wire)	
<b>2200F</b>	Two-thread, 42 V, 50/60 Hz, protection class III (safety extra low voltage)	
<b>2200FA</b>	Single-thread, 42 V, 50/60 Hz, protection class III (safety extra low voltage)	
998A61A	Single-phase safety transformer, splash-proof, primary 220 V, secondary 42 V	
<b>2200GA</b>	Two-thread portable bag closer for geotextiles	
<b>2200GM</b>	Two-thread portable bag closer, 12 V DC, for geotextiles and protection nets	
998M61A	Single-phase safety transformer, splash-proof, primary 220 V, secondary 12 V	
USI890	Presser foot lifter complete with rolls for hail protection nets	
<b>2200M</b>	Two-thread, 12 V DC, protection class III (safety extra low voltage)	
<b>2200MA</b>	Single-thread, 12 V DC, protection class III (safety extra low voltage)	
<b>2200L</b>	Two-thread, pneumatic motor, operating air pressure 50 psi (3.5 bar)	
<b>2200LA</b>	Single-thread, pneumatic motor, operating air pressure 50 psi (3.5 bar)	
<b>2200LC</b>	Two-thread, pneumatic motor, chromium plated sewing parts, operating air pressure 50 psi (3.5 bar)	
<b>2200LAC</b>	Single-thread, pneumatic motor, chromium plated sewing parts, operating air pressure 50 psi (3.5 bar)	
Z1-344-250WS	Thread cone, cotton, approx. 250 g, N <sub>m</sub> 34/4-ply white, 24 cones per carton	
90191M	Top lock spring balancer for styles 2200 A, AE, AA, AAE, AS, AAS, B, BA, F, FA, GA, GM, L, LA, LC, LAC, M, MA with handle to hang on ceiling	

## **Portable Bag Closing Machines 2200 Series**

Style	Description	
<b>2200AZ4015</b>	Two-thread, only sewing head, series 2200 without handle and motor	
<b>2200AAZ4015</b>	Single-thread, only sewing head, series 2200 without handle and motor	
<b>2200AZ4015FAN</b>	Two-thread, only sewing head, series 2200 with drive pinion and pneumatically actuated thread chain cutter for bag closing equipment	
<b>2200AAZ4015FAN</b>	Single-thread, only sewing head, series 2200 with drive pinion and pneumatically actuated thread chain cutter for bag closing equipment	
<b>2200ABZ4015FAN</b>	Two-thread, only sewing head, series 2200 with drive pinion, tape folder (for 50 or 60 mm width - please specify) and solenoid operated tape and thread chain cutter, 220-240 V, 50/60 Hz, protection class I (with ground wire) for bag closing equipment	
<b>2200AB</b>	Two-thread, includes tape folder (for 50 or 60 mm width - please specify) and solenoid operated tape and thread chain cutter, 220-240 V, 50/60 Hz, protection class I (with ground wire)	
<b>2200AAB</b>	Same as 2200AB, but single-thread	
<b>2200BB</b>	Same as 2200AB, but 110 V	
90191MA1	Top lock spring balancer for styles 2200AB, AAB, BB	
999-114UB50	Tape roll, width 50 mm, length 50 m	
999-114UB60	Tape roll, width 60 mm, length 50 m	
<b>2200FAC</b>	Single-thread, 42 V, 50/60 Hz, protection class III (safety extra low voltage), chromium-plated sewing parts Needle: 9854G170/067	
<b>2200FC</b>	Same as 2200FAC, but two-thread	
Z1-344-250WS	Thread cone, cotton, approx. 250 g, N <sub>m</sub> 34/4-ply white, 24 cones per carton	
998A61A	Single-phase safety transformer, splash-proof, primary 220 V, secondary 42 V	
90191M	Top lock spring balancer for styles 2200FAC, FC	
<b>2200MB</b>	Two-thread, 24 V DC, complete with battery belt, part No. 90195 and battery charger, primary 230 V, part No. 90195B	
<b>2200MAB</b>	Same as 2200MB, but single-thread	
If requested as an extra:		
90195	Battery belt	
90195B	Battery charger, primary 230 V	



## **Portable Bag Closing Machines 2200 Series**



**Common Specification:**

Built-in thread chain cutter.

Housing for electric motor and handle made of fiberglass- reinforced break-resistant polyamide.

Combined top and bottom feed for greater power grips both sides of the bag.

Standard needle: 9854G200/080.

Heavy duty version for all bag materials.

Weight: 11 pounds (5 kg).

Style	Description	
<b>2200ABZ3222</b>	Two-thread, with tape folder, possible widths of tape 50 or 60 mm (please specify) and solenoid operated tape and thread chain cutter, 220-240 V, 50/60 Hz, protection class I (with ground wire). With pedestal, foot switch and knee switch for stationary installation, e.g. movable table	
<b>999-114UB50</b>	Roll with crepe tape, width 50 mm, length 50 m	
<b>999-114UB60</b>	Roll with crepe tape, width 60 mm, length 50 m	



## **Portable Bag Closing Machines 3000 Series**

### **Common Specification:**

Built-in thread chain cutter.

Housing for electric motor and handle made of ABS plastic.

Lower Feed

Standard needle: 9858G200/080.

Light weight version for paper, PP-woven and jute bags

Weight: 7.5 pounds (3.4 kg).

<b>Style</b>	<b>Description</b>	
<b>3000A</b>	Single-thread, 220-240 V, 50/60 Hz, protection class I (with ground wire)	
<b>3000B</b>	Single-thread, 110-125 V, 50/60 Hz, protection class I (with ground wire)	
<b>3000M</b>	Single-thread, 12 V DC, protection class III (safety extra low voltage)	
90191M1	Top lock spring balancer for styles 3000A, B, M	
2199	Neck strap	



## **Portable Bag Closing Machines 3000 Series For Finishing Section**

**Common Specification:**

Built-in thread chain cutter.

Housing for electric motor and handle made of ABS plastic.

Lower Feed

Standard needle: 9858G160/063.

Light weight version for thin sewing material

Weight: 7.5 pounds (3.4 kg).

<b>Style</b>	<b>Description</b>	
<b>3000AZ4025</b>	Single-thread, 220-240 V, 50/60 Hz, protection class I (with ground wire), with throat plate A 10424 with small stitch hole and thin needle 9858G160/063	
Z1-344-250WS	Thread cone, cotton, approx. 250 g, N <sub>m</sub> 34/4-ply white, 24 cones per carton	
90191M1	Top lock spring balancer	
2199	Neck strap	

### **Accessories for Portable Bag Closing Machines**

Style	Description	
2199	Neck strap, complete, for all portable styles	
2203E	Bag-guide with finger guard	
2103E	Bag-guide with finger guard (long version for stationary used machines with pedestal)	
2130	Auxiliary needle hole section for throat plate	
77K	Screw for 2130	
93065C	Thread stand extension for filler cord	
998-204HE	Lamp, halogen, cpl	
H1400F	Pedestal for table installation, consisting of base, column (535 mm long), machine support and foot switch assembly. For styles 2200A, AE, AA, AAE, AS, AAS, B, BA, F, FA, FAC	
H1400TWS	Pedestal, same as H 1400 F, but without foot switch For style 2200AT (with feeler)	
If desired, H1400F and H1400T also available with:		
1403B1300	Column, 1300 mm long, surcharge	
90709PR	Table with built-in roller type conveyor, table size: 1060 x 550 x 790 mm	
90709PS	Movable table with built-in roller type conveyor with two fixed and two castor wheels, table size: 1060 x 550 x 920 mm	
90709PSA	Movable table with built-in roller type conveyor and carrier for electro foot switch, on/off switch, socket and with two fixed and two castor wheels, table size: 1060 x 550 x 920 mm	
A9847B	Small movable table with two fixed and two castor wheels, table size 760 x 550 x 700 mm	
A9847BS	Small movable table and carrier for electro foot switch, on/off switch, socket and with two fixed and two castor wheels, table size 760 x 550 x 700 mm	

### Thread and Filler Cord

Z1-124-250WS	Thread cone, viscose, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 32 cones per carton	
Z1-124-250RT	Thread cone, viscose, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), red, 32 cones per carton	
Z1-124-250GE	Thread cone, viscose, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), yellow, 32 cones per carton	
Z1-124-250GN	Thread cone, viscose, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), green, 32 cones per carton	
Z1-124-250BL	Thread cone, viscose, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), blue, 32 cones per carton	
Z1-204-250WS	Thread cone, polyester, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 32 cones per carton	
Z1-204-250BL	Thread cone, polyester, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), blue, 32 cones per carton	
Z1-204-250RT	Thread cone, polyester, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), red, 32 cones per carton	
Z1-204-250WS12/3	Thread cone, polyester, approx. 200 g, N <sub>e</sub> 12/3-ply (N <sub>m</sub> 20/4), white, 32 cones per carton	
Z1-204-250WSOEL	Thread cone, polyester, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), oiled, white, 32 cones per carton	
Z2-124-200WS	Thread cone, polypropylene, approx. 200 g, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 24 cones per carton	
DF1-065-150	Filler cord, approx. 150 g, N <sub>m</sub> 0,65, grey, (2200 series only), 24 cones per carton	



## Portable Single-Thread Bag Closing Machines 4000 Series for efficient, fast and easy closing of bags

### **Specification:**

Single-thread plain feed machine with build-in thread chain cutter.

The 4000 is a well-balanced hand-held machine that fits perfectly in an operator's hand. It's designed for closing bags made of light-weight-jute, burlap, cotton, paper, plastic or polypropylene woven fabric.

An optional top lock spring balancer (Part # 90191M1) is available for suspended operation.

Sewing speed: 1600-1800 SPM (depending on material)

Stitch length: 3 1/2" (7.2 mm)

Sewing capacity: 1/16" (12 plies of paper)

Stitch/Seam type: 101 SSa-1

Needle: D5-200/080

for light Material

Motor power: 90 Watt

Weight: 5,5 Kg

Style	Description	
<b>4000A</b>	Single-thread, 220-240 V, 50/60 Hz, protection class I (with ground wire)	
<b>4000B</b>	Single-thread, 110-125 V, 50/60 Hz, protection class I (with ground wire)	
<b>Thread</b>	Please see page 6	
90191M2	Top lock spring balancer with suspension hook for styles 4000A, B	



**Automatic Bag Closing Equipment  
1200LOE, LOEAB and 1500LOE, LOEAB  
with integrated Class 2200 Sewing Head**

**Common Specification:**

Telescopic Column with base plate  
Manual height adjustment on 1200LOE, 1200LOEAB  
motor driven height adjustment on 1500LOE, 1500LOEAB  
Range of adjustment:  
1200: 270mm (765-1035 mm, floor to needle)  
  
1500: 400mm (765-1165 mm, floor to needle)

Start and stop of sewing machine and thread chain trimming  
automatically actuated by light barrier  
Motor:220-240, 380-415 V, 3-phase, 50 Hz, 025 Kw, IP54,  
Control voltage 24 V DC  
Sewing Speed 10 m/min  
Sewing direction: right to left

Style	Description	
<b>Telescopic column, manually height adjustable</b>		
1200LOE	Includes two-thread machine, stitch type 401, sewing machine 2200AZ4015FAN. Also available with single-thread machine.	
1200LOEAB	Includes two-thread machine, stitch type 401, sewing machine 2200ABZ4015FAN, equipped with tape folder (for 50 or 60 mm width - please specify) and solenoid operated tape cutter, 220-240 V, 50/60 Hz, protection class I (with ground wire)	
<b>Telescopic column, motor driven height adjustable</b>		
1500LOE	Includes two-thread machine, stitch type 401, sewing machine 2200AZ4015FAN. Also available with single-thread machine.	
1500LOEAB	Includes two-thread machine, stitch type 401, sewing machine 2200ABZ4015FAN, equipped with tape folder (for 50 or 60 mm width - please specify) and solenoid operated tape cutter, 220-240 V, 50/60 Hz, protection class I (with ground wire)	
1200-6	Bag-top fold-over sword for styles 1200/1500LOE, bag-top folded to the rear	
20401FK	Small movable base for column 1200LOE and 1500LOE	

**Conveyors for 1200LOE, LOEAB and 1500LOE, LOEAB**

Working height: 0.8 m  
Guide rail: front and rear  
Motor: 220-240, 380-415 V, 3phase, 50 Hz, 0.25 kW, IP 54  
Speed: frequency controlled

Style	Description	
91606KG...	<b>Belt-type conveyor</b> 91606KG ... (total length - width of belt)	
91606KG1.50-0.25	1.5 m (total length - 0.25 m width of belt)	
91606KG2.00-0.25	2.0 m (total length - 0.25 m width of belt)	
91606KG2.50-0.25	2.5 m (total length - 0.25 m width of belt)	

**Installation, supervision and training charges not included in our prices.  
Please ask for the costs of a technician.**

## High Speed Bag Closing Machines

### BC200 Series

#### Common Specification for all Styles BC200



Internal forced lubrication system in closed casting with large outside mounted oil filter and rust-protected parts.

Optimized sewing parts for easy processing of all known bag materials.

Vertically-acting presser foot system.

Independently-adjustable chaining and presser foot pressure for optimized bag feeding.

Minimized presser foot pressure and independent spring loaded chaining section to protect bag material and sewing machine.

Low thread tension reduces the risk of thread breakage.

Low noise and vibration.

Stitch length: easily adjustable from 6.5-12.5 mm (2-4 SPI), standard setting 8 mm (3 SPI)

Sewing speed: up to 2750 RPM, depending on sewing material and operation

Linear travel speed: up to 33 m/min. at max. RPM and max. stitch length

Sewing capacity: up to 12.7 mm (1/2 inch)

Sewing capacity on paper: 32 plies, depending on weight of paper

Sewing machine hand wheel: adjustable, working diameter 90 mm (3.5 inch) to 108 mm (4.25 inch)

Standard needle(s): 9848GF250/100

Equivalent continuous A-weighted sound pressure level (LpAd) at workstation: 78.5 dB(A) according to ISO 10821-CB-M1 at 2700 RPM and 50% duty cycle.

Painting: white, similar to RAL 9002

### Standard Bag Closing Machines

Style	Description	
BC211P01-1	<p><b>Two-thread double locked chain stitch machine, standard version,</b> corresponding to 80800C, Stitch type 401</p> <p><b>Start-stop:</b> actuated by foot switch of column</p> <p><b>Thread chain cutter:</b> by continuously driven nibbler knives</p>	
BC291P01-1	<p><b>Single-thread chain stitch machine, standard version,</b> corresponding to 80800D, Stitch type 101</p> <p><b>Start-stop:</b> actuated by foot switch of column</p> <p><b>Thread chain cutter:</b> by continuously driven nibbler knives</p>	
29926NBC	Needle cooling device	

**High Speed Bag Closing Machines BC200 Series  
Automatic Bag Closing Machines**

Style	Description	
<b>BC211P12-1M</b>	<b>Two-thread double locked chain stitch machine, automatic version,</b> corresponding to style 80800RLM, Stitch type 401 <b>Start-stop:</b> automatically by feeler controlled proximity switch <b>Thread chain cutter:</b> automatically with electro-pneumatically operated jump out scissors <b>Control voltage:</b> 24 V DC	
<b>BC211P12-1A</b>	Same as BC211P12-1M, but control voltage 200-230 V, 50/60 Hz	
<b>BC211P12-1B</b>	Same as BC211P12-1M, but control voltage 100-110 V, 50/60 Hz	
<b>BC211P12-1AZ4061</b>	Same as BC211P12-1M, but with double-acting air cylinder drive and built-in needle cooler pipe. <b>Control voltage:</b> 230 V AC	
<b>BC211P12-1MZ4061</b>	Same as BC211P12-1M, but with double-acting air cylinder drive and built-in needle cooler pipe.	
<b>BC211P12-1AZ4063</b>	Same as BC211P12-1M, but with <u>throat plate G10024BC2</u> (front bent down for manual feeding). <b>Control voltage:</b> 230 V AC	
<b>BC211P12-1MZ4063</b>	Same as BC211P12-1M, but with <u>throat plate G10024BC2</u> (front bent down for manual feeding).	
<b>BC211P11-1</b>	<b>Two-thread double locked chain stitch machine, automatic version,</b> Stitch type 401 <u>Without electro-mechanical components</u> (without feeler, proximity switch and solenoid valve). <b>Thread chain cutter:</b> with pneumatically operated jump out scissors	
<b>BC211P11-1N4</b>	Same as BC211P11-1, but with double acting cylinder for pneumatically operated jump out scissors, with optimized presser foot and bracket for light barrier. With <u>long throat plate G10024BC1</u> (front bent down for manual feeding). Designed for exchanging Newlong (extra base plate G11667VN at €298,70) and Fischbein sewing heads.	
<b>BC291P12-1M</b>	<b>Single-thread chain stitch machine, automatic version,</b> corresponding to style 80800SLM, Stitch type 101 <b>Start-stop:</b> automatically by feeler controlled proximity switch <b>Thread chain cutter:</b> automatically with electro-pneumatically operated jump out scissors <b>Control voltage:</b> 24 V DC	
<b>BC291P12-1A</b>	Same as BC291P12-1M, but control voltage 200-230 V, 50/60 Hz	
<b>BC291P12-1B</b>	Same as BC291P12-1M, but control voltage 100-110 V, 50/60 Hz	
29926NBC	Needle cooling device	

## High Speed Bag Closing Machines BC200 Series Universal Automatic Bag Closing Machines



Style	Description	
<b>BC211U14-1M</b>	<b>Two-thread double-locked stitch machine, automatic version,</b> stitch type: 401 for simultaneously binding the bag mouth of filled bags with or without a crepe paper tape, <b>Start-Stop:</b> automatically by feeler-controlled proximity switch <b>Tape or thread chain cutter:</b> automatically with electro-pneumatically operated guillotine cutter close behind the needle <b>Tape folder:</b> adjustable for 50-70 mm wide crepe tape <b>Speed:</b> up to max. 2500 RPM (at 8 mm stitch length), depending on sewing material and operation Control voltage: 24 V DC	
<b>BC211UA14-1M</b>	Same as BC211U14-1M, but <u>without tape folder.</u> <u>For application with bag feed-in devices</u>	
<b>BC211UA14-1MZ4065</b>	as replacement for style BC111TA12-1M	
29926NBC	Needle cooling device	
N360G	Tape reel complete (necessary in connection with sewing head and column)	

Depending on circumstances at site, such as bag material, filling material, sewing speed, type of crepe tape, outside temperature and atmospheric humidity, the use of a crepe tape puller is necessary (on double-head columns two crepe tape pullers). We therefore recommend:

29950F	Crepe tape puller Electro-pneumatically operated. Pulling speed 9-22 m/min., infinitely variable by a reduction valve. For easily inserting a new crepe tape roll, the puller is equipped with an on/off switch for the compressed air. The crepe tape puller is suitable for all tape widths used and is mounted to the traverse of the columns 20600	
29950FF	Crepe tape puller and tape control with built-in photo-cell	
29926FH	Tape control device with built-in photocell for use without crepe tape puller	
999-114UC50	Crepe tape roll, width 50 mm, length 400 m	
999-114UD50	Crepe tape roll, width 50 mm, length 700 m	
999-114UC60	Crepe tape roll, width 60 mm, length 400 m	
999-114UD60	Crepe tape roll, width 60 mm, length 700 m	



## High Speed Bag Closing Machines BC200 Series Universal Automatic Bag Closing Machines

Style	Description	
<b>BC211U13-1</b>	Same as BC211U14-1M, but <u>without electro-pneumatic components</u> (without feeler, proximity switch and solenoid valve). Stitch type: 401 <b>Tape and thread chain cutter:</b> automatic by electro-pneumatically operated guillotine close behind the needle. <b>Tape folder:</b> adjustable to 50-70 mm wide fold-over tape <b>Speed:</b> up to max. 2500 RPM (at 8 mm stitch length), depending on sewing material and operation Control voltage: 24 V DC	
<b>BC211UA13-1</b>	Same as BC211U13-1, but <u>without fold-over tape</u> . (For application with bag feed-in device)	
<b>BC291U14-1M</b>	<b>Single-thread chain stitch machine, automatic version,</b> Stitch type: 101, for closing filled bags with a crepe paper tape and simultaneously binding the seam with a paper tape for an "easy-open" closure. <b>Start-Stop:</b> automatic by feeler-controlled proximity switch <b>Tape and thread chain cutter:</b> automatically with electro-pneumatically operated guillotine cutter close behind the needle <b>Folder:</b> adjustable to 50-70 mm wide tape <b>Speed:</b> up to max. 2500 RPM, depending on sewing material and operation Control voltage: 24 V DC	
<b>BC291U13-1</b>	Same as BC291U14-1M, but <u>without electro-mechanic components</u> (without feeler, proximity switch and solenoid valve)	
29926NBC	Needle cooling device	
N360G	Tape reel complete (necessary in connection with sewing head and column)	
N360E	Tape reel complete (necessary for easy open sewing head BC291 in connection with column)	

Style	Description	
BC211UA15-1N5	<p><b>One-needle double-locked stitch machine, automatic version,</b>  Stitch type: 401  Equipped with long throat plate and knife drive activated by double-acting cylinder (advanced guillotine). But without electro-pneumatic components (without feeler, proximity switch and solenoid valve).  For exchange of Newlong and Fischbein sewing heads. (On Newlong machines extra machine support G11667VN at €298,70 required)</p>	
BC211UA16-1MZ4061	<p><b>One-needle double-locked stitch machine, automatic version,</b>  Stitch type: 401  for simultaneously binding the bag mouth of filled bags without a crepe paper tape,  <b>Start-Stop:</b> automatically by feeler-controlled proximity switch  <b>Thread chain cutter:</b> automatically operated by advanced electro-pneumatically guillotine close behind the needle (actuated by double acting cylinder)  <b>Speed:</b> up to max. 2500 RPM, depending on sewing material and operation  <b>Control voltage:</b> 24 V DC  <b>Advantages:</b> separately adjustable chaining and presser foot pressure for optimized feeding of bag  Rust protection</p>	
93065BF	Thread stand extension for filler cord or additional thread cone	
For <b>replacement machines</b> we recommend additional machine support:		
20651EA	Swing-out machine support (Swing-out plate)	

## High Speed Bag Closing Machines BC200 Series Automatic Bag Closing Machines

Style	Description	
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Depending on circumstances at site, such as bag material, filling material, sewing speed, type of paper strip, outside temperature and atmospheric humidity, the use of a paper strip puller is necessary (on double-head columns two resp. four paper strip pullers).

**We therefore recommend:**

29950F	Crepe tape puller Electro-pneumatically operated. Pulling speed 9-22 m/min., infinitely variable by a reduction valve. For easily inserting a new crepe tape roll, the puller is equipped with an on/off switch for the compressed air. The crepe tape puller is suitable for all tape widths and is mounted to the traverse of the columns 20600	
29950T	Paper strip puller (Easy Open) Electro-pneumatically operated. Pulling speed 9-20 m/min., infinitely variable by a reduction valve. For easily inserting a new paper strip roll, the puller is equipped with an on/off switch for the compressed air. The paper strip puller is suitable for one paper strip roll and is mounted to the traverse of the columns 20600	
29950FF	Crepe Tape puller and tape control with built-in photo-cell	
29926FH	Tape control with built-in photo-cell but without crepe tape puller	
999-114UC50	Crepe tape roll, width 50 mm, length 400 m	
999-114UD50	Crepe tape roll, width 50 mm, length 700 m	
999-114UC60	Crepe tape roll, width 60 mm, length 400 m	
999-114UD60	Crepe tape roll, width 60 mm, length 700 m	
999-114EOW9	Easy-Open tape, white, width 9 mm, 3 kg roll	
999-114EOB9	Easy-Open tape, beige, width 9 mm, 3 kg roll	

**High Speed Bag Closing Machines BC200 Series  
Automatic Bag Closing Machines**

Style	Description	
<b>BC211K12-1M</b> Stitch length: 6.5-10 mm Standard: 8 mm	<b>Two-thread double locked chain stitch machine for simultaneously seaming and sealing the seam with adhesive crepe tape</b> with vertically-acting presser foot system and rust-protected parts, <b>automatic version,</b> (corresponding to style 80800TLM) Stitch type 401 <b>Start-stop:</b> automatic by feeler controlled proximity switch <b>Thread chain and tape cutter:</b> automatic with electro-pneumatically operated knives <b>Control voltage:</b> 24 V DC <b>Tape folder:</b> not adjustable Suitable for 50 to 60 mm wide tape. Kindly specify when ordering. Standard: 50 mm <b>Speed:</b> up to max. 1600 RPM, depending on sewing material and operation	
<b>BC211KA12-1M</b>	Same as BC211K12-1M, (corresponding to style 80800TALM) For use with combined bag feed-in, trimming and taping devices (VN)-F29920A. (VN = rust-protected parts)	

Depending on circumstances at site, such as bag material, filling material, sewing speed, type of paper strip, outside temperature and atmospheric humidity, the use of a paper strip puller is necessary (on double-head columns two resp. four paper strip pullers).

**We therefore recommend:**

29950K	Crepe tape puller Electro-pneumatically operated. Pulling speed 5-25 m/min., infinitely variable by a reduction valve. For easily inserting a new crepe tape roll, the puller is equipped with an on/off switch for the compressed air. The crepe tape puller is suitable for all tape widths used and is mounted to the traverse of the 20600 columns	
29950KK	Tape puller and control device with built-in photocell for use with adhesive tape	
999-114TB50	Adhesive crepe tape roll, width 50 mm, length 200 m	
999-114TB60	Adhesive crepe tape roll, width 60 mm, length 200 m	
29926BABCM	Socket with flip-flop time relay, complete (part of control box of bag closing unit)	
90238UTTK	Control kit, needed when replacing 80800TL, TLM, TAL, TALM	
N360G	Tape reel complete (necessary in connection with sewing head and column)	

**High Speed Bag Closing Machines BC200 Series  
Automatic Two-Needle Bag Closing Machines**

Style	Description	
BC211UD16-2M	<p><b>Two-needle four-thread double locked chain stitch machine, automatic version,</b></p> <p>(corresponding to style 80800RDLM),  <b>Stitch type:</b> (401.401)  <b>Start-stop:</b> automatic by feeler controlled proximity switch  <b>Thread chain cutter:</b> automatically operated by advanced electro-pneumatic guillotine close behind the needle (actuated by double acting Aircylinder)  <b>Control voltage:</b> 24 V DC  <b>Needle distance:</b> 7.2 mm, staggered  <b>Speed:</b> up to 2500 RPM, depending on material and operation  <b>Advantages:</b> separately adjustable chaining and presser foot pressure for optimized feeding of bag  Rust protection</p>	
93065BF	<p>Thread stand extension for filler cord or additional thread cone (2 additional thread stands required for two-needle machines)  For <b>replacement machines</b> we recommend additional machine support:</p>	
20651EA	Swing-out machine support (Swing-out plate)	



## Bag Closing Machines 80800 Series Standard bag closing machines

Start-stop: actuated by foot switch of column

Thread chain cutter: by continuously driven nibbler knives

Standard needle: 9848G250/100

Stitch length: adjustable from 6.5-11 mm, standard setting 8 mm

Speed: up to 1800 RPM, depending on sewing material and operation

Style	Description	
<b>80800C</b>	Two-thread double locked chain stitch machine. Equipped with extra long throat plate 80624CF. Stitch type 401	
<b>80800CD</b>	Same as 80800C, but two-needle four-thread double locked chain stitch machine Stitch type (401.401) <b>Needle distance:</b> 7.2 mm, staggered Advantages: refer to 80800RD, RDL	
<b>80800D</b>	Same as 80800C, but single-thread chain stitch machine Stitch type 101	
93065BF	Thread guide and thread disc assembly (two additional thread stands required for two-needle machines)	



**Bag closing units suspended on top lock spring balancer including sewing machine 80800C,**

Machine support:

with control box

start-stop by pushbutton

continuous sewing speed through enclosed V-belt drive, therefore also applicable with conveyor, sewing speed (with 8 mm stitch length) 8.5 / 10.0 and 11.3 m/min.,

standard: 10 m/min.

hand wheel for easy threading of needle and looper

<b>80800LA</b>	For 230 V, single phase, 50 Hz Top lock spring balancer included in price	
<b>80800LG</b>	For 220-240, 380-415 V, 3-phase, 50 Hz Top lock spring balancer included in price	
93065BF	Kit of parts for filler cord or thread cone (to extend the thread stand)	



## **Bag Closing Machines 80800 Series**

### **Automatic bag closing machines**

**Start-stop:** automatically by feeler controlled proximity switch

**Thread chain cutter:** automatically by jump out scissors

**Stitch length:** adjustable from 6.5-11 mm, standard setting 8 mm

**Standard needle:** 9848G250/100

**Speed:** up to 1800 RPM, depending on sewing material and operation

Style	Description	
<b>80800RLM</b>	Two-thread double locked chain stitch machine Stitch type 401 Equipped with electro-pneumatically operated scissors <b>Control voltage:</b> 24 V DC	
<b>80800RLMZ4063</b>	Same as 80800RLM, but with extended throat plate 80628RF for easier insertion of bags.	
<b>80800RL</b>	Same as 80800RLM, but control voltage 230 V, 50/60 Hz	
<b>80800RLB</b>	Same as 80800RLM, but control voltage 100-110 V, 50/60 Hz	
<b>80800R</b>	For replacement only Two-thread double locked chain stitch machine Stitch type 401 Equipped with solenoid operated scissors. <b>Control voltage:</b> 230 V, 50 Hz	
<b>80800SLM</b>	Single-thread chain stitch machine Stitch type 101 Equipped with electro-pneumatically operated scissors <b>Control voltage:</b> 24 V DC	
<b>80800SL</b>	Same as 80800SLM, but single-thread chain stitch machine Stitch type 101	
<b>80800SLB</b>	Single-thread chain stitch machine Stitch type 101 Equipped with electro-pneumatically operated scissors <b>Control voltage:</b> 100-110 V AC, 50/60 Hz	
<b>80800S</b>	For replacement only Single-thread chain stitch machine Stitch type 101 Equipped with solenoid operated scissors <b>Control voltage:</b> 230 V, 50 Hz	
<b>29926NM</b>	Needle cooler device	
<b>20651EA</b>	Swing-out base plate for sewing head	

## Bag Closing Machines 80800 Series

### Automatic two-needle bag closing machines

**Start-stop:** automatically by feeler controlled proximity switch  
**Thread chain cutter:** automatically with jump out scissors  
**Stitch length:** adjustable from 6.5-11 mm, standard setting 10 mm  
**Standard needles:** 9848G250/100  
**Needle distance:** 7,2 mm Staggered  
**Speed:** up to 1800 RPM, depending on sewing material and operation

Style	Description	
<b>80800RDLM</b>	Two-needle four-thread double locked chain stitch machine Stitch type (401.401) Equipped with electro-pneumatically operated scissors. <b>Control voltage:</b> 24 V DC	
<b>80800RDL</b>	same as 80800RDLM, but control voltage 230 V, 50/60 Hz	
<b>80800RD</b>	For replacement only: Two-needle four-thread double locked chain stitch machine Stitch type (401.401) Equipped with solenoid operated scissors <b>Control voltage:</b> 230 V, 50/60 Hz	
<b>80800RDZ4070</b>	Same as 80800RD, but with electro-pneumatic guillotine cutter (with special chain cutting kit 999-330) instead of electro-pneumatic scissors.	
93065BF	Thread guide and thread disc assembly (two additional thread stands required for two-needle machines)	

#### **Advantages of the two-needle machine:**

1. Due to two independent rows of stitching the strength of the closure is improved.
  2. Due to the staggered setting of the needles a labyrinth is formed. The sealing quality of the closure is improved
  3. Due to the labyrinth effect the standard stitch length of 8 mm could be increased up to 12 mm at same sealing quality.
- With the longer stitch length the linear speed (conveyor speed) can be increased up to approx. 21.5 m/min.

**Bag Closing Machines 80800 Series**  
**Automatic bag-closing machines for sew-thru**  
**crepe tape closure**

**Start-stop:** automatically by feeler controlled proximity switch  
**Thread chain and tape cutter:** automatically actuated  
**Stitch length:** adjustable from 6.5-10 mm, standard setting 8 mm  
**Standard needle:** 9848G250/100  
**Speed:** up to 1800 RPM, depending on sewing material and operation

Style	Description	
<b>80800ULM</b>	Two-thread double locked chain stitch machine Stitch type 401 Equipped with electro-pneumatically operated tape cutter <b>Tape folder:</b> adjustable for 50-70 mm wide crepe tape. <b>Control voltage:</b> 24 V DC	
<b>80800UL</b>	Same as 80800ULM, but control voltage 230 V, 50/60 Hz	
<b>80800ULB</b>	Same as 80800ULM, but control voltage 100-110 V, 50/60 Hz	
<b>80800U</b>	For replacement only Two-thread double locked chain stitch machine Stitch type 401 Equipped with solenoid operated tape cutter <b>Tape folder:</b> adjustable for 50-70 mm wide crepe tape <b>Control voltage:</b> 230 V, 50 Hz	
<b>80800UALM</b>	Same as 80800ULM, but without tape folder. For use with bag feed-in, trimming and taping devices FB29910A, GBR29910G <b>Control voltage:</b> 24 V DC	
<b>80800UAL</b>	Same as 80800UALM, but control voltage 230 V, 50/60 Hz	
<b>80800UALB</b>	Same as 80800UALM, but control voltage 100-110 V, 50/60 Hz	
<b>80800UA</b>	For replacement only Same as 80800U, but without tape folder. For use with bag feed-in, trimming and taping device GBR29910G	
	Above machines are also available as single-thread chain stitch machines, stitch type 101 Surcharge	
29950F	Crepe tape puller Electro-pneumatically operated. Pulling speed 9 - 22 m/min., infinitely variable by reduction valve. For easily inserting a new crepe tape roll, the puller is equipped with an on/off switch for the compressed air. The crepe tape puller is suitable for all tape widths used and is mounted to the traverse of the columns 20600	
29950FF	Tape control device with built-in photocell for use with crepe tape puller	
29926FH	Tape control with built-in photo-cell, but without crepe tape puller	
999-114UC50	Crepe tape roll, width 50 mm, length 400 m	
999-114UD50	Crepe tape roll, width 50 mm, length 700 m	
999-114UC60	Crepe tape roll, width 60 mm, length 400 m	
999-114UD60	Crepe tape roll, width 60 mm, length 700 m	

## Bag Closing Machines 80800 Series

### Automatic bag-closing machines for self-adhesive crepe tape over seam closure

Start-stop: automatically by feeler controlled proximity switch  
 Thread chain and tape cutter: automatically actuated  
 Stitch length: adjustable from 6.5-8 mm, standard setting 8 mm  
 Standard needle: 9848G250/100  
 Speed: up to 1500 RPM, depending on sewing material and operation  
 Folder: not adjustable, available for 50 or 60 mm wide adhesive crepe  
 Please specify when ordering, standard width 50 mm

Style	Description	
<b>80800TLM</b>	Two-thread double locked chain stitch machine Stitch type 401 Equipped with electro-pneumatically operated tape cutter <b>Control voltage:</b> 24 V DC	
<b>80800TL</b>	Same as 80800TLM, but control voltage 230 V, 50/60 Hz	
<b>80800TALM</b>	Same as 80800TLM, but for use with bag feed-in and trimming devices FB29920A, GBR29920G	
<b>80800TAL</b>	Same as 80800TALM, but control voltage 230 V, 50/60 Hz	
	Above machines are also available as single-thread chain stitch machines, stitch type 101 Surcharge	
29926BA	Kit of parts for additional cutting impulse available at the start, to be added to the control box	
	Depending on circumstances at site, such as bag material, filling material, sewing speed, type of self-adhesive crepe tape, outside temperature and atmospheric humidity, the use of a self-adhesive crepe tape puller is necessary (on double-head columns two self-adhesive crepe tape pullers). We therefore recommend:	
29950K	Self-adhesive crepe tape puller Pneumatically operated. Pulling speed 5-10 m/min., infinitely variable by a reduction valve. For easily inserting a new self-adhesive crepe tape roll, the puller is equipped with an on/off switch for the compressed air. The self-adhesive crepe tape puller is suitable for all tape widths used and is mounted to the traverse of the columns 20600	
29950KK	Self-adhesive crepe tape puller and tape control with built-in photocell	
999-114TB50	Roll with self-adhesive crepe tape, width 50 mm, length 200 m	
999-114TB60	Roll with self-adhesive crepe tape, width 60 mm, length 200 m	



## Bag Feed-In Devices with frequency controlled speed for Automatic Bag Closing Machines BC200 and 80800 Series

### Common Specification:

Rubber coated conveying chains to protect the bag material  
 Gear motor with frequency converter  
 Standard voltage for motor: 230 V, single phase, 50/60 Hz  
 Degree of protection: IP 55. Insulation class: F  
 Painting: RAL 9002, powder coated  
 Delivery includes pre-feeler switch 29926A to start the sewing machine

Style	Description	
<b>FB29905A</b>	<b>Bag feed-in device. Long V-type bag in-feed (V).</b> For machines styles BC211P12-1M, -1A, -1B, BC291P12-1M, -1A, -1B, BC291U14-1M, 80800RLM, RL, RLB, SLM, SL, SLB. The spread paper, HDPE - foil or woven PP bag is fed into the sewing machine. Speed 9-23 m/min. Depending on the length and filling height of the bag the seam can be adjusted to a depth of up to 120 mm from the top of the bag, standard setting 30-40 mm	
<b>FBS29905A</b>	Same as FB29905A, but long <u>parallel bag in-feed (II)</u>	
<b>F29905A</b>	Same as FB29905A, but short version (V)	
<b>FS29905A</b>	Same as FBS29905A, but short version (II)	
29926EO	<b>Light barrier</b> , mounted above feeding chains to start the sewing machine	
93051R	<b>New Bag-top fold-over device</b> to fold the bag-top to the rear. Assembling to the bag feed-in devices FB29905A and FBS29905A required. For all kinds of self-supporting bags. Performance test of bag material recommended	
Style	Description	

<b>FB29910A</b>	<b>Combined bag feed-in, trimming and taping device</b> , long V-type bag in-feed (V), with crepe tape folder. For machine styles BC211UA14-1M, 80800UALM, UAL, UALB. Tape folder not adjustable. Folder available for 50, 55 and 60 mm wide tapes. Please specify when ordering. Standard width 60 mm. Speed 9-23 m/min. The paper or HDPE-foil bag top is trimmed approx. 20 mm (max. 90 mm). Taped before sewing Performance test of bag material recommended	
<b>FBS29910A</b>	Same as FB29910A, but long parallel bag in-feed (II)	
<b>F29910A</b>	Same as FB29910A, but short version (V)	
<b>FS29910A</b>	Same as FBS29910A, but short version (II)	

Style	Description	
<b>FB29915A</b>	<b>Combined bag feed-in, trimming and fold-over device.</b> Long V-type bag in-feed (V). For machine styles BC211P12-1M, -1A, -1B, BC291P12-1M, -1A, -1B, 80800RLM, RL, RLB, SLM, SL, SLB. Speed 9-23 m/min. The paper or HDPE-foil bag top is trimmed approx. 20 mm (max. 50 mm), folded over to the rear by approx. 30-40 mm and fed into the sewing machine. Performance test of bag material recommended	
<b>FBS29915A</b>	Same as FB29915A, but long parallel in-feed (II)	
<b>F29915A</b>	Same as FB29915A, but short version (V)	
<b>FS29915A</b>	Same as FBS29915A, but short version (II)	
<b>29926EU</b>	<b>Light barrier</b> , mounted below feeding chains to start the sewing machine	
<b>VN-FB29905A</b>	Long bag feed-in device (V)	
<b>VN-FBS29905A</b>	Long bag feed-in device (II)	
<b>VN-FB29910A</b>	Long bag feed-in device (V)	



**Bag Feed-In Devices with frequency controlled speed for Automatic Bag Closing Machines BC200 and 80800 Series**

Style	Description	
<b>FB29920A</b>	<b>Combined bag feed-in and trimming device, long V-type bag in-feed (V).</b> For machine styles BC211KA12-1M, 80800TALM. Speed 9-14 m/min. The paper or HDPE-foil bag top is trimmed approx. 20 mm (max. 90 mm). Taped after sewing. Without tape folder. Performance test of bag material recommended	
<b>FBS29920A</b>	Same as FB29920A, but long <u>parallel bag in-feed (II)</u>	
<b>F29920A</b>	Same as FB29920A, but short version (V)	
<b>FS29920A</b>	Same as FBS29920A, but short version (II)	
29926EO	<b>Light barrier</b> , mounted above feeding chains to start the sewing machine	



## **Bag Feed-In Devices for Automatic Bag Closing Machines BC200 and 80800 Series**

### **Common Specification:**

Rubber coated conveying chains to protect the bag material.  
Standard voltage for gear motor: 220-240, 380-415 V, 3-phase, 50 Hz, 243-277, 420-480 V, 3-phase, 60 Hz

*Degree of protection: IP 55. Insulation class: F*

**Painting: RAL 9002, powder coated**

Delivery includes pre-feeler switch 29926A to start the sewing machine  
Extra charge for other voltages and frequencies see page 34

<b>Style</b>	<b>Description</b>	
<b>GB29905G</b>	<b>Bag feed-in device.</b> For machine styles BC211P12-1M, -1A, -1B, BC291P12-1M, -1A, -1B, BC291U14-1M, 80800RLM, RL, RLB, SLM, SL, SLB. The spread paper, HDPE-foil or woven PP bag is fed into the sewing machine. Feed-in speed 11 - 23 m/min. at 50 Hz. Depending on the length and filling height of the bag, the seam can be adjusted to a depth of up to 120 mm from the top of the bag, standard setting 30-40 mm.	
<b>GBR29905G</b>	Same as GB29905G, but speed 9 - 16 m/min. at 50 Hz	
<b>G29905G</b>	Same as GB29905G, but short version	
<b>GR29905G</b>	Same as GBR29905G, but short version	
<b>GRS29905G</b>	Same as GBR29905G, but short version and parallel in-feed	
29926EO	<b>Light barrier</b> , mounted above feeding chains to start the sewing machine	
93051R	<b>New Bag-top fold-over device</b> to fold the bag-top to the rear. Assembling to the bag feed-in devices GB29905G, GBR 29905 G required. For all kinds of self-supporting bags. Performance test of bag material recommended	
<b>GB29910G</b>	<b>Combined bag feed-in, trimming and taping device</b> with crepe tape folder. For machine styles BC211UA14-1M, 80800UJALM, UAL, UALB. Width of tape not adjustable. Folder available for 50, 55 and 60 mm wide tapes. Please specify when ordering, standard width 60 mm. Feed-in speed 11 - 23 m/min. at 50 Hz. The paper or HDPE-foil bag top is trimmed approx. 20 mm (max. 90 mm). Taped before sewing. Performance test of bag material recommended	
	Extra charge for other voltages and frequencies.	
	Extra charge for crepe tape control.	
	Extra charge for thread break detector.	
<b>GBR29910G</b>	Same as GB29910G, but speed 9 - 16 m/min. at 50 Hz	
<b>G29910G</b>	Same as GB29910G, but short version	
<b>GR29910G</b>	Same as GB29910G, but speed 9 - 16 m/min. at 50 Hz and short version	

Style	Description	
GB29915G	<p><b>Combined bag feed-in, trimming and folding device.</b> For machine styles BC211P12-1M, -1A, -1B, BC291P12-1M, -1A, -1B, 80800RLM, RL, RLB, SLM, SL, SLB. Feed-in speed 11 - 23 m/min. at 50 Hz and short version</p> <p>The paper or HDPE-foil bag top is trimmed approx. 20 mm (max. 50 mm), folded over to the rear by approx. 30-40 mm and fed into the sewing machine.</p> <p>Performance test of bag material recommended.</p>	
GBR29915G	Same as GB29915G, but speed 9 - 16 m/min. at 50 Hz	
29926EU	Light barrier, mounted below feeding chains to start the sewing machine	
GBR29920G	<p><b>Combined bag feed-in and trimming device.</b> For machine styles BC211KA12-1M, 80800TALM, TAL, TALB. Feed-in speed 9-12 m/min. at 50 Hz.</p> <p>The paper or HDPE-foil bag top is trimmed approx. 20 mm (max. 90 mm). Taped after sewing. Without tape folder.</p> <p>Performance test of bag material recommended.</p>	
29926EO	<b>Light barrier</b> , mounted above feeding chains to start the sewing machine	



## Columns 20600 for Bag Closing Machines

### BC200 and 80800 Series

#### Specification:

Square telescopic columns for bag closing machines BC200 and 80800 series

Manual height adjustment 700 - 1350 mm, infinitely variable 300 mm

in connection with conveyors (price without sewing machine and conveyor)

Standard voltage for motors: 220-240, 380-415 V, 3-phase, 50 Hz / 243-277, 420-480 V, 3-phase, 60 Hz

Standard control voltage: 24 V DC

Degree of protection: IP 55. Insulation class: F

Painting: RAL 9002

#### Single-head columns, manually height adjustable

Style	Description	
<b>20600AE</b>	Without control box, motor and filter regulator kit	
<b>20600BEBC</b>	With simplified electrical equipment, 3-phase motor, motor protection switch and foot switch. For BC211P01-1, BC291P01-1, 80800C, D standard bag closing machines	
29926CB	Conveyor controls with foot switch (extra charge)	
<b>20600EEBC</b>	With control box, foot switch for sewing machine and three-phase motor. For BC211P01-1, BC291P01-1, 80800C, D standard bag closing machines	
29926CE	Conveyor controls with foot switch (extra charge)	
<b>20600FEBC</b>	With control box, filter regulator kit 29916PP and brake motor. For BC200 and 80800 automatic bag closing machines	
29926CM	Conveyor controls with foot switch (extra charge)	
<b>20600HEBC</b>	With control box for feed-in device, filter regulator kit and brake motor. For BC200 and 80800 automatic bag closing machines and feed-in devices	
29926CM	Conveyor controls with foot switch (extra charge)	
93065BF	Kit of parts for filler cord or thread cone (to extend the thread stand)	
20401F	Movable base	
20401M	Stationary base (recommended when column base is not fixed to the floor)	

## **Columns 20600 for Bag Closing Machines BC200 and 80800 Series**

**Specification:**

**Round telescopic columns** for bag closing machines BC200 and 80800 series

Height adjustment 725 - 1400 mm, infinitely variable  
in connection with conveyors (price without sewing machine and conveyor)

Standard voltage for motors: 220-240, 380-415 V, 3 phase, 50 Hz /  
243-277, 420-480 V, 3 phase, 60 Hz

Standard control voltage: 24 V DC

Degree of protection: IP 55. Insulation class: F

Painting: RAL 9002

### **Single-head columns, manually height adjustable**

Style	Description	
<b>20600A</b>	Without control box, motor and filter regulator kit	
<b>20600BBC</b>	With simplified electrical equipment, three-phase motor, motor protection switch and foot switch. For BC211P01-1, BC291P01-1, 80800C, D standard bag closing machines	
29926CB	Conveyor controls with foot switch (extra charge)	
<b>20600EBC</b>	With control box, foot switch for sewing machine and three-phase motor. For BC211P01-1, BC291P01-1, 80800C, D standard bag closing machines	
29926CE	Conveyor controls with foot switch (extra charge)	
<b>20600FBC</b>	With control box, filter regulator kit 29916PP and brake motor. For BC200 and 80800 automatic bag closing machines	
29926CM	Conveyor controls with foot switch (extra charge)	
<b>20600HBC</b>	With control box for feed-in device, filter regulator kit and brake motor. For BC200 and 80800 automatic bag closing machines and feed-in devices	
29926CM	Conveyor controls with foot switch (extra charge)	
93065BF	Kit of parts for filler cord or thread cone (to extend the thread stand)	
20401F	Movable base	
20401M	Stationary base (recommended when column base is not fixed to the floor)	

## Double-head columns, manually height adjustable

20600HDBC	Same as 20600FBC or HBC (depending on order) For two automatic bag closing machines BC200 and 80800 Special version for standard bag closing machines available	
29926CM	Conveyor controls with foot switch (extra charge)	
93065BF	Kit of parts for filler cord or thread cone (to extend the thread stand) Two kits required (per kit € 107,15)	
20401F	Movable base	
20401M	Stationary base (recommended when column base is not fixed to the floor)	

## **Columns 20600 for Bag Closing Machines**

### **Single-head column, motor-driven height adjustable**

Style	Description	
<b>20600TBC</b>	With control box, filter regulator kit 29916PP and brake motor. For BC200 and 80800 automatic bag closing machines	
29926CM	Conveyor controls with foot switch (extra charge)	
93065BF	Kit of parts for filler cord or thread cone (to extend the thread stand)	
20401F	Movable base	
20401M	Stationary base (recommended when column base is not fixed to the floor)	

### **Double-head column, motor-driven height adjustable**

<b>20600TDBC</b>	Same as 20600TBC For two BC200 and 80800 automatic bag closing machines	
29926CM	Conveyor controls with foot switch (extra charge)	
93065BF	Kit of parts for filler cord or thread cone (to extend the thread stand) <b>Two kits required</b> (per kit € 107,15)	
20401F	Movable base	
20401M	Stationary base (recommended when column base is not fixed to the floor)	

**Installation, supervision and training charges not included in our prices.**

**Please ask for the costs of a technician.**



## Chemical-proof Components

(stainless steel, No. 1.4571 (316Ti), except construction-related parts)

### Columns 20800 for styles BC200

**Description:**

Square telescopic column for High Performance Bag Closing Machines Styles BC200

manual height adjustment from 700 - 1350 mm, 300 mm range of continuous adjustment by crank handle  
 standard voltage for brake motors: 220-240 V, 380-415 V, three-phase, 50 Hz / 243-277 V, 420-480 V, three-phase, 60 Hz  
 standard current: 24 V DC

protection class: IP55, insulation class: F

material group: 1.4571 (316Ti)

**Single-head column, continuous height adjustable by crank handle**

Style	Description	
<b>20800HEBC-M</b>	With control box for bag feed-in device filter regulator VV-29916PP For BC200 automatic bag-closing machines	
29926CM	Conveyor controls with foot switch (extra charge)	
<b>VV-20401F</b>	Movable base	
<b>VV-FB29905A</b>	<b>Frequency-controlled bag feed-in device, long V-shaped in-feed (V)</b> applicable with column 20800HEBC-M feeding speed 9 - 23 m/min. Depending on length and filling height of bag the seam can only be placed 120 mm max. from the top of the bag, usually approx. 30-40 mm	
<b>VV-FS29905A</b>	Same as VV-FB29905A, but short version with <u>parallel chain in-feed (II)</u>	
<b>VV-29926EU</b>	Optical sensor below feeding chains of the feed-in device, for pre-starting the machine	
<b>VV-29926NBC</b>	Needle cooling device	
<b>VV-93051FA</b>	Bag folder (to the back)	
<b>VV-998M28ABC</b>	Thread detector complete	





### **Thread Cones for BC200 and 80800 Series**

<b>Style</b>	<b>Description</b>	
Z1-124-1000WS	Thread cone, viscose, approx. 1 kg, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 50 cones per carton	
Z1-124-2500WS	Thread cone, viscose, approx. 2.5 kg, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 24 cones per carton	
Z1-124-4500WS	Thread cone, viscose, approx. 4.5 kg, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 9 cones per carton	
Z1-124-7500WS	Thread cone, viscose, approx. 7.5 kg, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 6 cones per carton	
Z1-204-1000WS	Thread cone, polyester, approx. 1 kg, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 50 cones per carton	
Z1-204-2500WS	Thread cone, polyester, approx. 2.5 kg, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 24 cones per carton	
Z1-204-2500BL	Thread cone, polyester, approx. 2.5 kg, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), blue, 24 cones per carton	
Z1-206-2500WS	Thread cone, polyester, approx. 2.5 kg, N <sub>e</sub> 12/6-ply (N <sub>m</sub> 20/6), white, 24 cones per carton	
Z1-204-4500WS	Thread cone, polyester, approx. 4.5 kg, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 9 cones per carton	
Z1-204-7500WS	Thread cone, polyester, approx. 7.5 kg, N <sub>e</sub> 12/4-ply (N <sub>m</sub> 20/4), white, 6 cones per carton	

### **Filler Cord for BC200 and 80800 Series**

DF1-065-1000	Filler cord, approx. 1 kg, N <sub>m</sub> 0,65, grey, 48 cylindrical spools per carton	
DF1-065-3000	Filler cord, approx. 3 kg, N <sub>m</sub> 0,65, grey, 12 cylindrical spools per carton	
DK1-050-3000GRB	Filler cord, approx. 3 kg, N <sub>m</sub> 0,50, grey, 12 cones per carton	
DK1-050-3000WS	Filler cord, approx. 3 kg, N <sub>m</sub> 0,50, white, 12 cones per carton	

## Conveyors for BC200 and 80800 Series

### Common Specification:

Standard voltage for motors: 220-240, 380-415 V, 3 phase, 50 Hz / 243-277, 420-480 V, Drehstrom, 60 Hz

Degree of protection: IP 55. Insulation class: F

Driven by gear motor 0.55 kW (depending on conveyor length), chain drive covered by protective guard. On the rear a height and width adjustable bag-guide rail is mounted

The conveyor speed depends on the conditions at site and the desired production (7.2 / 9.5 / 12.5 / 14.3 / 16.5 and 18 m/min.)

Standard speed: 9.5 m/min.

Extra charge for other voltages and frequencies see page 35

Style	Description	
91605G...	<b>Belt-type conveyor</b> 91605G... (distance between shafts) The conveyor is equipped with a two-ply, oil-resistant belt. Belt width 400 mm. Total conveyor width 470 mm, across the motor 830 mm. Height of belt conveyor body 125 mm, adjustable ground clearance 140 to 200 mm. Total length: distance between shafts plus approx. 125 mm.	
91605G2.00	2.0 m distance between shafts	
91605G2.50	2.5 m distance between shafts	
91605G3.00	3.0 m distance between shafts	
91605G3.50	3.5 m distance between shafts	
91605G4.00	4.0 m distance between shafts	
91605G4.50	4.5 m distance between shafts	
91605G5.00	5.0 m distance between shafts	
91605G5.50	5.5 m distance between shafts	
91605G6.00	6.0 m distance between shafts	
	Extra charge for additional front bag guide rail up to 2.5 m	
	Each additional meter extra charge	
	Extra charge for movable version fitted with castors up to 3 m distance (longer distance on request)	
91605GF...AH	<b>Belt-type conveyor</b> 91605GF...AH movable, for mounting to a column, motor driven height adjustment 300 - 900 mm	
91605GF2.50AH	2.5 m distance between shafts	

## Conveyors for BC200 and 80800 Series

Style	Description	
91605L...	<b>Slat-type conveyor 91605L...</b> (distance between shafts) The conveyor is equipped with 400 mm long, 70 mm wide and 20 mm thick wooden slats. The gap between the slats is 30 mm. Total conveyor width 605 mm, across the motor 1000 mm. Height of conveyor body 330 mm, adjustable ground clearance 140 to 200 mm. Total length: distance between shafts plus approx. 480 mm.	
91605L2.50	2.5 m distance between shafts	
91605L3.00	3.0 m distance between shafts	
91605L3.50	3.5 m distance between shafts	
91605L4.00	4.0 m distance between shafts	
91605L4.50	4.5 m distance between shafts	
91605L5.00	5.0 m distance between shafts	
91605L5.50	5.5 m distance between shafts	
91605L6.00	6.0 m distance between shafts	
	Extra charge for additional front bag guide rail up to 2.5 m	
	Each additional meter extra charge	
	Extra charge for movable version fitted with castors up to 3 m distance (longer distance on request)	

**Further height-adjustable belt and slat type conveyors are also available.**

**Prices on request.**

**Installation, supervision and training charges not included in our prices.**

**Please ask for the costs of a technician.**

## Label Dispenser for individual paper labels



### Common Specification:

20680AET1V: labels sewn to front

20680AET1H: labels sewn to back

Dimensions of labels: min. height: 80 mm

max. height: 160 mm

min. width: 80 mm

Capacity: 20 labels/min.

Capacity of the label dispenser: up to 300 pieces (depending on thickness of paper)

Standard voltage: 230 V AC

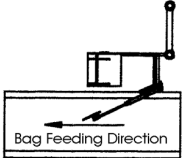
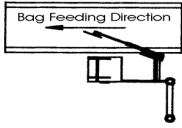
Pneumatic operating pressure: 6 bar

Width of dispenser: approx. 800 mm

Weight: 35 kg

**APTITUDE TEST OF LABELS ESSENTIAL!**

**ONLY APPLICABLE WITH LONG FEED-IN DEVICES!**

Style	Description	
20680AET1H		
20680AET1V		



**Mineral Oil and Grease available for:**

**Portable Bag Closing Machines  
Series 2000, 2200, 3000, 4000**

**Bag Making and Closing Machines  
Series 80000**

**Oil**

Part No.	Description	
G28604L	Mineral oil (UNSP Spec. 86) 0,5 l	
G28604L5	Mineral oil (UNSP Spec. 86) 5.0 l	

**Grease**

999-253	Grease, 25 g tube	
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**Bag Making Machines  
Series BM100, 39500, 53000, 56000**

**Bag Closing Machines  
Series BC100, BC200**

**Oil**

28604U	Mineral oil (UNSP Spec. 175) 0,5 l	
28604V	Mineral oil (UNSP Spec. 175) 5.0 l	

**White Mineral Oil for Food-Processing Industry**

28604UW	White mineral oil, 0.5 l Meets the following international standards: DAB 1996 and FDA (Regulations 21 CFR 172.878 and 21 CFR 178.3620 (A))	
28604VW	White mineral oil, 5,0 l Meets the following international standards: DAB 1996 and FDA (Regulations 21 CFR 178.878 and 21 CFR 178.3620 (A))	

**Chain Fluid heavy for Bag Feed-in-Device**

28604KE	Chain fluid Heavy, 0,5 l	
	Meets the following international standards: FDA (Regulations 21 CFR 178.3570)	

**Grease**

999-114G	Sealing grease, 100 g can	
----------	---------------------------	--

Union Special GmbH  
Raiffeisenstr.. 3  
D-71696 Möglingen  
Tel.: 07141/247-0, Fax: 07141/247-100  
[www.unionspecial.de](http://www.unionspecial.de)

## Product Specification - Technical Data Sheet

Description of article:	Ne 12/4 bag closing thread
Raw material:	100 % Viscose
Color:	raw white
Make-up:	for portable bag closers cones approx. 200 g for bag closing units cones approx. 1 kg, 2.5 kg, 4.5 kg and 7.5 kg, precision winding, knotless.
Running length:	in theory: 5.000 m/kg effective, dry: approx. 4.500 m/kg
Strength:	approx. 3,600 g

## Product Specification - Technical Data Sheet

Description of article:	Ne 12/4 bag closing thread
Raw material:	100 % Polyester
Color:	raw white
Make-up:	for portable bag closers cones approx. 200 g for bag closing units cones approx. 1 kg, 2.5 kg, 4.5 kg and 7.5 kg, precision winding, knotless.
Running length:	in theory: 5.000 m/kg effective, dry: approx. 4.500 m/kg
Strength:	approx. 7,000 g
Heat resistance:	softening point ~ 230 - 240° C                      melting point ~ 250 - 260° C

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## Thread Consumption on Bag Closing Sewing Heads

based on a stitch length of 8 mm

### Stitch Type 401 (two-thread double locked chainstitch)

#### 3-ply paper bag

40 cm width and  
2 x 3 cm long chain

Consumption per bag:  
2.30 m = 0,51 g

With **1 kg of thread**  
approx. **1950 bags** can  
be closed.

#### 5-ply pape bag

50 cm width and  
2 x 5 cm long chain

Consumption per bag:  
3.00 m = 0,66 g

With **1 kg of thread**  
approx. **1500 bags** can  
be closed.

#### Jute bag

55 cm width and  
2 x 3 cm long chain

Consumption per bag:  
3.05 m = 0,67 g

With **1 kg of thread**  
approx. **1450 bags** can  
be closed.

### Stitch Type 101 (single-thread chainstitch)

#### 3-ply paper bag

40 cm width and  
2 x 3 cm long chain

Consumption per bag:  
1.74 m = 0,38 g

With **1 kg of thread**  
approx. **2600 bags** can  
be closed.

#### 5-ply pape bag

50 cm width and  
2 x 5 cm long chain

Consumption per bag:  
2.28 m = 0,50 g

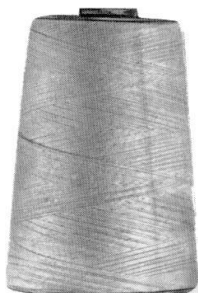
With **1 kg of thread**  
approx. **2000 bags** can  
be closed.

#### Jute bag

55 cm width and  
2 x 3 cm long chain

Consumption per bag:  
2.31 m = 0,51 g

With **1 kg of thread**  
approx. **1950 bags** can  
be closed.

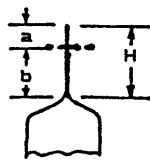



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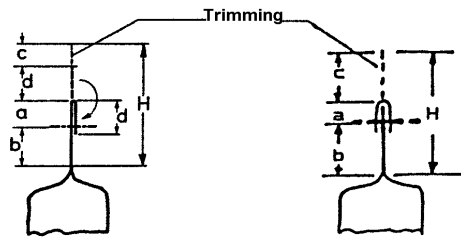
Union Special GmbH  
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## Bag Sizes related to Sewing Machine used

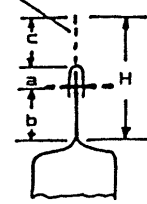
### Types of Closure



1. Plain Closure



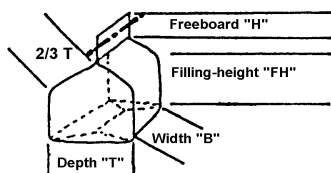
2. Fold-over Closure



3. Fold-over Tape Closure

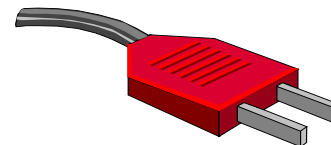
Sewing Machine BC211, BC291	Sewing Machine 80800	Closure	a mm	b mm	c mm	d mm	H (min)
P01-1	C, D	1	20-150	45	-	-	65
P12-1M, -1A, -1B UD16-2M	R,RL,RLB,RLM, S,SL,SLB,SLM	1	20-150	45	-	-	65
P12-1M, -1A, -1B, with bag feed-in device FB29905A, GB29905G or GBR29905G	R,RL,RLB,RLM, S,SL,SLB,SLM with bag feed- in device FB29905A or GBR29905G	1	20-120	90	-	-	110
P12-1M, -1A, -1B UD16-2M with short bag feed-in device F29905A, G29905G or GR29905G	R,RL,RLB,RLM, S,SL,SLB,SLM with short bag feed-in device GR29905G	1	20-120	50	-	-	70
P12-1M, -1A, -1B with bag feed-in device FB29905A, GB29905G or GBR29905G and bag top fold-over device 93051FA	R,RL,RLB,RLM, S,SL,SLB,SLM with bag feed-in device FB29905A or GBR29905G, and bag top fold-over device 93051FA	2	20	90	-	35	145
P12-1M, -1A, -1B with bag feed-in, trimming and fold-over device FB29915A, GB29915G or GBR29915G	R,RL,RLB,RLM, S,SL,SLB,SLM with bag feed-in, trimming and fold-over device FB29915A or GBR29915G	2	20	90	10-50	35	155
U14-1M	U, UL, ULM	3	20	45	-	-	65
UA14-1M with bag feed-in, trimming and taping device FB2910A, GB29910G or GBR29910G	UA, UAL, UALM, with bag feed-in, trimming, taping and tape-over device FB29910A or GBR29910G	3	20	90	10-90	-	120
K14-1M	TL	3	20	45	-	-	65
KA14-1M with bag feed-in and trimming device FB29920A or GBR29920G	TAL, with bag feed-in and trimming device FB29920A or GBR29920G	3	20	90	10-90	-	120

### Determination of the Bag Size



The necessary bag size results from the required volume (determined by the specific weight of the filling product), the slant range ( $2/3$  of the depth "T"), and the freeboard "H" from the chart above.

# Alternate Voltages and Frequencies



## Columns 20600

	Control Box	Motors			
	Control Voltage	Voltage / 3-phase	Frequency	Degree of Protection	Tropical Insulation
<b>Standard</b>	for <b>BC200 and 80800 series:</b> 24 V DC	220-240, 380-415V 243-277, 420-480V	50 Hz 60 Hz	IP55	"Standard" F
<b>Special Version</b>  20600BEBC, BBC 20600EEBC, EBC 20600FEBC, FBC 20600HEBC, HBC 20600TBC 20600HDBC 20600TDBC	for <b>BC200 and 80800 series :</b> 230 V, 50/60 Hz, 110-120 V. 50/60 Hz	other voltage and/or frequency		IP65 on request	"increased"

### Bag feed-in device and conveyor motors

	Voltage / 3-phase	Frequency	Degree of Protection	Tropical Insulation
<b>Standard only F29900</b>	220-240 V, single-phase	50/60 Hz	IP55	"Standard" F
<b>Standard G29900</b>	220-240, 380-415 V 243-277, 420-480V	50 Hz 60 Hz	IP55	"Standard" F
<b>Special Version G29900</b>	other voltage and/or frequency		IP65 on request	"increased"
Bag feed-in device				
Conveyor				

#### Example:

##### Column 20600HBC

- Control voltage: 230 V, 60 Hz
- Brake motor: 220/440 V, 60 Hz

##### Bag feed-in device G29900

- Gear motor: 220/440 V, 60 Hz

##### Conveyor

- Gear motor: 220/440 V, 60 Hz