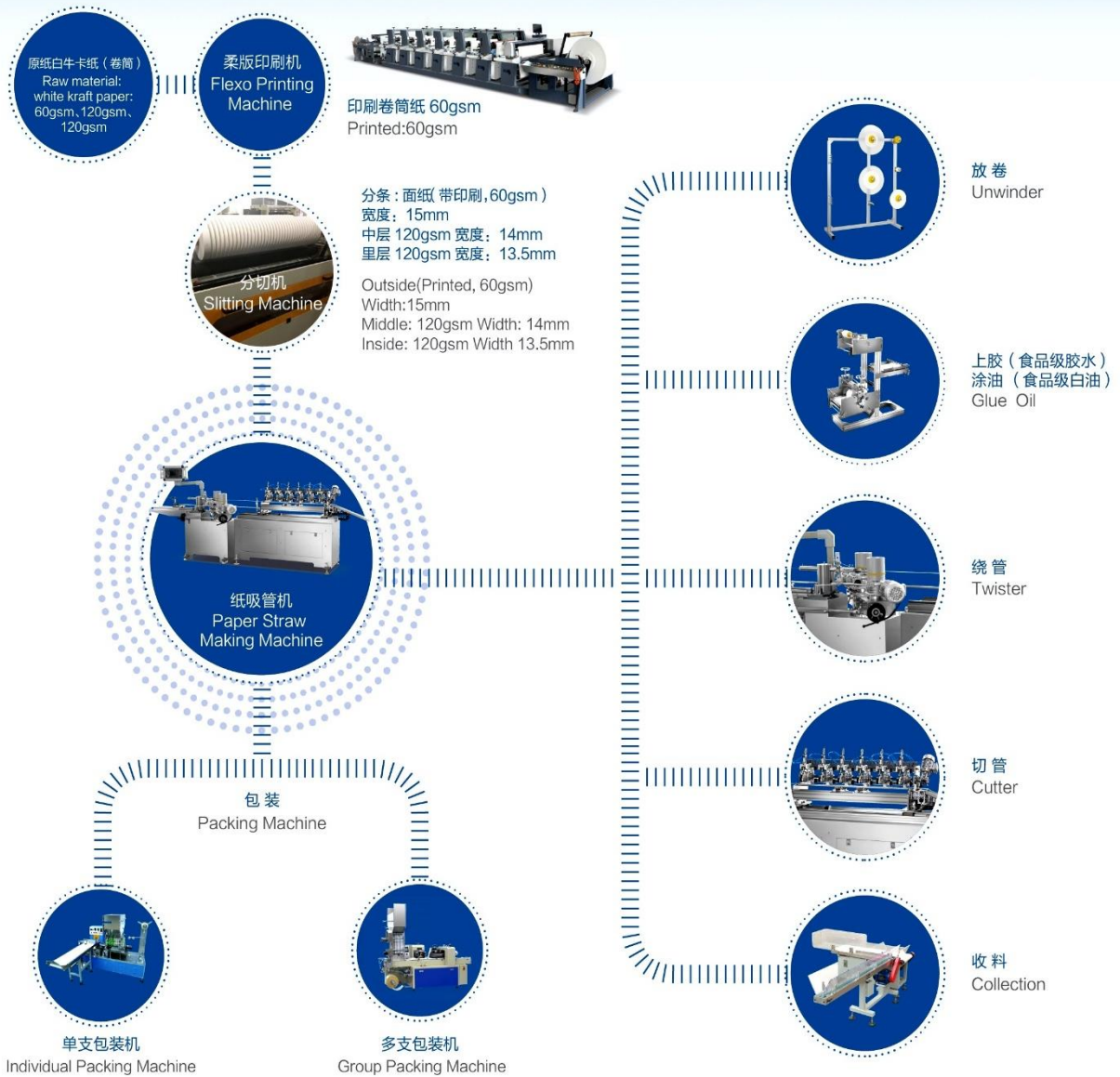


TECHNICAL DATA SHEET (TDS)

STRAW MAKING PROCESSING LINE

纸吸管生产工艺流程

Paper Straw Making Process



Note: The Flexo Printer is Optional. Smaller printer units are now available with most lines.



TECHNICAL DATA SHEET (TDS) STRAW MAKING PROCESSING LINE

Typically, three separate grades of paper are required for producing bio-degradable paper straws. These being;

- Surface (Exterior) Grade 60 gsm @ 15mm width
 - Medium Layer 120 gsm @ 14mm width
 - Inner Layer 120 gsm @ 13.5mm width
-
- Packaging (Grade) 32 gsm (Optional)



Upon request, NMFC may arrange the acquisition of pre-cut rolls to be delivered with the line for immediate production upon delivery.

Buyer can take a one-time delivery of an unspecified tonnage count or multiple delivery ranging from six months to up to a 12 months period or less, while the converter he/she secures an in-country supplier.



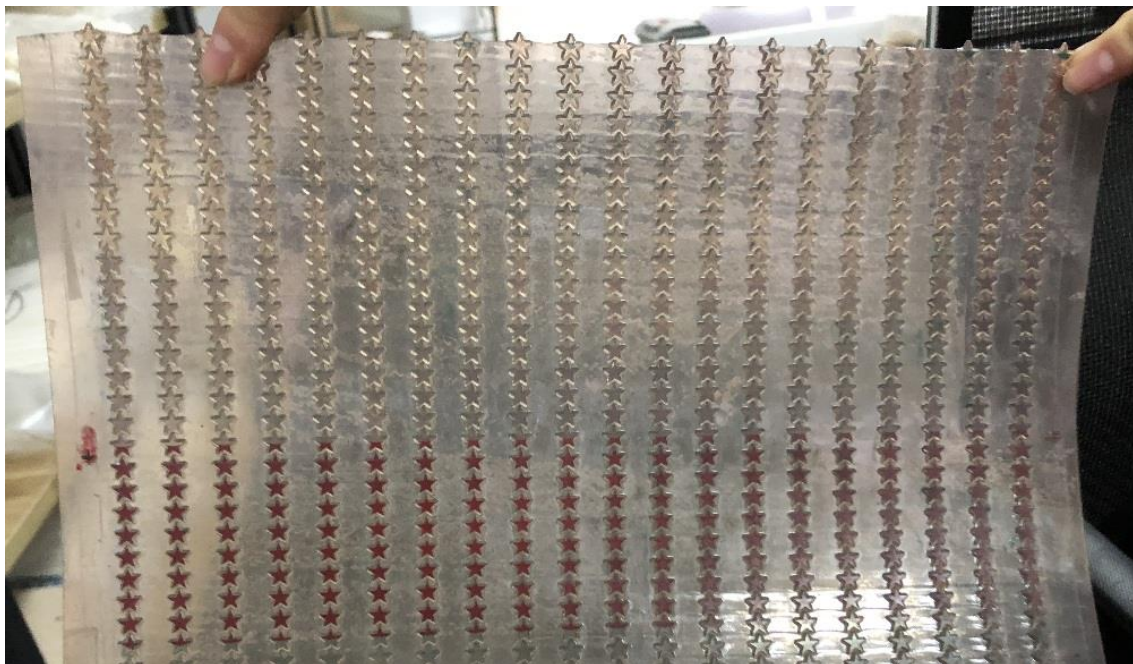
TECHNICAL DATA SHEET (TDS) STRAW MAKING PROCESSING LINE

Typically, separate principal sections that are needed to be acquired and then configured to meet the daily production of paper straws. Typically, for the production of paper straws, these basic components are needed;

1. Slitter Rewinder Section with Basic Unwind Stand(s)
2. Paper Straw Making Machine (various models)
3. Single (or 2) Color Printing Unit
4. High Speed Synchronized Cutting Machine (6 Cut Standard)
5. Custom Sized Conveyance (to meet the daily production)
6. Sorting Hopper
7. Packaging (option for individual or 100~500 pc ct. packing)

When purchased with a printing unit, the client must purchase the pattern molds. Single color is the easiest to work with and will allow for up to 300 pieces per minute on a single line. Two colors decrease the output time to 200 pieces or less.

The molds are sometimes negotiated in the price (free) but often times incur a separate fee. Approximately \$100 +/- per mold design and the client can choose from ready made to the making of his/her own original design. Note: Color choices are limited, and all inks are bio-degradable food grade standard.



TECHNICAL DATA SHEET (TDS) STRAW MAKING PROCESSING LINE

Number of personnel (ideally) for running a line producing up to 10-Million-piece count per month (working in shifts):

4 Personnel + 1 Supervisor

- Slitting Section Operator
- Paper Straw Making Machine Operator
- Printing Machine Operator
- Group Packing (Sorting) Machine
- Individual Packing Machine Operator

- Supervisor or Production Leader

APPROXIMATE COST – INVESTMENT:

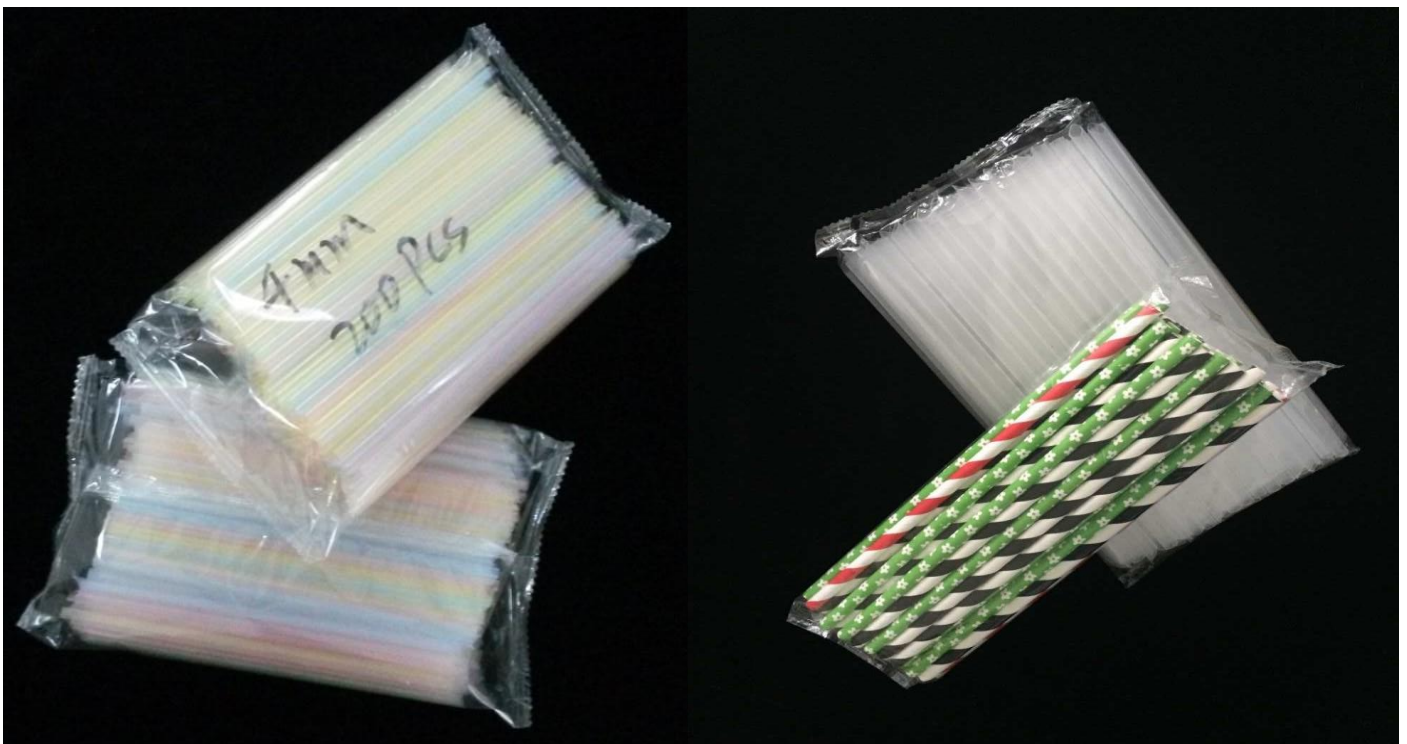
A standard line for up to 500 pieces per minute or 10.8 Million straws per month @ 12-hour shifts. Minimum investment could run approximately \$48,500 USD. For a custom production configuration, prices will, naturally, vary. This is for a middle level supplier. A higher level unit runs approximately \$68,000 USD.



NOTE: Pricing did not factor spare parts and or supplies. FYI.

TECHNICAL DATA SHEET (TDS) STRAW MAKING PROCESSING LINE

REFERENCE PHOTOS:



TECHNICAL DATA SHEET (TDS) STRAW MAKING PROCESSING LINE

