

ReliPak

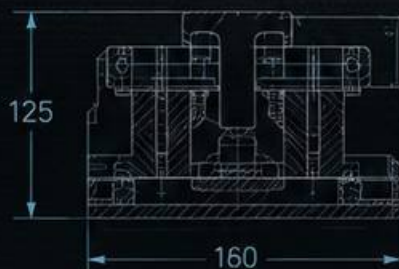
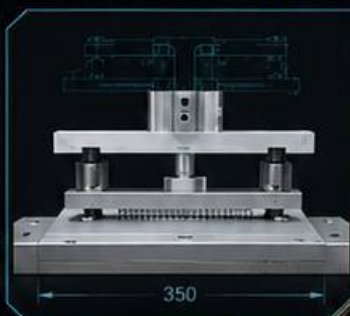
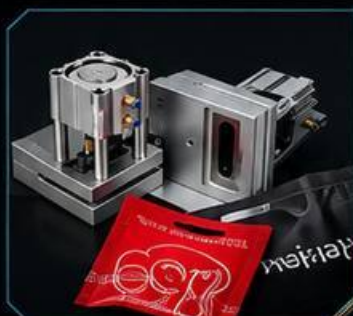
PNEUMATIC PUNCHING UNITS

Precision Punching Solutions for Bag-Making Machines





WE OFFER CLASSIC ONLY



A selection of precision punching units for bag-making and automated packaging lines.



PRECISION
ENGINEERING



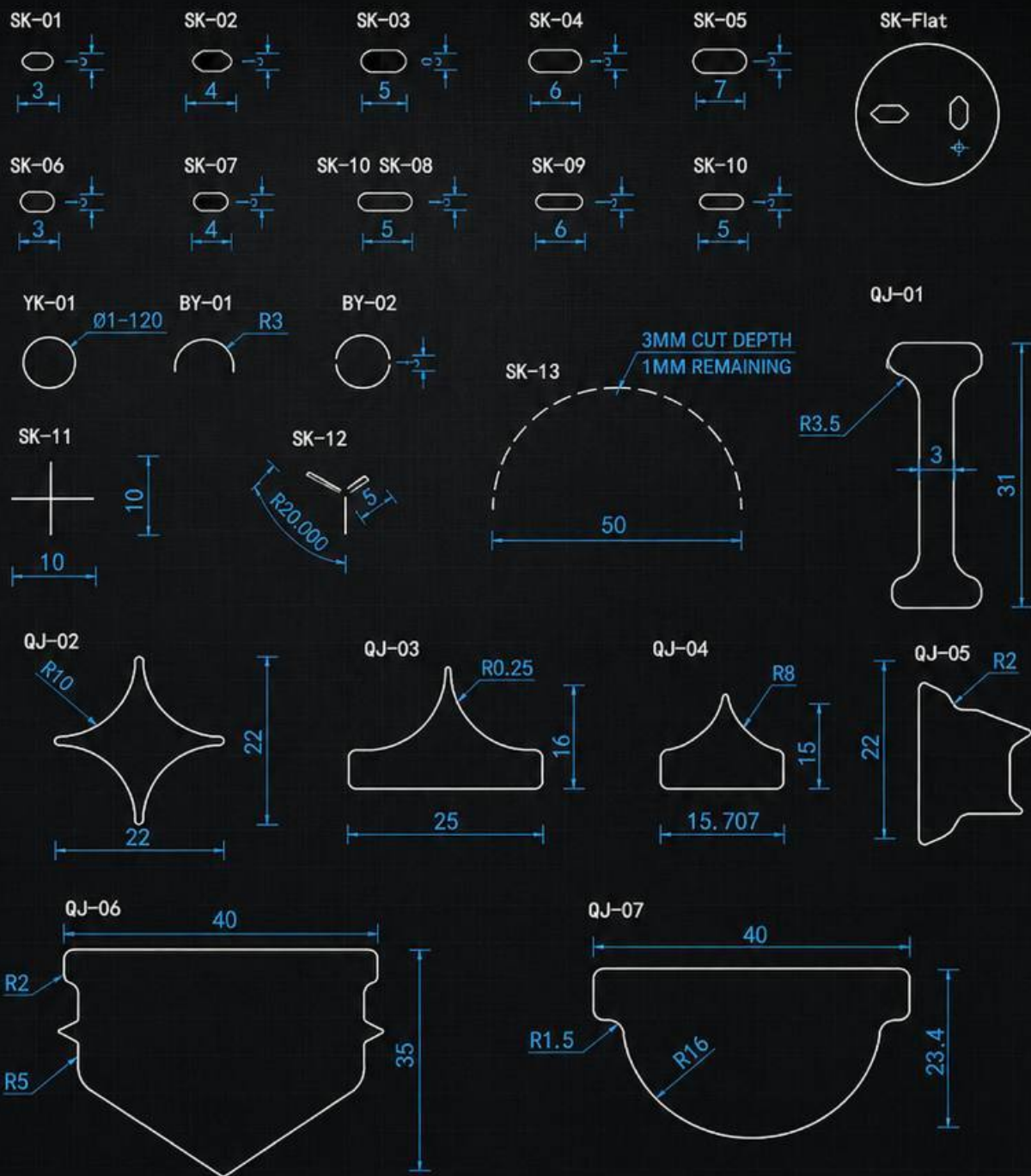
DURABLE
CONSTRUCTION



EASY
INTEGRATION



WIDE RANGE OF
APPLICATIONS



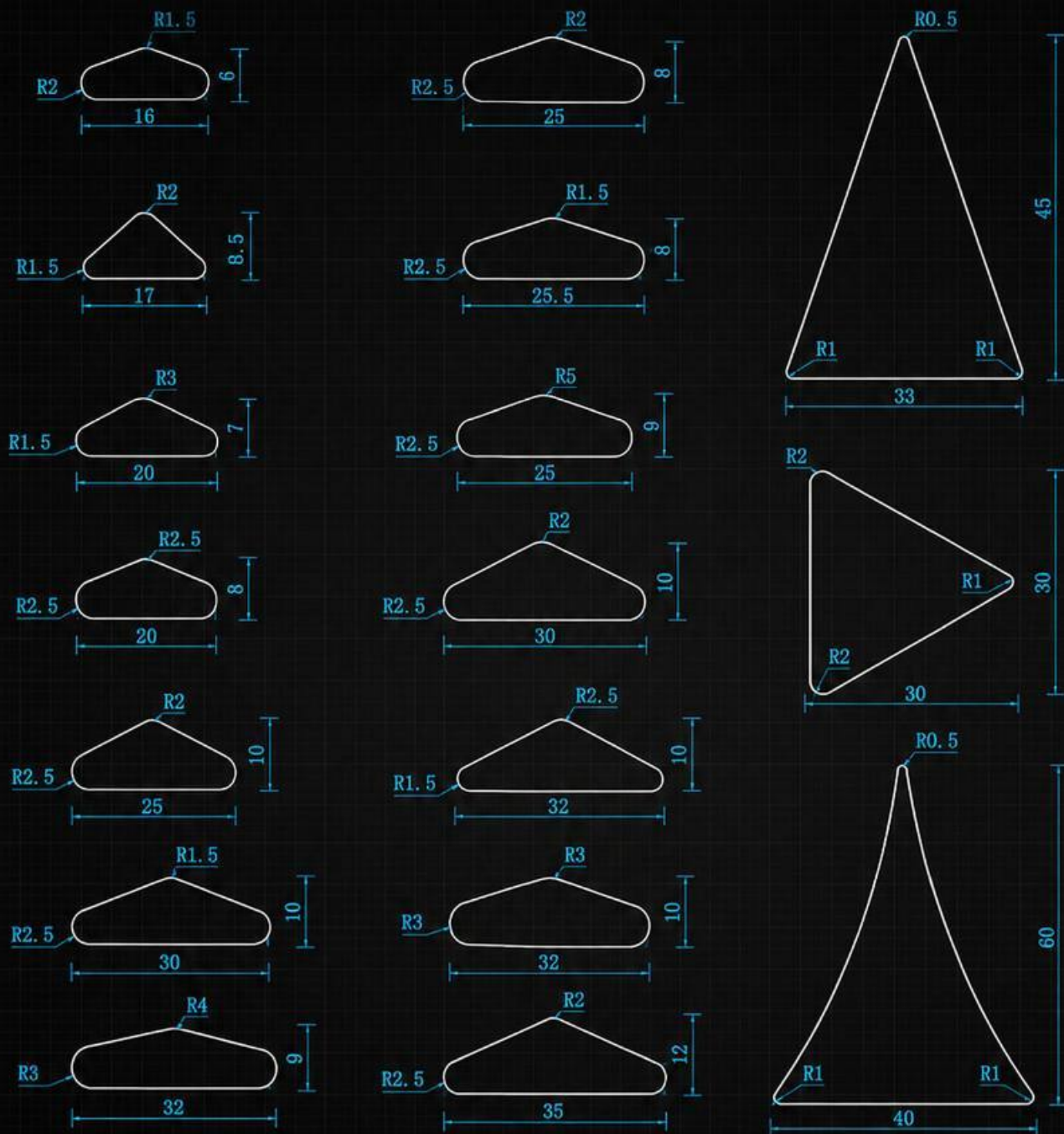
Tear hole, round hole, Cutaway hole (ordinary type, lengthened)

Suitable for PE, OO, PVC, PPE, CPE and other plastic bags, stationery bags, food bags and other packaging.

Tear holes, cutaway holes, round holes and other configurations enable reliable break points and hanging functions.

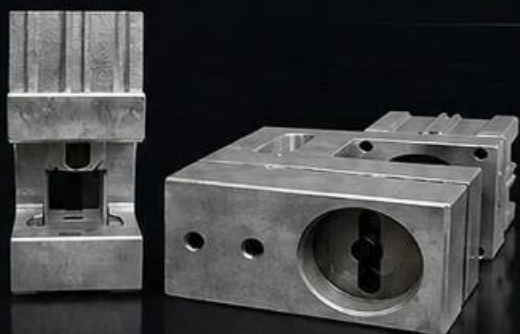
Compatible with material thickness from 0.02mm to 0.2mm.

Speed: up to 250 beats / min.



Suitable for PE, Po, PP, OPP, PVC, PPE, PPU, CPE, such as plastic bags and tied with Cutaway, can be washed off all kinds of plastic film over 0.02MM, at speeds up to 250 beats / min.

Standard and custom butterfly-hole profiles for bag-making applications.



BUTTERFLY HOLE

Suitable for PE, PO, PP, OPP, PVC, PPE, PPU, CPE and other plastic bags chuck, breathable, pearl film, hook holes, punching the elevator and other products.

Can be washed off the monolayer material thickness 0.02mm plastic bag, speed up to 250 beats / min.



FJ-01 	FJ-08 	FJ-15
FJ-02 	FJ-09 	FJ-16
FJ-03 	FJ-10 	FJ-17
FJ-04 	FJ-11 	FJ-18
FJ-05 	FJ-12 	FJ-19
FJ-06 	FJ-13 	FJ-20
FJ-07 	FJ-14 	FJ-21



APPLICATION

Suitable for PE, PO, PP, OPP, PVC, PPE, PPU, CPE and other plastic bags chuck, breathable, pearl film, hook holes, punching the elevator and other products.



MATERIAL THICKNESS

Can be washed off the monolayer thickness of the material 0.02mm plastic bag



SPEED

Up to 250 beats / min.

ST-01



ST-06



ST-02



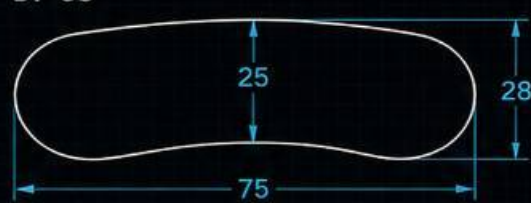
ST-07



ST-03



ST-08



ST-04



ST-09



ST-05



ST-10



PRECISION ENGINEERED

CNC-machined for tight tolerances, clean cuts and long-lasting performance.



VERSATILE SOLUTION

Compatible with a wide range of materials and packaging machines.



APPLICATIONS

Durable handle-hole configurations for shopping bags, rice bags and flexible packaging.

FRESH RICE

ReliPak | HANDLE & PROFILE HOLES

Custom handle and profile punching solutions for high-speed bag-making lines.

ST-11



ST-12



ST-13



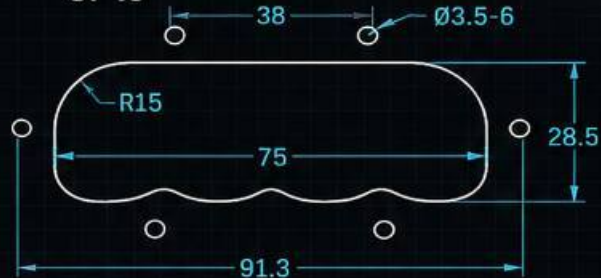
ST-14



ST-15



ST-16



ST-17



ST-18



ST-19



PRECISION ENGINEERING

Accurate dimensions and clean punch quality for consistent performance.



PREMIUM MATERIALS

Hardened tool steel for long service life and wear resistance.



HIGH-SPEED READY

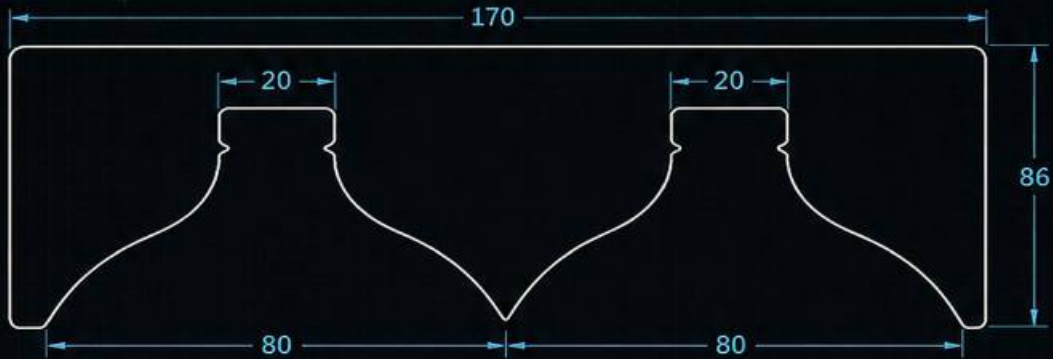
Optimized punching profiles for smooth operation on high-speed lines.



CUSTOM SOLUTIONS

Tailored handle shapes and hole profiles to meet your specific needs.

YX-06



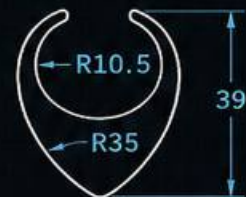
YX-07



YX-08



YX-09



YX-10



SPECIAL-SHAPED HOLES

Custom-developed profiles for specialized bag-making and packaging requirements.

Hole punching machine for punching a variety of nozzle shaped jelly bags, milk bags, punching bags, laundry detergent, and automatic packaging machines.

Engineered profile punches matched to material, bag format and production speed.

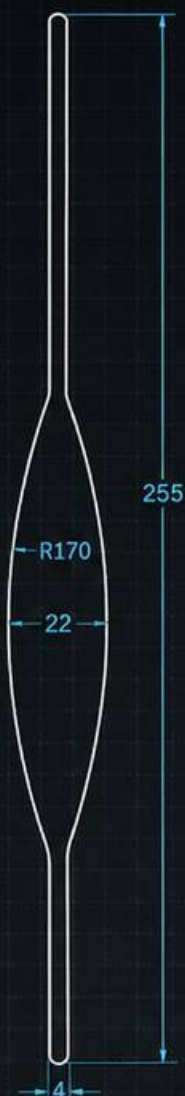
YX-01



YX-03



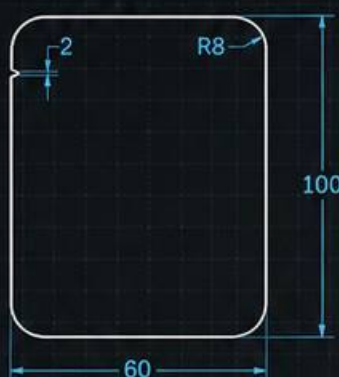
YX-05



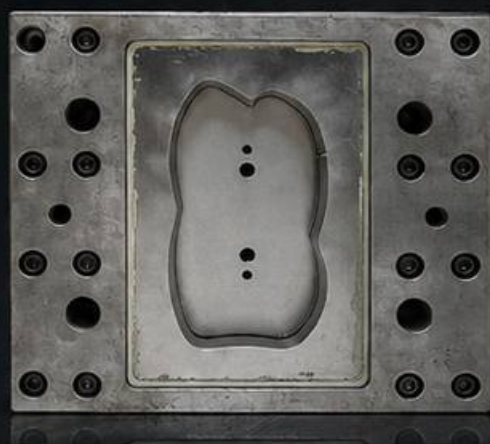
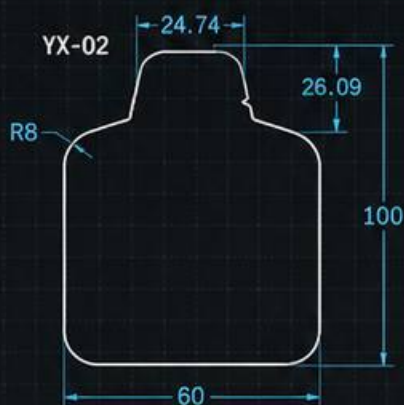
YX-04



YX-05



YX-02



PRECISION PROFILE

Tight tolerances and smooth edges for clean, consistent punching.



DURABLE DESIGN

Hardened steel construction for long tool life and reliable performance.



APPLICATION FLEXIBILITY

Custom shapes for a wide range of bag formats and material types.



PRODUCTION READY

Engineered to match your production speed and equipment.

ReliPak / ALUMINUM-BAR HOLE PATTERNS

Precision multi-hole aluminum-bar systems for fast, repeatable production.

X0-11



X0-11



X0-16



X0-23



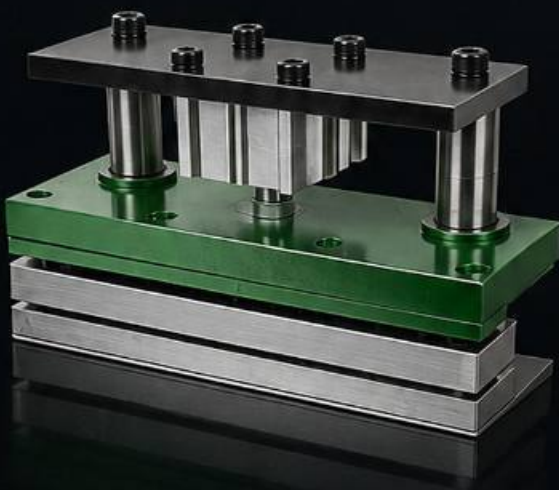
X0-30



X0-14



X0-22



ALBUM HOLE

The album is divided into 11 holes, 16 holes, 27 holes, 29 holes, 30 holes and other porous mold, album hole drilling machine for album bags, blank pages, and other documents.

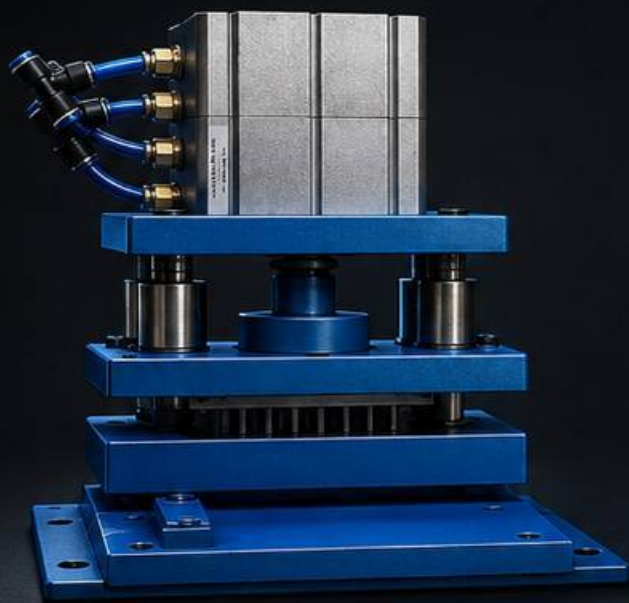


PERFORMANCE

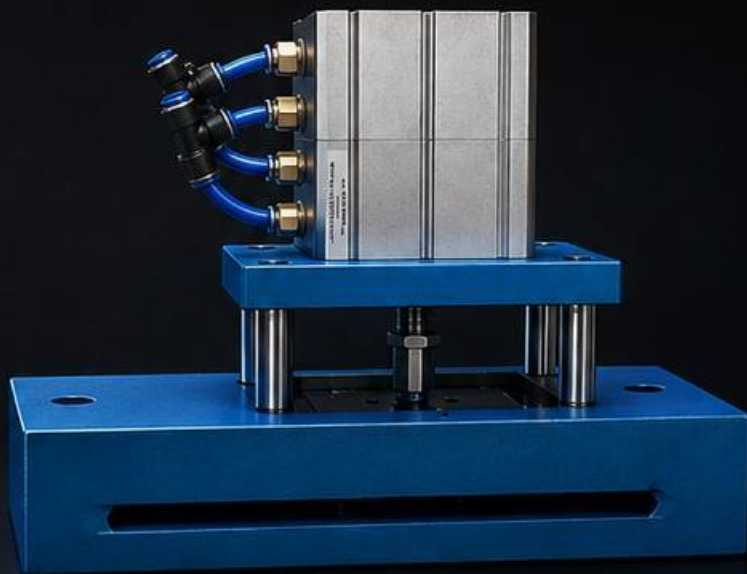
Speeds up to 250 times / min.

ReliPak

PUNCHING UNIT PORTFOLIO



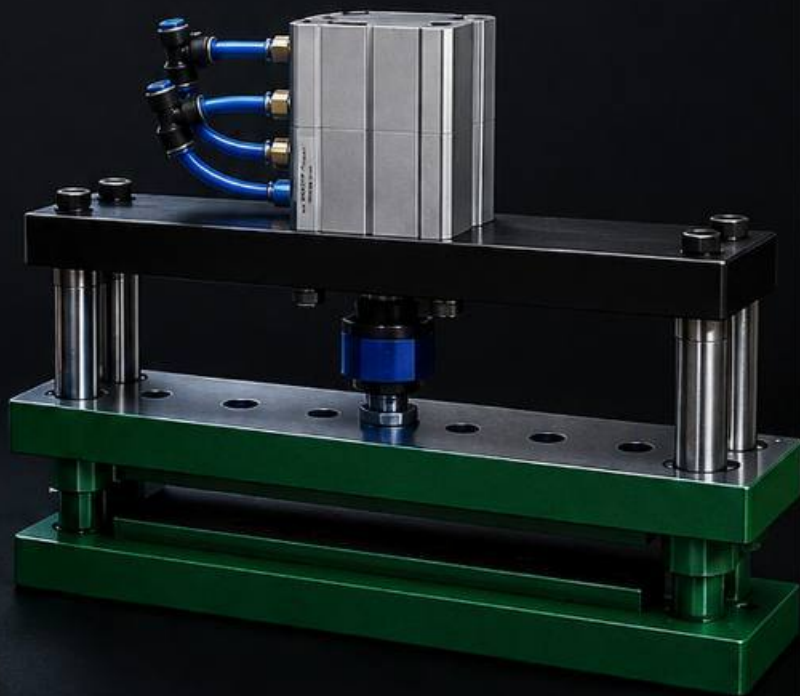
Rocker-Arm Punching Unit



Profile Punching Unit



Multi-Hole Punching Unit



E310 Split Punching Unit

PNEUMATIC PUNCHING UNIT – OPERATING GUIDE



OPERATING PRECAUTIONS



BEFORE USE

- Inspect the punch and lower-die cutting edge for debris.
- Remove all debris before operation.
- Lubricate the upper punch and sliding parts.



DURING OPERATION

- Keep all lubrication points adequately oiled.
- Stop and inspect immediately if abnormal noise occurs.
- Never strike the unit with steel tools.



RECOMMENDED AIR PRESSURE:

3–5 kg/cm²



AFTER USE

- Clean the punch and lower die.
- Apply lubricant, then lower the punch to its bottom position for protection.



COMMON TROUBLESHOOTING



PUNCH DOES NOT RETURN

- Adjust air pressure to 4–5 kg/cm².
- Raise the punch position by 0.5 mm to reduce punching depth.



BURRS OR INCOMPLETE PUNCHING

- Polish the lower die with a diamond file for 5–6 minutes, then finish with an oilstone for 2–3 minutes.
- Contact ReliPak if the issue persists.



PLASTIC BAG TEARS

- Check air pressure, the punch signal system and synchronization with the cutter.



INTERMITTENT OR MISSED PUNCHING

- Check air pressure and air supply.
- Inspect the solenoid valve, silencer and cylinder for blockage, water or air leakage.