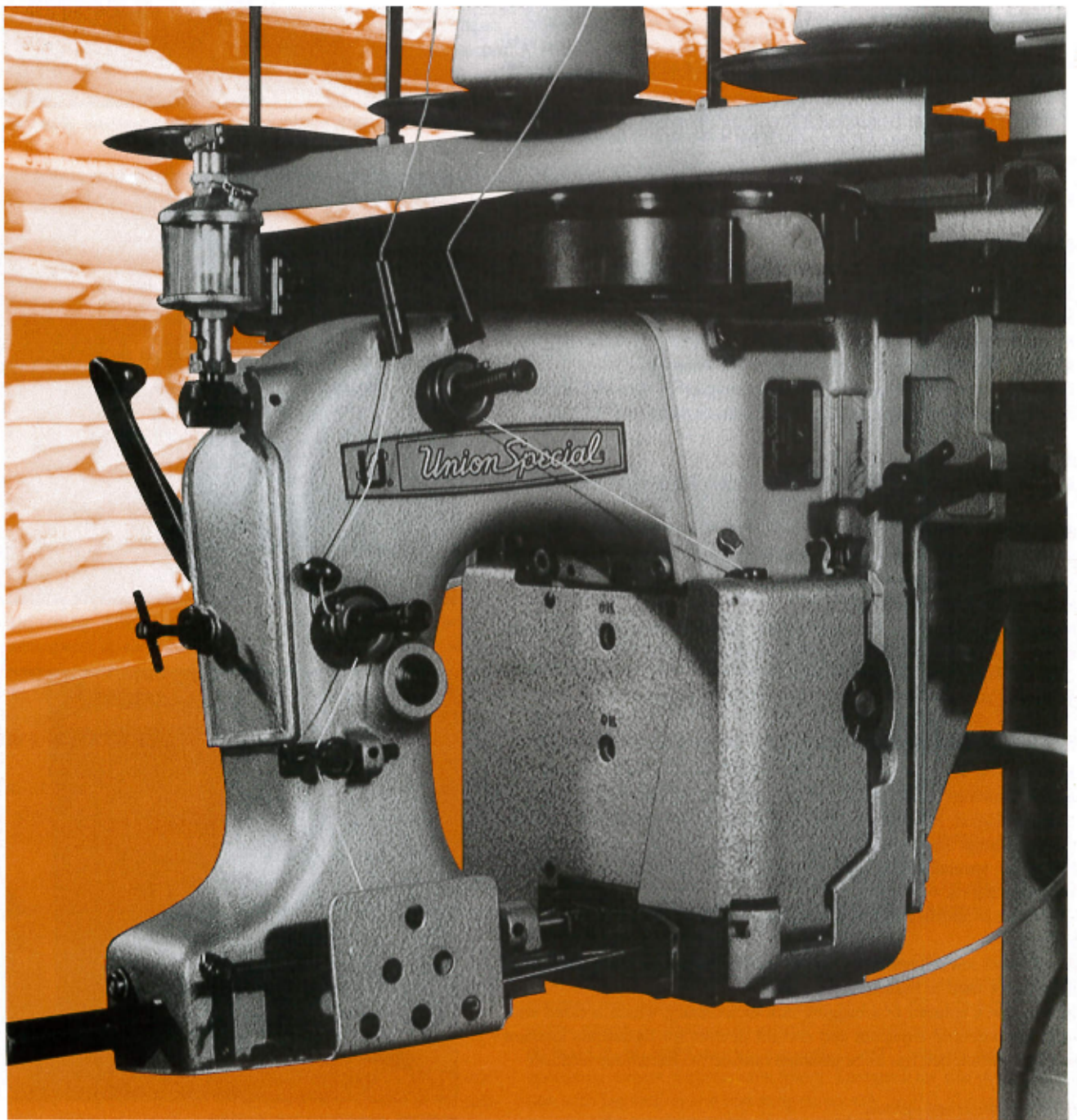


 *Union Special*[®]

80 800

Bag Closing Machines

sturdy – reliable – efficient



Bag Closing Machines Class 80 800

Bag Feed-in Devices

GA 29 905

Bag feed-in devices for use in connection with UNION SPECIAL sewing machines of Styles 80 800 R, RL, S and SL.

The prefolded paper- or plastic bag is guided to the sewing machine.

To fold the upper edge of bag of the rear, bag feed-in device No. GA 29 905 can be equipped additionally with bag folding parts kit No. 93 051 F (suitability test of the bag fabric is required).

GA 29 910

Bag feed-in and trimming device for use in connection with UNION SPECIAL sewing machines of Styles 80 800 UA, UAL and TL.

The upper edge of the prefolded paper- or plastic bag is trimmed and guided to the sewing machine.

On Styles 80 800 UA and UAL a 2", 2 $\frac{3}{8}$ " or 2 $\frac{1}{2}$ " (50, 55 or 63 mm) wide crepe paper or plastic tape is folded over the upper edge of bag, before the sewing machine closes it.

Please indicate the desired tape width when ordering. If the tape width is not indicated, the folder for a 2" (50 mm) wide tape is standard equipment.

Standard Sewing Machines

80 800 C

Stitch type: Two thread double locked stitch (type 401)

Stitch length: Adjustable from 2 $\frac{1}{2}$ to 4 SPI (6 $\frac{1}{2}$ to 11 mm)

Standard setting: 3 SPI (8 mm)

Maximum speed: up to 1800 stitches/min, depending on stitch length and speed of conveyor as well as on operation and material

Capacity under presser foot: $\frac{7}{16}$ " (11 mm), adjustable up to $\frac{5}{8}$ " (16 mm)

Sewing capacity on paper bags: up to 32 plies of paper

80 800 D

Same as Style 80 800 C, but single thread chain stitch (type 101)

80 800 H

Stitch type: Two thread double locked stitch (type 401)

Stitch length: Adjustable from 2 $\frac{1}{2}$ to 4 SPI (6 $\frac{1}{2}$ to 11 mm)

Standard setting: 3 SPI (8 mm)

Maximum speed: up to 1800 stitches/min, depending on stitch length and speed of conveyor as well as on operation and material

Capacity under presser foot: $\frac{9}{32}$ " (7 mm)

Sewing capacity on paper bags: up to 24 plies of paper

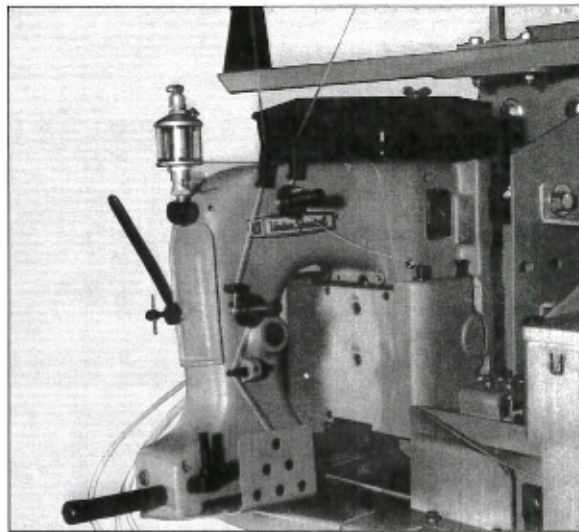
Sewing Machines for Hazardous Locations

Automatic sewing machines with electrical components for use in hazardous locations are available under style Nos. 80 800 RLE, SLE, TLE, ULE and UALE. Proximity switch (according to Namur/DIN 19 234) for Start and Stop. The necessary (Ex) i^{*}-control device is part of the switch box of the specially designed UNION SPECIAL columns for use in hazardous locations.

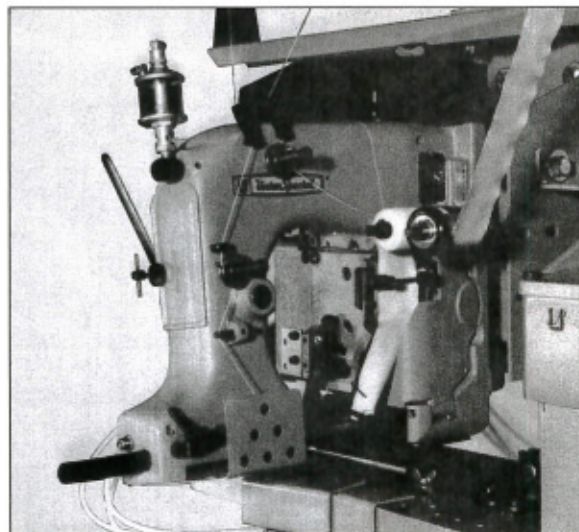
The cutter is operated electropneumatically with an (Ex) S G 4* solenoid valve.

As standard sewing machines do not include any electrical components, they can be used in hazardous locations as well.

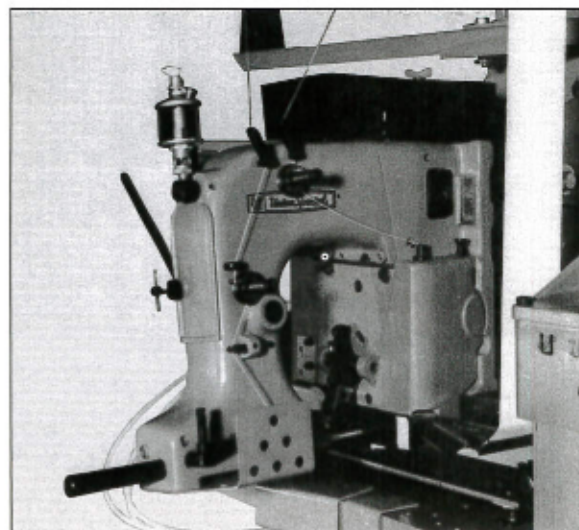
In any case a column or a bagging unit is necessary, which is fitted with motors, switching elements and control devices for hazardous location use. The switch box has to be installed outside the hazardous location.



80 800 RL (R) with bag feed-in device GA 29 905 and bag folding parts kit 93051 F



80 800 TL with bag feed-in device GA 29 910.



80 800 UAL with bag feed-in device GA 29 910.

* according to German safety regulations
Front cover showing 80 800 R with column 20600 F

Union Special®

High-performance sewing machines for closing filled bags and sacks made of jute, cotton, paper, plastic (minimum thickness of foil 180 µm / .007", .18 mm) or woven polypropylene tapes as well as bituminized or foil laminated materials. Guide for application of filter cord for sealing needle punctures is standard equipment.

Automatic Sewing Machines

(Styles 80 800 R, RL, S, SL, TL, U, UL, UA, UAL)

Automatic sewing machines are fitted with built-in devices for automatic start and stop of the machine and with automatically operated thread chain or tape cutters.

The bag being fed into the machine starts the sewing operation by a feeler controlled, contactless, electronic proximity switch. When the bag is closed, the machine stops automatically.

Thread chain or thread chain with binding tape are cut automatically.

Styles 80 800 R, S, U and UA are fitted with solenoid operated cutters. Styles 80 800 RL, SL, TL, UL and UAL are fitted with electropneumatically operated cutters.

When a compressed air supply is available, it is recommended to use machines with electropneumatically operated cutters, because of the

longer service life of the air cylinder resulting in a higher number of cutting cycles.

Bag Feed-in Devices

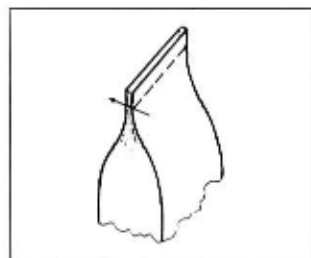
Automatic sewing machines can be fitted with bag feed-in devices, thus easing the work load of the operator. On suitable applications the bag feed-in devices allow the bag closing to be done without an operator.

Coated conveyor chains for protecting the bag material.

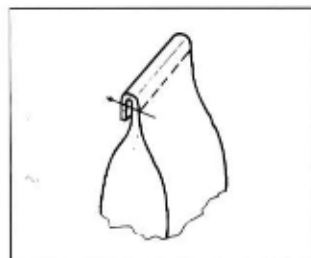
Standard Sewing Machines (Styles 80 800 C, D, and H)

Unlike automatic sewing machines, standard sewing machines are foot switch controlled and work without automatic start and stop. They are fitted with a continuously running chain cutting knife allowing an absolutely safe cutting of the thread chain by the operator.

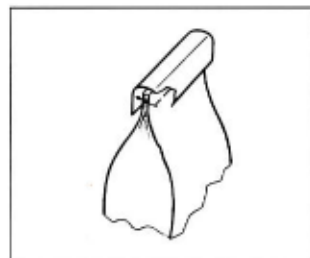
Various Bag and Sack Closures with Different Styles of Sewing Machines



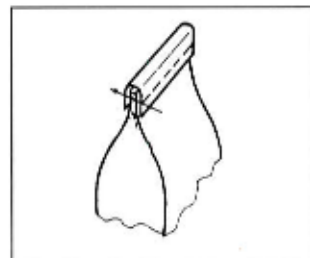
80 800 C, D, R, RL, S, SL



80 800 C, D, R, RL, S, SL



80 800 TL



80 800 H, U, UL, UA, UAL

Automatic Sewing Machines

80 800 R with solenoid operated thread chain cutter.

Protective system of the cutting solenoid IP 54 (according to DIN 40 050).

Stitch type: Two thread double locked stitch (type 401)

Stitch length: Adjustable from 2½ to 4 SPI (6½ to 11 mm)

Standard setting: 3 SPI (8 mm)

Maximum speed: up to 1800 stitches/min, depending on stitch length, and speed of conveyor as well as on operation and material

Capacity under presser foot: 7/16" (11 mm), adjustable to 5/8" (16 mm)

Sewing capacity on paper bags: up to 32 plies of paper

80 800 S Same as style 80 800 R, but single thread chain stitch (type 101).

80 800 RL Same as style 80 800 R, except with electropneumatically operated thread chain cutter. Operating pressure 44 to 59 PSI (3 to 4 bar). Protective system of the solenoid valve IP 65 (according to DIN 40 050).

80 800 SL Same as style 80 800 S, except with electropneumatically operated thread chain cutter. Operating pressure 44 to 59 PSI (3 to 4 bar). Protective system of the solenoid valve IP 65 (according to DIN 40 050).

80 800 TL For closing filled bags and sacks made of paper or plastic foil and simultaneously folding a 2" (50 mm) or 2¾" (60 mm) wide self-adhesive crepe paper tape over the closed bag opening and the seam, which seals the bag air tight.

Electropneumatically operated thread chain and tape cutter. Operating pressure 44 to 59 PSI (3 to 4 bar). Protective system of the solenoid valve IP 65 (according to DIN 40 050).

The projecting length of tape on both ends of bag is approx. 1¾" (35 mm.)

Stitch type: Two thread double locked stitch (type 401)

Stitch length: Adjustable from 2½ to 3 SPI (6½ to 10 mm)

Standard setting: 3 SPI (8 mm)

Maximum speed: up to 1500 stitches/min, depending on stitch length and speed of conveyor as well as on operation and material

Capacity under presser foot: 9/32" (7 mm)

Sewing capacity on paper bags: up to 24 plies of paper

80 800 U For closing filled bags and sacks made of paper and plastic foil while simultaneously attaching a crepe paper tape or a plastic tape of 2" to 2¾" (50 to 70 mm) width (folder adjustable). With solenoid operated tape cutter. Protective system of the cutting solenoid valve IP 54 (according to DIN 40 050).

The projecting length of tape on both ends of bag is approx. 1¾" (40 mm).

Stitch type: Two thread double locked stitch (type 401)

Stitch length: Adjustable from 2½ to 4 SPI (6½ to 10 mm)

Standard setting: 3 SPI (8 mm)

Maximum speed: up to 1800 stitches/min, depending on stitch length and speed of conveyor as well as on operation and material

Capacity under presser foot: 9/32" (7 mm)

Sewing capacity on paper bags: up to 24 plies of paper

80 800 UL Same as style 80 800 U, except with electropneumatically operated tape cutter. Operating pressure 44 to 59 PSI (3 to 4 bar). Protective system of the solenoid valve IP 65 (according to DIN 40 050).

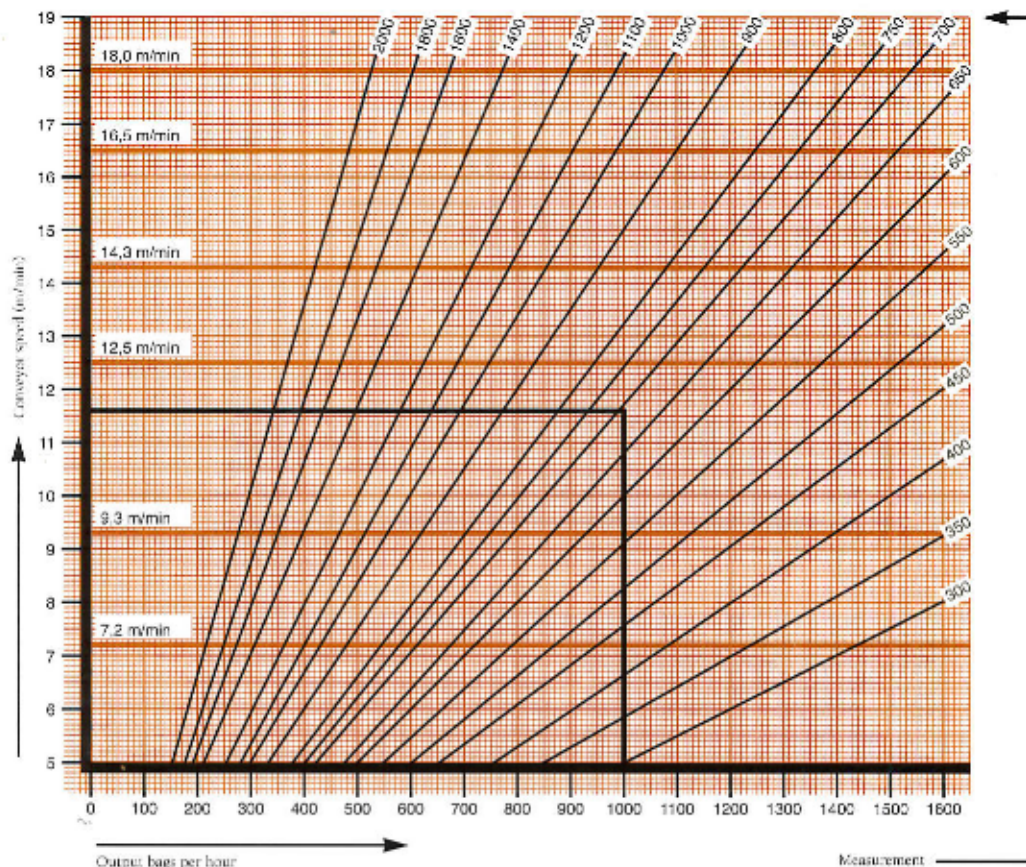
80 800 UA, 80 800 UAL Same as style 80 800 U and 80 800 UL, respectively, except without tape folder. Designed for use in connection with bag feed-in and trimming device GA 29 910. The tape folder is part of the bag feed-in device.

Production Figures at One Glance

Important factors for the production figures are the following: Dimension of bag, amount of filled bags to be closed, conveyor speed as well as the distance between the bags on the conveyor.

The following diagram refers to the theoretical possible output of the sewing machine only. The actual output depends on local conditions.

Follow on the ordinate, indicating the output, of the above chart from 1000 vertically upwards to the point of intersection with the oblique line 700, and you come to a conveyor speed of 11.7 m/min. The next standard conveyor speed must be chosen. In this case it is 12.5 m/min. The width of the bag is constantly 450 mm. The distance between bags would consequently be increased to 300 mm.



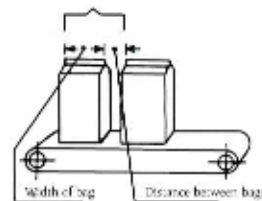
* Minimum distance:

with sewing machines with mechanical trimmer 100 mm

with automatic sewing machines with solenoid or electropneumatically operated cutter 200 mm

Example: Desired output per hour: 1000 bags

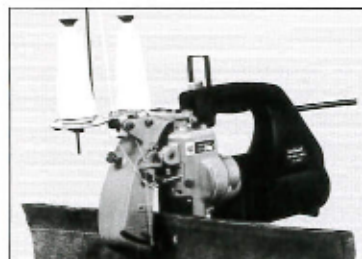
Width of bag	450 mm
+ desired distance between bags*	250 mm
(Measurement on top of oblique line)	700 mm



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UNION SPECIAL CORPORATION PACKAGING DIVISION
One Union Special Plaza, Huntley, IL 60142
847/669-4200, Toll-free in US: 800/344-9698, FAX: 847/669-4355

Union Special GmbH, Raiffeisenstraße 3,
D-71696 Möglingen, Federal Republic of Germany
Telefon 07141/247-0, Telex 7264349 unsp d
Telefax 07141/247-100



Easy to operate, versatile, efficient. The portable class 2200 Bag Closing Machine with integral electric or compressed air motor. For closing filled bags and sacks of all kinds.

Available for single thread and two thread chain stitch.

Weight only approx. 11 pounds (5

kg.). This machine, used by the tens of thousands in all parts of the world, is a necessity in every factory where bags are closed.

It is the perfect stand-by unit when your regular equipment is temporarily out of service.

UNION SPECIAL bag closing machines are unsurpassed in efficiency and reliability. In the tropics as well as under arctic conditions, in sugar and food plants, in flour, feed and salt mills, for cement, fertilizers and other chemicals, no matter what your product may be—UNION SPECIAL builds the right bag closing machine for the job!

This pamphlet gives information on sewing machines you may choose from. Ask for further circulars on complete bag closing units and sewing columns for application with conveyors already existing.

Subject to change without notice.