



## Miza company for Import and Export.

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مكتبه خريطة ميرة ليبيا - طرابلس - رقم الهاتف\_01: 091733319 - رقم الهاتف\_02: 0913103162 - رقم الهاتف\_03: 0923103162

Address: Al-Masira Al-Kubra Street / Opposite Al-Jumhouria Bank - Tripoli (Libya)

العنوان: خارج المصيرة الشري / مقابل مصرف الجمهورية - طرابلس (ليبيا)

values. It consists of two reel-holding spindles, a splicer and a material reserve.

该单元用于材料放卷，经过低和恒张力控制的设计，可设定值。它由两个料架，一个接料装置和材料备用组成。

### Technical specifications: 技术参数

- Reel max weight 料架最大载重 : 150KG
- Reel max diameter 材料最大外径: 800mm
- Reel inside diameter 卷内径: 76 mm or 3 inch

### Main features are as follows 主要特点

- **Equip with raw material loading guide rail** 配有原料接料导轨



شركة ميرة للإستيراد والتصدير  
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Double swing lever Proportional Valve tension control 双摆杆式张力控制

➤ **2 Pneumatic spindles.** 双气涨轴料架

For alternative uses, it can realize splicing at zero speed, both automatic and manual splicing is available

A-B 双气涨轴料架备用，可实现 0 降速自动接料，手动和自动接料都可实现。

➤ **Servo Motors Drive Two Pneumatic spindles.** 伺服电机控制放卷，双气涨轴料架

➤ **1 splicer** 接料装置

Automatic splice , when one roll is finish, connect automatically .

自动接料，当一卷用完时，自动接料。

➤ **Automatic web guide controller (No. 5 , width : 300mm)**

自动纠偏装置 5，宽度 300mm

➤ **Material presence detector** 材料检测

Two spindles applied Auto alarm and stop machine when raw material broken

两个料架都配备材料检测，断料自动报警停机

Raw material middle joint detection, auto defect rejection

材料中间接头检测，自动剔废

➤ **PE film with Position Cutting Function** 底膜带定位切功能

**Cloth like backsheet lamination online** 布质底膜在线复合

There are two sets raw material spindles. One is nonwoven other is PE film. Also have a glue gun for lamination ,web guider system and auto material splice. When the cloth like backsheet lamination online will connet the backsheet application.

**Backsheet Non Woven Passive Unwinding** 底膜无纺布放卷

**Nonwoven Part Technical specifications:** 无纺布技术参数

Reel max weight 料架最大载重 : 150KG

Reel max diameter 材料最大外径: 800mm

Reel inside diameter 卷内径: 76 mm or 3 inch

**Nonwoven Part Main features are as follows** 无纺布主要特点

**Equip with raw material loading guide rail** 配有原料接料导轨



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Double swing lever Proportional Valve tension control 双摆杆式张力控制

## 2 Pneumatic spindles. 双气涨轴料架

For alternative uses, it can realize splicing at zero speed, both automatic and manual splicing is available

A-B 双气涨轴料架备用，可实现 0 降速自动接料，手动和自动接料都可实现。

**Servo Motors Drive Two Pneumatic spindles.** 伺服电机控制放卷，双气涨轴料架

1 Automatic splice , when one roll is finish, connect automatically .

一套自动接料，当一卷用完时，自动接料。

**Automatic web guide controller (No. 6 , width : 250mm)** 自动纠偏装置 6，宽度 250mm

## Material presence detector 材料检测

Two spindles applied Auto alarm and stop machine when raw material broken

两个料架都配备材料检测，断料自动报警停机

Raw material middle joint detection, auto defect rejection 材料中接头检测，自动剔废

## **Backsheet PE Film Passive Unwinding** 底膜无纺布放卷

### PE Film Part Technical specifications: PE 膜技术参数

Reel max weight 料架最大载重 : 150KG

Reel max diameter 材料最大外径: 600mm

Reel inside diameter 卷内径: 76 mm or 3 inch

### PE Film Part Main features are as follows PE 膜主要特点

**Equip with raw material loading guide rail** 配有原料接料导轨

Double swing lever Proportional Valve tension control 双摆杆式张力控制

## 2 Pneumatic spindles. 双气涨轴料架

For alternative uses, it can realize splicing at zero speed, both automatic and manual splicing is available

A-B 双气涨轴料架备用，可实现 0 降速自动接料，手动和自动接料都可实现。

**Servo Motors Drive Two Pneumatic spindles.** 伺服电机控制放卷，双气涨轴料架

1 Automatic splice , when one roll is finish, connect automatically .

一套自动接料，当一卷用完时，自动接料。

**Automatic web guide controller (No. 7, width:380mm)** 自动纠偏装置 7，宽度 380mm



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## Material presence detector 材料检测

Two spindles applied Auto alarm and stop machine when raw material broken

两个料架都配备材料检测，断料自动报警停机

Raw material middle joint detection, auto defect rejection 材料中间接头检测，自动剔除

## Leg elastic applicator 腿部橡筋供给

- Right & left with 4 pieces separate 左右各 4 条
- The roll elastic is available 可用卷料橡筋
- Active feeding, servo control, the elastic tension degree can be set on touch screen  
主动送料，伺服控制，橡筋的松紧度可在触摸屏上设定

## Leg elastics pressing and sealing 腿部橡筋压实和密封

A roll press and seals the elastics area. 辊压机和密封弹性的部分。

## Frontal Tape applicator 前腰贴供给

The unit is designed to apply the frontal tape or the belt product on the diaper.

该单元被设计讲前腰贴添加到尿布上

It consists of an unwinder unit for the raw material and the cut and place applicator .

它包含一个原材料放卷装置，以及分切和放置的装置。

- Reels unwind stand (two reels location), Auto Alarming after the remainder detecting  
放卷料架 (可放两卷)，检测残余后自动报警
- Feeding roll ( Passive unwinding ) 进料辊 (被动放卷)
- Vacuum roll (anvil) 真空辊 (砧座)
- Knife roll 刀辊
- Transfer vacuum roll 真空辊
- Gear phase 齿轮调相
- Supports and frames. 支架和框架
- Missing detecting and auto rejecting 缺失检测和自动剔除
- **Servo Motor Drive (With Position Cutting) Mitsubishi** 伺服电机驱动 (位置切割)

**Use the photocell to detect the color mark on the raw material , then position cutting base on the color mark.** 利用光电检测原料上的颜色标记，然后根据颜色标记进行位置切割。





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## **Pulling system** 拉动系统

Unit consisting of an upper roll in silicon rubber and two lower steel rolls.

包含一个在硅橡胶和两个较低的钢辊上的上辊

## **Hot melt application** 热熔胶供给

- Back sheet : Continuous coating. 底膜: 连续涂胶
- ELASTICS: Intermittent spray. 橡筋: 间歇喷胶



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## C. TOP SHEET CONSTRUCTION 面层构造

### Top Non Woven applicator section 表层无纺布供给

The unit has been engineered to unwind the material at a low and constant tension, with settable values. It consists of two reel-holding spindles, a zero-speed splicer and a material reserve.

该单元用于材料放卷，经过低和恒张力控制的设计，可设定值。它由两个料架，一个 0 速接料装置和材料备用组成。

#### Technical specifications: 技术参数

- Reel max weight 料架最大载重 : 150KG
- Reel max diameter 材料最大直径: 800mm
- Reel inside diameter 卷内径: 76 mm or 3 inch

#### Main features are as follows 主要特点:

- **Equip with raw material loading guide rail** 配有原料接料导轨  
Double swing lever Proportional Valve tension control 双摆杆式张力控制
- **2 Pneumatic spindles.** 双气涨轴料架  
For alternative uses, it can realize splicing at zero speed, both automatic and manual splicing is available  
A-B 双气涨轴料架备用，可实现 0 降速自动接料，手动和自动接料都可实现
- **Servo Motors drive Two Pneumatic spindles.** 伺服驱动控制放卷，双气涨轴料架
- **1 splicer** 接料装置  
Automatic splice , when one roll is finish, connect automatically :  
自动接料，当一卷用完时，自动接料
- **Automatic web guide controller(No.8 , width: 250mm)** 自动纠偏装置 8, 宽度 250mm
- **Material presence detector** 材料检测  
Two spindles applied Auto alarm and stop machine when raw material broken  
两个料架都配备材料检测，断料自动报警停机  
Raw material middle joint detection, auto defect rejection 材料中间接头检测，自动剔废

### Standing Leakage Cuff Applicator 立体护围供给

Complete unit, capable to apply two elasticized leg cuffs on the Nonwoven. The unit consists of and



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unwinding section, cutting device which cut the raw material in two identical narrow strip and the applicator unit which applies them onto the top sheet.

这是一个完整的过程，能够添加两弹性腿围在无纺布上。该装置由放卷装置，能够分切两个相同窄条原材料的切割装置，以及将腿围涂胶在无纺布上

## 1) Unwinding Section Device (Hydrophobic Non woven Supply)

放卷装置（拒水无纺布供给）

Unit composed with an unwinding section with of two non woven unwinding shafts one running while the other one is in stand-by. Automatic guiding system installed. Automatic splice “zero speed” type .

一个放卷装置配两个无纺布轴组成，一个运转，而另一个备用。自动纠偏装置。实现零速自动接料。

### Technical specifications: 技术参数

- Reel max weight 料架最大载重 : 100KG
- Reel max diameter 材料最大直径: 800mm
- Reel inside diameter 卷内径: 76 mm or 3 inch

### Main features are as follows 主要特点

- **Equip with raw material loading guide rail** 配有原料接料导轨  
Double swing lever Proportional Valve tension control 双摆杆式张力控制
- **2 Pneumatic spindles.** 双气涨轴料架  
For alternative uses, it can realize splicing at zero speed, both automatic and manual splicing is available  
A-B 双气涨轴料架备用，可实现 0 降速自动接料，手动和自动接料都可实现
- **Servo motors Drive Two Pneumatic spindles.** 伺服电机驱动控制放卷，双气涨轴料架
- **1 splicer** 接料装置  
Automatic splice , when one roll is finish, connect automatically .  
自动接料，当一卷用完时，自动接料
- **Before Slitting -Automatic web guide controller (No.9 , width : 300mm)**  
分切前自动纠偏装置 9, 宽度 300mm
- **Material presence detector** 材料检测  
Two spindles applied Auto alarm and stop machine when raw material broken



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两个料架都配备材料检测，断料自动报警停机

Raw material middle joint detection, auto defect rejection

材料中间接头检测，自动剔废

## 2) Middle Cutting Device 对分切装置

➤ Adopt the electric slitting unit. 采用电动机分切机构

➤ Longitudinal rotary knife to slit the non-woven band into two separate bands.

纵向的旋转刀片将无纺布分切成两条

➤ **After slitting-2 Automatic web guide controller (No.10 & No.11 Width:180mm)**

分切后 2 套自动纠偏装置 10/11, 宽度 180mm

Elastic guiding and stretching device for Spooled elastic material.

用于弹性材料的弹性纠偏和拉伸装置。

Two automatic guiding systems installed before the gluing of the elastic and the folding of the cuff edge.

两台纠偏器安装在橡筋喷胶和折边前。

## 3) Cuff Elastic application 立体护围橡筋施加

➤ Apply 2 Cuff Elastics for both sides separately 左右各 2 条。

➤ **Servo control**, the elastic tension degree can be set on the touch screen directly

主动送料，伺服控制，橡筋的松紧度可在触摸屏上设定。

## 4) Folding System 折边系统

➤ Fold the the cuff edge over the elastic thread.Auxiliary adhesive unit 拒水布折边、橡筋复合装置

## 5) Glue system for Leakage Cuff: 立体护围涂胶系统

Glue system in order to perform the following applications: 喷胶系统是为了实现以下的应用:

➤ Continuous gluing of the leg cuffs for fixation to the web. 连续涂胶腿围，为了固定无纺布。

➤ Intermittent gluing of the leg cuffs for fixation at the ends of the diaper.

间歇涂胶腿围，为了固定尿布的两端。

➤ Intermittent gluing of elastics. 间歇涂胶弹性橡筋





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## D. DIAPER ASSEMBLY AND FINISHING 尿裤的复合和完成

In this section the back sheet, the cores and the top sheet are assembled together in order to produce a continuous web of diapers.

这一过程复合了底膜，芯体和表层，尿裤成型。

An end seal unit consisting in two rolls, one upper rubber coated roll and one bottom steel roll, presses both materials, back sheet and top sheet, in each diaper ends in order to fix perfectly these ones by means the applied glue.

### D1. Front Ear S Cut Non Woven applicator section 前端小耳朵 S 切无纺布供给部分

The unit has been engineered to unwind the material at a low and constant tension, with settable values. It consists of two reel-holding spindles, a zero-speed splicer and a material reserve.

这一部分被设计成底膜恒张力低速放卷，张力可设置，双气涨轴，不降速自动接料装置，张力储料

#### Technical specifications: 技术规格:

- Reel max weight 卷最大重量: 150KG
- Reel max diameter 卷最大直径: 800mm
- Reel inside diameter 卷内径: 76 mm or 3 inch

#### Main features are as follows

- **2 spindles.** 双料架 For alternative uses 双料架交替使用。
- **Before S cut, equip with one Automatic web guide controller**  
**S 切前 1 台自动纠偏装置(No.12, width 宽度 : 200mm )**
- **Material presence detector** 原材料检测  
Two spindles applied Auto alarm and stop machine when raw material broken  
原材料检测，断料，自动报警和停止运转机器
- 1) Middle S-shape Cutting Device S 切装置**
  - Longitudinal rotary knife to cut the PP non-woven into two separate bands.  
纵向旋转 S 切 PP 无纺布成 2 条
  - **Servo Motor Drive** 伺服驱动
  - **After S-cut, equip with 2 sets of Automatic web guiding controller(No.13&14 )**  
自动纠偏装置



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Two automatic guiding systems installed before front ear thermo bonding.

两台自动纠偏系统安装在后部耳朵热压粘合之前

## Front Ear S Cut short cut & transfer unit, apply to the diaper edge of back sheet

**S cut** 短切&转移装置，施加到尿裤底模边侧

- Surface layer, absorption layer, back sheet compound and compaction
- Front S cut thermo compression bonding (embossing) unit, surface layer, S cut Side tape, back sheet triple ply compaction S 切热压粘装置，面层，S 切左右贴，底模 3 层压实

## Elastic Ear S Cut Non Woven applicator section-弹性耳朵 S 切无纺布供给部分

The unit has been engineered to unwind the material at a low and constant tension, with settable values. It consists of two reel-holding spindles, a zero-speed splicer and a material reserve.

### Elastic Non woven Unwinding

#### Technical specifications: 技术规格:

- Reel max weight 卷最大重量 : 150KG
- Reel max diameter 卷最大直径: 800mm
- Reel inside diameter 卷内径: 76 mm or 3 inch

#### Main features are as follows 主要特点如下:

- **Equip with raw material loading guide rail** 配备材料上料导轨  
Double swing lever Proportional Valve tension control 双摆杆比例阀张力控制
- **2 Pneumatic spindles.** 双气涨轴  
For alternative uses, it can realize splicing at zero speed, both automatic and manual splicing is available 两气涨轴交替使用，零降速接料装置，自动收到接料都可以用
- **SERVO motors Drive Two Pneumatic spindles.**
- **1 splicer** 自动接料装置  
Automatic splice , when one roll is finish, connect automatically .  
自动接料，当一卷材料用完自动接料。
- **Automatic web guide controller** 自动纠偏装置(No.15 )



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## ➤ **Material presence detector** 原材料检测

Two spindles applied Auto alarm and stop machine when raw material broken

原材料检测，断料，自动报警和停止运转机器

Raw material middle joint detection, auto defect rejection 材料中间接头检测，自动剃废

## **Hook Unwinding** 魔术扣放卷

### ➤ **1 raw material stand , passive unwinding** , 单料架被动放卷

### ➤ **Before S cut -Automatic web guide controller** (No.16, width : 100mm)

S 切前自动纠偏装置 第 16 台，宽度 100mm

## **Combine Unit** 压合装置

### ➤ **Glue gun scrap glue onto back of Hook** 魔术扣背面刮胶

### ➤ **Laminate with S-cut Non woven** S 切无纺布和扣复合

### ➤ **Compress by Rubber roller** 胶辊压合

## **Elastic Ear S cut System** 弹性 S 切耳朵供给系统

### Technical specifications: 技术规格:

#### ➤ **Reel max weight** 卷最大重量 : 100KG

#### ➤ **Reel max diameter** 卷最大直径: 800mm

#### ➤ **Reel max width** 卷宽 : base on width of baby diaper 根据尿裤宽度

#### ➤ **Reel inside diameter** 卷内径: 76 mm or 3 inch

### Main features are as follows

#### ➤ **2 spindles.** 双料架 For alternative uses 双料架交替使用。

#### ➤ **Before S cut, equip with one Automatic web guide controller**

S 切前 1 台自动纠偏装置(No.17, width 宽度 : 200mm )

#### ➤ **Material presence detector** 原材料检测

Two spindles applied Auto alarm and stop machine when raw material broken

原材料检测，断料，自动报警和停止运转机器

## 2) **Middle S-shape Cutting Device** S 切装置



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- Longitudinal rotary knife to cut the PP non-woven into two separate bands.  
纵向旋转 S 切 PP 无纺布成 2 条
  - **Servo Motor Drive** 伺服驱动
  - **After S-cut, equip with 2 sets of Automatic** web guiding controller(No.18&19)  
自动纠偏装置  
Two automatic guiding systems installed before Back ear thermo bonding.  
两台自动纠偏系统安装在后部耳朵热压粘合之前
  - Elastic Ear S Cut short cut & transfer unit, apply to the diaper edge of back sheet**  
**S cut** 短切&转移装置，施加到尿裤底模边侧
  - Surface layer, absorption layer, back sheet compound and compaction  
面层，吸收层，底模复合压实
  - S cut thermo compression bonding (embossing) unit, surface layer, S cut Side tape, back sheet triple ply compaction S 切热压粘装置，面层，S 切左右贴，底模 3 层压实

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