



科达陶机



科达制造



KEDA GROUP

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## 陶瓷、板材 智能包装设备

Equipment for Auto Packing & Logistics



让幸福更久远  
GREEN SOLUTION · GREENER LIFE

## 包装线简介 Brief

陶瓷砖包装线用于陶瓷墙地砖生产线的包装工序，具有生产效率高、包装费用低、工人劳动强度低以及包装整齐美观、外型标准统一等优点，是现代化墙地砖生产企业必不可少的生产装备之一。

陶瓷砖包装线集机械、气动及电气技术为一体，以连续或间歇作业方式完成陶瓷砖叠垛、包装及码垛等包装作业，由触摸屏工控机、PLC、变频器以及各种传感器组成的控制系统，具有人性化的操作界面、柔性的产品适应性以及可靠的控制功能。

秉承“创新永无止境，永远追求更好”的经营理念 and “为客户创造价值”为企业宗旨，科达包装线以设备包装速度快、运行稳定可靠、操作简便、码包方式多样化而受到客户好评。

Packing line is used in the terminal process of ceramic tile production, which is featured with high efficiency, lower packing cost, less labor intensity, tidy & good-looking, and uniformed appearance. It is one of necessary equipments for modern ceramic factories.

Integrated with mechanical, pneumatic and electronic technology, packing line can connect or disconnect with Polishing line and Squaring & Chamfering Line, completes tile stacking, packaging and palletizing operations. By the industrial touch screen computer, PLC, inverter and electric control system, it realizes human-friendly operation interface, flexible product adaptability and reliable control function.

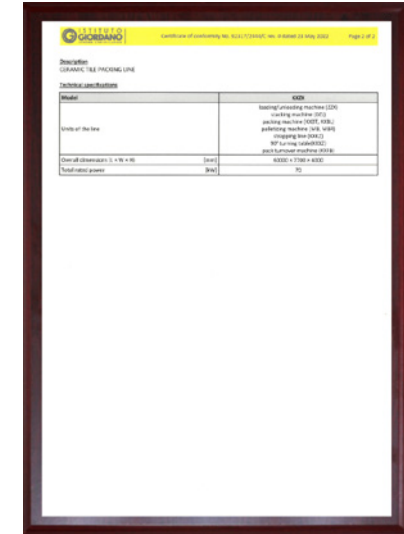
Devoting to "Limitless innovation and boundless pursuit of excellence" and "To create value for customers", KEDA has being researched & developed different packing machines featured with fast, reliable, easy operation and variable mode.

## 大事记 Milestones

- 2010年11月自主研发的科达大规格包装线研制成功并投入批量生产。
  - 2014年科达 KXZX800/600 高效大规格陶瓷砖包装线获“国家重点新产品”荣誉称号。
  - 2017年11月科达首条超大规格包装线在印度成功运行。
  - 2019年底科达高速大规格全兼容包装线成功投产，速度可达 13.3 包 / 分钟。
  - 2020年3月份科达快速大板 KXBT900B/1.8 包装机成功投产，速度可达 10 包 / 分钟。
  - 2020年5月多等级自动拣选包装线在海外顺利验收。
  - 2020年7月包装机械事业部正式成立。
  - 2020年12月多工位吸盘分选叠砖系统研制成功。
  - 2021年3月全自动码包捆托系统成功投产。
  - 2021年10月双工位包装机研制成功并已投产，速度可达 16 包 / 分钟。
  - 2022年3月科达第三代大板包装线成功投产。
- 
- In Nov. 2010, big-size tile packing line with own technology developed and put into mass production.
  - In 2014, KXZX800/600 big size tile packing line honored as National Key New Product.
  - In Nov. 2017, the first super large size tile packing line successfully run in India.
  - High-speed large-size fully compatible packing line was put into production successfully at the end of 2019, packing speed up to 13.3 pack/min.
  - In Mar. 2020, fast packing machine KXBT900B/1.8 for slab was put into service successfully, the packing speed up to 10 pack/min.
  - In May 2020, auto sorting & packing line for multi-grade tile accepted by the overseas customer.
  - In Jul. 2020, packing & logistics machine division established.
  - In Dec. 2020, multi-station suction disc sorting & stacking system developed.
  - In Mar. 2021, automatic palletizing & stack fastening system was put into service.
  - In Oct. 2021, double-station packing machine was developed and put into service, max. packing speed: 16 pack/min.
  - In Mar. 2022, 3rd generation of slab packing line was put into service successfully.

## CE 认证 CE Certification

- 科达包装线于 2012 年通过了欧洲的 CE 认证。
- 专利、政府嘉奖。
- KEDA Packing Line certified by CE in 2012.
- Patents, Government Awards.



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## 快速全兼容直连包装线整线

## Fast direct-connected packing line



### 参数说明 Technical Parameter

| 适用瓷砖规格范围<br>Tile size<br>(mm) | 包装速度<br>Packing speed<br>(packs/min) | 整线长度<br>Length<br>(m) |
|-------------------------------|--------------------------------------|-----------------------|
| 1200×800 ~ 600×300            | 11                                   | 48                    |

## 高速全兼容直连包装线整线

High-speed direct-connected packing line



### 参数说明 Technical Parameter

| 适用瓷砖规格范围<br>Tile size<br>(mm) | 包装速度<br>Packing speed<br>(packs/min) | 整线长度<br>Length<br>(m) |
|-------------------------------|--------------------------------------|-----------------------|
| 1500×750 ~ 800×400            | 13                                   | 51                    |



## 大板直连包装线整线

Direct-connected packing line for slab



### 参数说明 Technical Parameter

| 适用瓷砖规格范围<br>Tile size<br>(mm) | 包装速度<br>Packing speed<br>(packs/min) | 整线长度<br>Length<br>(m) |
|-------------------------------|--------------------------------------|-----------------------|
| 2000×1000 ~ 800×800           | 10                                   | 44                    |

## 长条砖直连包装线整线

Directed-connected packing line for rectangle tile

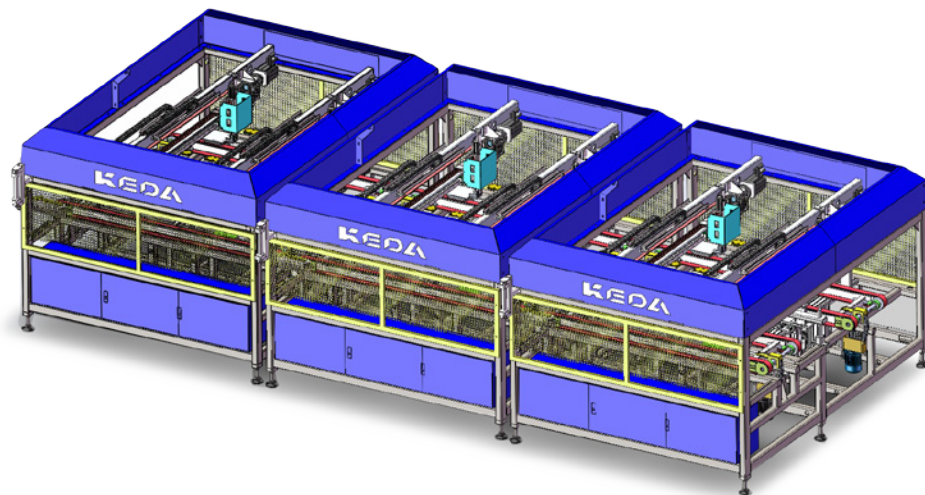


### 参数说明 Technical Parameter

| 适用瓷砖规格范围<br>Tile size<br>(mm) | 包装速度<br>Packing speed<br>(packs/min) | 整线长度<br>Length<br>(m) |
|-------------------------------|--------------------------------------|-----------------------|
| 1200×600 ~ 600×150            | 7                                    | 25                    |

## 叠砖机

## Stacking machine



吸盘式叠砖，将陶瓷砖叠加成砖垛并送入下一工位。

Stack the tile by suction cup, convey the tile stack to the next procedure.



降垛式叠砖，将陶瓷砖定量叠放成砖垛并送入下一工位。

Dropping mode stack, convey the tile stack to the next procedure.

### 技术参数 Technical Parameter

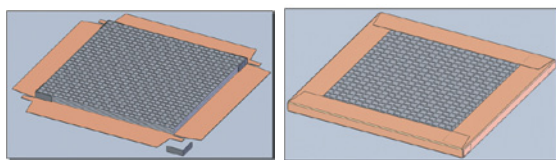
| 型号<br>Model          | 适用瓷砖规格范围<br>Tile size<br>(mm) | 外形尺寸<br>Overall dimension<br>L×W×H<br>(mm) | 总功率<br>Total power<br>(kW) | 总重<br>Total weight<br>(kg) | 叠砖速度<br>Stacking speed<br>(pcs/min) |
|----------------------|-------------------------------|--|----------------------------|----------------------------|-------------------------------------|
| DZJ1200 叠砖机          | 1200×800 ~ 600×600            | 4200×2300×1900                             | 2.6                        | 776                        | 45 片 / 分钟 (600×600)                 |
| DZJ1200A 叠砖机         | 1200×900 ~ 600×300            | 3900×2120×1660                             | 3.49                       | 1150                       | 70 片 / 分钟 (400×800)                 |
| DZJ1200X1800/1 吸盘叠砖机 | 1800×900 ~ 800×400            | 3440×2260×1600                             | 7.7                        | 1050                       | 80 片 / 分钟 (400×800)                 |

## 包装机

## Packing machine

本设备为砖垛套塑料包角、配纸箱及折成砖包。采用四点独立旋转取角、上吸纸方式取纸、坛式包装的多工步流水线式同步动作，由伺服电机控制，移砖定位精确，包装美观、稳定、快速。

Plastic corner capping, carton set and folding. 4-point independent capping, upper carton suction, in-phase working of production line, servo motor guarantees exactly position, stable and quick packing with good-looking.



包装效果 Packing mode

### 技术参数 Technical Parameter

| 型号<br>Model         | 适用瓷砖规格范围<br>Tile size<br>(mm) | 包装方式<br>Packing mode  | 外形尺寸<br>Overall dimension<br>L×W×H<br>(mm) | 总功率<br>Total power<br>(kW) | 总重<br>Total weight<br>(kg) | 包装速度<br>Packing speed<br>(packs/min) |
|---------------------|-------------------------------|---|--|----------------------------|----------------------------|--------------------------------------|
| KXBT1200B/0.9 坛式包装机 | 1200×800 ~ 600×300            | 套包角、坛式包装<br>Corner capping tray-mode                                | 5500×3800×2200                             | 4.5                        | 1800                       | 11包 / 分钟                             |
| KXBT1600/0.9 坛式包装机  | 1600×800 ~ 600×600            |   | 4620×4440×2030                             | 5.5                        | 2940                       | 13包 / 分钟                             |
| KXBT1000C/2 坛式包装机   | 2000×1000 ~ 600×600           | 套包角（中间护角可选）、坛式包装<br>corner capping (middle cap optional), tray mode | 10120×3650×2310                            | 10.5                       | 4068                       | 9包 / 分钟                              |
| KXBT1500A/0.9 坛式包装机 | 1500×750 ~ 600×600            | 套包角、坛式包装<br>Corner capping tray-mode                                | 8270×4450×2280                             | 7.6                        | 4589                       | 16包 / 分钟                             |

## 捆扎线 Strapping line



由6台捆扎机和一台90度转台组成，完成将砖包进行交叉捆扎固定的工作。采取“两用一备”和“集中控制”的工作模式，以便操作人员在不停机的情况下，解决换带等问题。

Consist of 6 strapping machines and a 90-degree turning table. Complete cross-strapping and fixing of the tiles. "2 run and 1 standby" and "centralized control", so that to realize the strip renewal without stopping the machine.

### 技术参数 Technical Parameter

| 型号<br>Model       | 适用瓷砖规格范围<br>Tile size<br>(mm) | 扎带要求<br>Strap   | 外形尺寸<br>Overall dimension<br>L×W×H<br>(mm) | 总功率<br>Total power<br>(kW) | 总重<br>Total weight<br>(kg) | 捆扎速度<br>Strapping speed<br>(packs/min) |
|-------------------|-------------------------------|---|--|----------------------------|----------------------------|--|
| KXKZ1200C/0.9 捆扎线 | 1200×800 ~ 600×300            | 扎带宽度 Strip width 9~10mm<br>宽度偏差 Width error ≤0.05mm<br>扎带厚度 Strip thickness 0.7~1.0mm<br>厚度偏差 Thickness error ≤0.05mm | 16250×1950×1500                            | 8.98                       | 1432                       | 11包 / 分钟                               |
| KXKZ1200B/0.9 捆扎线 | 1200×900 ~ 600×300            |   | 11140×1900×1600                            | 11.8                       | 2400                       | 13包 / 分钟                               |
| KXKZ1000/2 捆扎线    | 2000×1000 ~ 1200×600          | 前3台捆扎机扎带要求: 宽度: 9~10mm; 后3台捆扎机扎带要求: 宽度: 12mm; 扎带厚度: 0.7~1.0mm; 厚度偏差: ≤0.05mm;   | 11140×2540×1280                            | 8.98                       | 2200                       | 9包 / 分钟                                |

## 码包机 Palletizing machine



### 码包机（翻托式） Palletizing machine (Pallet overturning)

本设备将砖包按一定秩序堆放在砖架上，由叉车转运入仓；也可以通过翻托装置，将砖架上的砖垛转移到木托上，再由叉车转运入仓。

Set the pack on the tile shelf orderly and transfer to warehouse by forklift; or transfer the tile from the shelf to wooden pallet and then to warehouse by forklift.

### 码包机（机器人） Palletizing machine (Robot)

集成机器人，通过夹具将转包按照一定秩序堆放在砖架上，由叉车转运入仓；也可通过翻托装置将砖架上的砖垛转移到木托上，再由叉车转运入仓。如需要在围码时实现转包和包装纸全部朝外、且喷码面（或盖章面）统一朝外的出口托要求，则需要配独立的转台和翻包机。

Integrated robot, the tile packs are stacked by gripper onto the tile shelf orderly, then conveyed to warehouse by forklift; or the tile packs can be moved to wooden pallet through turnover device, and then conveyed to warehouse by forklift. Independent turning table and pack turnover machine is needed, for pack turnover and mark (seal) outwards when palletizing.



### 技术参数 Technical Parameter

| 型号<br>Model        | 适用瓷砖规格范围<br>Tile size<br>(mm) | 外形尺寸<br>Overall dimension<br>L×W×H<br>(mm) | 总功率<br>Total power<br>(kW) | 总重<br>Total weight<br>(kg) | 码包速度<br>Palletizing speed<br>(packs/min) |
|--------------------|-------------------------------|--|----------------------------|----------------------------|--|
| KXML12060D/120 码包机 | 1200×800 ~ 600×300            | 5200×7300×4900                             | 5.9                        | 5560                       | 5 次 / 分钟                                 |
| MBR12060B/2 码包机    | 1200×800 ~ 600×300            | 3500×7400×2500                             | 24.5                       | 4080                       | 5 次 / 分钟                                 |
| MBR20090/2 码包机     | 2000×1000 ~ 1200×600          | 5200×7810×2500                             | 27.8                       | 3570                       | 5 次 / 分钟                                 |

☑ 码包效果 Palletizing mode



500×500(出口托、进仓托):  
500 tile enclosed  
木托尺寸:  
Support size: 1100×1100mm  
数量: 48包  
Qty: 48packs  
(12+12+12+12)



600×300 (多层码垛):  
600 tile enclosed  
木托尺寸:  
Support size: 1100×1100mm  
数量: 96包  
(三层横立, 高 900)  
Qty: 96packs  
(8+8+8+8)× 3  
(pack pallet needed)



600×600 (出口托, 进仓托):  
600 tile enclosed  
木托尺寸:  
Support size: 1100×1100mm  
数量: 40包  
Qty: 40 packs  
(10+10+10+10)



800×400(进仓托):  
800 tile enclosed  
木托尺寸:  
Support size: 1100×1100mm  
数量: 44包  
Qty: 44 packs  
(11+11+11+11)



800×800 (七个区、欧托)  
800 tile, support  
木托尺寸:  
Support size: 1100×1100mm  
数量: 30包  
Qty: 30 packs  
(3+2+4+12+4+2+3)



800×800 (出口托、进仓托):  
800 tile enclosed  
木托尺寸:  
Support size: 1100×1100mm  
数量: 28包  
Qty: 28packs  
(7+7+7+7)



900×900 砖围码 (工字托):  
900 tile stand + lie  
木托尺寸:  
Shelf size: 1100×1100mm  
数量: 35包  
Qty: 35 packs  
(2+30+3)



1000×1000 砖 (立加平):  
600 tile lie  
木托尺寸:  
Shelf size: 1100×1100mm  
数量: 32包  
Qty: 32packs  
(30+2)



1200×600 围码 (出口托, 进仓托):  
800 tile lie  
木托尺寸:  
Support size: 1100×1100mm  
数量: 52包  
Qty: 52 packs  
(13+13+13+13)



1500×750 砖围码 (出口托, 进仓托):  
500 tile enclosed  
木托尺寸:  
Support size: 1100×1100mm  
数量: 32包  
Qty: 32 packs  
(8+8+8+8)



1200×1200 (立放):  
1200 tile enclosed  
木托尺寸:  
Support size: 1250×1250mm  
数量: 33包  
Qty: 33 packs

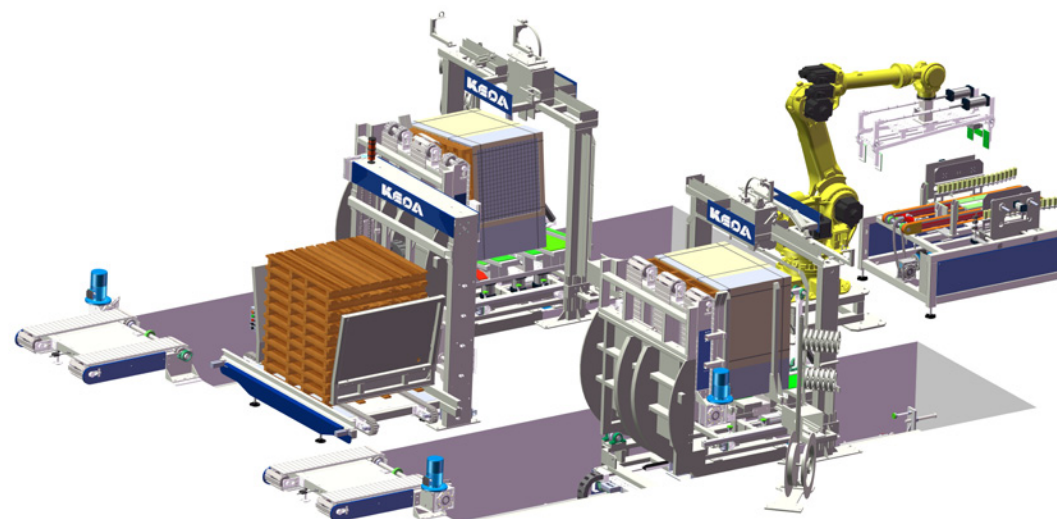


1800×900 立放木托, 三角架:  
1800 tile enclosed  
木托尺寸:  
Support size: 1850×800mm  
数量: 53包  
Qty: 53 packs

## 智能码垛捆托系统 Full automatic palletizing & stack fastening system

系统集成卧托式码包机、自动捆托机、自动托盘库及链式输送线，能实现高效完成多种规格的进仓托、口字托等码垛，自动取送托盘及物流输送的智能码垛，采用模块式设计能对接 AGV 等智能输送设备，完成包装、码垛、仓储物流及出货装车自动化。

System is integrated with lie type palletizing machine, automatic stack fastening machine, automatic tray store and chain conveyor, applicable for stack palletizing with a variety specifications of support, automatic tray handling and intelligent logistics, modular design, suitable for AGV intelligent transportation, including packing, stack palletizing, warehousing logistics and shipment loading automation.



### 技术参数 Technical Parameter

| 型号<br>Mode              | 适用瓷砖规格范围<br>Tile size<br>(mm) | 外形尺寸<br>Overall dimension<br>L×W×H<br>(mm) | 总功率<br>Total power<br>(kW) | 总重<br>Total weight<br>(kg) | 捆托速度<br>Stack fastening speed<br>(packs/min) |
|-------------------------|-------------------------------|--|----------------------------|----------------------------|--|
| KXMK750/1.5<br>智能码垛捆托系统 | 1500×750 ~ 600×600            | 7860×6100×4000                             | 22                         | 3500                       | 13托 / 分钟                                     |



## 分拣下砖线

## Sorting & unloading line

瓷砖经抛光线或磨边线加工并通过分级分色标记后，由分拣下砖线接收标记信号将成品砖拣放到对应砖架。

The finished tile after polishing or squaring will be graded and marked by the unloading line, and then placed on the different shelves.



### 技术参数 Technical Parameter

| 型号<br>Mode   | 适用瓷砖规格范围<br>Tile size<br>(mm) | 外形尺寸<br>Overall dimension<br>L×W×H<br>(mm) | 总功率<br>Total power<br>(kW) | 总重<br>Total weight<br>(kg) | 单工位拣砖速度<br>Single station sorting speed<br>(packs/min) | 整线进砖速度<br>Feeding speed<br>(pcs/min)    |
|--------------|-------------------------------|--|----------------------------|----------------------------|--|---|
| KXFJ12080/N  | 1200×800 ~ 500×500            | (5000+N×2250)×6700×2100                    | 0.8 + 工位数 × 2.1            | 400+N×1000                 | 9 片 / 分钟   | 60 片 / 分钟 (600×600)、50 片 / 分钟 (800×800) |
| KXFJX12090/N | 1200×800 ~ 500×500            | (5000+N×2250)×6000×1700                    | 0.55+(3.2×N)               | 400+N×780                  | 9 片 / 分钟   | 60 片 / 分钟 (600×600)、50 片 / 分钟 (800×800) |
| KXFJ18090/N  | 1800×900 ~ 600×600            | (4680+N×5600)×6110×1980                    | 0.75 + 拣砖机数 × 6.65         | 400+N×1650                 | 7.5 片 / 分钟   | 60 片 / 分钟 (600×600)、50 片 / 分钟 (800×800) |

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